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|  | <b>SERVICE INSTRUCTION</b>          | No. <b>SI-2024-3</b>    |
|                                                                                   | <b>INSTALLATION OF STALL STRIPS</b> | Rev. <b>0</b>           |
|                                                                                   |                                     | Date: <b>28.08.2024</b> |

**A. APPLICABILITY:**

All aircraft without stall strips or with installed composite stall strips.

**B. MATERIAL AND TOOL INFORMATION:**

Material:

| ITEM                              | QUANTITY |
|-----------------------------------|----------|
| Stall strip 400 mm, D574000040    | 2 pcs    |
| Stall strip 200 mm, D574000050    | 2 pcs    |
| Araldite 2022-1 (50 ml)           | 1 pc     |
| Stall strips templates, 8 pcs set | 1 pc     |
| Masking tape                      | AR       |
| Technical gasoline                | AR       |

Tools:

| ITEM                                | QUANTITY |
|-------------------------------------|----------|
| Application gun for Araldite 2022-1 | 1 pc     |
| Measuring tape (2 m)                | 1 pc     |

**WARNING**

**DUE TO SHORT POT LIFE OF ADHESIVE BOND THE STALL STRIPS ONE BY ONE TO AVOID OF ADHESIVE CURING BEFORE THE STALL STRIP IS CORRECTLY POSITIONED!**

|                                                                                   |                                     |                         |
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### C. **PROCEDURE:**

- 1) Remove the old composite stall strips from leading edge if installed.
- 2) Repair the paint of affected areas after removed composite stall strips according to AMM.
- 3) Prepare the set of templates or print/cut the templates from suitable background material (e. g. plywood, plastic or composite panel) in scale 1:1 according to data in any of the attached files:  
**LH1.ipt, LH2.ipt, LH3.ipt, LH4.ipt, RH1.ipt, RH2.ipt, RLH3.ipt, RH4.ipt or**  
**SI-2024-3\_R0\_Templates\_DWG.dwg or**  
**SI-2024-3\_R0\_Templates\_DXF.dwx or**  
**SI-2024-3\_R0\_Templates\_PDF.pdf.**
- 4) Establish the wing span positions of stall strips (without bonding) according to Fig. 1 on wing leading edge (right side shown, left side mirrored).
- 5) Clean the leading edge properly as the stall strips are bonded directly on paint.
- 6) Use the templates to define the stall strip position on leading edge profile. The templates are positioned 20 mm from stall strip ends (Fig. 2).
- 7) Mark the stall strips positions on the wing leading edge using a masking tape.
- 8) Degrease the bonding surfaces of stall strips and wing leading edge.
- 9) Prepare the adhesive Araldite 2022-1 and apply on the stall strips (Fig. 3). Consider that the pot life of adhesive is approx. 10 minutes at 25 °C.
- 10) Place the stall strips to the marked positions on the leading edge, check the correct positions using templates (Fig. 2), press and fix the stall strips (Fig. 1) using the adhesive tape or suitable jig. The stall strip's edges must be filled with adhesive.
- 11) Remove an excessive adhesive and clean the stall strips and their surrounding using technical gasoline.  
Let the adhesive to harden for 30 minutes at room temperature approx. 20 °C. During hardening of adhesive, the stall strips must be properly pressed to the leading edge, otherwise, the voids may be created in the adhesive and stall strips bonding will be insufficient!
- 12) Remove the stall strips fixation.
- 13) Clean residual adhesive that was impossible to clean during stall strips bonding procedure (Fig. 4, Fig. 5). Do not damage the stall strips or leading edge!
- 14) Check the attachment of stall strips.

