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## SERVICE LETTER 47

### HINGED ACCESS DOORS AND BAGGAGE BAY FLOOR INSTALLATION

|                        |   |  |  |
|------------------------|---|--|--|
| <b>By:</b> MAS         | <b>Aircraft Makes/Model(s):</b><br>DeHavilland DHC-6 Series | <b>Float Model(s):</b><br>13000 Series | <b>Note(s):</b><br>Optional Compliance<br>Service Letter P/N 1002425 |
| <b>Approved:</b> DRH   |   |  |  |
| <b>Date:</b> 5/23/2024 |   |  |  |
| <b>Rev:</b> D          |   |  |  |

### 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  |
| D        | Updated Approximate Shop Hours section.   | 5/23/2024  |

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 50 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](http://www.wipaire.com).

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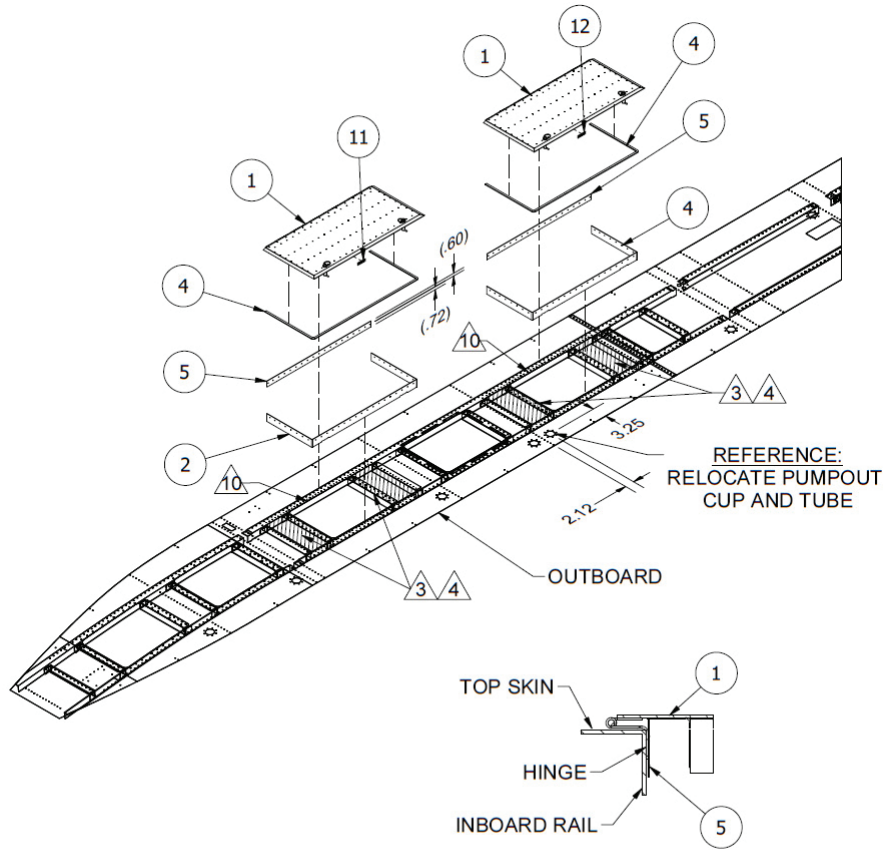
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**ITEMS PROVIDED IN SERVICE KIT 1002425-01 (PER SET OF FLOATS)**

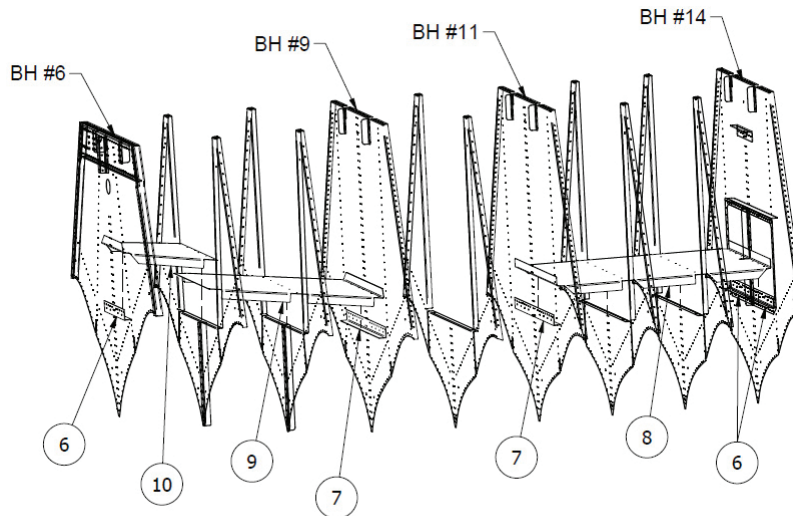
| ITEM | QTY   | PART NUMBER  | DESCRIPTION                 |
|------|-------|--------------|-----------------------------|
| 1    | 4     | 10A01000-464 | ASSEMBLY, DOOR, BAGGAGE BAY |
| 2    | 4     | 13A01162-052 | BAGGAGE LIP                 |
| 3    | 8     | 1012317      | CROSS TIE, TOP DECK         |
| 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            |



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REFERENCE : HINGE TO SIDERAIL  
 SCALE 3 / 8



BULKHEAD REFERENCE



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## 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.

| <b>Weight &amp; Balance</b> |               |            |               |
|-----------------------------|---------------|------------|---------------|
| <b>Item</b>                 | <b>Weight</b> | <b>Arm</b> | <b>Moment</b> |
| 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           |
| <b>Total</b>                | <b>16.75</b>  | <b>730</b> | <b>2547</b>   |

**NOTES:**

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