



# SERVICE BULLETIN

No. 575

Piper Aircraft Corporation

Lock Haven, Pennsylvania, U.S.A.

"Modification DOA EA-1 Approved"

August 3, 1977

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Subject:

Inspection of Horizontal Stabilizer and Vertical  
Fin Stringer Attachment Rivets

Models Affected:

Serial Numbers Affected:

PA-31 and PA-31-325 Navajo .....	31-7712057 to 31-7712078 inclusive, 31-7712081 and 31-7712083
PA-31-350 Navajo Chieftain.....	31-7752099, 31-7752101, 31-7752103, 31-7752105 to 31-7752114 inclusive, 31-7752117 to 31-7752131 inclusive and 31-7752134 to 31-7752138 inclusive

Compliance Time: At the next scheduled Programmed Inspection Event, not to exceed the next fifty (50) hours of operation.

Purpose: The stabilizer (top and bottom) and fin skin panels are attached to stringers, located between the stabilizer and fin front and rear spars. Flush head rivets are used for skin attachment, and are spaced along the corresponding stringers between the stabilizer inboard rib (Sta. 12.62) and tip rib (Sta. 91.12), both top and bottom surfaces, and on the vertical fin along the stringers between the fin tip rib and bottom rib.

It has been determined that an improper number of rivets may have been used to attach stringers to skin panels in the areas referenced above. An inadequate number of rivet in the above locations may permit local buckling of the skin between rivets. The attached sketch/instruction data visually defines affected areas.

This Service Release provides instructions to inspect the stabilizer and fin skin/stringer attachment in the areas described above (and illustrated on the attached sketch/instruction data) to insure that an adequate number of rivets are installed.

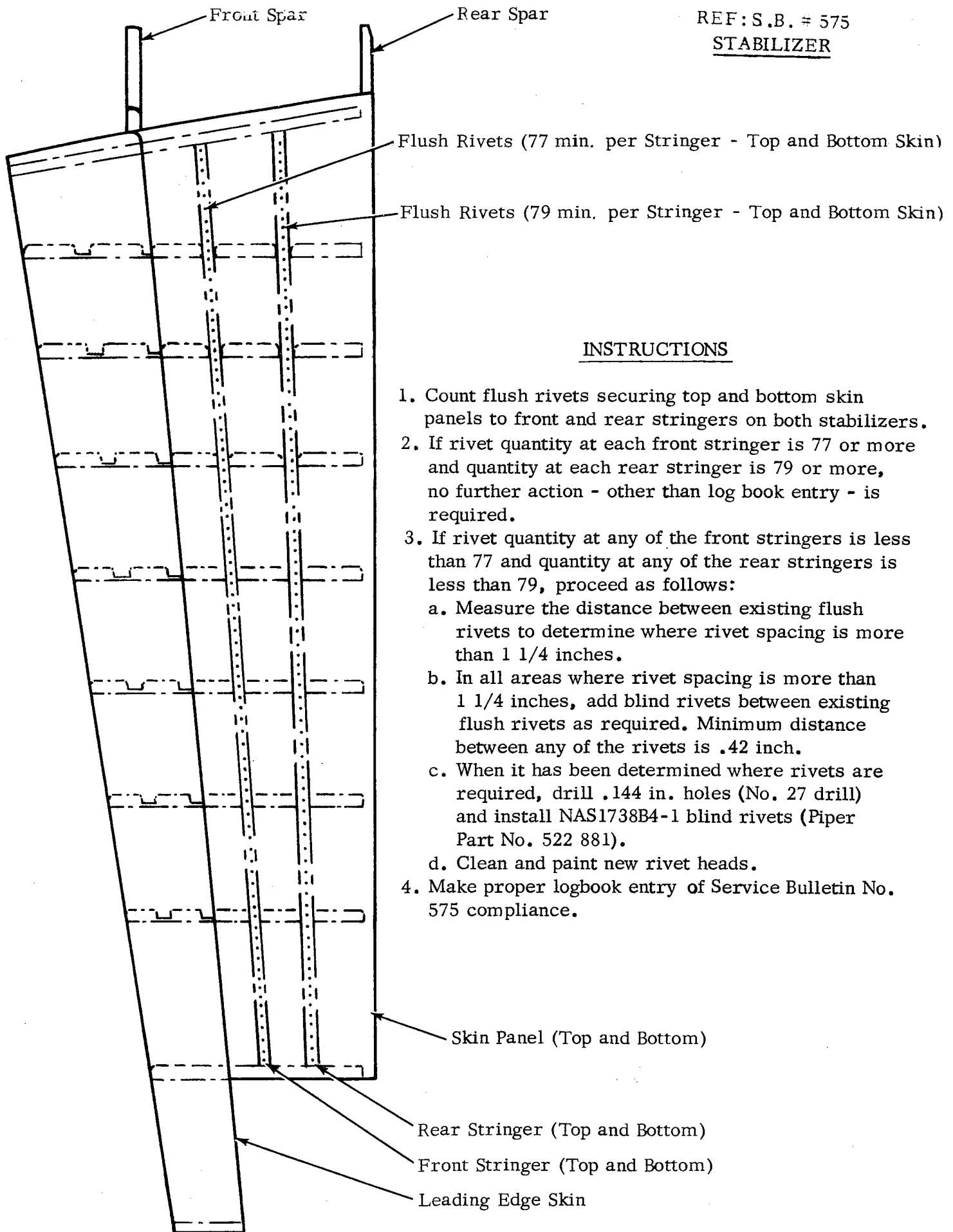
Instructions: Refer to attached sketch/instruction data for inspection guidelines and (if required) proper rivet installation procedures.

