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SERVICE LETTER 257

13000 Straight Float Keel Wear Strip

Aircraft Makes/Model(s):	Float Model(s):	Compliance: Optional	By: MAS
DeHavilland DHC-6	13000S	Part Number: 1012398	Approved: DRH
		Date: 5/23/2024	Revision: B

LOG OF REVISIONS

Revision	Description	Date
A	Initial release	10/11/2023
B	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 model DHC-6 Twin Otter aircraft equipped with Wipline 13000 Seaplane (Straight) Floats per STC SA2CH.

COMPLIANCE:

Compliance is optional.

BACKGROUND:

Keel wear strips are standard on amphibious 13000 floats to preserve the keel in the event of a gear up runway landing, but are not standard on 13000 straight floats. They may however be desired as a sacrificial layer for anticipated wear that may be incurred during operation (beaching, for example).

COMPLIANCE METHOD:

Install keel wear strip as described in the work instruction section of this letter.

APPROXIMATE SHOP HOURS:

Performing the work instruction will take approximately 25 labor hours to complete per float set.

WARRANTY INFORMATION:

This service letter does not include warranty for labor and parts.

TECHNICAL DATA:

Copies of this service letter, associated service kit (if applicable), float service manual, and float parts manual are available by contacting Wipaire customer service.

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ITEMS PROVIDED IN SERVICE KIT 1012398-01 (1 KIT PER AIRCRAFT)			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1012278	WEAR STRIP, 13000S
2	2	1012223	SPLICE, WEAR STRIP, MAIN KEEL, 13000S
3	24	AN3-6A	BOLT, #10-32, 25/32" LG
4	24	NAS1149D0316J	WASHER, ALUMINUM, #10, 0.016" THK
5	24	NAS1149D0363J	WASHER, ALUMINUM, #10, 0.063" THK
6	24	MS21044N3	NUT, LOCKING, #10

Work Instructions

1. Position and prepare floats/aircraft for safe maintenance. If floats are installed on airframe, an overhead hoist will be required.
 2. Drill out existing flush rivets in keel area where 1012223 splice will go.
 3. Cut keel at step bulkhead, taking care not to cut into skeg or keel gusset flanges. Cut will need to be rounded at bottom edge of keel for tight mate with 1012223 splice piece. See detail in Figure 1.
 4. Position 1012223 splice. Drill rivet holes through splice using existing holes that are in keel and skag, countersink.
 5. Temporarily fasten (cleco) 1012223 splice. Match drill fwd fastener location through keel and temporarily fasten that location.
 6. Butt/lap 1012278 wear strip up against 1012223 splice piece. Match drill (11) locations through float keel.
- Note:** 1012278 wear strip is not symmetrical. Angled cut at aft end of 1012278 wear strip is meant to lap over 1012223 splice.
7. Wet install 1012223 splice piece. Rivet with MS20426AD6 rivets and fasten at forward end with (1) each of: AN3-6A, NAS1149D0316J (head side), NAS1149D0363J (nut side), MS21044N3.
 8. Wet install wear strip and fasten with (11) each of: AN3-6A, NAS1149D0316J (head side), NAS1149D0363J (nut side), MS21044N3.
 9. Finish (prep/prime/paint as needed) to match.

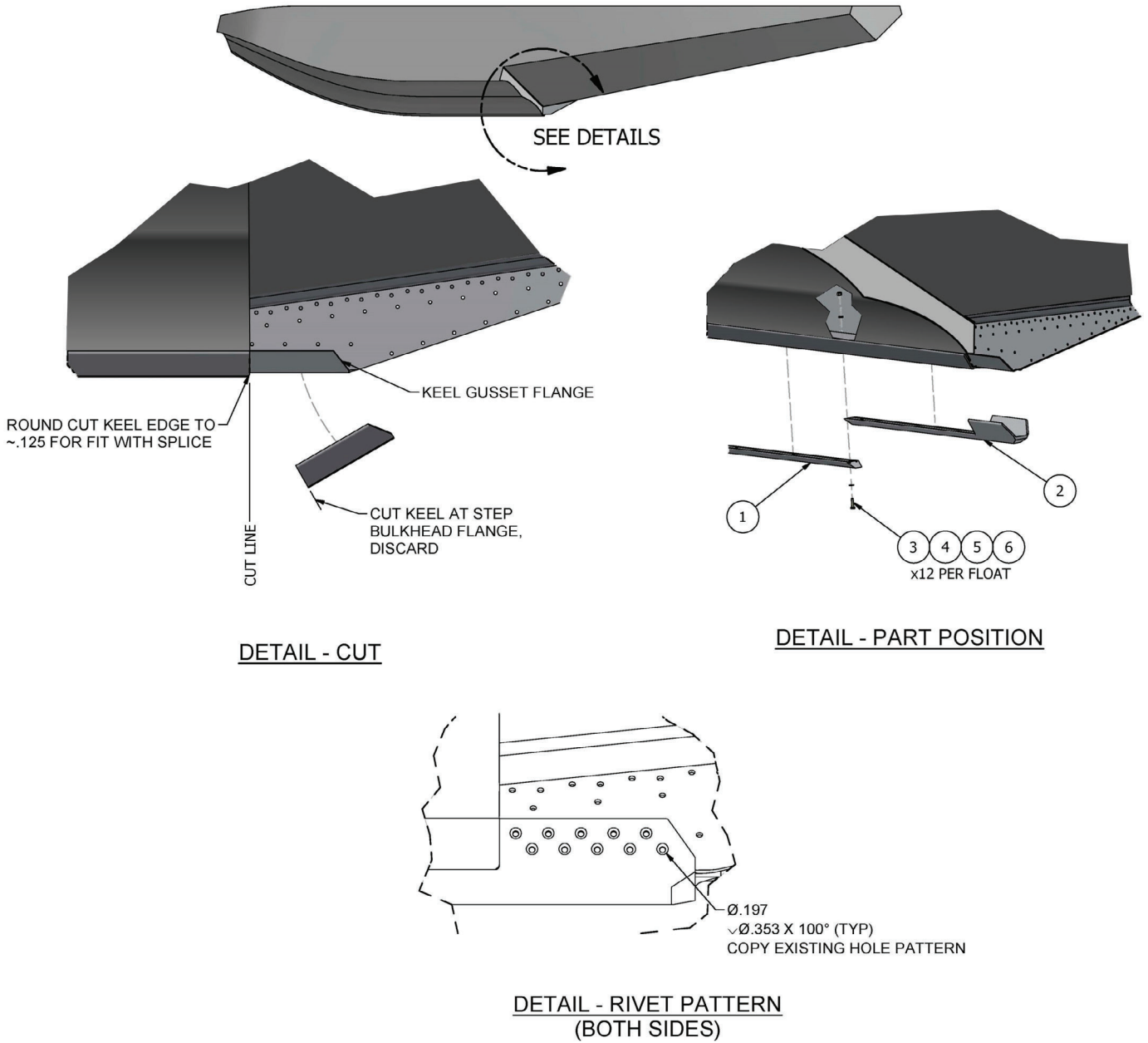


Figure 1

Aircraft Closing & Return to Service

1. Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire Service Letter 257.