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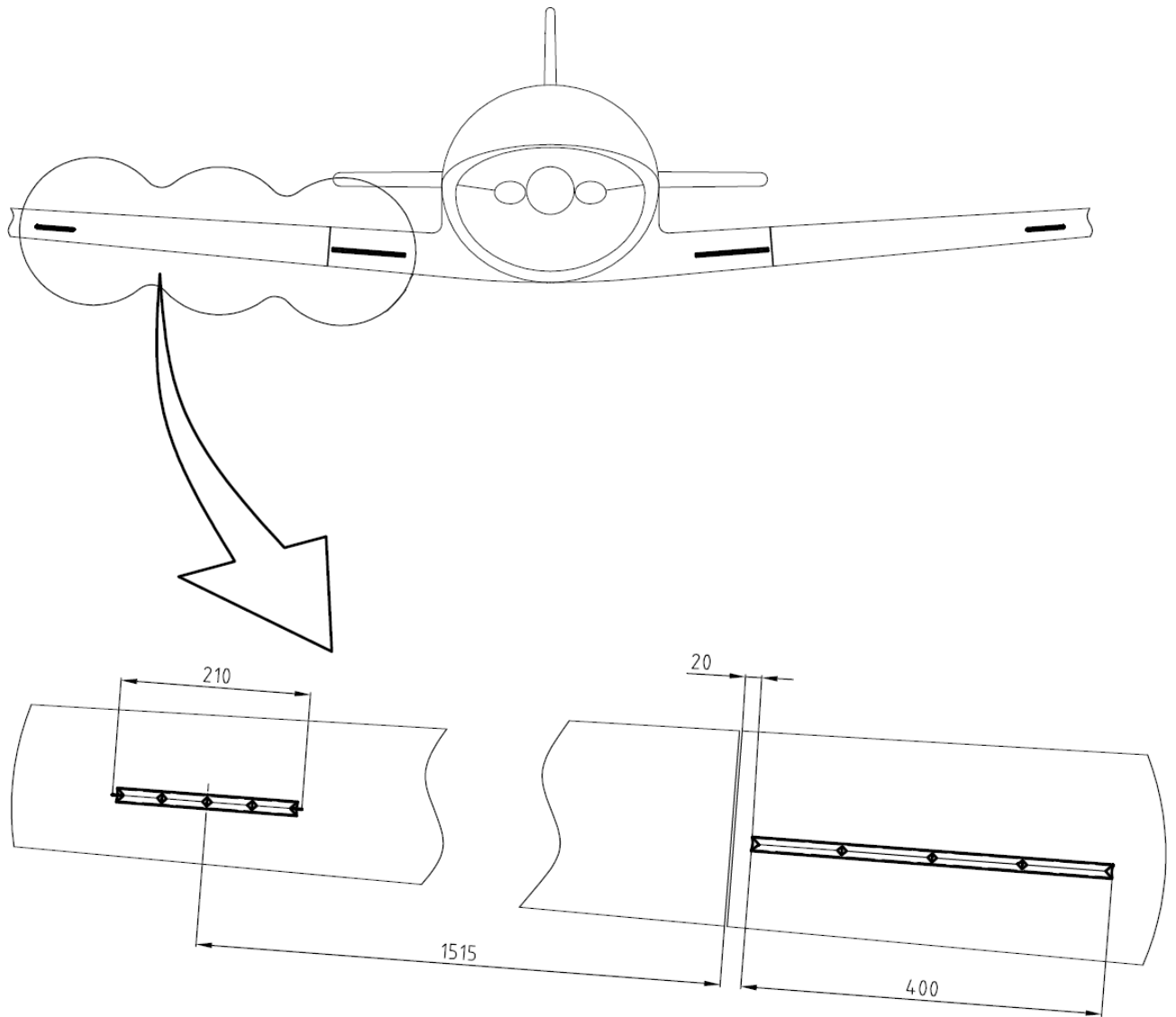


