



SERVICE BULLETIN

SUBJECT: Norco, Inc. A2972-1 and -2 Strut Assembly Rework to A2972-11 and -21

1. PLANNING INFORMATION

A. Effectivity

First unit and on, not mandatory, accomplish at user option.

B. Reason

Allow A2972-1 and -2 Strut Assemblies to be reworked to A2972-11 and -21 tip configuration.

C. Description

This service bulletin provides detailed instructions for reworking Norco Strut Assemblies A2972-1 and -2 to A2972-11 and -21.

D. Manpower

Required to remove Strut Assembly from Aircraft	.5 hrs.
Disassemble, rework tip, and reassemble	1.0 hrs.
Replace Strut Assembly in aircraft	<u>.5 hrs.</u>
TOTAL	2.0 hrs.

E. Material Cost and Availability

The parts required to accomplish this service bulletin are available from the manufacturer as rework kit part number RW2972-12. The rework kit contains a tip, part number AM2972-11-12, and rivet, part number MS20613-4C16.

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The rework can also be accomplished by remachining the tip in Strut Assemblies A2972-1 and -2 to the configuration required for Strut Assemblies A2972-11 and -21. This procedure requires a tip in satisfactory condition and a new rivet, part number MS20613-4C16.

Operators should submit a purchase order for the rework kits or rivets required. The purchase order should specify this service bulletin number. Delivery schedule will be furnished upon receipt of request.

Direct purchase order to: MarathonNorco Aerospace, Inc.
8301 Imperial Dr.
Waco, Texas 76712
254-776-0650 Main Line
254-776-6558 Fax

F. Weight

Incorporation of this service bulletin will not significantly change the weight of Strut Assemblies A2972-1 or -2.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Install new Tip

- 1) Remove old tip by drilling out rivet in end of lock rod using a 0.125 inch diameter drill. Drill rivet on side with undeformed head.
- 2) New tip, part number AM2972-11-12, will have only one rivet hole. Insert the new tip into hole in the lock rod and align the hole in the tip with a hole in the lock rod. Drill the second hole in the tip using the hole in the lock rod as a pilot. Use a No. 30 drill (0.1285 diameter).
- 3) Insert a new rivet, part number MS20613-4C16 and spin or set head. Check that rivet head is properly formed without cracks.

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B. Rework Existing Tip

- 1) Remove tip by drilling out rivet in end of lock rod using a 0.125 inch diameter drill. Drill rivet on side with undeformed head.
- 2) Remachine tip end to new configuration shown in figure 1.
- 3) Repassivate per QQ-P-35
- 4) Insert tip into hole in lock rod and align rivet holes.
- 5) Insert a new rivet, part number MS20613-4C16, and spin or set head. Check that rivet head is properly formed without cracks.

C. Reidentify

After incorporation of this service bulletin, a number 1 (one) should be added after the last digit of the part number.

D. Material Information

A rework kit is available under part number RW2972-12 which contains all parts required to accomplish this service bulletin.

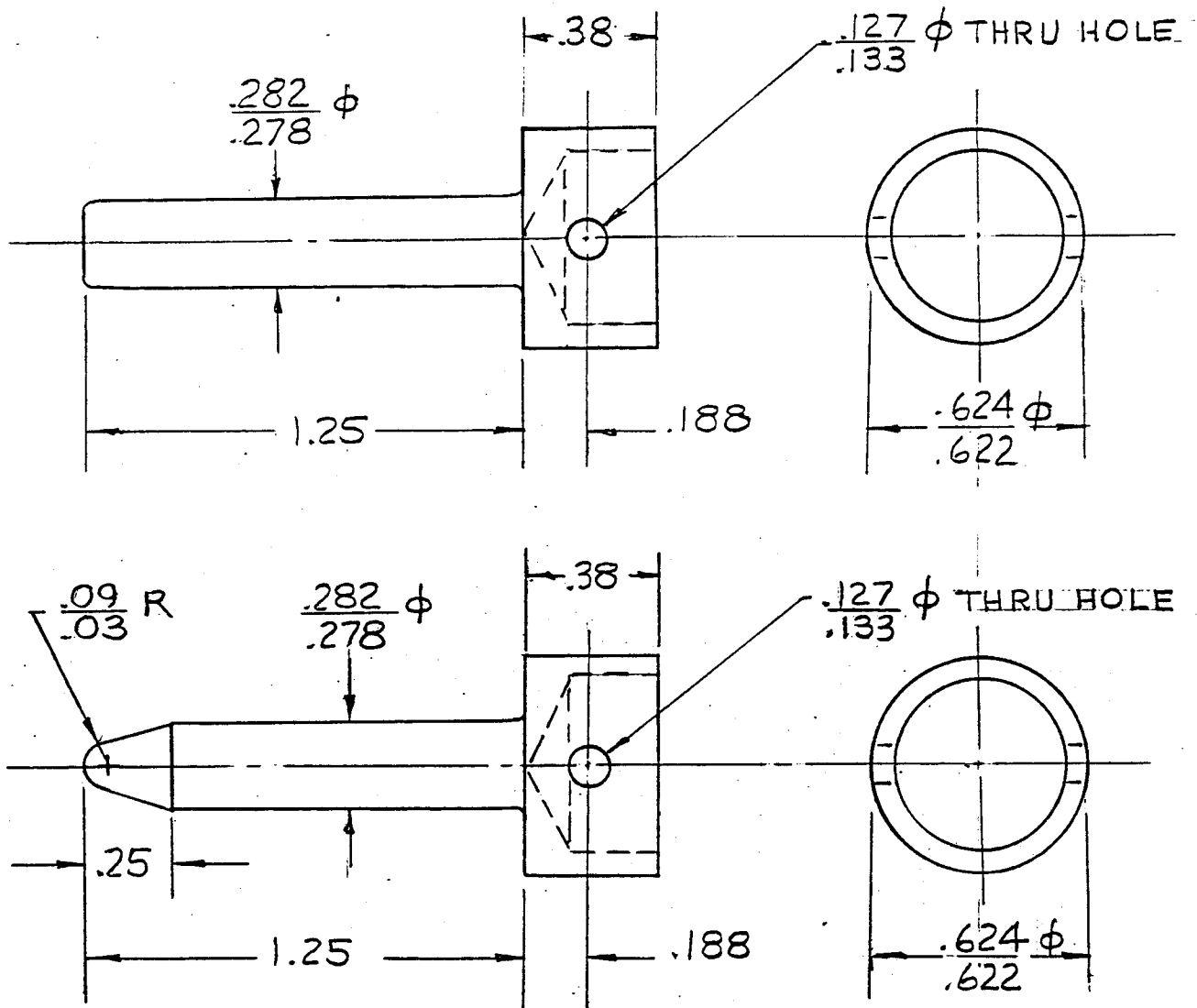
<u>Item #</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
1	AM2972-11-12	1	Tip
2	MS20613-4C16	1	Rivet

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A2972-1 and -2 Tip



A2972-11 and -21 Tip

FIGURE 1 TIP DIMENSIONS

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