



**moravan · otrokovice · čssr**



**SERVICE BULLETIN Z 326/69  
Z 526/37**  
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1. Concerns : All aircraft Z 326, Z 326 A, Z 526, Z 526 A, Z 526 F, Z 526 L, Z 526 AFS, Z 526 AF.
2. Reason : Removal of abnormal clearance in the upper butt hinge of the wing.
3. Measure : In the event the abnormal clearance in spherical seating of the upper hinge of wing is ascertained, replacement of an upper wing attachment fitting should be performed. Till prod. No. 1148 incl., replace upper attachment fitting by attachment fitting of draw. No. AS 526.211-01.P1 (for bolts of wing of dia. 18).  
From prod. No. 1149 replace upper attachment fitting by attachment fitting of draw. No. L 526.211-01.P1 (for bolts of wing of dia. 20).  
The bulletin must be incorporated in the Overhaul Manual.
4. Measure to be performed by : User.
5. Expenses to be borne by : User.
6. Necessary material to be supplied by :  
Manufacturer according to user's order.
7. Working process : Stated on next page of this bulletin.
8. THE BULLETIN COMES INTO FORCE ON DAY OF DELIVERY TO THE USER!  
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ing. Machálka

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Manufacturer's Representative

mjr. Pařil

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Customer's Representative

28.6.1973

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Date

ing. Háva

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OMNIPOL

ing. Kyzlink

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State Aviation Inspection

## 7. Working proces :

Lay removed wing without fuel tank on prepared stands - see fig.1. To facilitate the access to heads of fitted bolts (ind.No. 2,3) we recommend to disconnect the pull rod of ailerons from the transmission lever and to insert it in the wing in order not to hinder from work. Remove 2 nuts M 5 (ind. No.7), 2 shims (ind.No.5) and 12 nuts M 6 (ind. No.8), 2 shims (ind. No.4) by aid of eye spanner and fork spanner. Mark shims (ind.No. 4,5) so that you can put them on original place when installing new attachment fitting. Knock out 2 fitted bolts of dia. 5 (ind. No. 2), 12 fitted bolts of dia. 6 (ind. No. 3) and remove attachment fitting (ind. No. 1) from the wing. Mark again further 2 shims (ind. No. 5), 2 shims (ind. No. 4) and 2 plates (ind. No. 6). Drill off rivets on 2 anchor nuts (ind. No. 9) using a drill of dia. 2.7 mm and remove them from the wing. In prolongation of axis of holes for fitted bolts, drill 6 holes of dia. 8 into a stiffener on the wing - see fig. 2. In a new attachment fitting (ind. No. 1), reream a marginal hole of lower row from dia. 4.8 mm to dia. 5 H 8 for a new fitted bolt (ind. No. 2). Slide on this new attachment fitting on the spar web and set plates (ind. No. 6) and shims (ind. No. 4,5) on original places in accordance with markings. Install new fitted bolt of dia. 5 (ind. No. 2), new M 5 nut (ind. No. 7) and tighten after installation of the fitting. Ream last hole in the upper row to dia. 6.1 H 8, install new fitted bolt of dia. 6.1 (ind.No. 11) new M 6 nut (ind. No. 8) and tighten them. Ream remaining holes to dia. 6.1 H 8, one hole to dia. 5.1 H 8 - see fig. 2. When reaming lower row, utilize drilled holes of dia. 8 in the stiffener on the wing. Install new fitted bolts of dia. 6.1 (ind. No. 11), new nuts M 6 (ind. No. 8), and fitted bolt of dia. 5.1 (ind. No. 10) with a new nut M 5 (ind. No. 7). After tightening, secure nut by means of three centre-punches. Rivet again nuts (ind. No. 9) with the use of rivets 3549 A - 2.6 - 8. Do not forget to connect the pull rod of ailerons to the transmission lever. In case of the second replacement of the attachment fitting, proceed in the same way. Apply, however, fitted bolts of dia. 6.2 draw.No. 990-375-04 and dia. 5.2 draw. No. 990-375-03. Ream then holes to dia. 6.2 H 8 and dia. 5.2 H 8.