Material Required: Piper Part Number 522 881 Rivet (NAS1738B4-1) as required.

Availability of Parts: Your Piper Field Service Facility.

Effectivity: This Service Release is effective upon receipt.

Summary: Please contact your Piper Field Service Facility to make arrangements for compliance with the provisions of this Service Release in accordance with Compliance Time, above. Inspection time requirements is minimal (removal of stabilizers and/or fin is not required either for inspection or rivet installation - if needed). Material and labor allowance credit is available through your Piper Field Service Facility, should rivet installation be required.

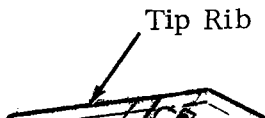


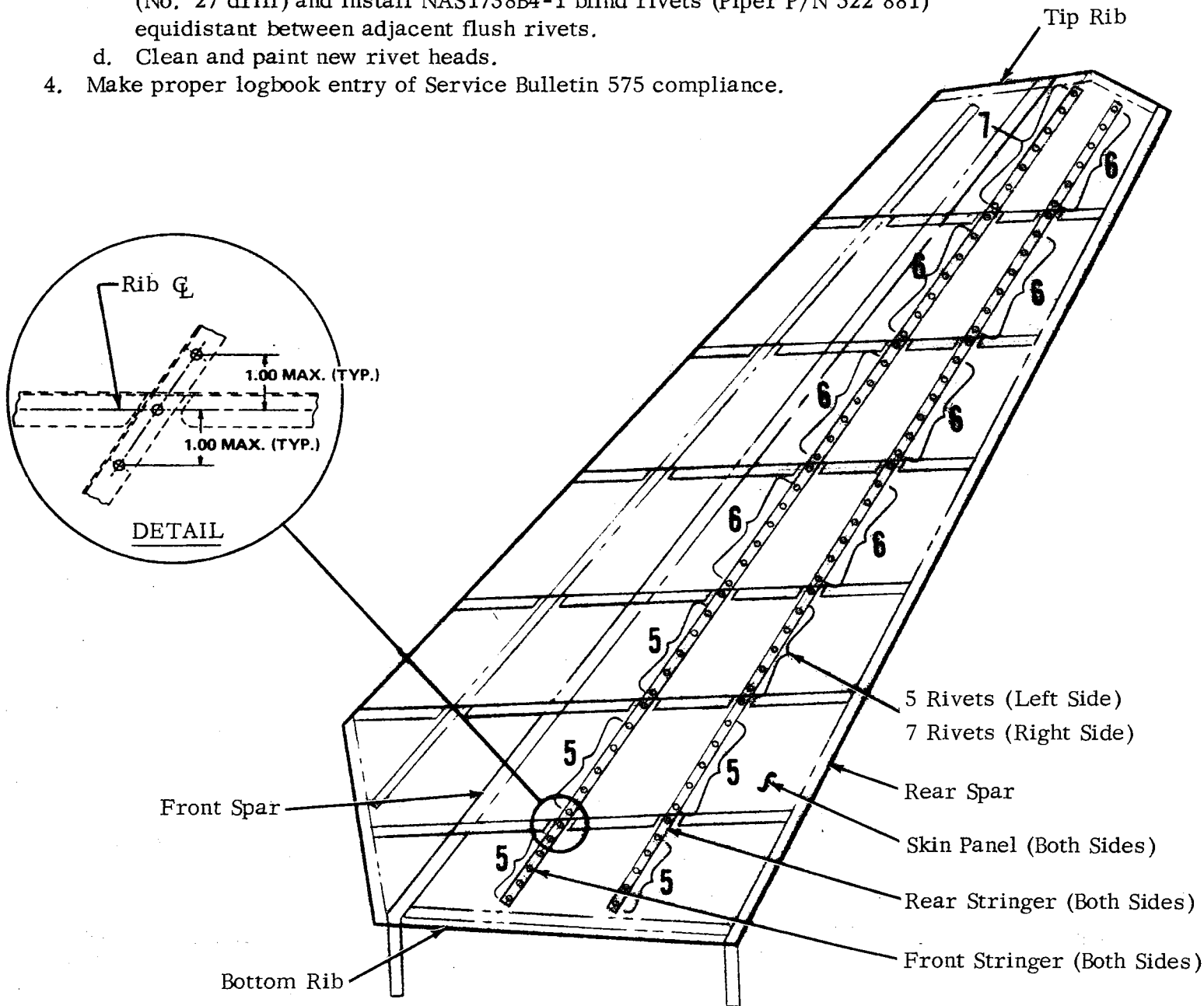
### INSTRUCTIONS

1. Count flush rivets securing top and bottom skin panels to front and rear stringers on both stabilizers.
2. If rivet quantity at each front stringer is 77 or more and quantity at each rear stringer is 79 or more, no further action - other than log book entry - is required.
3. If rivet quantity at any of the front stringers is less than 77 and quantity at any of the rear stringers is less than 79, proceed as follows:
  - a. Measure the distance between existing flush rivets to determine where rivet spacing is more than 1 1/4 inches.
  - b. In all areas where rivet spacing is more than 1 1/4 inches, add blind rivets between existing flush rivets as required. Minimum distance between any of the rivets is .42 inch.
