



SERVICE LETTER

Service Letter Number	Simplex Model	Description of Revision	Revision	Revision Date
SI2012-005 rev.B	508	Revised quantity of fasteners given the substitution allowances. Combined figures 2 and 3	B	September 10th, 2012

Prepared by:

David Cornelius
Engineering

Approved by:

Bonnie Mcvicker
Quality Assurance manager

Approved By:

Stan Franz
Director of Engineering

Joe Rodriguez
Production Manager

Subject: Replacement of fasteners in Turret Assembly.

Applicability: This service letter is applicable to Simplex Manufacturing Model 508 P/N 508-302102-501

Purpose: Operators have reported instances of fastener movement and loosening in portions of the Turret box. This service letter provides the instructions for replacement of fasteners in the Model 508 Turret.

Compliance: Required. This change has been deemed minor per the Simplex/FAA SACO STC Minor Change agreement.

Weight and Balance: No effect

Electrical Loads: No effect

Special Tooling: CherryMax rivet gun

Item #	Part Number	SMC#	Description	Quantity
1	508-302102-501	508-302102-501	Turret, Transition Assembly	rework
2	HL18-5-5	000-114801-000	HL18 5/32" pin 5/16" grip	25
3	HL18-5-3	000-114802-000	HL18 5/32" pin 3/16" grip	15
4	HL70-5	000-114801-001	HL 5/32" collar	40
5	CR3213-5-04	000-114788-000	CherryMax Rivet, Univ Head, 5/32 Diam	10
6	CR3213-5-06	000-114788-006	CherryMax Rivet, Univ Head, 5/32 Diam	10

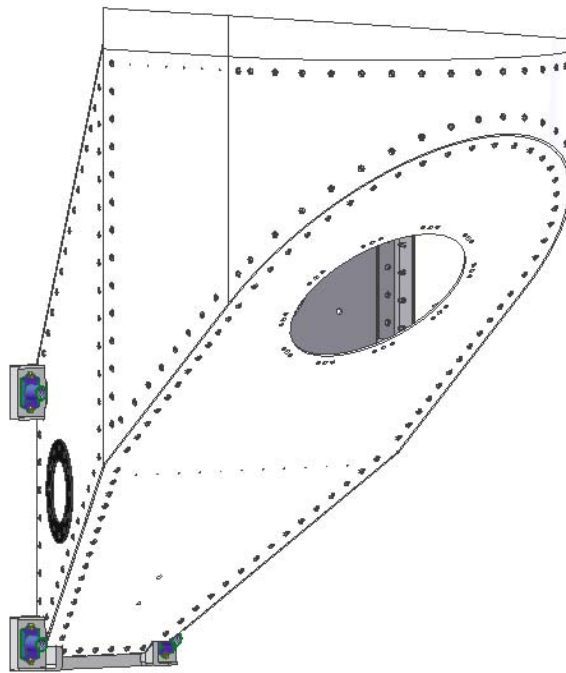
Rev B: Extra quantity listed due to assembly variation and possible substitution of fasteners.

