



MODIFICATION BULLETIN

AIRPL
MODEL

91

91.5/1

Safir

PAGE 1 OF 1

Outer wing panel. Introduction of drive screws on the wing underside at the wing spar.

URGENCY: III November 1st, 1951 at the latest

EFFECT ON WEIGHT DISTRIBUTION:

TIME OF DELIVERY
FOR NECESSARY PARTS: April 21st, 1951WEIGHT CHANGE
LBS.STATION
IN.MOMENT CHANGE
LBSIN.

K/K

MARKING:

None

Drawings: Not essentialParts required per plane:Item Ref. figure

01 22 Drive screw 3,5x6,4 AS 211508

Parts required per spare part:

01 11 Drive screw 3,5x6,4 AS 211508

Aircraft concerned:91101-91104, 91106-91123, 91125-
91130, 91132-91148Spare parts involved:

Outer wing panel 91.5500

Outer wing panel 91.5550

At high loads on the wing, stress concentrations may occur in the inner rivets between the wing spar and the attachment plate between the spar flange and the sheet panel, which may cause rivets to loosen. To prevent this, drive screws should be introduced between the existing rivets in the spar flange and the sheet panel. The rivets in the spar flange and the attachment plate are covered by the sheet panel and not visible.

Work procedure:

Dismount the wings and place them on trestles upside down. Localize the position of the spar flange in chord- and span direction from the wing root. See figure. Draw a line perpendicular to the spar flange 83 mm from the inner end of the spar flange. Draw a line parallel with the edge of the front sheet panel at a distance of 4 mm from the spar flange about 300 mm towards the wing tip. In order to check that this line is parallel with the flange spar the position of the flange at the outer end of the line can be determined through the drain hole in the sheet panel about 400 mm from the wing root. Insert a thin bent steel wire in the hole according to section B-B in the figure and feel the position of the spar flange, thus determining the distance x, see figure. Mark off this distance plus 4 mm from the edge of the hole. The point reached thus should coincide with the previously drawn line. Draw a line parallel with the previous one at a distance of 14 mm according to the figure. The location of the drive screws item 01 should be marked on the lines and holes ϕ 2.8 mm drilled. Depth of holes 8 mm (max. depth 10 mm). Use a drill of a rated diameter = 2.8 mm. Be careful when drilling not to make the holes too large. Drive in the drive screws, 11 in each wing. Use thereby a rivet hammer for round head rivets. Remount the wings.

April 7, 1951

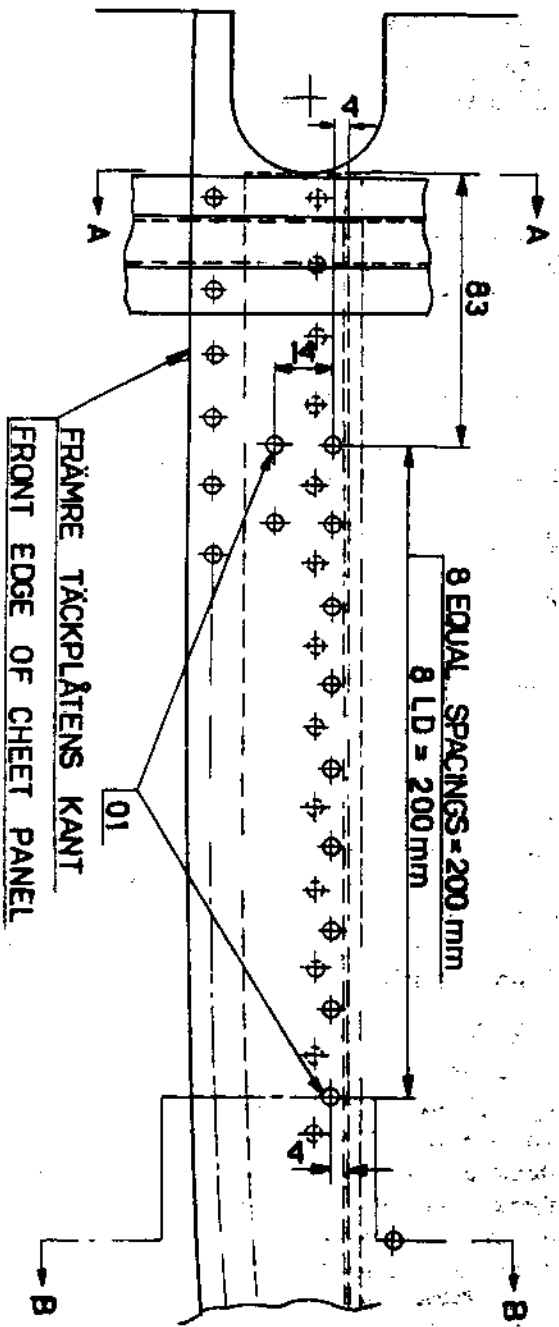
SAAB SERVICE DEPT:

SAAB DESIGN DEPT:

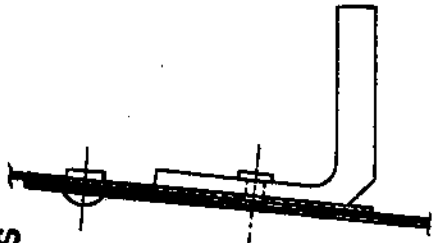
ROYAL SWEDISH AERONAUTICS BOARD:

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FLYGRIKTNING
DIRECTION OF FLIGHT



SECTION A-A



SECTION B-B

