SERVICED

Title  SPAR SPLICE — LEFT REAR
THE PILOT'S AIRPLANE

MODELS AFFECTED  SERIALS AFFECTED

170  18003 thru 27169
172  28000 & on
175  55001 & on
180  30000 & on
182  33000 & on
185  185-0001 & on
210  57001 & on

ESTIMATED INSTALLATION TIME: 16 HOURS.

CHANGE IN WEIGHT AND BALANCE:

MODEL  170 - 172 - 175 - 180 - 182 - 185 - 210
WEIGHT INCREASE  Negligible

PARTS LIST:

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<td>10008-17-2</td>
<td>Segment - Rear Spar Splice Left</td>
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<td>10008-17-3</td>
<td>Angle - Left</td>
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<td>10008-17-4</td>
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<td>0523400-12</td>
<td>Channel - Spar Reinforcement</td>
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1. DESCRIPTION OF INSTALLATION.

Installation of Service Kit 70A50-2 consists of:

a. Installing a spar splice in the left wing rear spar.

2. INSTALLATION INSTRUCTIONS.

a. (Refer to figure 1.) Install the spar splice as follows:

   NOTE

This repair can be made without wing removal, however, for working convenience wing may be removed.

(1) Remove fuel tank cover and tank.

(2) Remove rivets in that part of the upper trailing edge skin which is just aft of the fuel tank opening. This will provide access to the rear face of the spar.

(3) Cut off damaged portion of spar and remove from wing. This cut must be a minimum of 11 inches and a maximum of 25-5/16 inches outboard of station 22.612 (centerline of bolt hole).
(4) Position channel (6) and plate (3) so they are centered over cut edge of spar (2), then rivet in place.

(5) Cut the spar segment (4) to the dimension shown between the outboard fuel tank bay rib (1) and the center of spar segment bolt hole.

(6) Slide spar segment (4) in place, between channel (6) and plate (3) and so the edge of the segment butts against the edge of spar (2). Clamp in place with "C" clamps and check dimensions before drilling and riveting.

(7) Rivet spar segment (4) in place using pattern shown.

(8) Trim and install joggled angle (5) so the outboard end of the angle butts against the inboard end of channel (6).

(9) Rivet skins previously removed in place and reinstall fuel tank and cover.

NOTE

If slight damage should occur in spar segment (4), repair of the segment may be made by use of plate (3), channel (5), and angle (5) without replacing segment (4).

Figure 1. Installation of Spar Splice