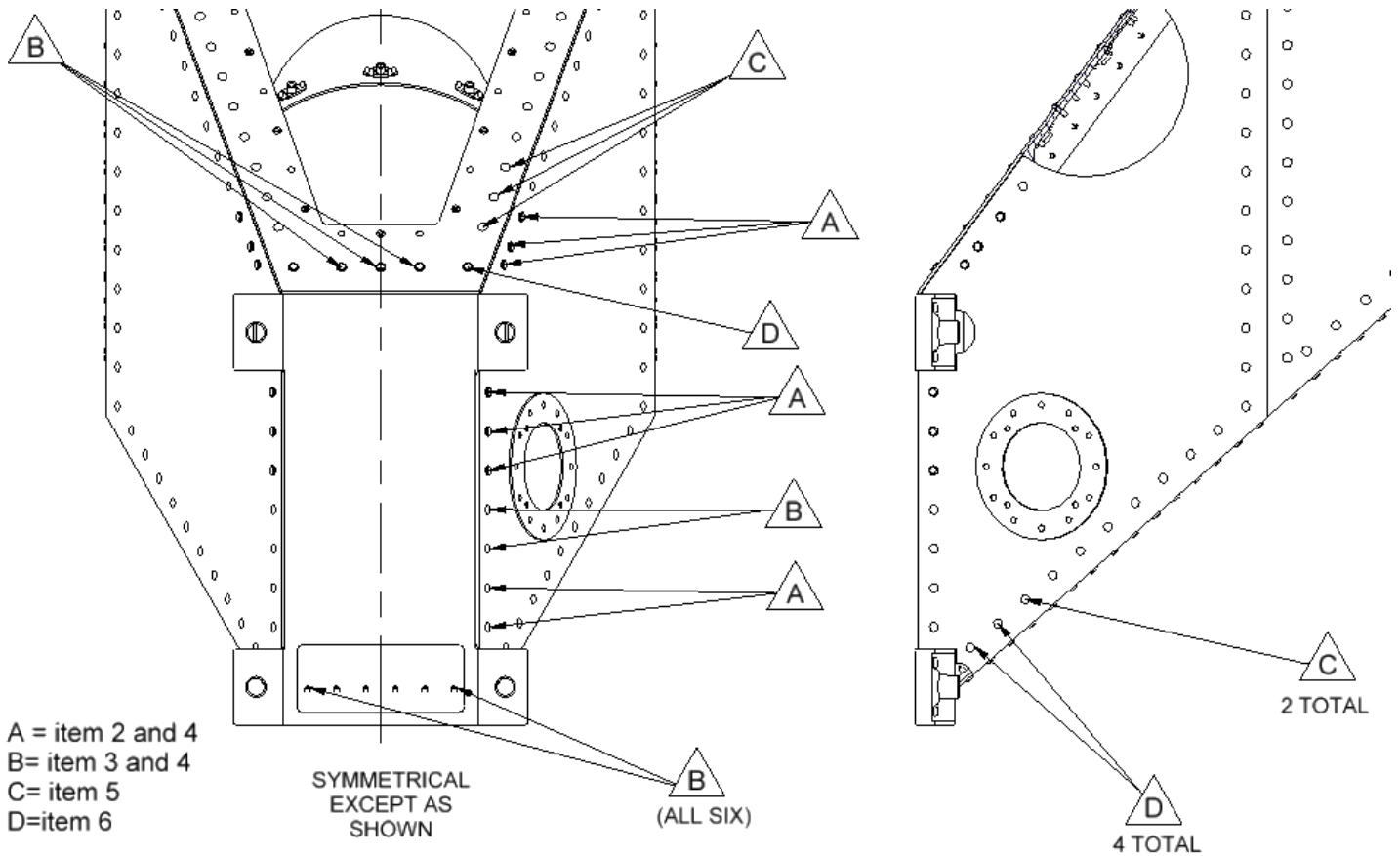
Consumables: Brush Alodine, Primer



Procedure:

1. Permissible to remove Turret from Box beam Assembly to facilitate fastener replacement.
2. Drill out and discard fasteners shown in fig. 2. Note edge margins prior to removing fasteners shown in fig. 2.
3. Using existing locations, install fasteners IAW fig. 2. HL18-5-x locations require #20 diam drill. CR3213-5-x rivets require #21 drill bit. Deburr holes and brush Alodine and chromate primer affected metal.
4. Touch up fastener heads to match surrounding structure.
5. Re-Assembly turret onto main box beam

**Figure 1 Turret Assembly**



REMOVE AND REPLACE FASTENERS AS SHOWN.
ACCEPTABLE TO USE ITEM 5 OR 6 WHERE EDGE
MARGIN OF 1.5D IS UNATTAINABLE FOR ITEM 2 OR 3 HI-LOCK

Figure 2 Fastener replacement