

CESSNA AIRCRAFT COMPANY  
**MODEL 100 SERIES (1963 - 1968)**  
SERVICE MANUAL

**SUPPLEMENTAL INSPECTION NUMBER: 55-11-03**

1. **TITLE:**  
Vertical Stabilizer Attach Bracket and Horizontal Stabilizer Rear Spar Attachment Inspection - Model 150
2. **EFFECTIVITY**  
Model 150 Serial Numbers 644, 649, 15059701 thru 15069308,  
Model F150 Serial Numbers F150-0001 thru F150-0389

**INSPECTION COMPLIANCE**

<b>ALL USAGE:</b>	<b>INITIAL</b>	2,000 Hours	or	4 Years <b>(NOTE)</b>
	<b>REPEAT</b>	2,000 Hours	or	4 Years <b>(NOTE)</b>

**NOTE:** Refer to Note 1, Section 2A-14-00.

3. **PURPOSE**  
To inspect the vertical and horizontal stabilizer rear spar attachments for signs of damage, cracks or deterioration.
4. **INSPECTION INSTRUCTIONS**
  - A. Do an inspection of the vertical stabilizer to horizontal stabilizer aft spar fitting. Refer to Figure 1, Detail B.
    - (1) Visually inspect the vertical stabilizer to horizontal stabilizer aft spar fitting for cracks or corrosion.
      - (a) Clean area before inspecting if grime or debris is present.
      - (b) Pay particular attention to the 0431009 brackets at the radius of the vertical to horizontal flanges.
    - (2) For airplane serial numbers 15061533 thru 15069308 and F150-0001 thru F150-0389:
      - (a) Do a surface eddy current inspection of the 0431009 brackets at the radius of the vertical to horizontal flanges. Refer to Section 2A-13-01, Nondestructive Inspection Methods and Requirements, Eddy Current Inspection, for additional inspection instructions.
  - B. Visually inspect the 0432005-1 and -2 fittings that attach the horizontal stabilizer rear spar to the fuselage.
    - (1) Inspect for loose screws in the attachment of the fittings to the horizontal stabilizer.
  - C. Remove 0432004 bracket from 0432001-15 reinforcement and visually inspect the horizontal stabilizer rear spar and vertical stabilizer attach bracket for cracks. Refer to Figure 1, Detail C.
    - (1) Clean area before inspecting if grime or debris is present.
    - (2) Visually inspect bracket and reinforcement for cracks. Use inspection holes to inspect around nut plates on upper and lower flanges.
    - (3) Pay particular attention to the edge of the plate welded to the aft side of the bracket.
    - (4) Visually inspect 0432001-56 spar for cracks near bracket and reinforcement attach area. Remove the inspection plate on the top surface of the horizontal stabilizer and use a borescope to inspect the forward side of 0432001-56 spar.
  - D. Detailed Inspection:
    - (1) If no cracks are found on 0432004 bracket during visual inspection, conduct a surface eddy current inspection. If no cracks are found during the surface eddy current inspection, proceed to 4.E. below.
    - (2) Conduct a surface eddy current inspection of 0432001-15 horizontal rear spar reinforcement, where the 0432004 bracket attaches. If no cracks are found during the surface eddy current inspection, proceed to 4.E. below.
    - (3) Remove 0432001-15 rear spar reinforcement and conduct a surface eddy current inspection of 0432001-56 spar, where the 0432004 and 0432001-15 are installed.
  - E. Install all removed parts. Refer to the Model 100 Series Service Manual.

