

HOFFMANN AIRCRAFT Ges.m.b.H.
Richard-Neutra-Gasse 5
1210 W i e n

S E R V I C E B U L L E T I N N o . 2 4
=====

Affected: Dimona H-36 all serial-numbers up to serial
no. 36 268.

Subject: Main bolt

Occasion: Measurement differences in the main bolt
aerea found out during routine inspections.

Actions: In accordance with enclosed Work Instruction
no. 9.

Compliance: Before the next flight.

Weight and balance: Not affected.

Remarks: All action must be performed by an certified
maintenance engineer and must be entered into
the log book.

Vienna, May 4th 1988

approved by Austrian Civil
Aviation Authorities


Dipl.Ing.L. Osvaldik

17. Mai 1988





Approval of translation has been done by best knowledge
and judgement -- in any case the original text
in German language is authoritative

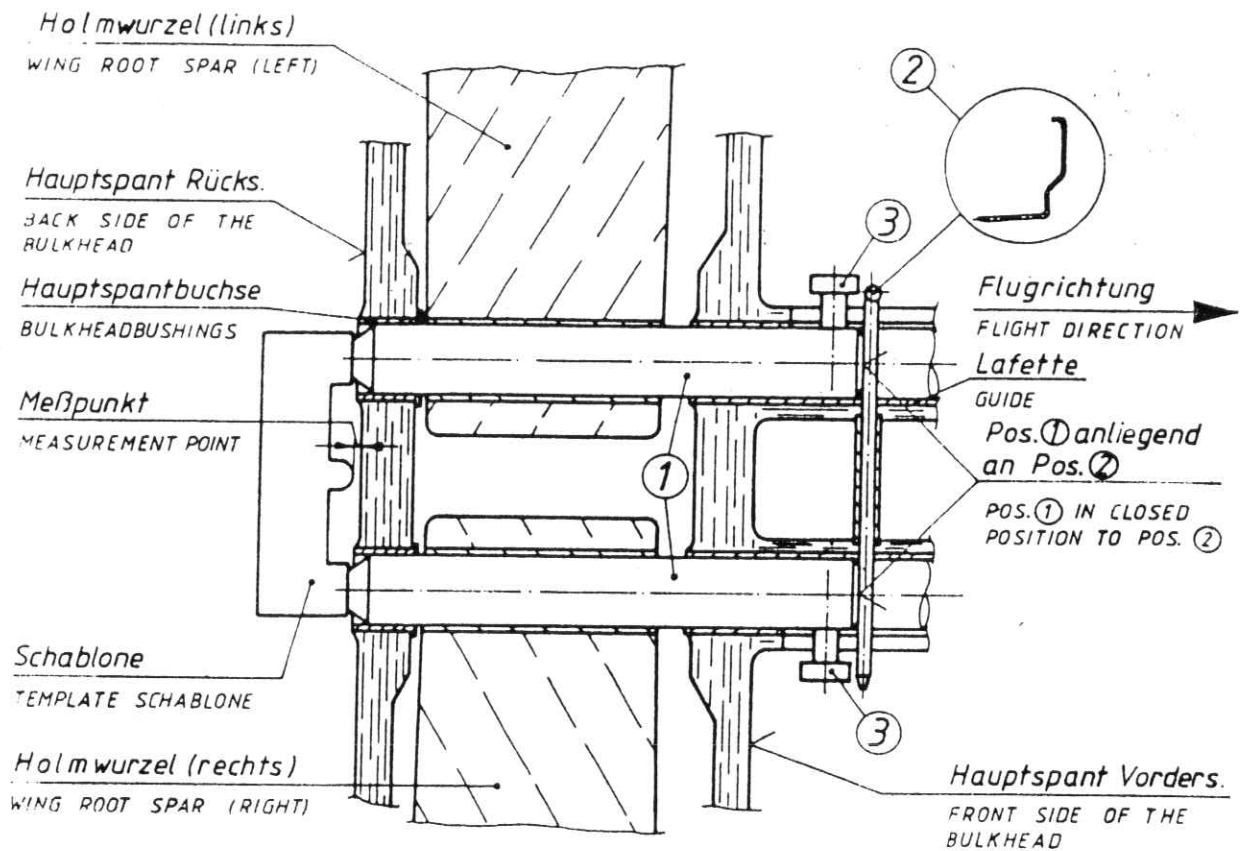
W O R K I N S T R U C T I O N N o . 9
=====

Measurement procedure:

1. Push the main bolt in flight direction up to the wing safety pin using wing assembling lever.
2. Measure the distances between the main bolt heads and the back side of main bulkhead using the enclosed template and torch light in accordance with sketch 1:
3. If the measurement point of template doesn't touch the main bulkhead:
no further actions necessary.
4. In case measurement point of template touches the main bulkhead
(excluded bad surface furnishings) performe the following actions using the main bolts which will be delivered by the manufacturer:
 - 4.1 Wing dissassembling in accordance with airplane flight manual
 - 4.2 Remove the fuel tank
 - 4.3 Remove the main bolt hexagon socket screws (pos. 3) secured by Loctite cement.
 - 4.4 Remove both main bolts against the flight direction. If necessary remove slightly the spoiler rod before.
 - 4.5 Compare the diamaters of new with the old main bolts. Tolerance: $\begin{matrix} + 0,0 \text{ mm} \\ - 0,04 \text{ mm} \end{matrix}$
 - 4.6 Check the conglutination of the main bulkhead bushings.
 - 4.7 Clean the main bolts, bulkhead bushings, guides of the main bolts and hexagon sockets with trichlore.
 - 4.8 Installe the main bolts into the previous propositon.
 - 4.9 Installe the hexagon sockets into the main bolts using Loctite 648 cement for security (using standard tork 16 Nm).

- 4.10 Grease the main bolts and the main bulkhead bushings.
- 4.11 Check smooth movement of main bolts.
- 4.12 Push the main bolt against the flight direction until the stop point. Check the distance between the main bolts and the bulkhead bushings in the wing spar tunnel by visual check from the other side.
- 4.13 If some construction details obstruct above actions - contact the manufacturers.

Skizze 1
SKETCH



Pos. ① Hauptbolzen
MAIN BOLT

Pos. ② Sicherungsstift
SAFETY PIN

Pos. ③ Innensechskantschraube M8
HEXAGON SOCKET (SCREW)

