Working instruction for TN301/26

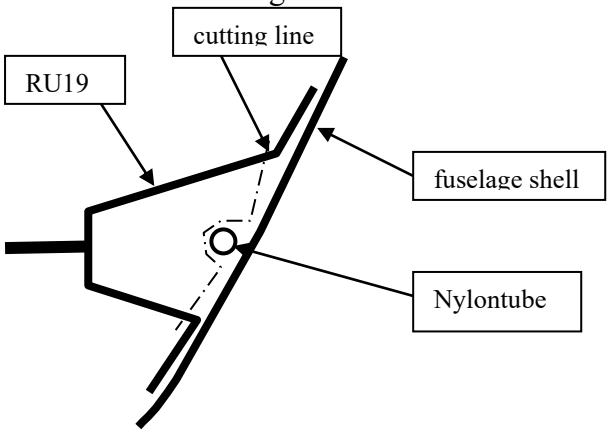
Part A: Inspection of the elevator control bearing stand RU19

1. Remove the left baggage compartment floor.
2. Remove nut and washer which fix the elevator control bellcrank St9/1 (see Service manual diagram 8). Move bellcrank and the 2 washers between bellcrank and bearing stand min. 20 mm (0.8 in.) away from the stand.
3. Check the face of the bearing stand for cracks or white areas. Use a powerful torch.
4. If any damage was detected the bearing stand must be replaced prior to next take-off see Part B.
5. Otherwise the DG-100 may be operated up to the due date of instruction 3 of TN301/26 (=Part B).
6. Reinstall the bellcrank, use a new self locking nut M6DIN985-8 zn.
7. Reinstall the left baggage compartment floor.

Material: 1 self locking nut M6DIN985-8 zn

Part B: Exchange of the elevator control bearing stand RU19

1. Remove the left baggage compartment floor.
2. Remove the elevator control bellcrank St9/1 (see Service manual diagram 8.
3. Cut away the bearing stand with a diamond coated flex-disc. Don't cut into the fuselage shell!
   DG-100 with all flying tailplane: If the Nylon tube and the cable for the trim control go through the stand be careful not to damage them.
4. Abrade the brink of the bearing stand until the fibreglass of the brink is completely removed and the Nylon tube is free, use a high speed grinder.



5. Sand the gluing surface of the new bearing stand and glue the stand to the same place. First apply resin/hardener to the gluing surfaces. Then mix resin/hardener with cotton flocks and apply to the stand. Press the stand to the fuselage wall and secure against slipping out of place.
   DG-100 with all flying tailplane: If the Nylon tube went through the stand make cut outs in the new stand for the tubes. Sand the stand min. 30 mm (1.2 in.) around the cut outs. Place the tube in the cut outs when gluing the stand to the fuselage shell. Lay glasfibre fabric 3x92125 above these areas after postionong the stand.
6. Let the resin cure min. 12 hours at 20°C, then post-cure for 18 hours at min. 54°C.
7. Reinstall the bellcrank, use a new self locking nut M6DIN985-8 zn.
8. Check the elevator displacements and readjust the elevator control if necessary according to Service manual pages 22 and 23.
9. Reinstall the left baggage compartment floor.

Material:

self locking nuts M6 DIN985-8 zn	Epoxy resin L285 with hardener L285 or 286 mixing ratio 100:39 or Epoxy resin LR385 with hardener LH385 or 386 mixing ratio 100:35
bearing stand RU19	
if necessary glasfibrefabric 92125	cotton flocks

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