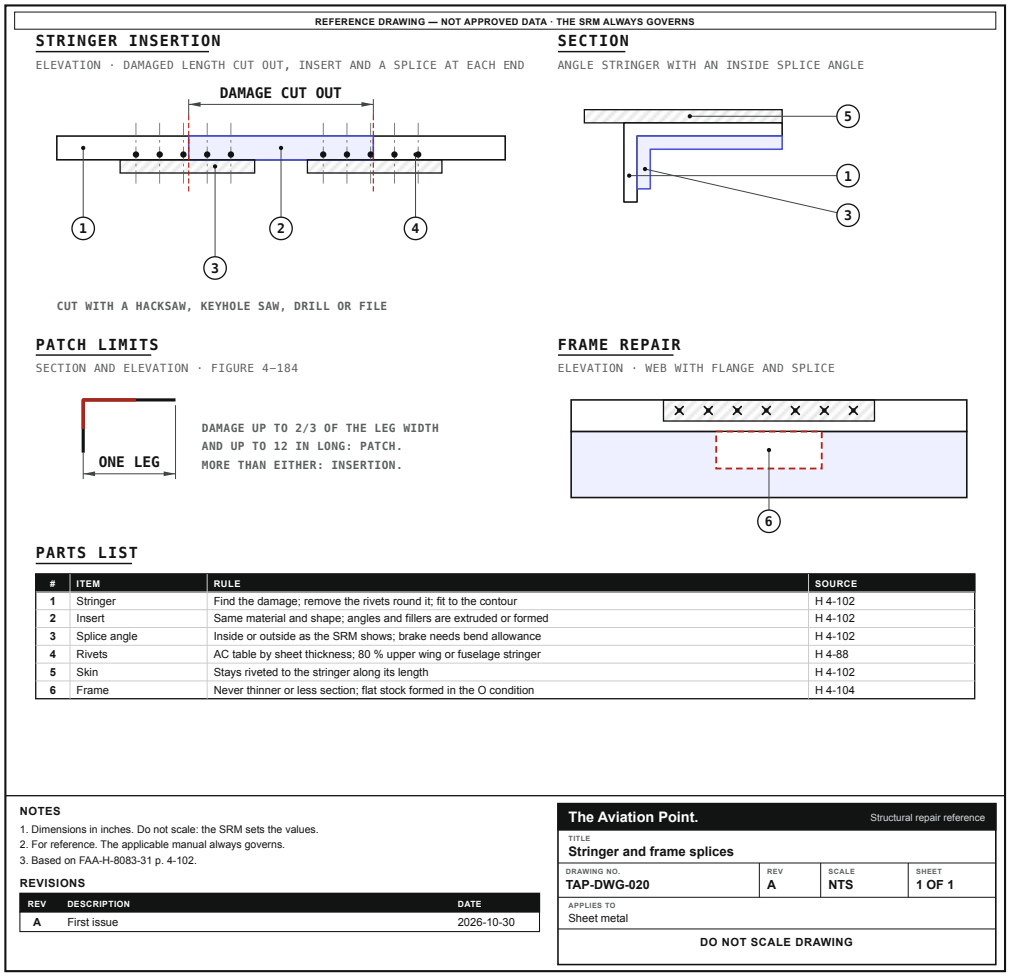
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Stringer and Frame Splices: Insert, Splice Angle and Rivets Each Side

Insert · splice angle · patch limit · rivets each side



After FAA-H-8083-31 pp. 4-102 to 4-104, figs 4-183 to 4-188. Typical only: the SRM gives the repair.

Patch, or insertion

Damage	Repair	Source
Up to 2/3 of one leg's width and 12 in long	Patch	H 4-102, fig. 4-184
More than 2/3 of one leg, part of the stringer removed	Insertion	H 4-102, fig. 4-185
One stringer, more than 12 in long	Insertion	H 4-102, fig. 4-186
More than one stringer, over 12 in	Insertion across the stringers	H 4-102, fig. 4-187
Longeron	As a stringer, with heavier rivets, pitch 4D to 6D	H 4-104

Key points

- **Patch** only up to 2/3 of one leg and 12 in long; else insert.
- **Insert:** same material and shape; splice angle at each end.
- **Splice angle** inside or outside as the SRM shows.
- **Rivets:** SRM or AC table; 80 % for upper-wing and fuselage stringers.
- **Frames:** never thinner or less cross-section.

Step by step

1. Find the extent; remove the rivets round it.
2. Cut out the damaged length.
3. Make the insert and splice angles.
4. Fit, drill, deburr, protect.
5. Rivet each side; inspect.

SOURCES · FAA-H-8083-31, AMT Handbook — Airframe, Volume 1, Chapter 4

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Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.

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