## Necessary material

Ind. No.		Assy units
1	Attachment fitting upper for bolts of wing of dia.18 AS 526.211-01.P1	1
	Attachment fitting upper for bolts of wing of dia.20 L 526.211-01.P1	1
2	Fitted bolt of dia. 5 Z 326.211-01.42	1
11	Fitted bolt of dia. 6.1 990-375-02	12
10	Fitted bolt of dia. 5.1 990-375-01	1
7	Nut M 5 ČSN 021401.44	2
8	Nut M 6 ČSN 021402.44	12
12	Countersunk-head rivet 3549A-2.6-8	4



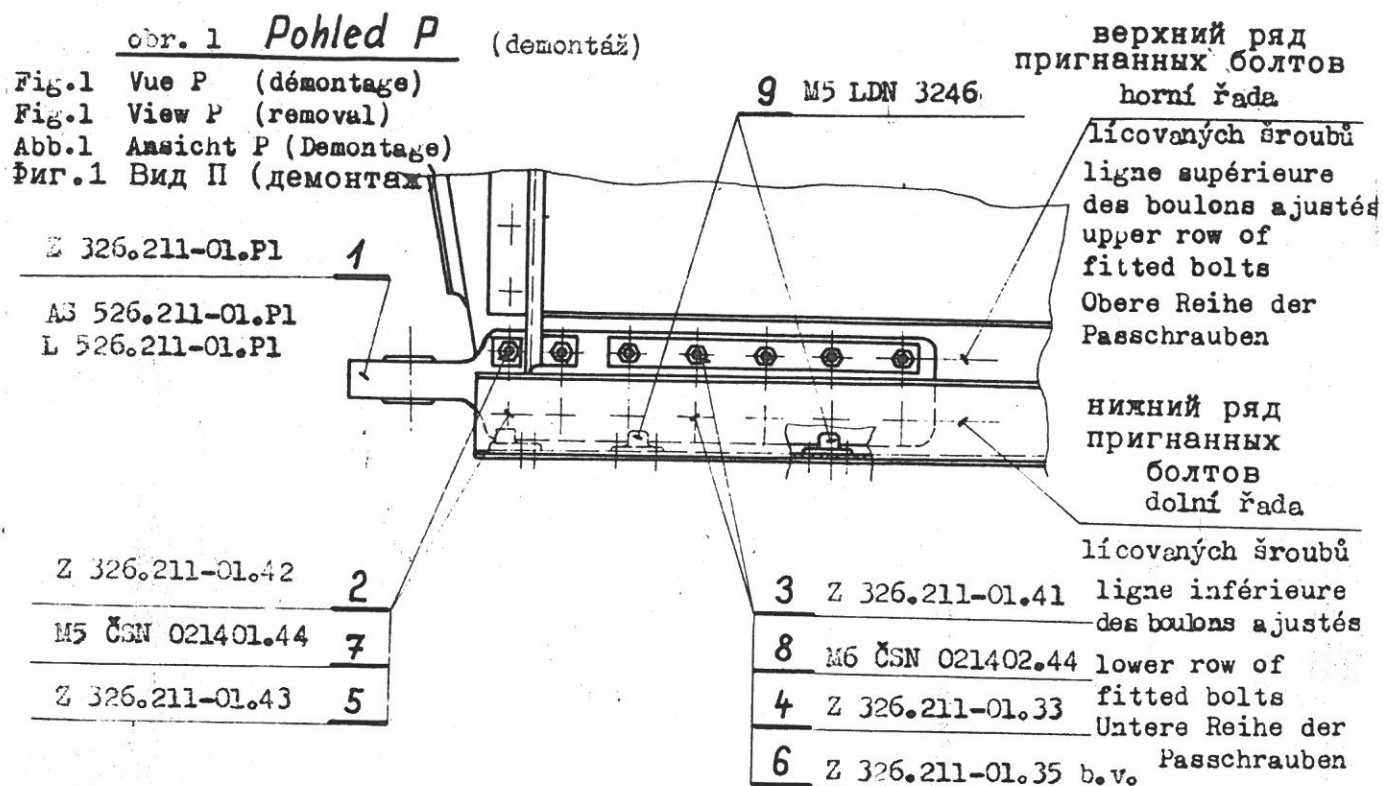
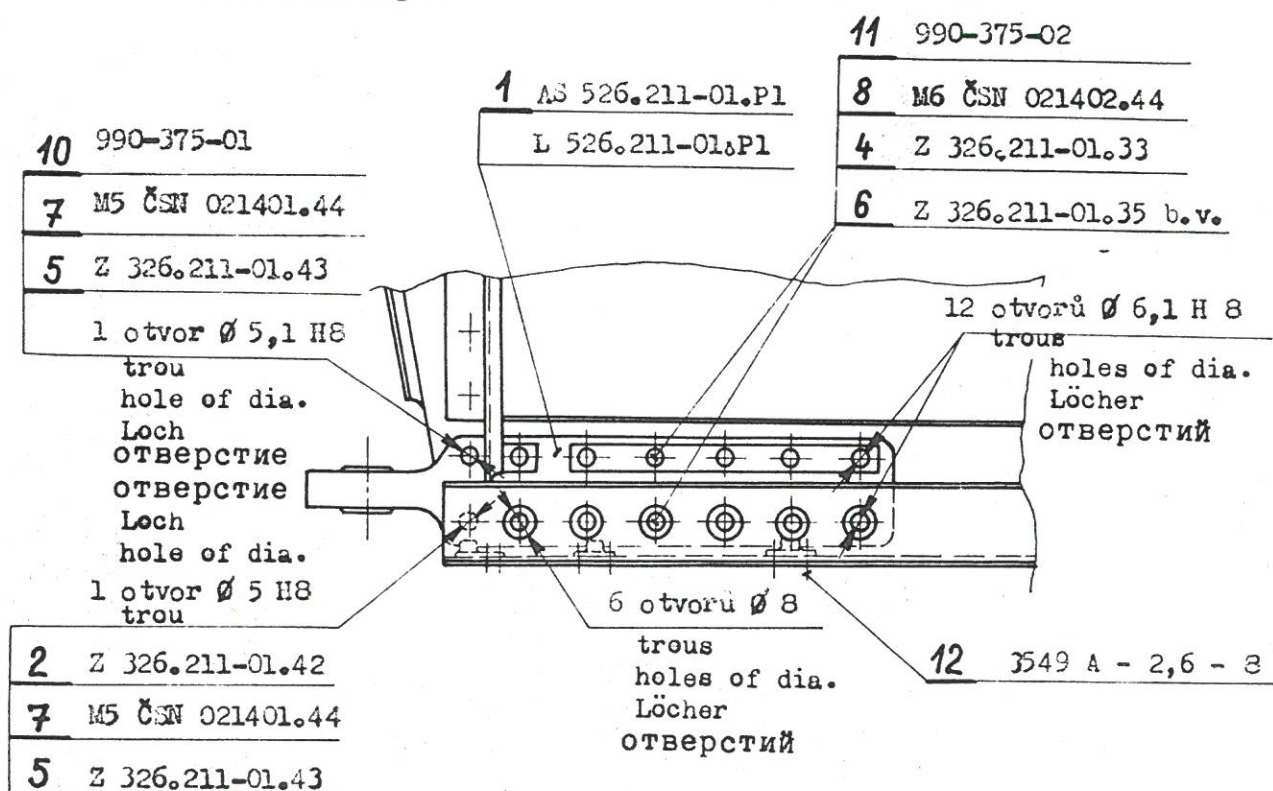


