## *Pre-Paint>Wings>Fit vibration damper to strut*

### Objectives of this task:

To fit the vibration damper strips to the rear underside of both struts prior to painting.

### Materials required:

Vibration damping strips (approx 975 x 11 x 3mm, pack of 2) ►

5-minute Araldite and flock

TAPK 3-3 1/16" CSK pop rivets (10 of, 5 per strut)

### *Fit the vibration damper*

Lay both struts on your workbench and mark them as being either left or right (the right side has the pitot head fitted) and then mark the top and bottom end of each strut. Mark the top side and the underside of each strut as they will be when fitted to the aircraft.

Measure and mark a position 460mm up from the bottom of each strut on the rear underside of each strut. This is the locating mark for the lower end of the vibration damper.

Place the damper strip on the strut as shown at right and on the drawing on the next page, 2mm in from the rear edge of the strut, 460mm up from the bottom of the strut, and hold it in place with tape or by hand.
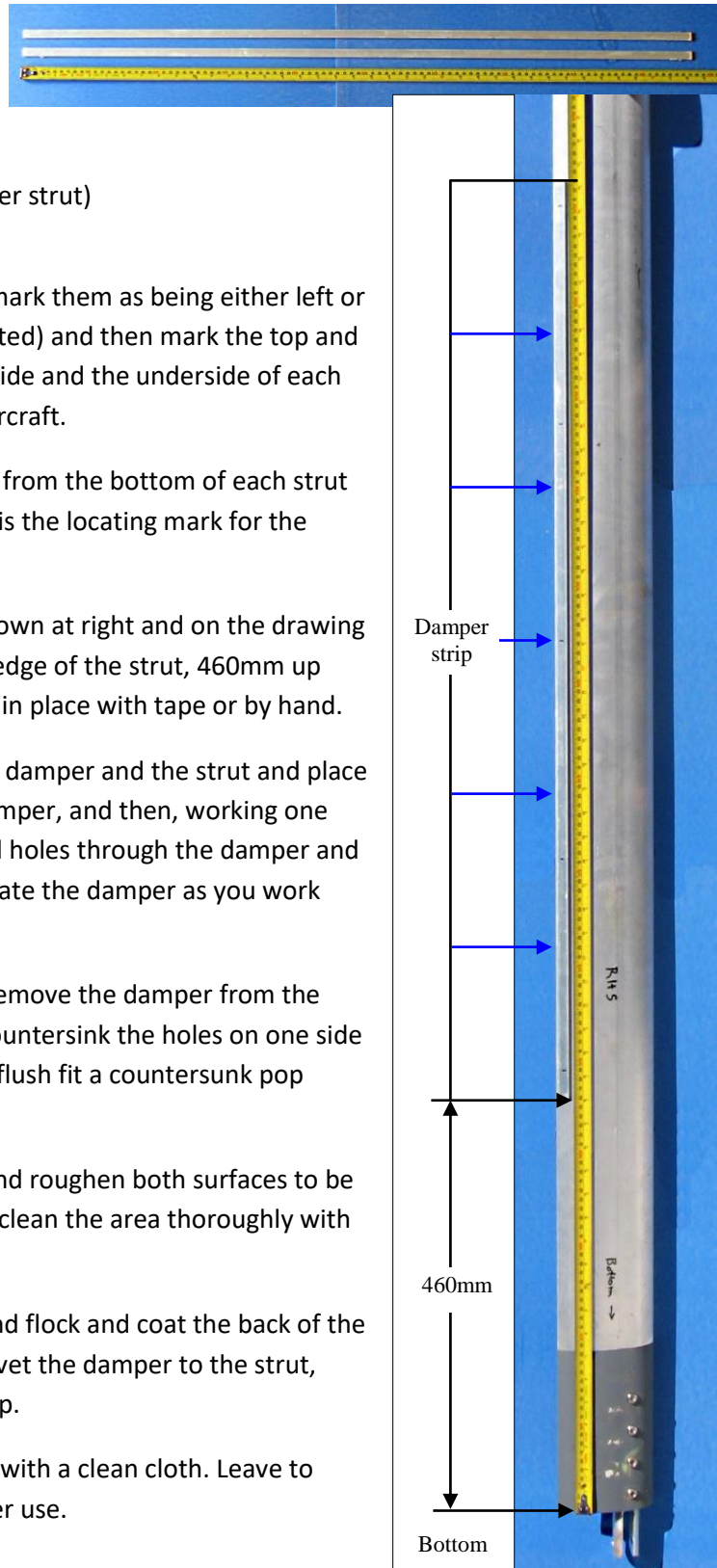
Drill a 1/16" hole through one end of the damper and the strut and place a pop rivet into the hole to locate the damper, and then, working one hole at a time, drill 4 more evenly spaced holes through the damper and the strut, using a rivet in each hole to locate the damper as you work along the damper strip.
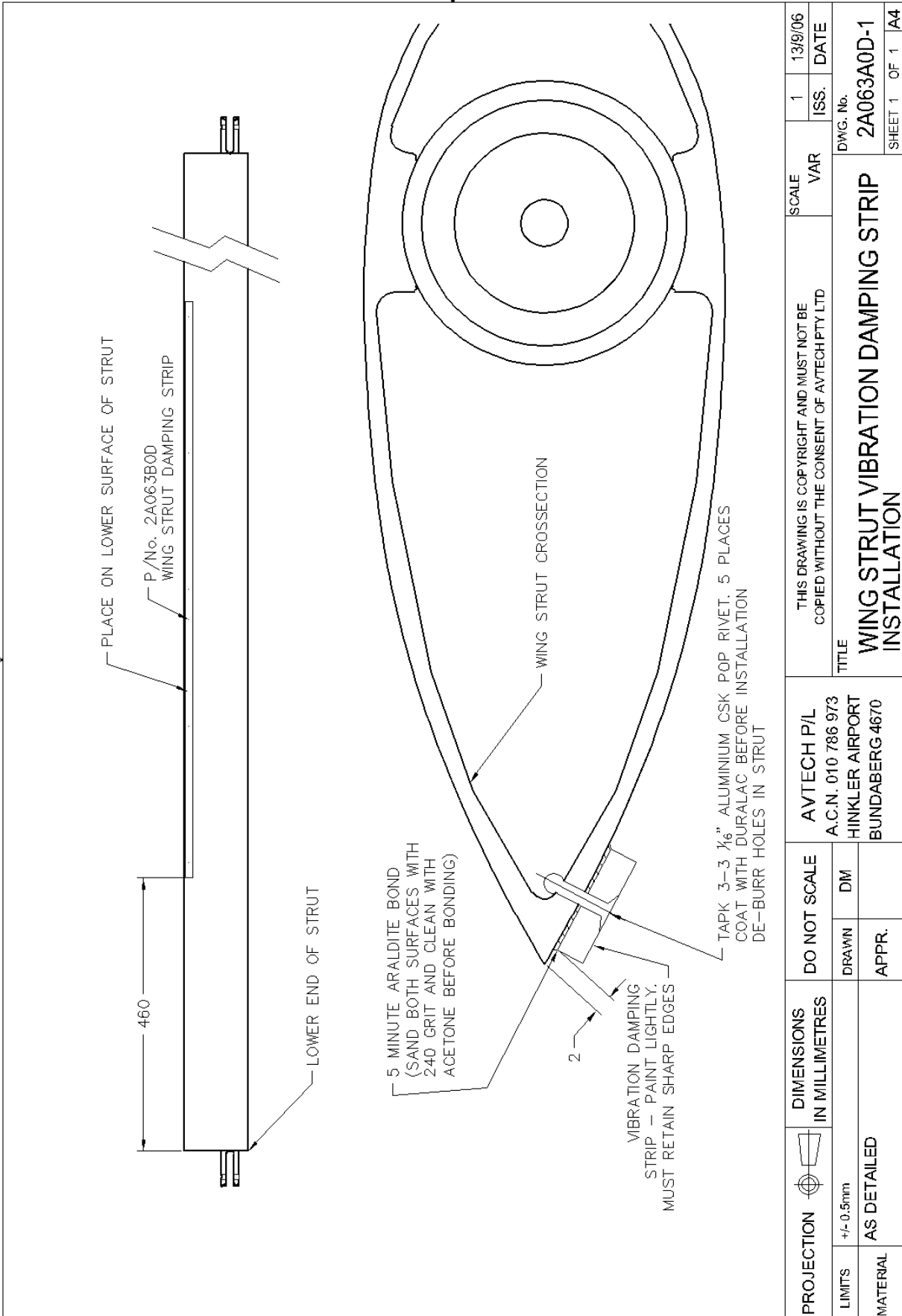
Once all of the holes have been drilled, remove the damper from the strut and use a 120° countersink bit to countersink the holes on one side of the damper strip just deep enough to flush fit a countersunk pop rivet.

