

SERVICE KIT: #47

DATE: January 27, 2005 **REV. A, August 3, 2005**

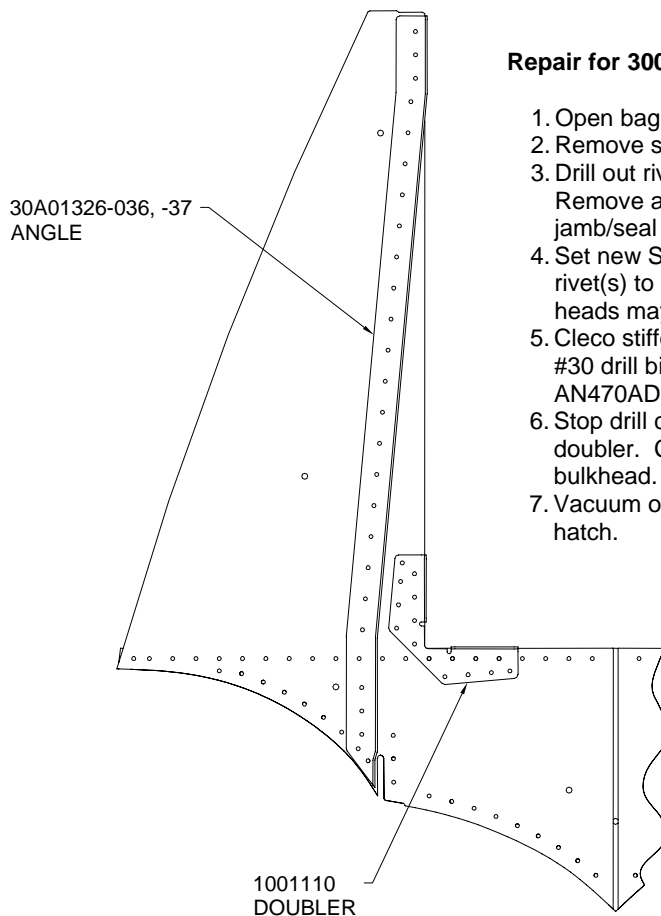
SUBJECT: Bulkhead Inspection and Repair

MODEL: All Model 3000 and 3450 Floats

INSTALLATION INSTRUCTIONS: See sketch below

PARTS LIST

<u>Part No.</u>	<u>Description</u>	<u>Qty</u>
1001110	DOUBLER – SUPPORT – RH/LH SIDE	4
30A01326-036	ANGLE – RH SIDE	2
30A01326-037	ANGLE – LH SIDE	2



Repair for 3000 & 3450 Floats (If cracks found in bulkhead)

1. Open baggage compartment hatch.
2. Remove screws from floor panel and remove panel.
3. Drill out rivets on upper & lower angles, 2 each side of bulkhead. Remove angles and discard. Flush head rivets may be hidden under jamb/seal retainer on upper angles.
4. Set new Support Angles in place to check for fit and identify which rivet(s) to drill out along horizontal row at bottom. Some existing rivet heads may need trimming to provide clearance from Support Angles.
5. Cleco stiffeners in place at top and bottom and back drill all holes to #30 drill bit. Remove stiffeners, deburr holes, install stiffener with AN470AD4 rivets.
6. Stop drill cracks in bulkhead. Drill out existing rivets in area of doubler. Cleco doubler to bulkhead, drill holes from doubler to bulkhead. Deburr and rivet doubler in place with AN470AD4 rivets.
7. Vacuum out compartment, re-install floor panel, close compartment hatch.