



CRUISER  
AIRCRAFT

## SERVICE BULLETIN

Czech Aircraft Group s.r.o  
Na Záhonech 212  
686 04 Kunovice  
Czech Republic  
info@cruiseraircraft.com

No.: SB-CR-081

Date: 2021-02-22

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Rev.: -

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<b>MODEL AFFECTED:</b>	PS-28 Cruiser
<b>SUBJECT:</b>	Rudder stops replacement
<b>AIRCRAFT AFFECTED:</b>	All PS-28 Cruiser aircraft.
<b>COMPLIANCE:</b>	According to the respective PS-28 Cruiser aircraft owner's decision.

### DESCRIPTION:

This Service Bulletin contains instructions for replacement of rudder stops. These stops are used to define and set the maximum deflection of rudder. This deflection is set to  $30^{\circ} \pm 2^{\circ}$  on both sides.

### AUTHORISATION TO PERFORM:

USA: Repairman (LS-M) or Mechanic (A&P)

Other: Part M or Part 145 Maintenance organization

### REASON:

Reinforced rudder stops (P/N: SF0262L and SF0262P) have been developed by the aircraft manufacturer with the objective to further increase operational reliability of the aircraft, mainly in highly demanding operational conditions.

### MANPOWER:

4 hours

### SPECIAL TOOLS:

Common tools for aircraft maintenance.

### WEIGHT AND BALANCE:

No effect

### ELECTRICAL LOAD DATA:

N/A

### PUBLICATIONS AFFECTED:

N/A

### MATERIAL AND COSTS:

All costs to be covered by the aircraft owner/operator.



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### MATERIAL:

NOMENCLATURE	PART NUMBER	DESCRIPTION	QUANTITY (PCS)
3171T032	16910512	rivet Avex 5	4
3171T030	16910410	rivet Avex 4	10
ST0050N-510-001	N/A	mounting device	1
3111x611	N/A	bolt M6x35	1
3121x602	N/A	nut M6	2
SF0262L	N/A	left stop	1
SF0262P	N/A	right stop	1
4410V002	N/A <sup>1</sup>	Emfimastic PU50 or	1
N/A	N/A <sup>1,2</sup>	3M Marine Adhesive Sealant 5200	1

<sup>1</sup>one of these, <sup>2</sup>order in local store

### ACCOMPLISHMENT INSTRUCTIONS:

1. Remove horizontal stabilizer (CR-MM-1-0-00, Chap 5.3), disconnect trim wires and elevator rod.
2. Remove rudder (CR-MM-1-0-00, Chap 5.3), disconnect control cables.
3. Drill out the rivets both sides (CR-MM-1-0-00, Chapter 15.2). All drilled rivets are marked on the picture (Fig. 1). Rivets marked as Avex 4 with drill bit D3,2mm and Avex 5 with drill bit D4,1mm.
4. Gently heat up the fairing with a hot-air gun in blue area.