Fig.2 (Montage) - Obr. 2 (montáž) - Fig.2 (Installation)  
Abb.2 (Montage) Фиг.2 (монтаж)



Necessary material in case of the second replacement of the attachment fitting.

Ind. No.			Assy units
1	Attachment fitting upper for bolts of wing of dia. 18	AS 526.211-01.P1	1
	Attachment fitting upper for bolts of wing of dia. 20	L 526.211-01.P1	1
2	Fitted bolt of dia. 5	Z 326.211-01.42	1
10	Fitted bolt of dia. 5.2	990-375-03	1
11	Fitted bolt of dia. 6.2	990-375-04	12
7	Nut	M 5 ČSN 021401.44	2
8	Nut	M 6 ČSN 021402.44	12
12	Countersunk-head rivet	3549A - 2.6 - 8	4

Note :

The attachment fitting upper - draw. No. AS 526.211-01.P1 - is delivered with predrilled holes of dia. 5.8; dia. 4.8 for rereaming for fitted bolts and with a hole of dia. 18 H 8 for the bolt of wing.

The attachment fitting upper - draw. No. L 526.211-01.P1 is delivered with predrilled holes of dia. 5.8; dia. 4.8 for rereaming for fitted bolts and with a hole of dia. 20 H 7 for the bolt of wing.

