



WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES
 AVIONICS • INTERIOR • MAINTENANCE • PAINT REFINISHING

SERVICE LETTER 47

HINGED ACCESS DOORS AND BAGGAGE BAY FLOOR INSTALLATION

By: MAS	Aircraft Makes/Model(s): DeHavilland DHC-6 Series	Float Model(s): 13000 Series	Note(s): Optional Compliance Service Letter P/N 1002425
Approved: DRH			
Date: 2/20/2023			
Rev: C			

LOG OF REVISIONS

Revision	Description	Date
A	Initial Release	10/10/2000
B	Updated kit for doors and baggage Floors, converted 7B1-4202 to 1002512.	7/15/2010
C	Updated title and format. Merged Service Kit 30 into Service Letter 47. Created Kit 1002425-01. Changed Cross Tie, Top Deck 1003425 to 1012317 in BOM list. Updated images and work instructions, and logbook note.	2/20/2023

FAA approval has been obtained for technical data in this publication that affects STC or TSO design compliance

EFFECTIVITY:

This service letter applies to: DeHavilland DHC-6 Series Twin Otter with Wipline 13000 Amphibious or Straight Floats with fixed access covers installed per STC SA2CH.

COMPLIANCE:

Optional compliance

BACKGROUND:

This service kit provides parts to replace the original fixed access covers with hinged baggage doors located on the top deck and install baggage bay floors.

COMPLIANCE METHOD:

Install the parts included in this service kit in accordance with the Work Instruction section of this service letter.

APPROXIMATE SHOP HOURS:

Installing the hinged access covers and baggage bay floors will take approximately 10 hours per float.

WARRANTY INFORMATION:

Labor and parts not included for this modification.

TECHNICAL DATA:

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

1700 Henry Ave - Fleming Field (KSGS), South St. Paul, MN 55075

Phone: 651.451.1205 | Fax: 651.457.7858

www.wipaire.com



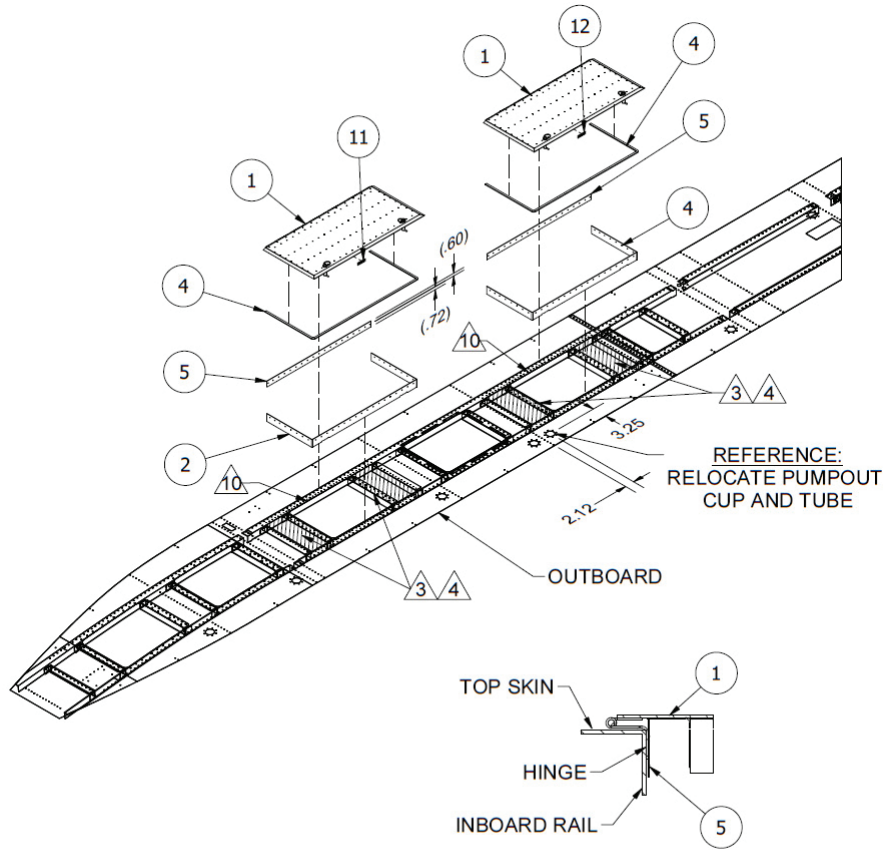
WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES
 AVIONICS • INTERIOR • MAINTENANCE • PAINT REFINISHING

ITEMS PROVIDED IN SERVICE KIT 1002425-01 (PER SET OF FLOATS)

