

2. Trim cracked section of leading edge off flush with front edge of elevator spar flange. Drill out all rivets through spar adjacent to the area trimmed. (See Figure 1)

3. Make cut-outs on ends of new section as marked in Step 1. Slip aft edge of new skin, Part No. 145-89043, in between elevator skin and spar flange. Clamp skin in position and, using existing holes in elevator skin as a template, drill rivet holes in new section using a No. 40 drill.

4. Remove leading edge section and trim excess material off aft edge leaving sufficient rivet edge distance ($\frac{1}{4}$ " minimum). Reinstall with aft edge of section on top side of elevator skin (See Section C-C) and rivet in place with AN455-AD3-3 Rivets and DR 134A-4 Explosive rivets where necessary (See N.A.A. Bulletin No. 33). $\frac{3}{32}$ " rivets should be used throughout except in instances where holes have been enlarged beyond tolerance by drilling, in which case $\frac{1}{8}$ " diameter rivets should be used.

PART B

1. If short cracks ($\frac{5}{8}$ " maximum) starting at corners of elevator hinge cut-outs are found, it is permissible to trim out cracked material as shown by dotted line in detail A of Figure 1 providing the cracks do not extend beyond the leading edge of the spar flange.

2. If crack is over $\frac{5}{8}$ " long, and does not extend beyond the leading edge of the spar flange, it will be necessary to trim away a section of the leading edge and replace it with a piece of the formed leading edge, Part No. 145-89043, furnished with this bulletin in a manner similar to that described above and as shown in detail B of Figure 1. CAUTION: Make certain that a double thickness of material does not extend over rib flanges as clearance is at a minimum in this area.

NOTE: All riveting should be accomplished before the elevator leading edge is riveted to the leading edge ribs (Ref. F.S.B. No. 33). This is necessary so that the leading edge can be opened up to facilitate bucking the rivets to be driven through the skin and spar.