



SERVICE LETTER NUMBER 125			
TITLE: BOW BULKHEADS, LOWER FLANGE REINFORCEMENT			
BY: K. TAYLOR	AIRCRAFT MAKE/MODEL(S):	FLOAT MODEL(S):	NOTE(S):
APP: R. ADLER	CESSNA 208, CARAVAN VIKING DHC-3, OTTER	8000S AND 8000A	OPTIONAL COMPLIANCE
DATE: 26-SEP-11			S/L P/N 1005509
REV: A			ECO 22250

FAA APPROVAL HAS BEEN OBTAINED FOR TECHNICAL DATA IN THIS PUBLICATION THAT AFFECTS STC OR TSO DESIGN COMPLIANCE

EFFECTIVITY:

This service letter applies to all S/N Wipline model 8000A/S, amphibian and seaplane floats, as installed on Cessna 208 Caravan and Viking DHC-3 Otter aircraft. This service letter applies to aircraft equipped with the following STCs:

STC SA270CH, SA149CH, or SA1311GL – Model 208 with 8000 seaplane or amphibian floats at 600 or 675 HP

STC SA331CH – Viking DHC-3 with model 8000 seaplane or amphibian floats

COMPLIANCE:

Service letter compliance is optional, and is recommended for aircraft operating regularly in rough water conditions.

BACKGROUND:

Certain aircraft operated in rough water regularly may experience cracking of the lower bulkhead flanges on the bow area of the float. This service letter and associated kit reinforce the lower bulkhead flanges of the bow bulkheads to assist in load transfer and reduce probability of cracking as a result of operations on rough water.

COMPLIANCE METHOD:

Install the parts included in service kit 81 in accordance with the instructions in the Technical Data section of this service letter.

APPROX. SHOP HOURS:

This service letter will take approximately 20 labor hours to complete.



WARRANTY INFORMATION:

Parts and labor warranty is not included for this modification.

TECHNICAL DATA:

Copies of this service letter, associated service kit, float service manual, and float parts manual are available on the website www.wipaire.com.

See service kit number 81 for a list of parts applicable to this modification.

For basic model 8000 maintenance information, see Wipaire Service Manual P/N 1002554.

For basic model 8000 parts information, see Wipaire Parts Manual P/N 1002178

To accomplish this modification: Install doublers P/N 1005147 and 1005146 on the lower bow bulkhead flanges at stations 11 thru 16 in accordance with drawing 1005526 latest revision. Drawing 1005526 is attached to this service letter.

NOTES:

After completion of the instructions in this service letter, make an entry as such in the aircraft logbook in accordance with your local Civil Aviation regulations.

Wipaire considers the weight and balance effect of this modification to be negligible; however, consult your local Civil Aviation Regulations with respect to logbook weight and balance entry requirements.

END

NOTES AND MODIFICATION INSTRUCTIONS:

1. SEE SERVICE LETTER 125 FOR BASIC INFORMATION. SEE SERVICE KIT 81 FOR A LIST OF REQUIRED PARTS AND HARDWARE.

2. THIS DRAWING SPECIFIES REINFORCEMENT OF THE LOWER FLANGE OF BULKHEADS 11 THRU 16 ON MODEL 8000 FLOATS.

3. FLANGE MAY FACE FORWARD OR AFT, DEPENDING ON BULKHEAD STATION.

4. BASIC INSTRUCTIONS:

A. REMOVE TOP DECK COVERS AND OPEN BAGGAGE HATCHES TO GAIN ACCESS TO BULKHEADS 11 THRU 16 ON THE BOW. REMOVE BAGGAGE HATCH FLOORS TO GAIN ACCESS TO LOWER BULKHEAD FLANGES.

