



- MANUFACTURERS OF WIPLINE FLOATS & SKIS
- SPECIALISTS IN AIRCRAFT MODIFICATION

1700 Henry Avenue - Fleming Field
South St. Paul, MN 55075
651-451-1205

SERVICE KIT: #52

DATE ISSUED: June 2, 2005 REV C (UPDATED 6-8-05)

SUBJECT: 802 Air Tractor Float Longeron and Float Bracket Repair with longer welded gusset.

MODEL: Floated AT-802 Air Tractors

INSTRUCTIONS:

Procedures for installing lengthened forward gusset (Wipaire p/n1001559).

1. Remove floats.
2. Drain fuel.
3. Remove fairings and fuel selector valve.
4. Remove fuel header tank and flap torque tube.
5. Plug all hoses and fuel openings, and clean and dry all fuel from the area.
6. Carefully cut opening in front fairing, install the doubler plate associated with this kit and drill the corresponding holes in the removed skin, creating a screw-on cover similar to that in Service Kit #51.
7. Remove Aluminum float attachment block.
8. Reshape the rear gusset as shown in Service Letter #71 if not already complied with.
9. Strip paint in all areas requiring welding or stress relieving.
10. Fill fuel tanks or provide other means of safety for welding near fuel tanks.
11. Weld in longer front gusset, as shown in Fig. 2, Area 1 (Wipaire p/n 1001559, Air Tractor p/n SK574-2 or customer fabricated), included with this kit as per Air Tractor instructions included with Service Letter 71 and in compliance with AC 43.13. Use steel spacers in attach plate during welding and stress relieving to retain alignment and shape.
12. Stress-relieve areas at end of the gusset and welded areas as per Air Tractor instructions (see Service Letter 71).
13. Clean, prime and paint areas that have been stripped or where the paint has been chipped or damaged.
14. Reassemble aircraft including grommet for fuel hose that is routed through the new gusset.

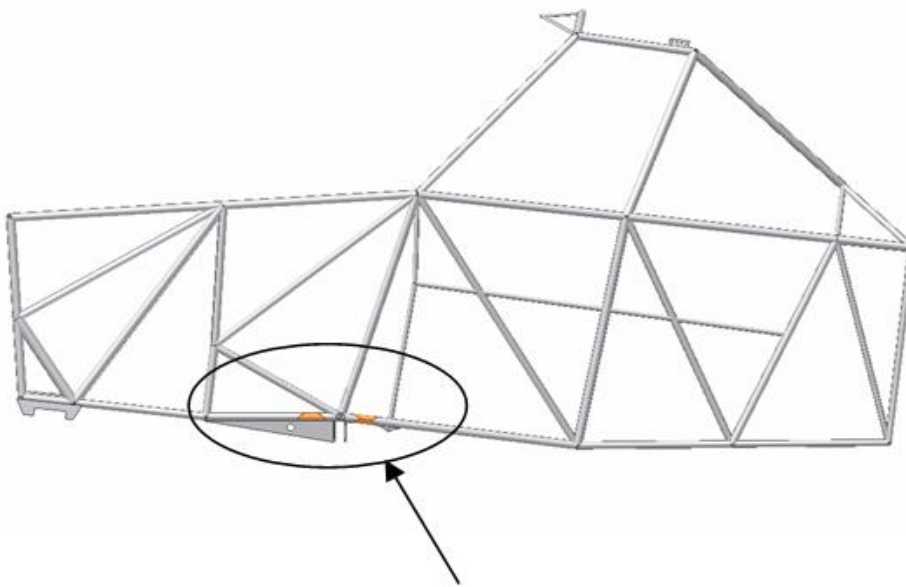
NOTE

**If sleeve (Figure 2, Item 5) was not installed at the time
Of gusset installation the aircraft may be safely flown
without it. It may be added post fire season.**

Accomplish all welding and stress relieving as per included instructions
from Air Tractor in Service Letter 71 and AC 43.13.