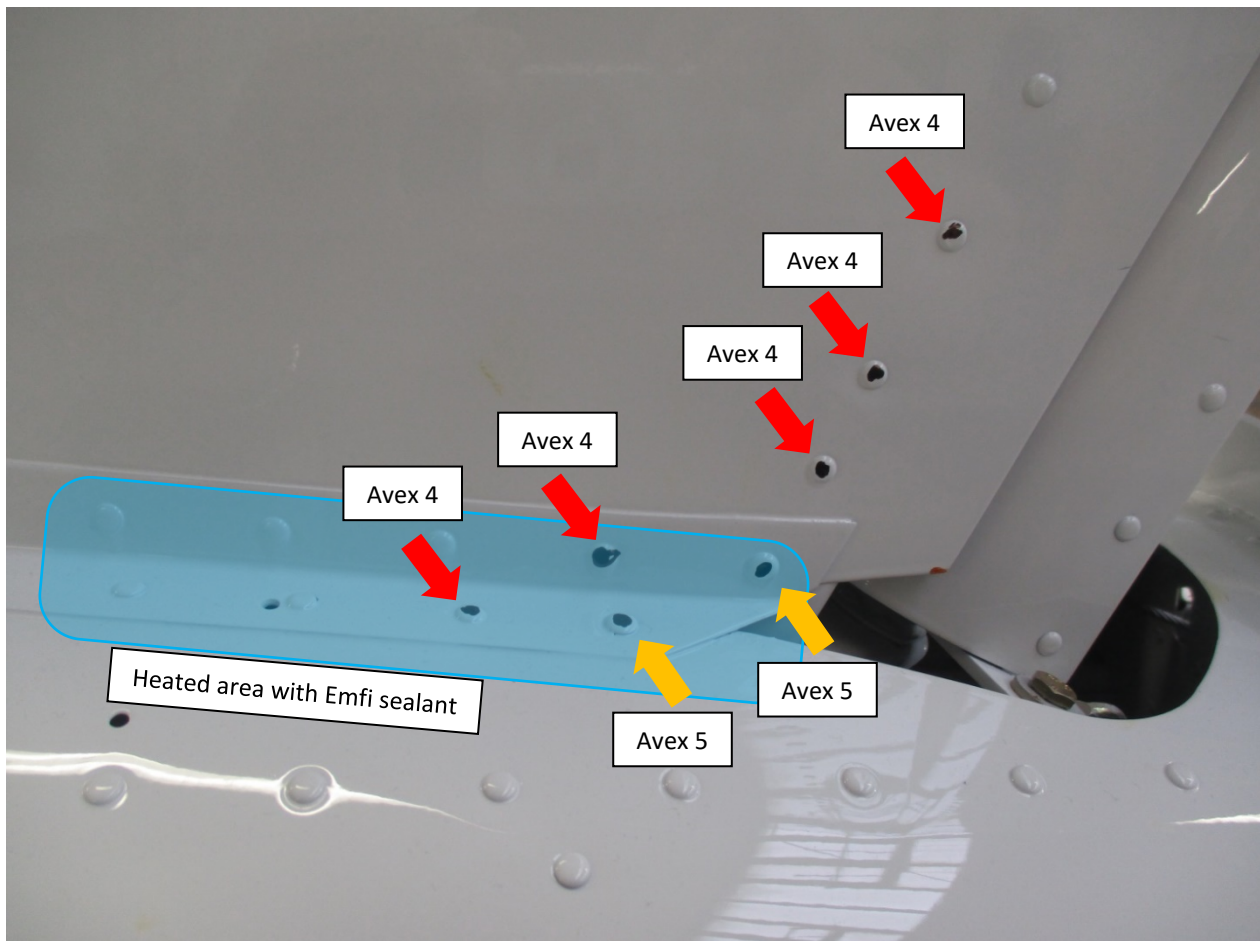


Fig. 1: Rivets marked to be drilled out



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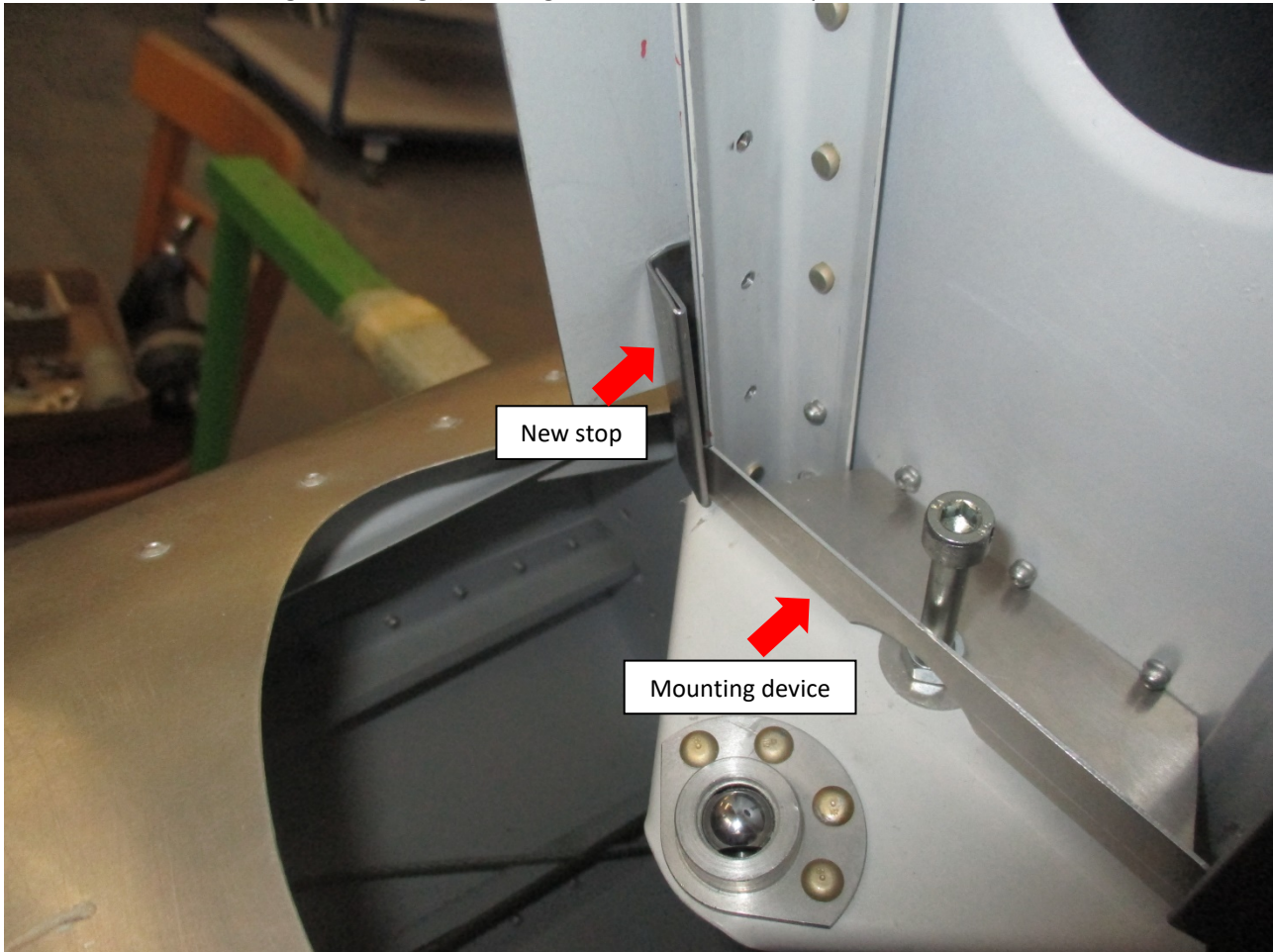
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5. Remove the stops.
6. Remove any residual Emfi sealant using a snap blade knife.
7. Install the mounting device (Fig. 2) for alignment of the new stops CF0262LP.



**Fig. 2:** Mounting device

8. Install the left and the right stop, keep stops in contact with the mounting device.
9. Drill the holes, D3,2mm for Avex 4 and D4,1mm for Avex 5, see Fig. 1.
10. Remove the stops and deburr the holes.
11. Apply Emfi/3M sealant where was the original sealant.
12. Install the stops back in place, fix the stops with clecos.
13. Gradually rivet (CR-MM-1-0-00, Chap 15.3) the rivets Avex 4-10 pcs. and Avex 5-4 pcs. See Fig. 1.
14. Remove the mounting device.
15. Clean the airframe from rest of rivets.
16. Install back the rudder (CR-MM-1-0-00, Chap 5.3), connect control cables.
17. Install back the horizontal stabilizer (CR-MM-1-0-00, Chap 5.3) and connect trim cables.
18. Check deflection of the rudder, system function and tension of the control cables (CR-MM-1-0-00, Chap 6.4).
19. Fill the holes in the rivet heads with Emfi/3M sealant, allow to cure and grind it.
20. Repair the paint (CR-MM-1-0-00, Chapter 15.6).



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## APPROVAL:

This Service Bulletin has been approved by:

Title	Head of Design Organization	Airworthiness Manager
Name	Jiří Sklenář	Jiří Sklenář
Hand written signature		