



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

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

SERVICE KIT: #55

DATE: October 5, 2005

SUBJECT: Fireboss Finlet-Bracket Field Repair

MODEL: AT-802 w/ Fireboss conversion

INSTRUCTIONS:

If cracks or corrosion from inspection required in Service Letter 76 is longer than .6 centimeters (1/4 inch), field replacement of the bracket will be necessary.

Procedures are as follows:

1. Remove fiberglass tip (Item 1) and remove rib (Item 2).
2. Remove rivets on ribs (Items 3 & 5) and bracket (Item 4). Remove ribs and bracket assembly from the finlet.
3. Remove rivets that attach bracket (Item 4) to rib (Item 3). Remove angle piece (Item 6) and remove original bracket (Item 4) and discard.
4. Cleco ribs (Items 3 & 5) in finlet and put new bracket (Item 4) in place but do not drill bracket at this time.
5. Bolt finlet and new bracket (Item 4) to the tail of the aircraft, making use of the tail As a jig.
6. Match drill holes thru skin (Item 10), creating holes on new bracket (Item 4) on each side.
7. Cleco holes thru skin (Item 10) and bracket (Item 4) and remove finlet from plane.
8. Match drill holes in angle (Item 6) thru bracket (Item 4).
9. Secure bracket (Item 4) to rib (Item 3) with a C-clamp to maintain correct position of the bracket & rib.
10. Remove ribs (Item 3 & 5) and bracket assembly. Match drill holes thru rib (Item 3) to bracket (Item 4).
11. Remove rivets (Item 3) that attach forward section of rib (Item 5) to rib (Item 3) in order to gain access for bucking rivets.
12. De-burr all parts and touch up with primer.
13. Rivet bracket (Item 4) to rib (Item 3) with AN470-4 rivets.
14. Install rib (Item 3) and bracket assembly (Item 4) in finlet and rivet in place with AN470 rivets. Size and length of rivets may vary slightly.
15. Rivet forward section of rib (Item 5) to rib (Item 3) using AN470 rivets.
16. Install rib (Item 5) and angle (Item 6) and rivet in place using AN470 rivets.
17. Install rib (Item 2) and rivet to ribs (Item 3, 8, 9) using AN470 rivets.
18. Install and rivet tip (Item 1) with included pop rivets and seal with silicone. Pop Rivets included come in 2 different lengths. The longer ones are for The holes that connect the fiberglass tip (Item 1) to the three ribs. The shorter Are for all the other holes that connect the tip onto the finlet.



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MAN HOURS REQUIRED: Bracket replacement - 5 hours per finlet.

WARRANTY: Parts only unless under the 1 year warranty period.

PARTS REQUIRED: Parts included.