Remove the burrs from all of the holes and roughen both surfaces to be joined with 240 grit sandpaper and then clean the area thoroughly with acetone.

Mix a small batch of 5-minute Araldite and flock and coat the back of the damper with a thin layer and then pop rivet the damper to the strut, working along from the bottom to the top.

Wipe away any excess Araldite and flock with a clean cloth. Leave to cure and then set the struts aside for later use.



Damper strip

460mm

Bottom

PLACE ON LOWER SURFACE OF STRUT

P/No. 2A063B0D
WING STRUT DAMPING STRIP

460

LOWER END OF STRUT

5 MINUTE ARALDITE BOND
(SAND BOTH SURFACES WITH
240 GRIT AND CLEAN WITH
ACETONE BEFORE BONDING)

VIBRATION DAMPING
STRIP – PAINT LIGHTLY.
MUST RETAIN SHARP EDGES

2

WING STRUT CROSSECTION

TAPK 3–3 ⅟₁₆" ALUMINIUM CSK POP RIVET. 5 PLACES
COAT WITH DURALAC BEFORE INSTALLATION
DE–BURR HOLES IN STRUT

| PROJECTION | DIMENSIONS IN MILLIMETRES | DO NOT SCALE | | AVTECH P/L A.C.N. 010 786 973 HINKLER AIRPORT BUNDABERG 4670 | THIS DRAWING IS COPYRIGHT AND MUST NOT BE COPIED WITHOUT THE CONSENT OF AVTECH PTY LTD | SCALE VAR | 1 13/9/06 |
|---|---|---|---|---|---|---|---|
| LIMITS +/- 0.5mm | | DRAWN DM | | | TITLE WING STRUT VIBRATION DAMPING STRIP INSTALLATION | | ISS. DATE |
| MATERIAL AS DETAILED | | APPR. | | | | DWG. No. 2A063A0D-1 | SHEET 1 OF 1   A4 |

This completes the *Pre-Paint>Wings>Fit vibration damper to strut* task.