

AERONCA AIRCRAFT CORPORATION

MIDDLETOWN, OHIO

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GAA-FILE COPY

SERVICE LETTER NO. 19

May 24, 1949

SUBJECT: Factory approved repair of elevator and rudder hinges on Models 7AC, 7BCM, 7CCM, 7DC, 11AC, 11BC and 11CC!

This Service Letter is published in response to many requests for factory approved repair to elevator and rudder hinges, on those models listed above which have become worn due to normal service wear. The following repair not only will correct for wear, but will greatly facilitate repairs later on, as future welding has been eliminated by the use of bushing inserts!

REFERENCE: Model 7 and 11 Service Manuals.  
Attached Sketch.

OPERATION:

1. Cut off the existing hinge bushings (AS1-6083-0-22) from both of the mating surfaces being repaired. Using a file, dress down the surface to conform with the basic tube contour.
2. Weld new hinge bushings (AS1-7083-0-22) to surfaces in the same relative positions as the old bushings. NOTE: Put a long piece of 1/4" Dia rod through all bushings on the same surface, to assure alignment of the bushings during and after the welding operation.
3. Ream bushings. To accomplish this, braze a Letter "N" (.302) drill to a long piece of 1/4" Dia. rod. Place the two mating surfaces together and line drill the six (6) bushings at the same time. Next, hand ream the individual bushings to  $.312 \pm .001$  inch Dia.
4. Press inserts (1-3737) into bushings.
5. Install control surfaces using same size flat head pins as originally used (AN394-71).

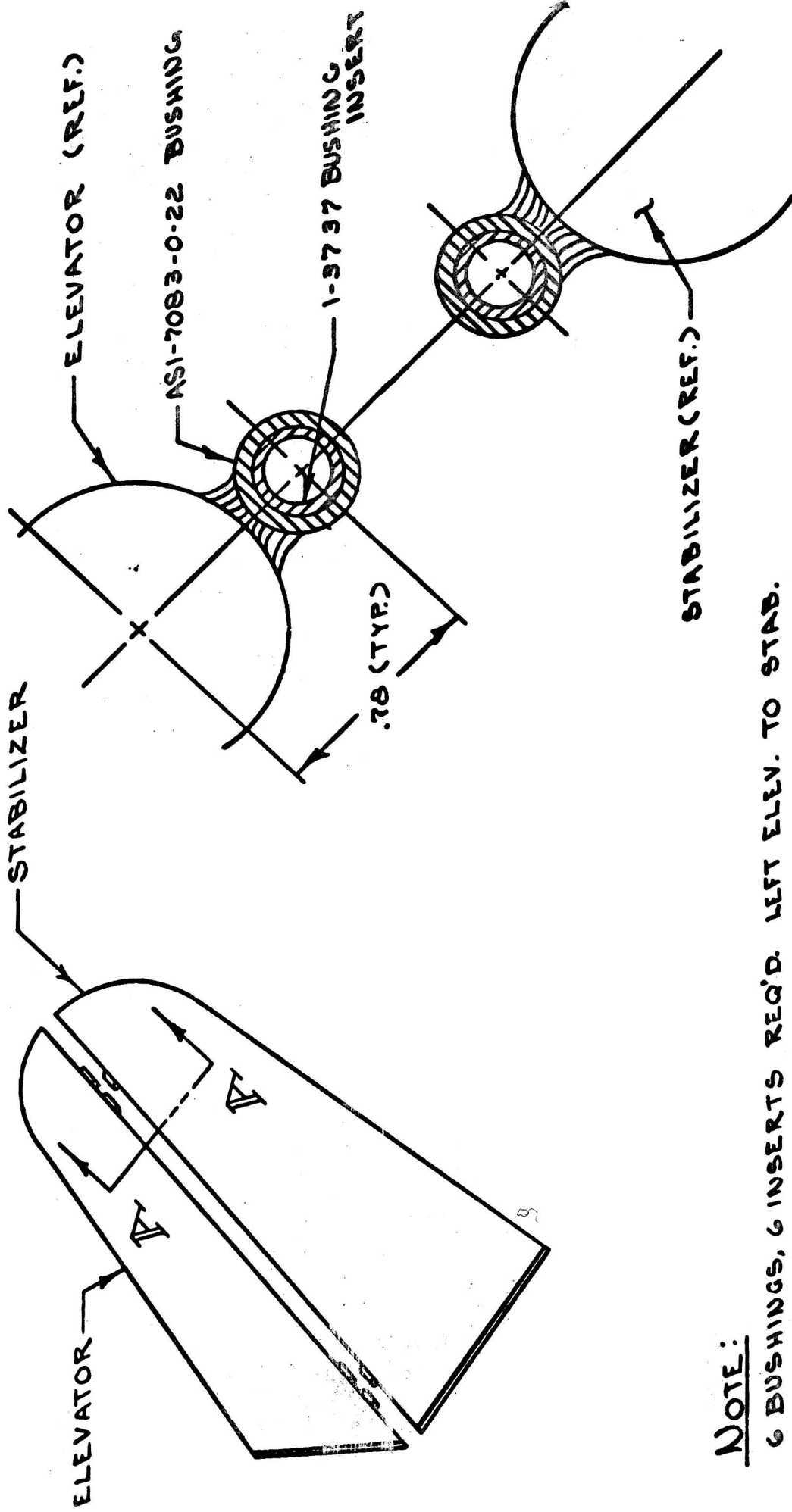
AS1-7083-0-22 bushings and 1-3737 inserts are now available and may be purchased from our Parts Department.

Sincerely yours,

AERONCA AIRCRAFT CORPORATION

W. B. Runyan, Jr.  
Service and Operations Manager

WBR:tr  
Attachment



NOTE:

- 6 BUSHINGS, 6 INSERTS REQ'D. LEFT ELEV. TO STAB.
- 6 BUSHINGS, 6 INSERTS REQ'D. RIGHT ELEV. TO STAB.
- 6 BUSHINGS, 6 INSERTS REQ'D. RUDDER TO FIN.

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