

SERVICE BULLETIN

STINSON DIVISION

CONSOLIDATED VULTEE AIRCRAFT CORPORATION

WAYNE, MICHIGAN

TITLE Reinforcement of Pivot Point on Front Seat Backs BULLETIN NO. 233

MODELS AFFECTED: 108 (Voyager 150)
Serial 108-1 through 108-99

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DATE March 30, 1946

To accomplish the subject modification, which has been incorporated into airplanes serial 108-100 and up, it is necessary to remove the two front seats from the airplane and detach their seat backs. To detach each seat, lift the seat adjustment locking lever, pull seat full forward, and remove the stop bolt through the front seat track. This bolt is accessible after lifting the lower edge of the seat cushion material just behind the right front corner of the right side. On some airplanes this is a bolt and nut, on others a pin and cotter. After removal of this bolt, lift the locking lever once again and push seat full aft, lifting up on the front edge so as to tilt seat back. Remove seat from cabin by taking out the bolts through the pivoting truss at the floor.

Detach the seat-back from the seat-base by taking out pin and cotter. Insert tube in open end of seat-back tube and drill three .190 inch diameter holes (3/16 Drill) as shown in Figure 1. The pivot hole must be drilled carefully so that the existing hole in the seat-tube is not enlarged. It is recommended that the insert tube be drilled in two operations for this hole; once from each side drilling through only one side of the insert tube.

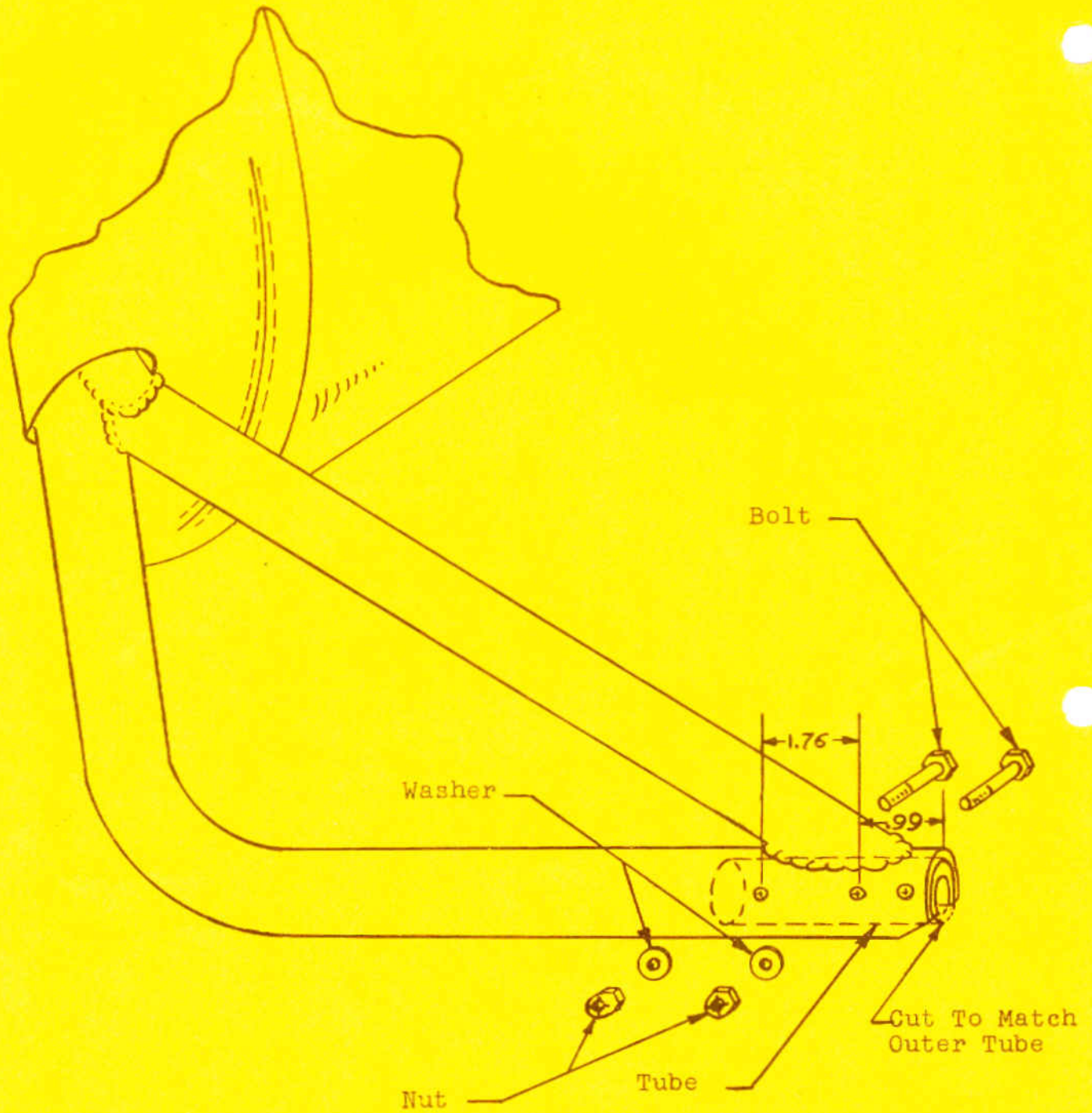
Install the bolts retaining the insert tube with their heads on the inside of the seat to avoid interference with the seat cushion once the back is installed. These insert tubes are to be added to each side of each front seat.

Reinstall the seat-back on the seat-base, putting the head of the pin on the outside of the seat, and the cottered end next to the seat cushion. When reinstalling the seats in the cabin, be sure to install the seat track stop bolt.

Parts required, tabled below, may be secured from our Service Department by advising the serial number of the plane for which they are required.

PARTS REQUIRED:

8 - AN-3-11A	Bolt
8 - AN-960-10	Washer
8 - AN-365-1032	Nut
4 - 108-3091019-300	Tube



George Martin

Service Department