



SERVICE LETTER NUMBER 137			
TITLE: INSTALLATION OF ANGLE REINFORCEMENT ON MODEL 7000 AFT BULKHEAD			
BY: D. Smith	AIRCRAFT MAKE/MODEL(S):	FLOAT MODEL(S):	NOTE(S):
APP: D. Garrett	Quest Kodiak 100	7000 Amphibian	OPTIONAL COMPLIANCE
DATE: 11/19/13			S/L P/N 1005839
REV: A			ECO--22949

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 Wipline model 7000 amphibious floats prior to serial number 70033A, as installed on Quest Kodiak 100 aircraft equipped with STC SA02848CH.

COMPLIANCE:

Service letter compliance is optional.

BACKGROUND:

P/N 1003229 is a doubler for the water rudder pivot block, and also helps reinforce the stern bulkhead. Certain hulls have exhibited buckling of the forward flange on P/N 1003229 during normal operations. The buckling behavior of this particular structure is not critical and does not affect airworthiness of the seaplane. This service letter and associated kit reinforce the flanges of P/N 1003229; two angles are added to the flanges of the doubler, to increase the buckling strength of the subject flange.

COMPLIANCE METHOD:

Install the parts listed in this service letter in accordance with the instructions in the Technical Data section of this service letter.

WARRANTY INFORMATION:

Parts and labor warranty is not included for this modification.

APPROXIMATE SHOP HOURS:

This service letter will take approximately 10 labor hours to complete.

TECHNICAL DATA AND INSTRUCTIONS:

Modification of this structure is defined by drawing 1005860.

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

See table 1 below for a list of parts and materials applicable to this modification.

For basic model 7000 maintenance information, see Wipaire Service Manual P/N 1004646.

For basic model 7000 parts information, see Wipaire Parts Manual P/N 1005250.

To accomplish this modification:

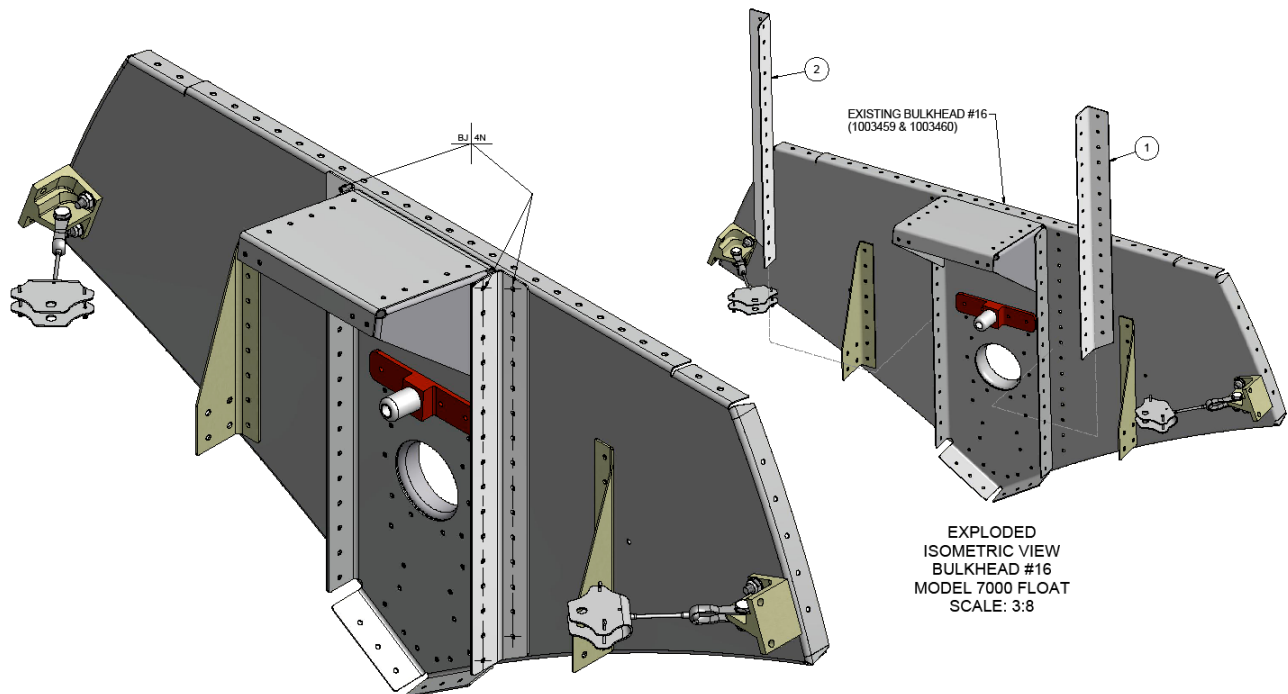
1. See image below.
2. Open aft most top deck cover to gain access to the forward face of the stern bulkhead.
3. If the flanges of P/N 1003229 are buckled or deformed, hand form them back into position using duckbill pliers or other sheet metal forming tools. Be sure not to penetrate the surface finish with pliers as to help prevent future corrosion.
4. Position the angles, one at a time, against the flange of the doubler.
5. Match drill the doubler flanges and stern bulkhead from the angle using a #30 drill bit. (see drawing).
6. Remove angles, deburr all drill holes, and touch up any exposed surfaces with primer.
7. Rivet angles to the doubler flange and the stern bulkhead. Parts should be riveted wet with adhesive/sealant (see Maintenance Manual 1004646 for adhesive/sealant type).
8. After riveting, touch up rivet heads with primer to help prevent corrosion.
9. Replace and seal stern top deck cover.

Table 1 – list of modification parts

QTY	P/N	Description
2	1005858	ANGLE, SUPPORT, WATER RUDDER DOUBLER
2	1005859	ANGLE, SUPPORT, WATER RUDDER DOUBLER
AR	MS20470AD4	RIVET

NOTES:

After completion of the instructions in this service letter, make an entry in the aircraft logbook in accordance with your local Civil Aviation regulations. Weight and balance is not materially affected by installation of the reinforcing angles.



END