

REPAIR AND OVERHAUL INSTRUCTIONS

**NACELLE BULKHEAD ATTACHMENT BRACKET
REPAIR SCHEME**

INTRODUCTION

1 The attachment brackets securing the bulkhead at Sta. 104 to the main spar frame have been found with the weld fractured. A repair scheme, applicable to both the port and starboard nacelles, has been devised to enable local repairs to be carried out.

INSTRUCTIONS

2 The following information is applicable to the repair of one broken bracket but is typical for any one of the three locations:

- (a) Remove the portion of the original bracket attached to the bulkhead.
- (b) Fabricate the required bracket in conjunction with the aircraft structure at the required location.
- (c) If a filler block is required as shown in Figure 3, fabricate to correct thickness to fit the aircraft.
- (d) Position and install the brackets, and spacers, if required, as shown in Figures 1, 2 or 3, as applicable.

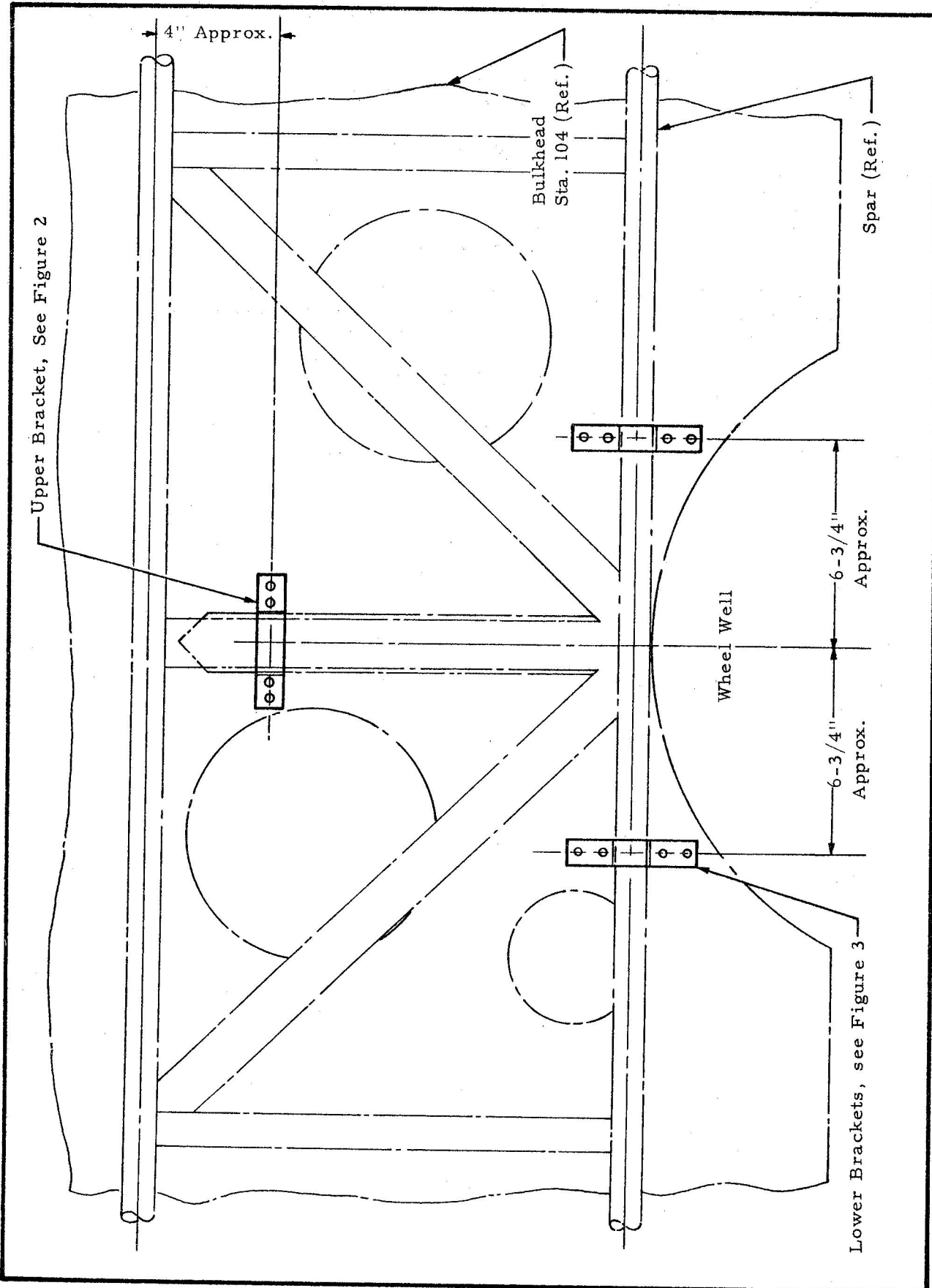


Figure 1 View Looking Aft in Nacelle

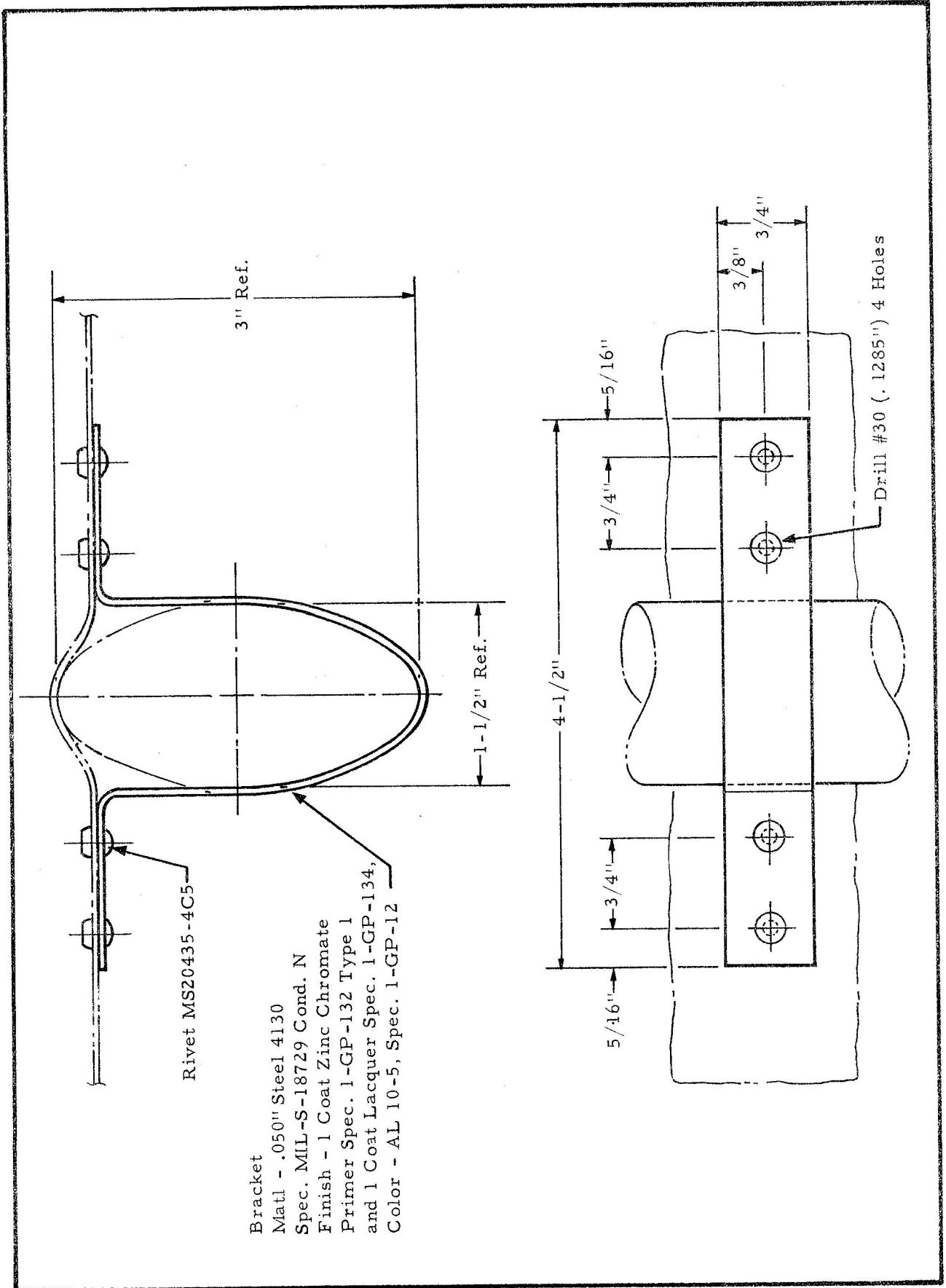


Figure 2 Upper Bracket

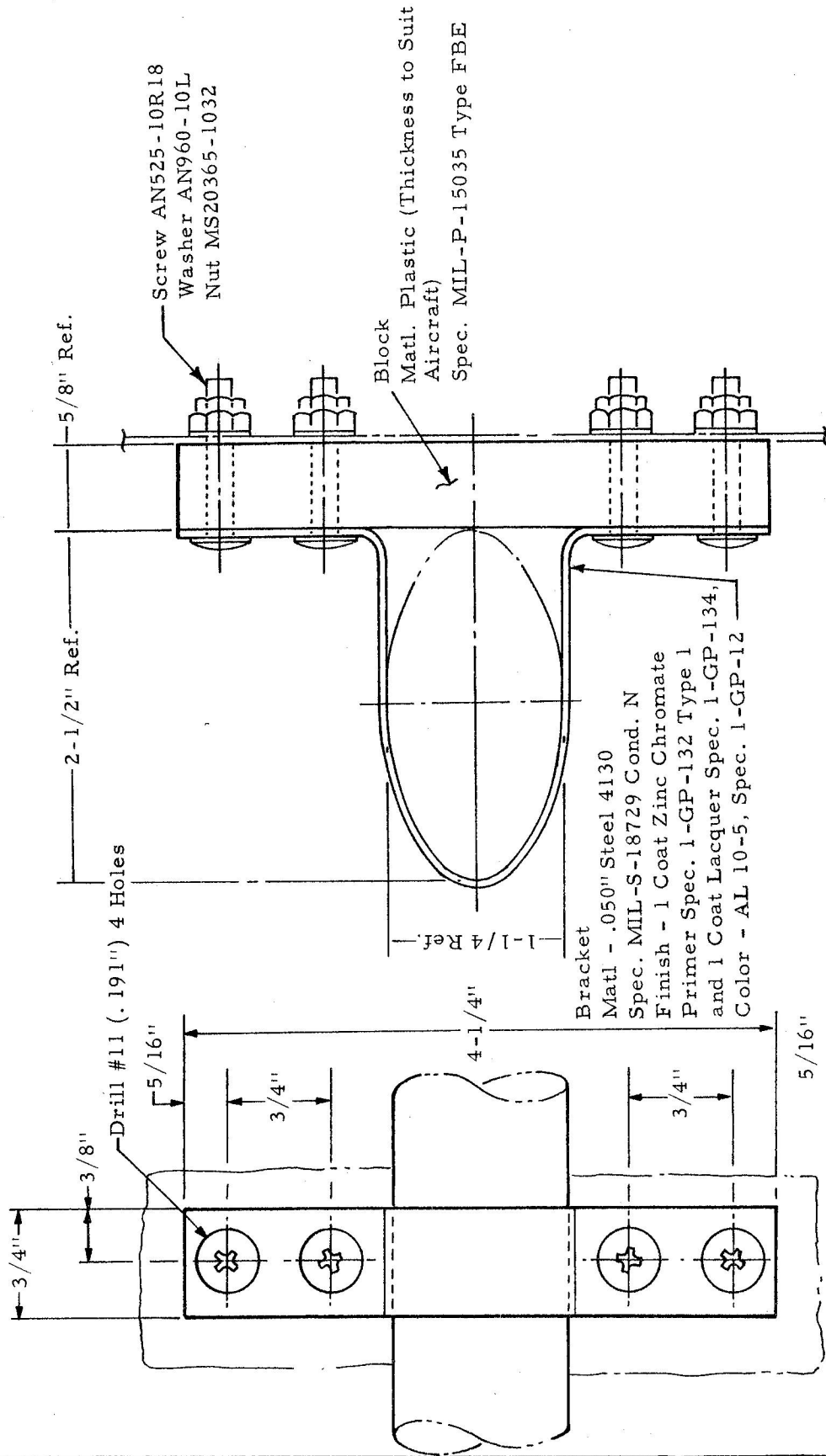


Figure 3 Lower Brackets