

Technical Note TN.JS-027

26 March 2015

TITLE

Elevator Auto Coupler Flange Repair

DESCRIPTION

The Elevator Auto Coupler's flange may be damaged during assembly or transport. This Technical Note sets out the procedure to repair a crack in this elevator driver flange.

INSTRUCTIONS

1. Scarf out and replace the carbon layers of the outside skin according to the JS1 Repair Manual, document number 1A-5.04.60. See figure 4 for the layup schedule of the Tailplane Auto-Coupler.

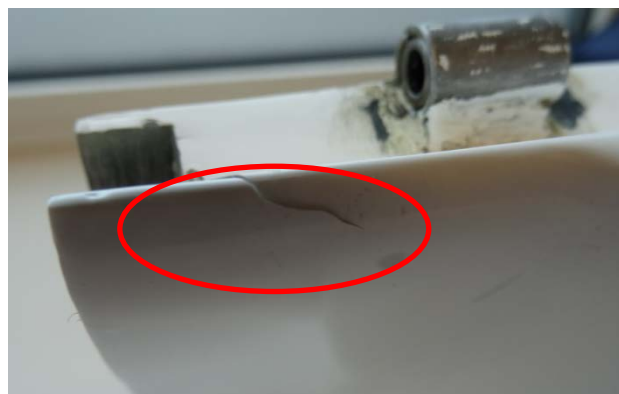


Fig. 1 - Outside Surface

2. Clean the crack and the surrounding area with an appropriate degreasing agent.
3. Inject bonding epoxy into the crack with a syringe, as illustrated in the figure below:

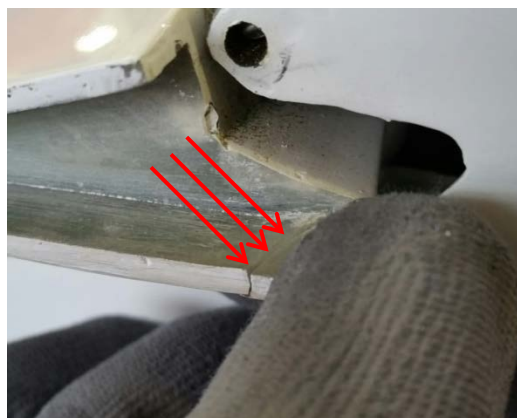
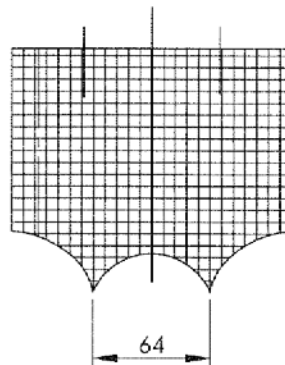


Fig. 2 - Inside Surface

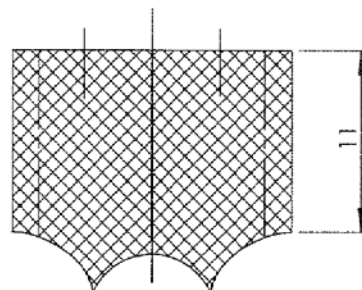
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4. Ensure the profile of the auto-coupler does not change by clamping the auto-coupler with a tongue depressor fitted to the inside surface.
5. Clean the excess epoxy bonding mix.
6. Allow to cure.
7. Apply Gelcoat to the repaired area and profile the surface.
8. Sand and paint the outside surface after curing.

① 98141 # ENTIRE AREA



② 98141 X ENTIRE AREA



③ 98141 # ENTIRE AREA

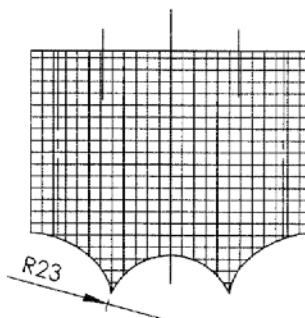


Fig. 4 - Auto-Coupler Layup Schedule

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MATERIAL SUPPLIED

None

MATERIAL REQUIRED

1. Bonding Epoxy Mix - Laminating resin mixed with Cotton Flocks and Cab-o-Sil
2. Gelcoat
3. Degrease agent (e.g. Acetone)
4. Clamp
5. Sanding Pad
6. Tongue Depressor
7. Paint
8. Polish
9. Paper Towel

MASS AND BALANCE

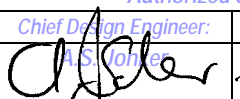
No change to mass or balance

MANUALS

No change to Flight or Maintenance Manuals

NOTES

This technical note must be implemented by an approved maintenance technician.

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