



Customer Services

SERVICE BULLETIN

No. 338

Piper Aircraft Corporation

Lock Haven, Pennsylvania, U.S.A.

"FAA DOA EA-1 Approved"

April 21, 1971

Subject:

Longitudinal Bulkhead Rivet Installation

Models Affected:

PA-31P Navajo

Serial Numbers Affected:

31P-12, 31P-23, 31P-24, 31P-26, 31P-27, 31P-29, 31P-31 to 31P-33 incl., 31P-35 and 31P-36.

Compliance Time:

Within the next 25 hours of operation.

Purpose:

To provide inspection data and, if required, supply material and instructions for the installation of additional rivets on the lower fuselage aft section between the left and right longitudinal bulkheads, fuselage stations 244 to 274; refer to sketch on reverse side of this bulletin for a pictorial description.

Instructions:

1. Inspect the above referenced aircraft in the area referred to on the sketch on the reverse side of this bulletin to determine the type of rivets presently installed.
2. If flush rivets are installed, additional rivets must be installed in accordance with the sketch/instruction data on the reverse side of this bulletin; refer to Material Required, below for rivet identification.
3. If brazier (round-head) rivets have been installed, no further action is required regarding this Service Bulletin.

Material Required:

1. Forty five (45) each (per aircraft) MS20470-AD4-4 Rivet, Piper part number 420 216, and
2. Three (3) each (per aircraft) CR2249-4-2 Rivet, Piper part number 522 882, or
Three (3) each (per aircraft) CR163-4-4 Rivet, Piper part number 422 897; refer to sketch/instruction data on reverse side of this bulletin for appropriate material location.

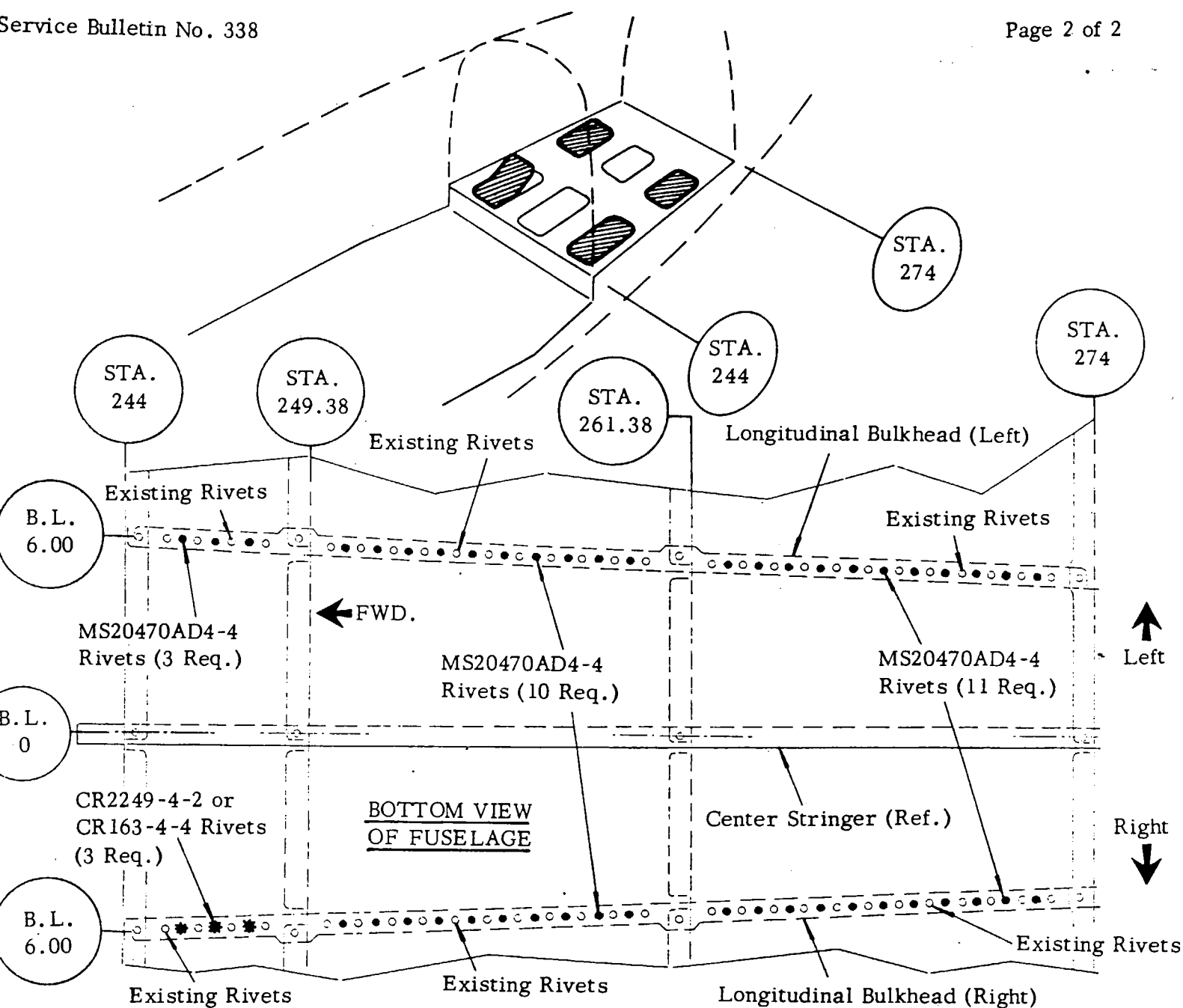
Availability of Parts:

Appropriate material is being supplied under separate cover on an automatic factory distribution, no charge basis.

Effectivity Date:

This Service Bulletin is effective April 21, 1971.

(over)



INSTRUCTIONS

1. Remove cargo net attachment plates from baggage compartment floor and lift carpet to gain access to floorboard.
2. Remove the two left outboard and right rear outboard access covers. Remove as many screws as possible from the right forward outboard access cover and carefully raise to gain access to the longitudinal bulkhead aft of Sta. 249.38.
3. Locate existing flush rivets in bottom skin at left and right longitudinal bulkheads, and draw a pencil line thru center of rivets from Sta. 244 to Sta. 274.
4. On the left longitudinal bulkhead, between Sta. 244 and Sta. 274 and on the right longitudinal bulkhead, between Sta. 249.38 and Sta. 274, mark and drill #30 holes midpoint between existing rivets as shown. On the right longitudinal bulkhead, between Sta. 244 and Sta. 249.38, mark and drill three #27 holes midpoint between existing rivets as shown. CAUTION: Use a drill stop so drill penetration is no more than 1/2 inch.
5. Install forty-five MS20470AD4-4 (P/N 420 216) in the #30 holes and three CR2249-4-2 (P/N 522 882) or CR163-4-4 (P/N 422 897) in the #27 holes as shown.
6. Reinstall access covers, carpet and cargo net attachment plates. Restore aircraft finish.

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BULLETIN SUPPLEMENT - PROCEDURAL OPERATING INFORMATION

<u>Material Allowance:</u>	Not applicable; appropriate modification material is being supplied to affected distributors on an automatic factory distribution, no charge basis.
<u>Labor Allowance:</u>	Comply with Service Publications Compliance/Credit Request procedure, indicating labor hours expended.
<u>Disposition of Parts in Stock:</u>	Not applicable.
<u>Disposition of Replaced Parts:</u>	Not applicable.

NOTE

Immediately subsequent to completion of this modification, notify the factory Customer Services Department in writing or by telex that Service Bulletin No. 338 has been fully complied with on PA-31P, Serial Number 31P-_____, Registration Number _____ on (date) _____.