B. POSITION AND MATCH DRILL DOUBLERS AT EACH LOWER BULKHEAD FLANGE, AFTER DRILLING INTERFERING RIVETS:.

I. MATCH DRILL THESE ROWS OF RIVETS TO EXISTING RIVETS IN LOWER FLANGE AND BULKHEAD FACE.

II. ADD THIS ROW OF RIVETS AT 0.5 EDGE DISTANCE ON UPPER DOUBLER FLANGE, MATCH SPACING ON LOWER FLANGE.

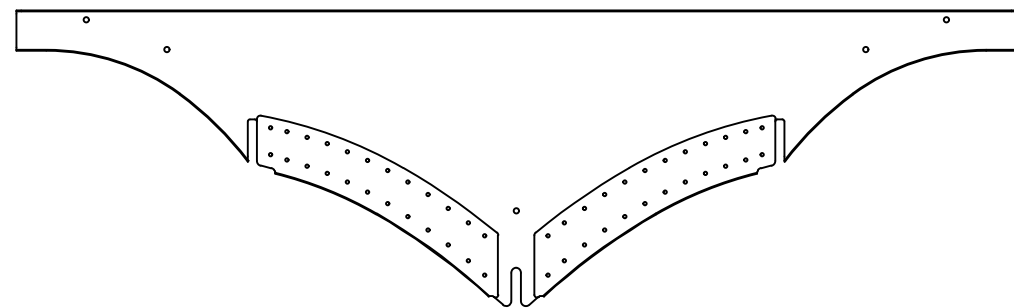
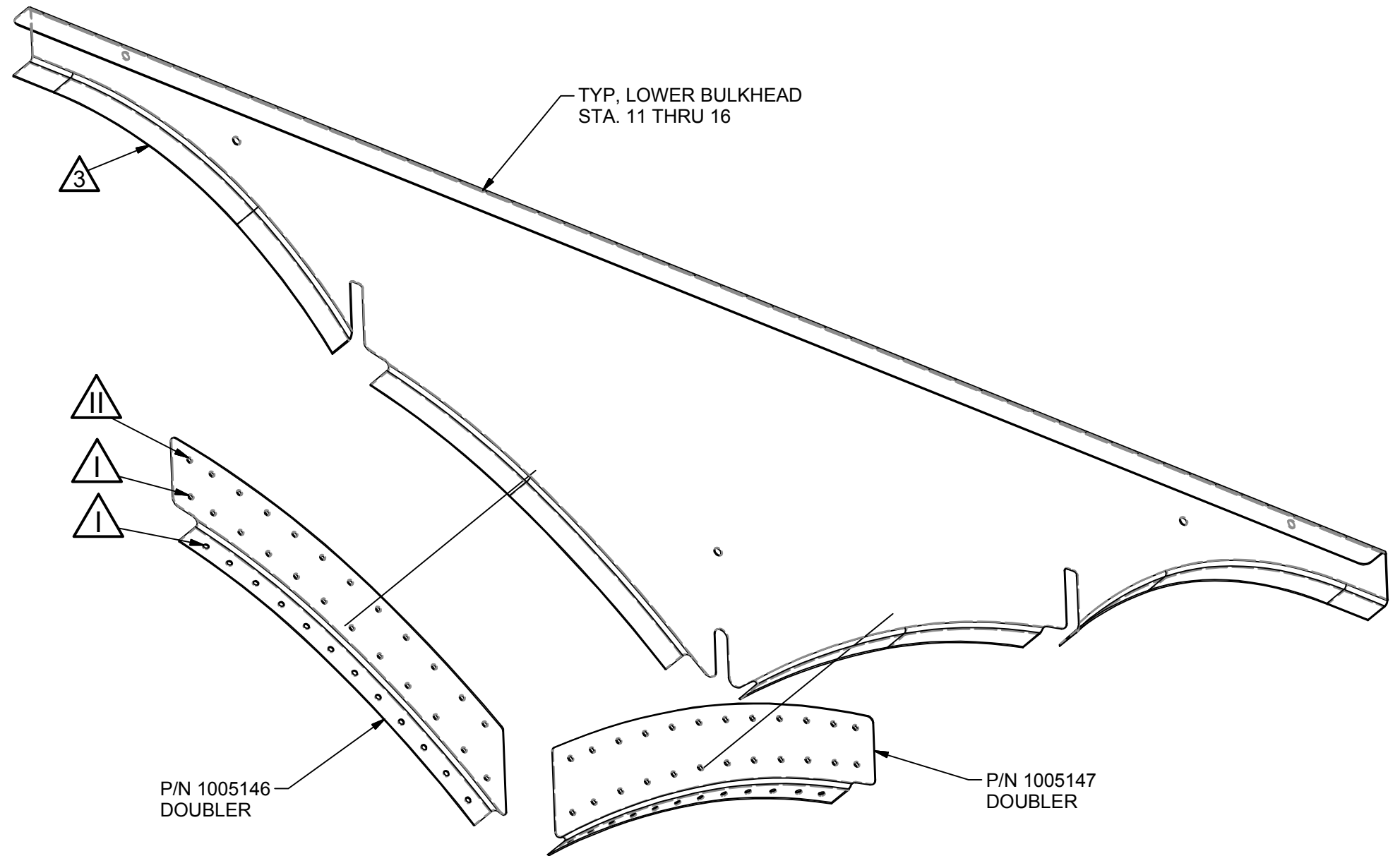
DEBURR ALL DRILLED RIVET HOLES IN BULKHEADS AND DOUBLERS.

C. ONE DOUBLER AT A TIME; APPLY SEALANT COMPLETELY TO MATING FACES OF DOUBLER, BULKHEAD, AND BOTTOM SKIN. THEN RIVET DOUBLERS 1005147 AND 1005146 TO LOWER BULKHEAD FLANGE AND BOTTOM SKIN USING MS20470AD4-4 RIVETS. PERFORM THIS OPERATION AT BOW BULKHEADS FROM STATIONS 11 TO 16. DRIVE RIVETS WHILE SEALANT IS WET. RIVET LENGTH MAY BE VARIED ONE DASH NUMBER AS REQUIRED.

D. WIPE AWAY EXCESS WET SEALANT AFTER RIVETING.

E. REPLACE BAGGAGE HATCH FLOORS AND REINSTALL TOP DECK COVERS WITH NEW SEALS.

REVISION HISTORY				
REV	DATE	ECO	DR	DESCRIPTION
A	4-OCT-11	22250	KMT	INITIAL RELEASE - SERVICE LETTER 125



MAT'L 2024-T3 DOUBLERS ON 6061-T6 BULKHEAD		WIPAIRE, INC. 1700 HENRY AVE. SOUTH ST. PAUL, MN 55075 (651) 451-1205				
FINISH N/A					TITLE MODEL 8000A/S, BOW BULKHEADS 11 TO 16, LOWER FLANGE REINFORCEMENT	
ALL DIMS IN INCHES & AFTER FINISH	THIRD ANGLE PROJECTION 	TOLERANCES .X= ±.05 .XX= ±.015 .XXX= ±.005 X' = ±.5'	SIZE B	SCALE NTS	PART NO. 1005526	REV A
		Sheet 1 of 1				