  - c. When it has been determined where rivets are required, drill .144 in. holes (No. 27 drill) and install NAS1738B4-1 blind rivets (Piper Part No. 522 881).
  - d. Clean and paint new rivet heads.
4. Make proper logbook entry of Service Bulletin No. 575 compliance.

TOP VIEW OF LEFT STABILIZER SHOWN - RIGHT OPPOSITE

## INSTRUCTIONS

1. Count flush rivets attaching front and rear stringers to skin panels on vertical fin (both sides).
  2. If rivet quantity at front stringer is 46 or more on each side, and rivet quantity at rear stringer is 44 or more on left side and 46 or more on right side, no further action is required.
  3. If count reveals less rivets than specified above on any stringer, either side, proceed as follows:
    - a. Refer to sketch for minimum number of rivets in each bay (area between ribs).  
In any bay with less than minimum number of rivets, add a NAS1738B4-1 blind rivet between each existing rivet.
    - b. The first rivet above and below each rib should be spaced 1" maximum, measured from the rib centerline. See detail.  
In any area where this spacing exceeds 1", add a NAS1738B4-1 blind rivet between rib and first stringer rivet.
    - c. When it has been determined where rivets are required, drill .144 holes (No. 27 drill) and install NAS1738B4-1 blind rivets (Piper P/N 522 881) equidistant between adjacent flush rivets.
    - d. Clean and paint new rivet heads.
  4. Make proper logbook entry of Service Bulletin 575 compliance.
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REF: S. B. #575  
FIN

LEFT SIDE VIEW OF VERTICAL FIN SHOWN - RIGHT OPPOSITE