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ASW 24  
Maintenance Instruction E  
Issue 1

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# DRAFT

**Subject:** Repair of the fuselage by scarfing.

**Affecting:** All serial no.s ASW 24, ASW 24 E, ASW 24 TOP

**Compliance:** Where required.

**Preface:** For the repair of the ASW 24 fuselage skins it is important that the hybrid laminate of the skins is repaired. This means that the layer sequence (from inside to outside), i.e.

glass, Carbon, Kevlar, (PA-veecee ~~not~~ replaced!) Carbon, Kevlar, Glass

is applied such that it matches the original.

**Wrong:**  *internal overlap*

**Correct:**

**Action:** 0 Make a 'backbone' jig by use of an unbroken ASW 24 fuselage.

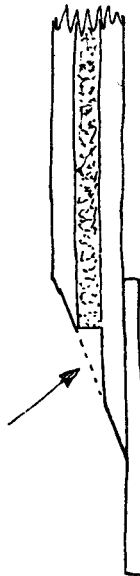
1. Trim edges of broken fuselage in simple geometric forms so that match with new part or prefabricated insert will be easy.
2. Prepare an internal overlap (2x 92140 ~~X~~ and 1x 92110 ~~#~~, about 180 to 200 mm long) and glue approx. 50 % into the wider part of fuselage.
3. Adjust other part on the backbone and glue parts together.
4. Prepare scarf joints according to Repair Manual.

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5. PKM (Polyester vleece) must not be replaced but is removed as a step:



**Overlap**

6. Innermost layer 92110 ~~#~~ is included in overlap and needs no action any more.

7. Laminate 1 layer CX12 ~~#~~ (scarf 16.5 mm minimum length) and overlap over scarf.

8. Laminate 1 layer 98612 ~~X~~ as far as into the end of the PKM steps.

9. Laminate 1 layer KDU 1009 ~~V~~ (scarf 40 mm minimum length) and overlap.

10 Laminate 1 layer 98612 ~~X~~ (scarf 16 mm minimum length) over scarf. Now wind peel ply all around and make bondage with tape to press for low resin content and harden. Remove peel ply after hardening and only scarf last layer 98612.

11 Laminate 1 layer 92145 ~~#~~ (scarf 22 mm minimum length) over scarf. Now again wind peel ply all around and make bondage with tape to press for low resin content and harden and post cure. Remove peel ply after hardening and only scarf last layer 92145, fill and gelcoat. Then finish.

**Material & drawings:**

Use original material only, refer to layer scheme drawing 240. ~~240~~ 11.9010 or 240.11.9002 (Su. ← 2404c)

**Notes:**

The repair can be accomplished by a competent person. It must be checked and certified by an appropriately licensed inspector for aeronautical products.

Poppenhausen, March 28, 1996

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The translation into English has been done by best knowledge and judgement; in any case of doubt the German original is controlling.

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