Title  
STABILIZER JACKSCREW ACCESS COVER  

MODELS AFFECTED  
180  
185 & A185  

SERIALS AFFECTED  
30000 thru 18053202  
185-0001 thru 18504328  

PARTS LIST:  

<table>
<thead>
<tr>
<th>QUANTITY</th>
<th>PART NUMBER</th>
<th>NOMENCLATURE</th>
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<tr>
<td>6</td>
<td>AN525-10R8</td>
<td>Screw</td>
</tr>
<tr>
<td>5</td>
<td>MS20470AD4-5</td>
<td>Rivet</td>
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<td>13</td>
<td>MS20470AD4-6</td>
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<td>0712083-3</td>
<td>Cover</td>
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<tr>
<td>1</td>
<td>0712083-1</td>
<td>Doubler Assy</td>
</tr>
<tr>
<td>1</td>
<td></td>
<td>Installation Instructions</td>
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CHANGE IN WEIGHT AND BALANCE:  

| WEIGHT INCREASE | 0.2 pounds | NET CHANGE |
| ARM             | 212.2 inches |            |
| RESULTANT MOMENT | 42.4 pound-inches |         |
| INDEX           | 0.042      |            |

1. DESCRIPTION OF INSTALLATION.  
   a. Installation of this kit consists of:  
      (1) Elevating tailcone of aircraft.  
      (2) Locating and cutting rectangular hole in aft tailcone skin for easy access to jackscrews.  
      (3) Installing doubler assembly and access cover plate.  

2. INSTALLATION INSTRUCTIONS.  
   a. (Refer to figure 2.) Stabilizer Jackscrew Access Cover Installation.  
      (1) Elevate tailcone of aircraft with hoist and strap or place on a stand approximately at station 172.00, to a sufficient height to allow adequate working freedom.  
      
      **CAUTION**  
      If placed on a stand, care should be utilized to prevent damage to the bulkhead resting on the stand.  

      (2) Locate area to be modified and drill out existing rivets (14) common to bulkhead (2) at station 215.687 and the inboard two brackets (5), per sheet 2 of 2.  

      (3) Obtain doubler assembly (15) from the kit and locate it inverted on skin (3) correctly positioned and cleco in place utilizing the hole (14) existing on centerline of station 215.687 bulkhead (2).
Line up the forward .098 pilot hole (18) on centerline of doubler assy (15) with the center line of the aircraft and drill thru skin (3). Insert cleco.

(4) With doubler assy (15) in place, scribe or mark on the skin (3) the two .193 attach holes (17) located on centerline utilized to secure to cover (6).

(5) Remove clecos and doubler assembly (15) from belly skin. Drill the two .193 holes (17) previously marked.

(6) Obtain cover (6) from the kit and locate in the correct position on skin (3) and cleco in place utilizing the two previously drilled .193 holes (17).

NOTE

Cover (6) is not symmetrical forward and aft.

(7) With the cover (6) in place, scribe or mark on skin (3) the outside perimeter of the cover (6). Remove clecos and cover from skin.

(8) Cut the rectangular hole in the skin (3) per previously scribed outline. Discard removed material. Check fit of cover (6) with opening in skin (3).

NOTE

It may be necessary to detach actuator assemblies or some equipment to provide access to insert doubler assembly thru hole.

(9) Drill out remaining rivets. Insert doubler (15) through hole and cleco in place. Back drill the remaining .128 holes. A hole finder may be utilized to locate and drill the four holes (18) along the forward edge of the doubler.

(10) Locate and drill two .128 holes (19), .63 on either side of centerline, through skin (3), doubler (15), and bulkhead (2).

(11) Rivet the doubler assembly (15) in place using the appropriate sized rivets as shown on sheet 2 of 2.

NOTE

Reinstall actuators (8) or any other equipment which may have been removed or disconnected to provide access to area being modified.

(12) Install cover (6) with screws (7).

(13) Paint the outside surface of the cover (6) to match existing color combination as required.

(14) Remove tailcone of aircraft from stand or hoist.
Figure 1. Stabilizer Jackscrew Access Cover Installation.
Figure 2. Stabilizer Jackscrew Access Cover Installation - Sheet 1 of 2.
Figure 2. Stabilizer Jackscrew Access Cover Installation - Sheet 2 of 2.