CESSNA AIRCRAFT COMPANY  
**MODEL 100 SERIES (1963 - 1968)**  
SERVICE MANUAL

**5. ACCESS AND DETECTABLE CRACK SIZE**

**ACCESS/LOCATION**

Rudder

**DETECTABLE CRACK SIZE**

Not Allowed

**6. INSPECTION METHOD**

Visual and Eddy Current

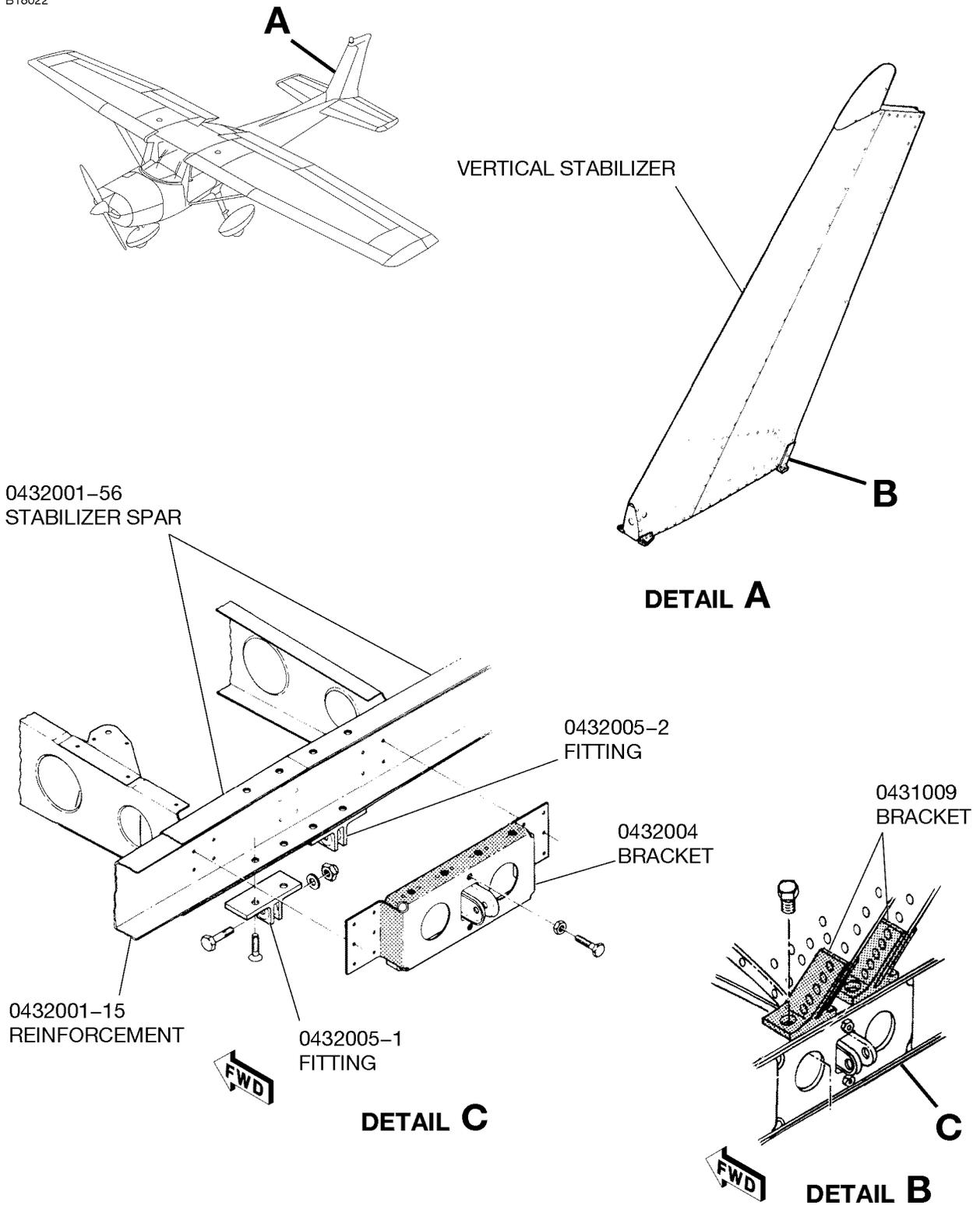
**7. REPAIR/MODIFICATION**

Replace damaged or cracked parts. 0431009-1 and -2 brackets may be replaced with 0431009-3 brackets. 0432004-1 or -9 fittings have been replaced by 0432004-10 fittings. The -10 fittings are heat treated after welding, and so cannot be rewelded and used without subsequent heat treatment. Repairs may be made in accordance with Section 19 (Structural Repair) of the Model 100 Series Service Manual. Any repair not available in Section 19 should be coordinated with Cessna Customer Service prior to beginning the repair.

**8. COMMENTS**

CESSNA AIRCRAFT COMPANY  
**MODEL 100 SERIES (1963 - 1968)**  
 SERVICE MANUAL

B18022



0410T1003

VERTICAL STABILIZER ATTACH BRACKET AND HORIZONTAL STABILIZER REAR SPAR ATTACHMENT  
 INSPECTION - MODEL 150

Figure 1 (Sheet 1)