175/73/M

Фиг. 1  
obr. 1

Abb. 1  
Fig. 1  
Fig. 1

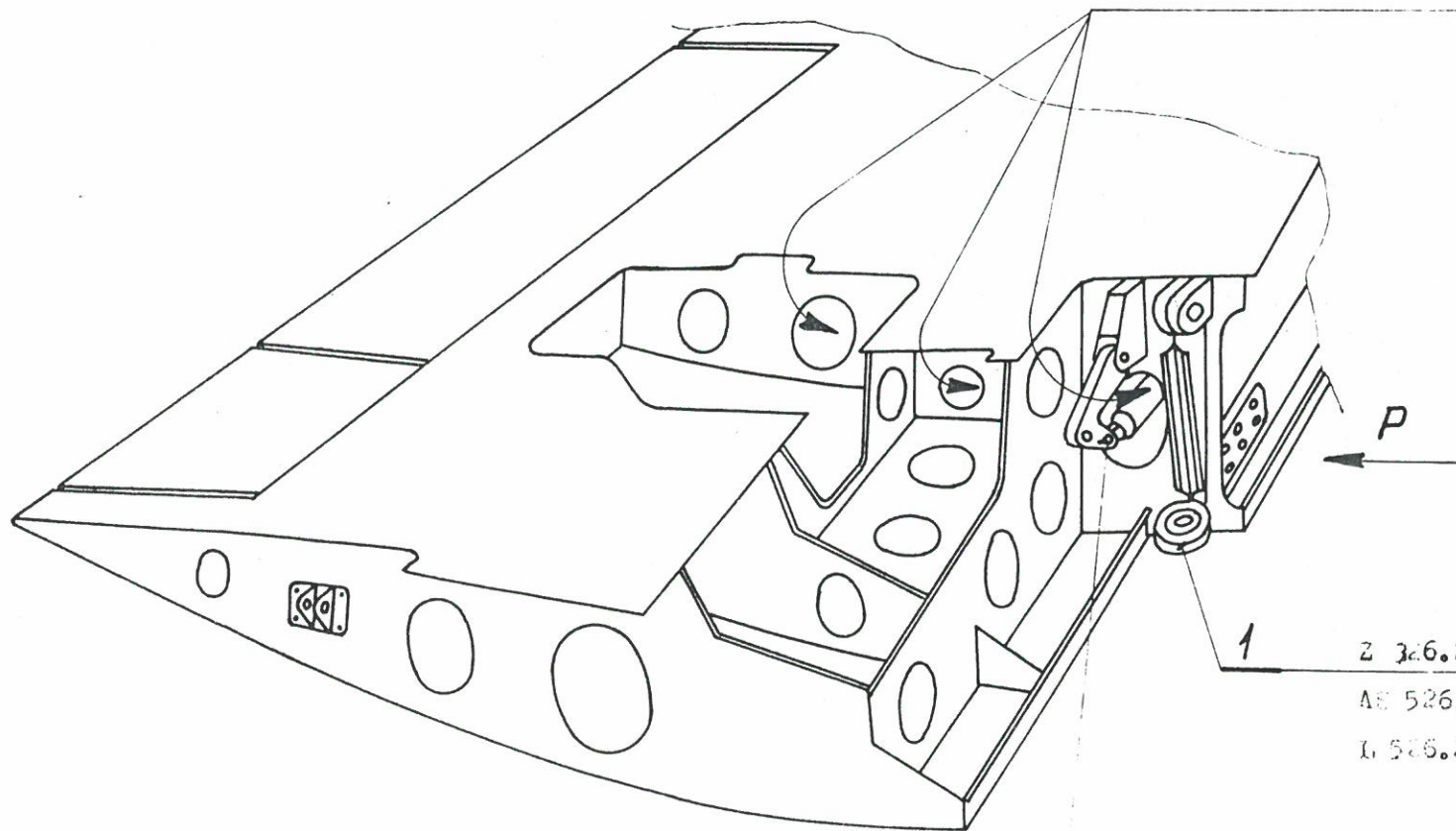
отверстия для доступа к головкам пригнанных болтов

Löcher für Zutritt zu den Passschraubenköpfen

Holes for access to heads of fitted bolts

Trous pour l'accès aux têtes des boulons ajustés

otvory pro přístup k hlavám lisovaných šroubů



первоначальный Ø 18

Original Ø 18

original dia.18

Ø original 18

Z 326.211-01.P1 } původní Ø 18

AE 526.211-01.P1 }

L 526.211-01.P1 } původní Ø 20

Ø original 20

original dia.20

Original Ø 20

первоначальный Ø 20

odjít tělo křídla od převodné páky

Désassembler la tringle des ailerons du levier de transmission

Disconnect pull rod of aileron from transmission lever

Zugstange der Querruder vom Übertragungshebel abmontieren

Отсоединить тягу элеронов от переводного рычага