



Reference  <u>Airplane 91B-2, C and D. Wing LH and RH.</u>  Introducing of extra rivet in stiffener, wing upper side.	Date January 26, 1962	No.  91.5/5
	Saab Service Dept. C Larsson <i>[Signature]</i>	
	Saab Design. Dept. S Lundgren <i>[Signature]</i>	
Urgency III	To be introduced at next overhaul at the latest. Max load factor 5.5 until the modification has been introduced.	
	Royal Swedish Board of Civil Aviation S Fogelström <i>[Signature]</i>	

Marking  -	Effect on weight distribution		
	Weight change Lbs	Station In.	Moment change Lbsin.
	-	-	-

Time of delivery for necessary parts  
-

C/C

Information:

In some cases during manufacturing the recesses in the stiffeners on the wing upper side have been made too large at the connection of the stiffeners to the wing spar between sta 425 and 1965. For that reason extra rivets are to be fitted.

Because the recesses in the stiffeners can not be inspected as the wings on the airplanes concerned have internal sheet linings in the fuel tank compartment, the modification shall be introduced in all suspected airplanes, see below.

Drawings: Not essential

Required parts per plane:

Item	Ref figures	Make	Designation	
01	22	Blind rivet	Avdel 402/508	} alt.
			Pop TAP/D/BS523	
			Cherry CR163-5-4	

Parts required per spare part:

11 Blind rivet of the alternatives above

Airplanes concerned:

91321-91432, 91439 with wing  
manuf. No. 501-583, 585-615  
LH <sup>each</sup> RH  
*and*

Spare parts involved:

Wing with manufacture No.  
501-583, 585-615 LH and RH

Work procedure:

Dismount the wings.

Remove the fuel tanks in LH and RH wing according to chapter 2:3:M in Airplane Manual Saab Safir (does not apply to 91B-2, which has fuselage fuel tanks).

Check that all holes in the tank compartment lining (except the holes for connection of the fuel tank and the wing spar lightening holes) are well covered with fabric strips to avoid metall chips from the drilling to enter the tank compartment and damage the tank. Drill holes  $\varnothing$  4 mm and insert an extra rivet in all stiffeners according to the figure.

Note The drill should be provided with a limiting stop that prevents it from drilling deeper than appr. 5 mm.

Fit the fuel tanks according to chapter 2:3:M in Airplane Manual Saab Safir.  
Mount the wings.