NOTE:

**The hole provided in the gusset may need to be expanded
to accommodate the fuel line.**



Affected Area

Figure 1

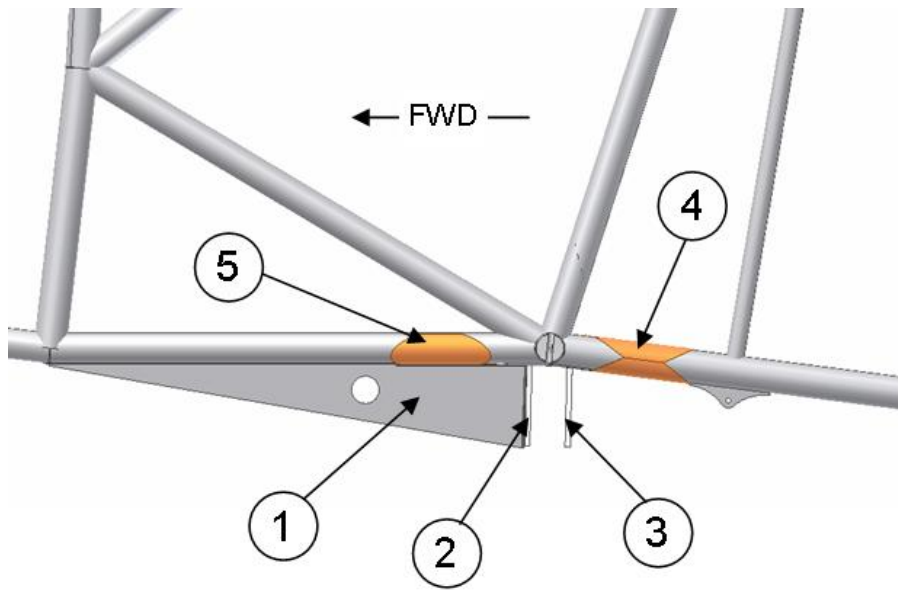


Figure 2

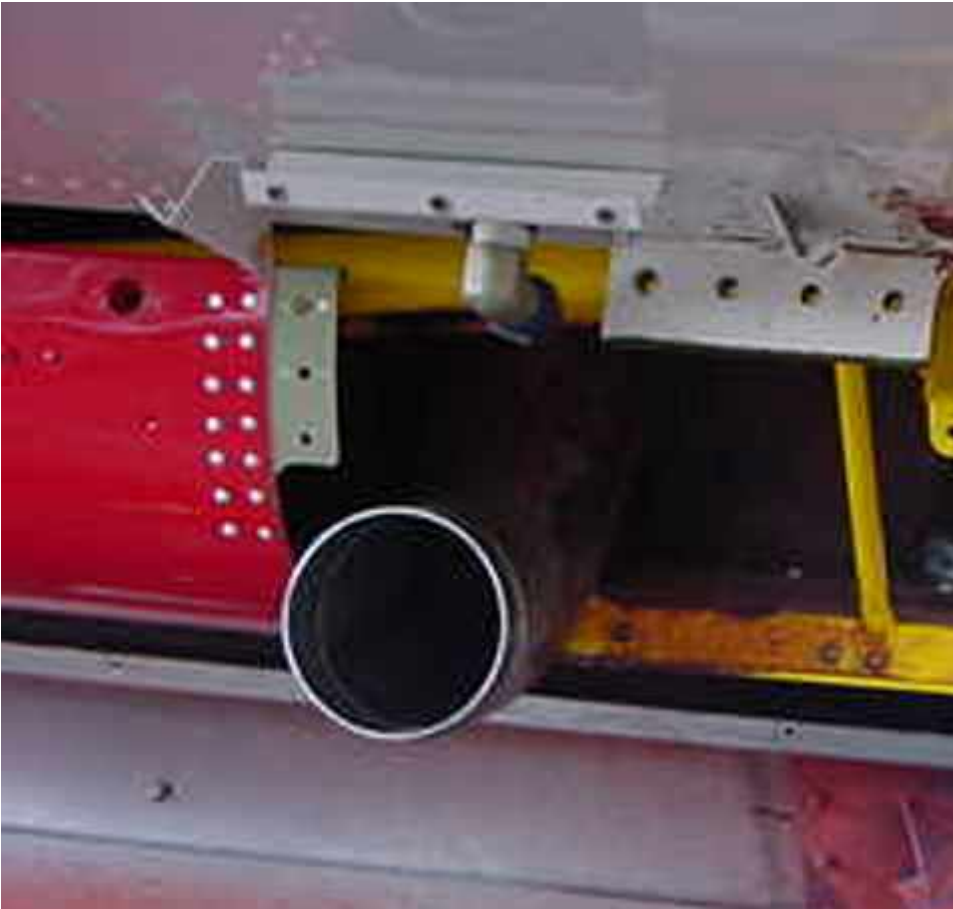
Image #1

Full view of access panels created for Service Kit # 51 and #52

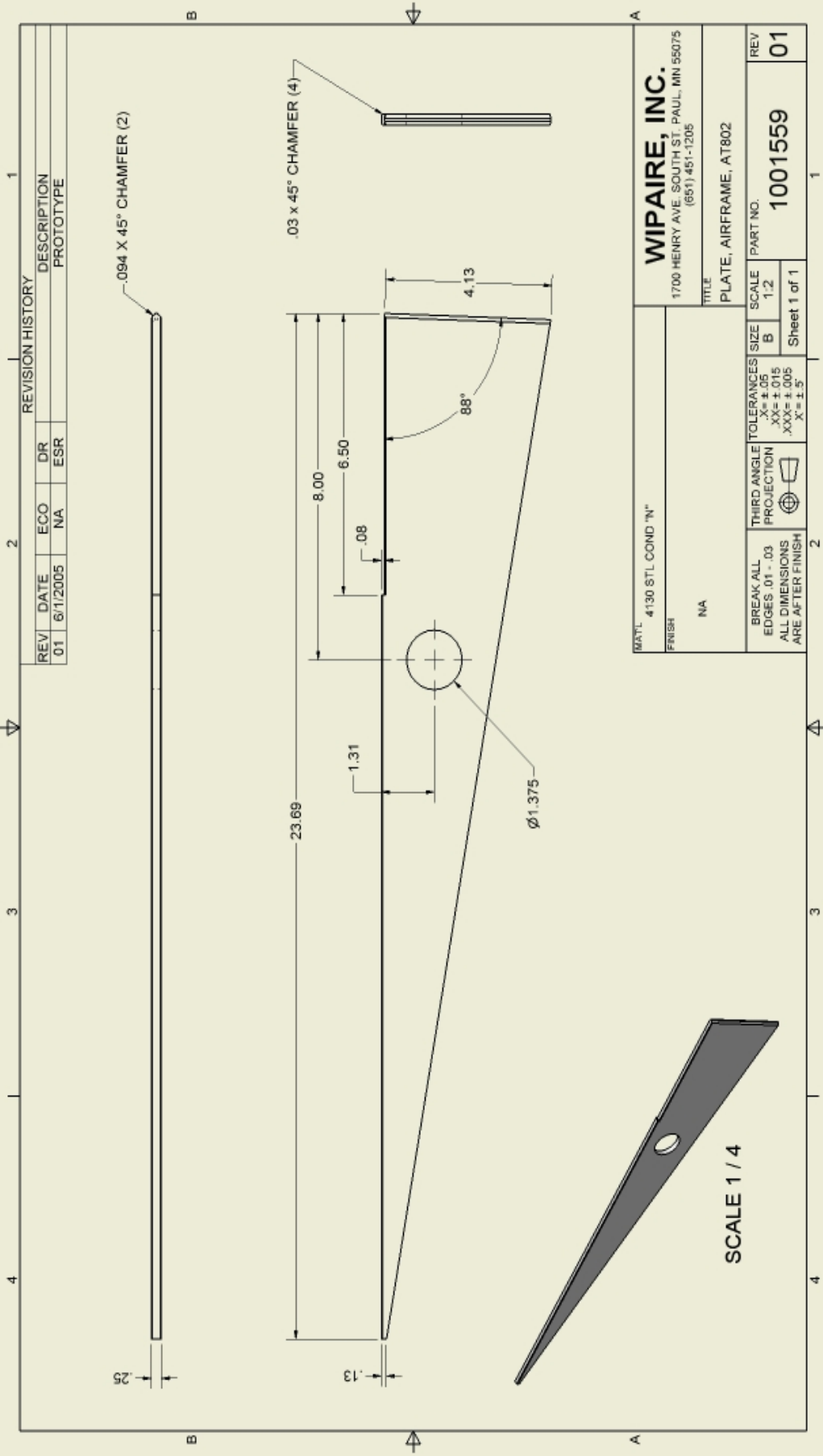


Image #2

Close-up of access panel and doubler modification for Service Kit #52.



REV		DATE		ECO		DR		DESCRIPTION	
01	6/1/2005	NA	ESR	NA	ESR	PROTOTYPE			



MATERIAL: 4130 STL COND "N"		FINISH: NA		TOLERANCES: X = ±.05 XX = ±.015 XXX = ±.005 X' = ±.5		THIRD ANGLE PROJECTION		SCALE: 1:2		PART NO: 1001559		REV: 01	
TITLE: PLATE, AIRFRAME, AT802				WIPAIRE, INC. 1700 HENRY AVE. SOUTH ST. PAUL, MN 55075 (651) 451-1205				Sheet 1 of 1					