

WIPAIRE, INC.
INVER GROVE HEIGHTS, MN

DATE: March 1, 1994

REISSUED: April 11, 1995

SERVICE KIT: #18

SUBJECT: Installation Cover-Wheel Well

MODEL: Model 4000 Amphibious Float

<u>Item</u>	<u>Quantity</u>	<u>Part No.</u>	<u>Description</u>
1.	2	4A01150-121	Cover-Wheel well
2.	2	4A01347-009	Keel-Section - Afterbody
3.	2	4A01163-051	Splice-Afterbody Keel
4.	4	4A01163-050	Angle-Cover Support
5.	A/R	AN470AD4	Rivets
6.	1	3B1-1185	Drawing
7.	1	#32	Service Letter

Instructions:

Install above parts according to Installation Drawing 3B1-1185.

(PIN 440194-009)

INSTALL AFTERBODY KEEL (1) INSTALL FLUSH TO FWD EDGE OF COVER. SHAPE AFT EDGE TO MATCH EXISTING AFTERBODY KEEL. SPACE (12) 250 DIA. HOLES EQUAL IN KEEL EA. SIDE AND SECURE WITH AM470AD4 RIVETS

(PIN 440113-051)

343-1183 SPLICE (1) CENTER OVER BOTH AFTERBODY KEELS AND SPACE (6) #30 DIA. HOLES AS SHOWN AND SECURE WITH AM470AD4 RIVETS

DRILL THIS RIVET OUT AND INSTALL 383-1181 COVER UNDER KEEL

DRILL THIS ROW OF RIVETS OUT IN AFT PANEL BEFORE INSTALLING COVER

(PIN 440150-121)

383-1181 COVER (1) POSITION OVER HOLES DRILLED OUT IN AFT PANEL UNDER AFTERBODY STRAP, AND AFTERBODY KEEL. BEFORE DRILLING AND BUSHING, DISCONNECT SHOCK STRUT AND SWING LEAD TO MAKE SURE THERE IS NO INTERFERENCE WITH TIRES AND COVER. CENTER COVER ON FLAT. SECURE WITH RIVETS PREVIOUSLY DRILLED OUT.

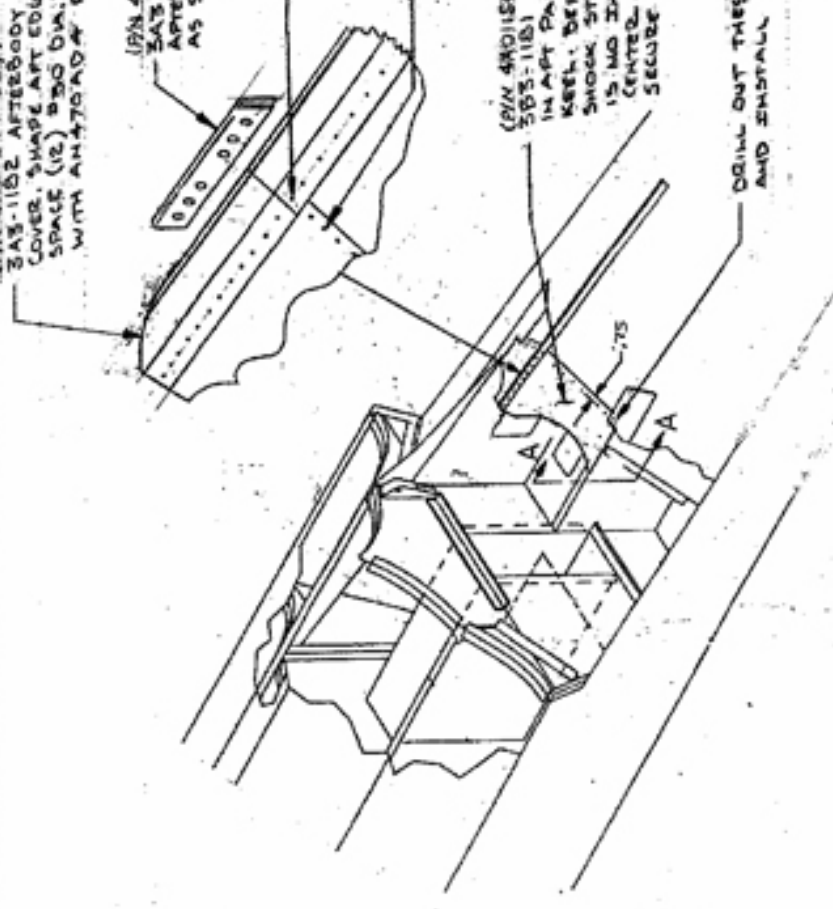
DRILL OUT THESE (2) RIVETS OUT IN AFTERBODY STRAP AND INSTALL 383-1181 COVER UNDER STRAP.

DRILL (3) #30 DIA. HOLES THRU COVER. SECURE WITH AM470AD4 RIVETS

USING STRAIGHT EDGE MAKE SURE FWD EDGE OF 383-1181 COVER IS IN LINE WITH AFTERBODY SKIN

(PIN 440113-050) 343-1184 ANGLE (2) SECURE ON FWD MOST EDGE OF COVER AND AGAIN AT WHEEL WELL SIDE AS SHOWN.

DRILL OUT (3) RIVETS UNDER 383-1184 ANGLE. SECURE ANGLE TO WHEEL WELL SIDE WITH AM470AD4 RIVETS



NO.		DATE		BY		REVISED	
MATERIAL		FINISH		TITLE		8530 PAPER FROM RIVER GROVE HTS. MN 55078	
NAME		DATE		TOLERANCES		P. NO.	
DR	J.A.	1/15/52		.00	1.015		
APP	L.F.	8-1-54		.000	1.006		

WIPARE, INC.

SECTION A-A