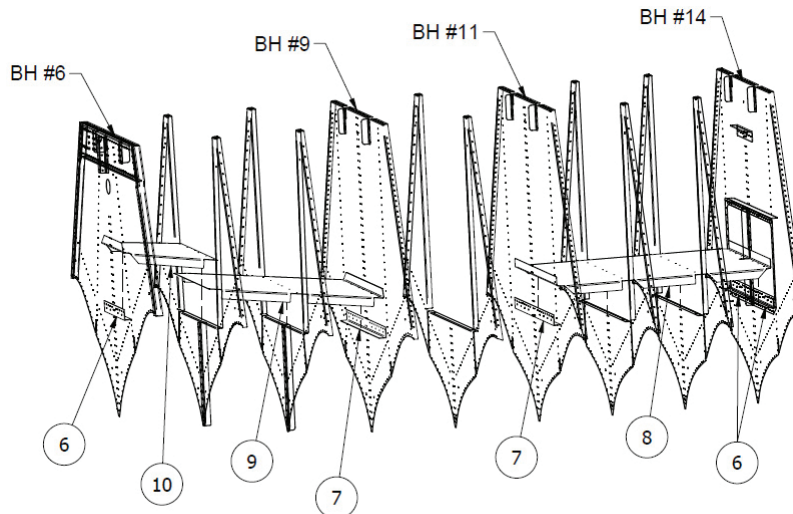
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	10A01000-464	ASSEMBLY, DOOR, BAGGAGE BAY
2	4	13A01162-052	BAGGAGE LIP
3	8	1012317	CROSS TIE, TOP DECK
4	28 FT	1009671	GASKET, DOOR
5	4	1002063	BAGGAGE LIP
6	6	1003672	ANGLE
7	4	1003673	ANGLE
8	2	1003675	PANEL
9	2	1003676	PANEL
10	2	1003677	PANEL
11	2	7A3-4205-1	PLACARD
12	2	7A3-4205-2	PLACARD
13	1	1004518	TEMPLATE
14	1	1004519	TEMPLATE
15	2	1005911	PUMPER TUBE
16	4	MS35489-19	GROMMET
17	92	SSTATP	FLOOR SCREW
18	36	CR3213-5-5	CHERRY MAX RIVET
19	12	CR3213-5-6	CHERRY MAX RIVET



WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES
 AVIONICS • INTERIOR • MAINTENANCE • PAINT REFINISHING



REFERENCE : HINGE TO SIDERAIL
 SCALE 3 / 8



BULKHEAD REFERENCE



WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES
 AVIONICS • INTERIOR • MAINTENANCE • PAINT REFINISHING

WORK INSTRUCTION

1. Drill out #1, 2, 3, 4 cross ties and remove from top skin. (In addition to the #5 rivets that attach the cross ties to the top skin. There are also #5 rivets that attach the cross ties to the top rail (inside the float compartment).
2. Cleco templates to top skin items 13 and 14, (making sure that the forward and inboard side are in the correct direction).
3. Mark cut lines onto top skin.
4. Cut, file, deburr baggage area. (Relocate pumpout cup noted).
5. Install cross ties in new locations. Forward compartments use old cross ties that were drilled out. Aft compartments use old cross ties on forward edge and new cross ties on aft edge.
6. All cross ties use a 3/4" rivet spacing (the forward two cross ties must be interspaced with existing rivet holes) and #4 flush rivets.
7. Attach cross ties to the top rails with #5 rivets. Three rivets through existing cross tie flanges.
8. Where the existing cross ties were removed, fill holes in top rail with #5 flush rivets.
9. Install baggage lips items 2 and 5. Open side of item 2 faces inboard. Place lip seals such that a 1/4" remains above the top skin.
10. Bevel inboard edge of baggage openings to accept baggage cover hinge.
11. Install baggage covers by clamping in place on the inboard baggage edge, drill with #30 drill, deburr, seal contact area, and rivet in place with #4 round head rivets.
12. Grind baggage cover lock catch. (Follow pattern that is in baggage flange).
13. Seal around baggage flange.
14. Install foam seal around baggage flange. (This seal will run around all three sides of baggage flange, starting at the hinge and ending at the hinge). Add seal to door 3 sides.
15. Install baggage placards item 11 and 12.

Weight & Balance			
Item	Weight	Arm	Moment
Baggage Doors - FWD (2)	3.95	123	485
Baggage Doors - AFT (2)	3.95	183	722
Baggage Floor - FWD (2)	1.45	112	162
Baggage Floor - FWD (2)	3.25	130	423
Baggage Floor - AFT (2)	4.15	182	755
Total	16.75	730	2547

NOTES:

1. Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire Service Letter 47.