

GLASTAR SERVICE BULLETIN 5

MANDATORY

Subject: AN470A4-7 soft rivets

Applicability: GlaStar tail and wing kits shipped prior to 10/1/95 with the following kit serial numbers: Tail kits #5002—5116, excluding 5004; Wing kits #5002, 5003, 5005—5008, 5011, 5012, 5014—5019, 5021, 5022, 5024, 5025—5032, 5034—5041, 5043—5045, 5048, 5049, 5051, 5052, 5054, 5055, 5059—5061, 5063, 5064, 5066, 5068, 5069, 5071, 5072, 5075—5077, 5080—5082, 5084, 5085, 5087—5090 and 5104

Discussion: It has come to our attention that the supply of AN470AD4-7 universal-head rivets shipped with several GlaStar tail and wing kits was contaminated with some AN470A4-7 rivets. These "A"-series rivets, which were inadvertently mixed in with the "AD"-series rivets by our vendor, are made of a much softer aluminum alloy than the "AD"-series specified for the GlaStar and therefore have insufficient strength. **They should not be used anywhere in GlaStar construction.**

Required Action: First, inspect your supply of AN470AD4-7 rivets and **remove** all the soft, "A"-series rivets. They can be distinguished from the "AD"-series rivets by the heads. As shown in Figure 1, the standard, "AD"-series rivets have a small dimple in the center of the head, while the soft, "A"-series rivets have plain heads.

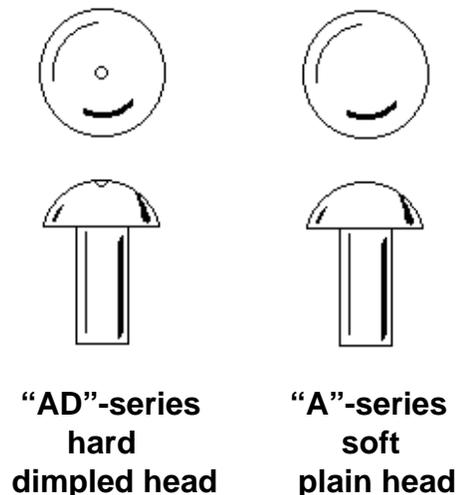
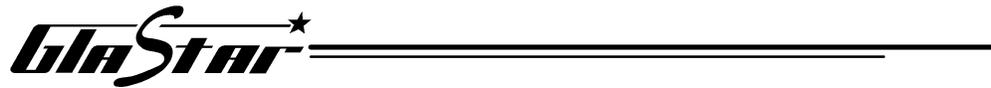


Figure 1

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Second, inspect the GlaStar assemblies specified in Table 1 (if you have completed them) to see if any soft, "A"-series rivets were used. If you discover any soft rivets, you must **drill them out and replace them** with proper AN470AD4-7 rivets. If necessary, refer to "SECTION II: TOOLS AND TECHNIQUES" in the *GlaStar Assembly Manual* to refresh your memory on the proper procedure for replacing defective rivets.



Note Table 1 gives several locations where AN470AD4-6 rivets were specified. Check these locations as well just in case you substituted -7 rivets for any reason.

LOCATION	GLASTAR ASSEMBLY MANUAL REFERENCE	SPECIFIED RIVET LENGTH
Horizontal stabilizer aft attach bracket	Section IV, Step 20	-7
Horizontal stabilizer forward spar web doublers	Section IV, Step 22	-7
Manual trim cable bracket assembly	Section V, Step 47	-6
Elevator control horns and attach angles	Section V, Step 50	-6
Trim tab counterweight arm and control horn	Section V, Step 67	-6
Center of elevator forward spar where overlapped skins are riveted through upper spar flange, doubler and hinge	Section V, Step 90	-6
Outboard aileron hinge assemblies	Section VI, Step 45	-7
Inboard aileron hinge assemblies	Section VI, Step 45	-7
Aileron bellcrank assemblies	Section VI, Step 46	-7

Table 1

If you run short of AN470AD4-7 rivets as a result of culling soft, "A"-series rivets from your stock, please contact Stoddard-Hamilton for replacements. However, we customarily send about ten percent more rivets of each size than specified, so you may find you have enough extra already on hand.