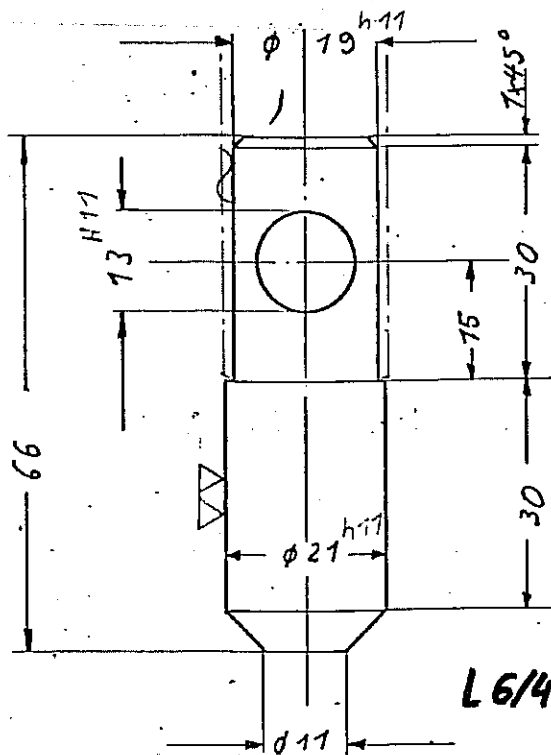


Subject: Assembly of the all flying tailplane
 Effectivity: DG-100 all W.Nrs. (not DG-100 G)
 Accomplishment: Till 30. May 1978
 Reason: Caused by an incomplete assembly of the tailplane a DG-100 crashed.
 To prevent a repetition a modification was worked out so that an incomplete assembly is to be seen from far away.
 Instructions: 1.) A plastic pin is to be glued into the main fitting of the all flying tailplane (see flight manual page 18 a).



Procedure:

- Degrease with acetone: Inside of tubular part of all flying tailplane fitting and cylindrical part L 6/4
- Scour with 100 grit sandpaper: Inside of tubular part and cylindrical part L 6/4 at 19 mm ϕ .
- Apply metal adhesive Araldit AW 106 with hardener HV 953 U or similar on cylindrical part outside and inside tube, push part L 6/4 into tubular part. Remove excess glue. The bore for the pip-pin must remain clean and open.
- Allow 20 hrs at min. 20° C. to cure.

- Change Service Manual page 18 article 5 by hand: "The cockpit trim control should be in the aft position."
- Add on Page 2 Amendments: "Assembly of the all flying tailplane, page 18."

Material: metal adhesive Araldit AW 106 with hardener HV 953-U or similar.
 part L 6/4 can be obtained from Glaser-Dirks.

Weight and balance: no effect

Remarks: This work can be done by an experienced person.

Bruchsal 4, 2.02.1978

W. D.



Approval of translation has been done by best knowledge and judgement - in any case the original text in German language is authoritative.
 8. Feb. 1978