

**AkroTech Aviation, Inc.**  
Service Bulletin #6

Models Affected: G-200

Part: Rear Wing Spar Carrythrough

Serial Numbers: 002, 004-028

All parts required for this service bulletin are provided by AkroTech Aviation, Inc. as follows:

- 1 ea. 53-20-1-2-0830 Rear Spar Bracket, Right Front
- 1 ea. 53-20-1-2-0831 Rear Spar Bracket, Left Front
- 1 ea. 53-20-1-2-0832 Rear Spar Bracket, Right Rear
- 1 ea. 53-20-1-2-0833 Rear Spar Bracket, Left Rear

*Bulletin*

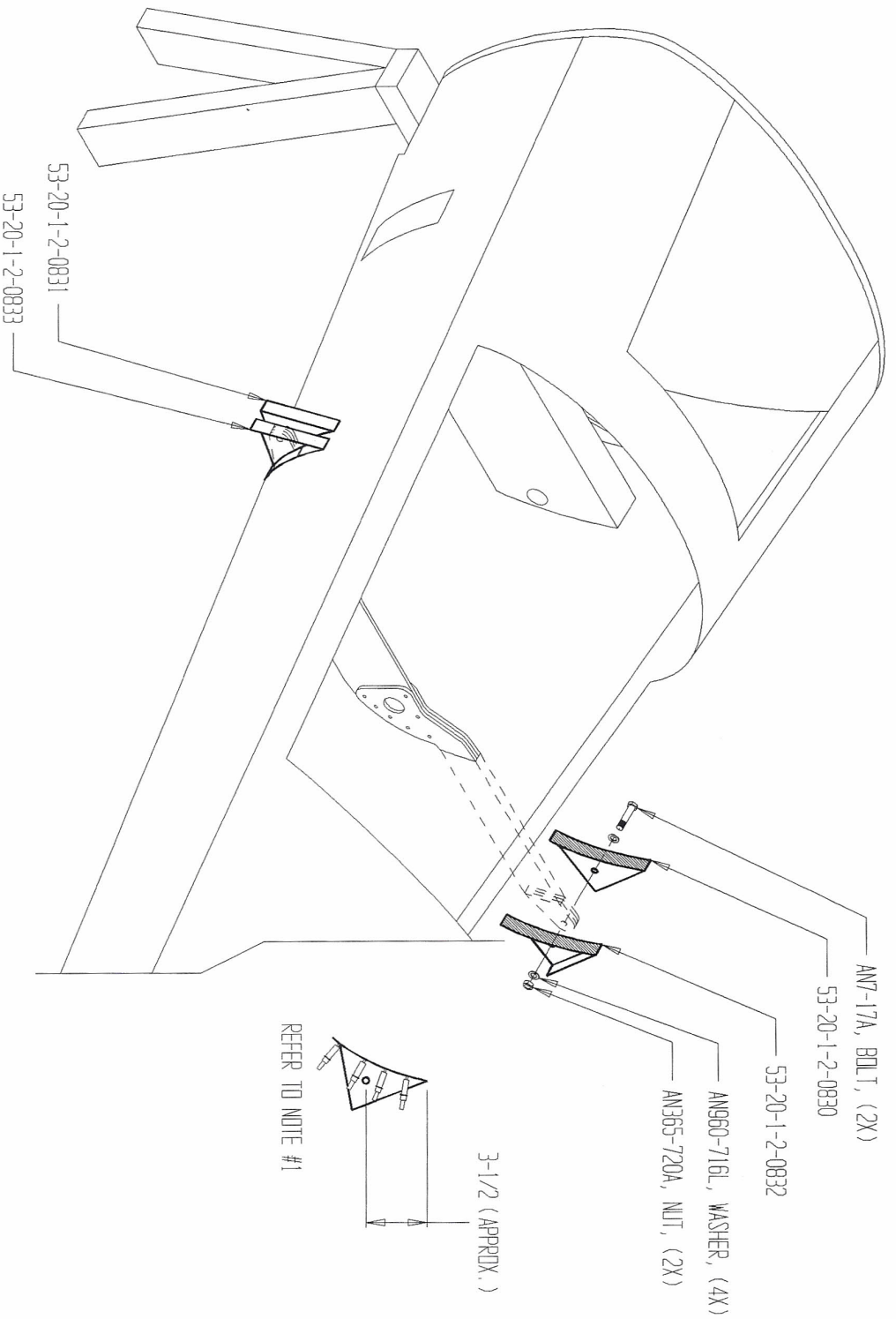
G-200 aircraft with the serial numbers listed above need to have the rear wing spar carrythrough structure modified as specified in this service bulletin. Compliance with this service bulletin should be accomplished before further flight.

*Procedure*

The aircraft will need to have the rear spar attach plates already attached, as per assembly manual task F-17. Remove the wings from the aircraft, if installed. Test fit the brackets as shown in the attached drawing. Each of the four brackets is different - make sure they are fit in the correct position. Mark each bracket's location on the fuselage. While holding the brackets in position drill several cleco holes through the fuselage and brackets. Cleco in place. Use a transfer punch to locate the center of the rear spar bolt hole in each bracket, one at a time. Remove the bracket and drill a 1/8" pilot hole at this position. Use a step drill or drill bits in 1/8" increments to carefully size the hole up to 7/16". Repeat for each of the four brackets.

Prepare the areas marked on the fuselage and four brackets for bonding by sanding thoroughly with 80 grit sandpaper then cleaning with acetone. Bond the brackets to the fuselage using Hysol. Hold in position during cure by inserting the rear spar attach bolt through the brackets and the rear spar plates. Finger tighten a nut onto the bolt to clamp the brackets against the backing plates. **DO NOT BOND THE BRACKETS TO THE ALUMINUM REAR SPAR PLATES ONLY TO THE FUSELAGE!** Allow to cure then remove clecoes and bolt.

Any questions regarding this bulletin should be directed to Eric Molstead at AkroTech Aviation, Inc. at 503- 543 7960.



NOTES:

- 1 - PREP SURFACES, APPLY HXSOL,  
ALIGN W/REAR SPAR BOLTS,  
HOLD IN POSITION W/CLIPS

REAR SPAR CARRY-THROUGH BRACKETS

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