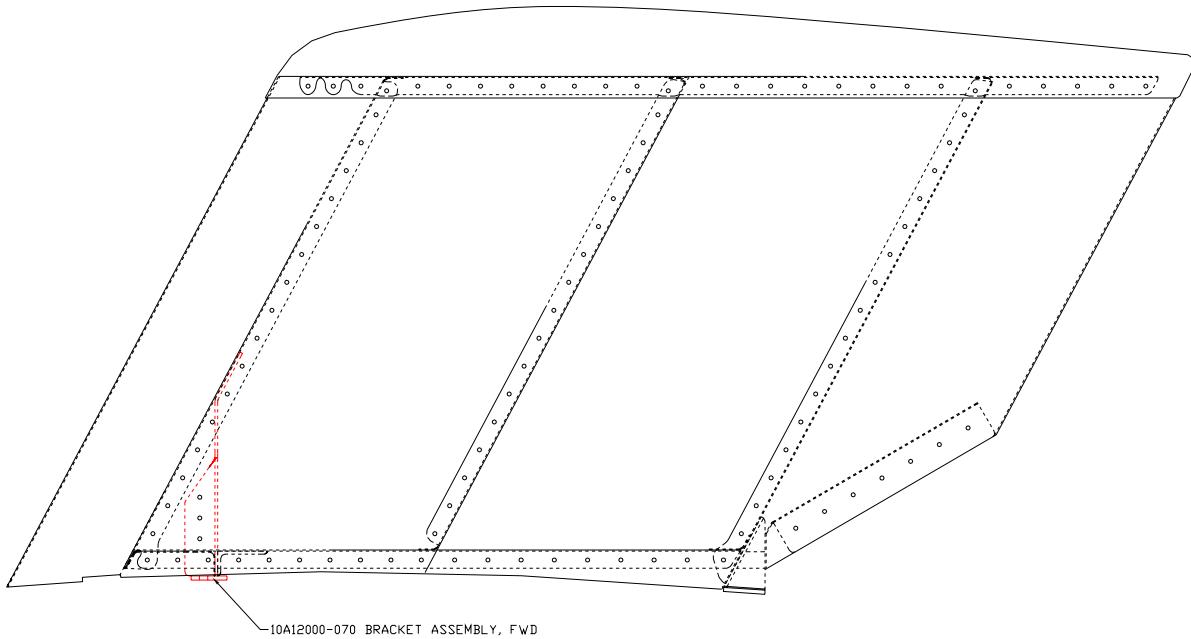
Parts List

1	p/n 10A12000-070	Bracket Assembly, Fwd
8	p/n 1692-0414-4-4	Longer Pop Rivets
50	p/n 1692-0414-4-3	Shorter Pop Rivets



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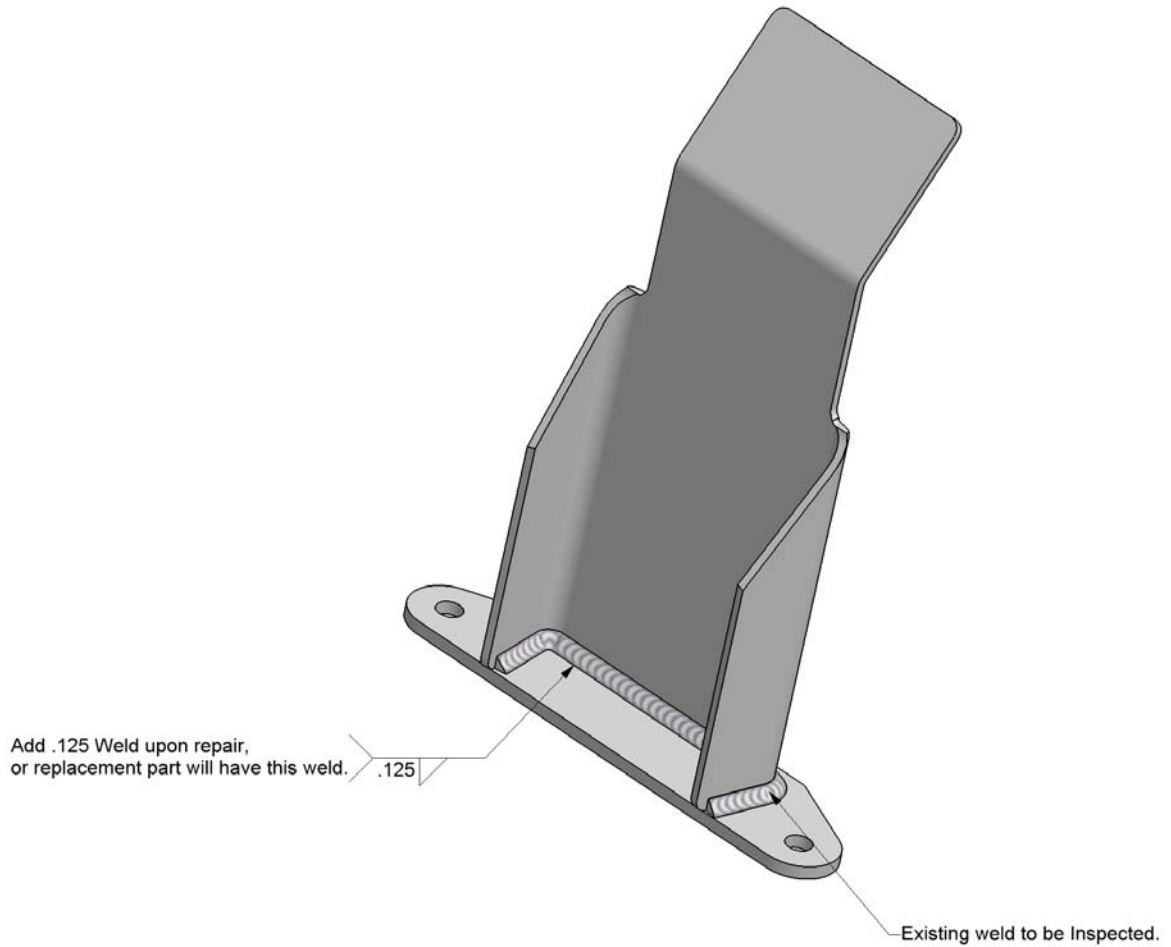
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