Fig. 1 Stall strips wing span position

|                                                                                   |                                     |  |                         |
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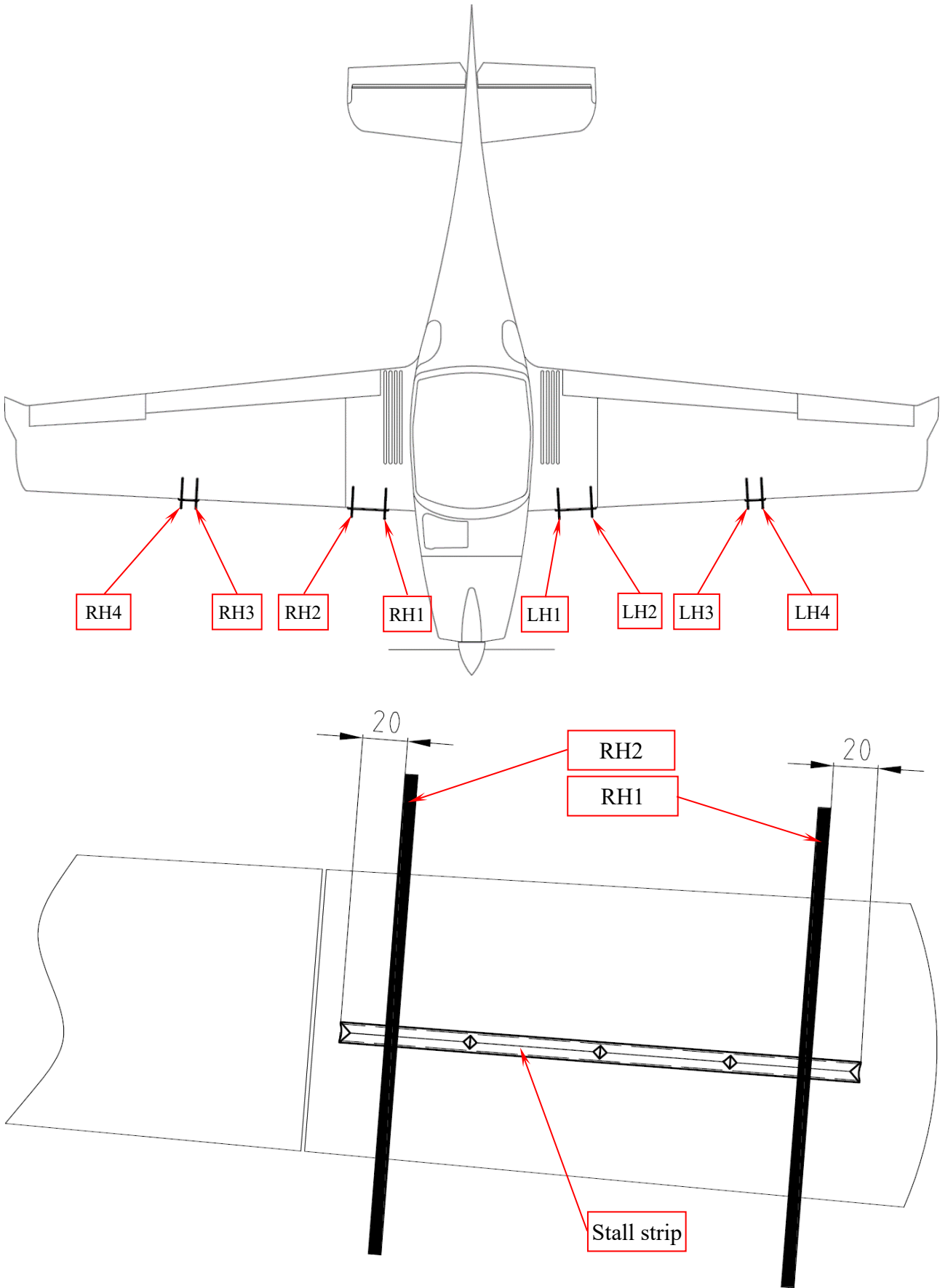


Fig. 2 Template/stall strip position and adjustment

|                                                                                   |                                     |  |                         |
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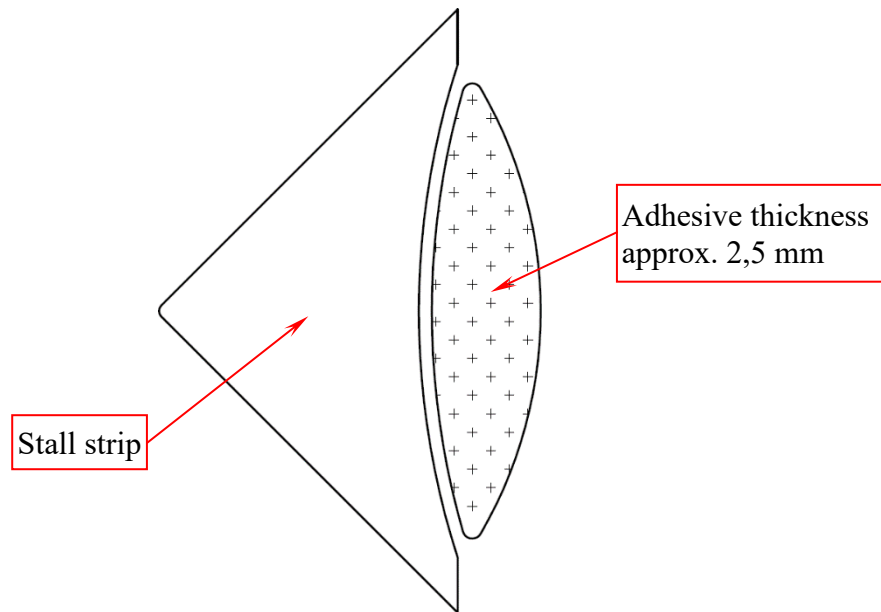


Fig. 3 Adhesive application



Fig. 4 Bonded 400 mm stall strip

|                                                                                   |                                     |                         |
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Fig. 5 Bonded 200 mm stall strip