

WIPAIRE INC.
INVER GROVE HTS., MN.

DATE: December 22, 1992

SERVICE KIT: # 10

SUBJECT: Reinforcement of Model 4000 float hull bulkheads

MODEL: 4000 Amphibian/Seaplane Floats

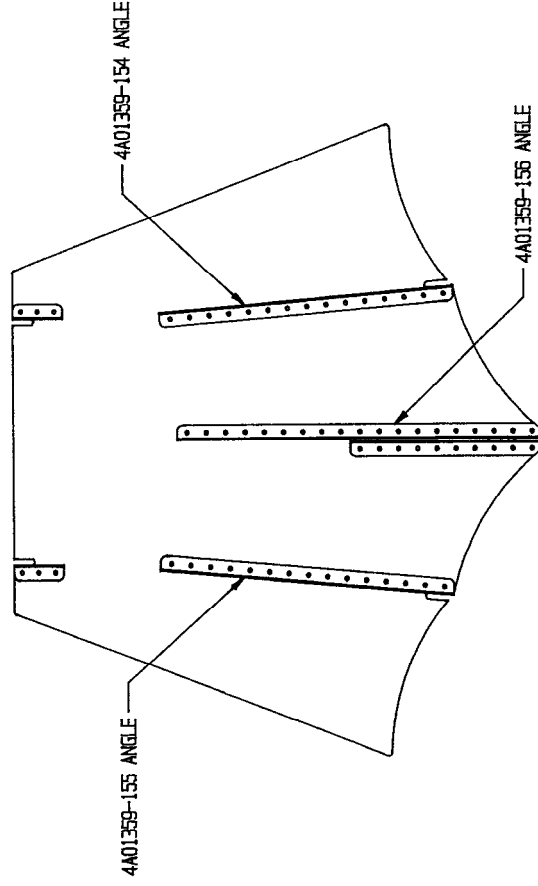
<u>ITEM</u>	<u>QTY</u> <u>PER SET</u>	<u>PART NO</u>	<u>DESCRIPTION</u>
1.	2	4A01359-096	angle
2.	4	4A01005-228	gusset
3.	2	4A01359-154	angle
4.	2	4A01359-155	angle
5.	2	4A01359-156	angle
6.	2	4A01359-158	angle
7.	2	4A01359-159	angle
8.	4	4A01359-160	angle
9.	2	4A01359-161	angle
10.	2	6A01359-011	angle
11.	2	4A01359-097	angle
12.	4	6A01008-014	angle
13.	4	6A01008-015	angle
14.	1	SHT 1	drawing
15.	1	SHT 2	drawing
16.	1	SHT 3	drawing
17.	1	SHT 4	drawing
18.	1	SHT 5	drawing
19.	1	SHT 6	drawing
20.	1	NO. 25	Service Letter

NOTES: Install above parts as shown and per installation instructions on drawings.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. LOCATE 4A01359-156 ANGLE ADJACENT TO EXISTING ANGLE. MARK #10 DIA. HOLE FROM EXISTING ANGLE TO NEW ANGLE. DRILL #10 DIA. HOLE IN 4A01359-156 ANGLE. MATCH DRILL (.18) #30, #21 DIA. HOLES FROM ANGLE THRU BULKHEAD. RIVET TO BULKHEAD WITH AN470AD4, AN470AD5, AN470AD5.5 RIVETS.
3. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.
4. DRILL OUT 3" LONG ANGLE AT BOTH SISTER KEELS.
5. LOCATE 4A01359-155 AND -154 ANGLE OVER EXISTING HOLES FROM 3" ANGLE. MATCH DRILL (.11) #30, #21 DIA. HOLES FROM 4A01359-155 & -154 THRU BULKHEAD. SECURE ANGLES TO BULKHEAD WITH AN470AD4, AN470AD5, AN470AD5.5 RIVETS.
6. MATCH DRILL #21 DIA. HOLES FROM SISTER KEEL THRU -155 AND -154 ANGLES, SECURE WITH AN470AD5 RIVETS.

NOTE:
SEAL BETWEEN ALL ANGLES BEFORE RIVETING .



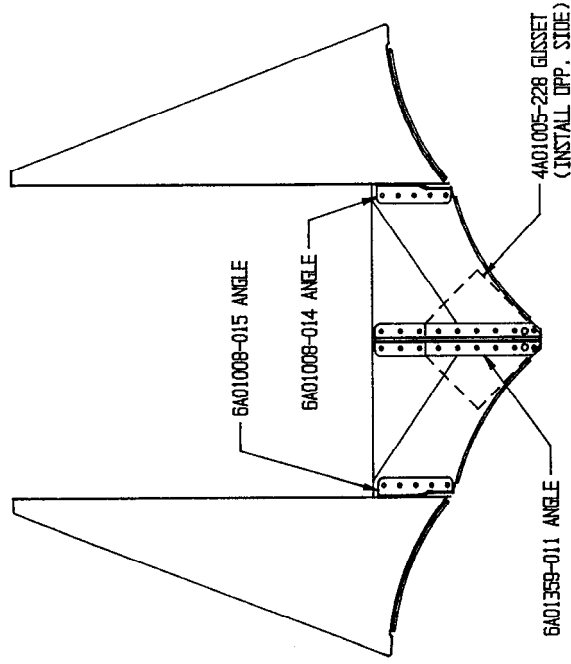
MODIFICATION TO #3 BULKHEAD

SHEET 1

REV.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. LOCATE 6A01359-011 ANGLE ADJACENT TO EXISTING ANGLE. MARK #10 DIA. HOLE FROM EXISTING ANGLE TO NEW ANGLE. DRILL #10 DIA. HOLE IN 6A01359-011 ANGLE, MATCH DRILL (9) #30 DIA. HOLES FROM ANGLE THRU BULKHEAD.
3. LOCATE 4A01005-228 GUSSET ON OPPOSITE SIDE OF BULKHEAD. DRILL OUT EXISTING RIVETS IN BULKHEAD UNDER GUSSET SO AS TO FIT FLAT TO BULKHEAD. LOCATE GUSSET APPROX. AS SHOWN AND MATCH DRILL #30 DIA HOLE FROM BULKHEAD THRU GUSSET.
4. RIVET 4A01005-228 GUSSET AND 6A01359-011 ANGLE TO BULKHEAD WITH AN470A04 RIVETS.
5. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.
6. DRILL OUT EXISTING RIVETS HOLDING BULKHEAD TO SISTER KEEL.
7. LOCATE 6A01008-014 AND -015 ANGLE TO SISTER KEEL, MATCH DRILL #30 DIA. HOLES (9) FROM ANGLES TO BULKHEAD. SECURE WITH AN470A04 RIVETS.
8. MATCH DRILL #21 DIA. HOLE FROM SISTER KEEL THRU ANGLE. SECURE WITH AN470A05 RIVETS.



MODIFICATION TO #4 BULKHEAD

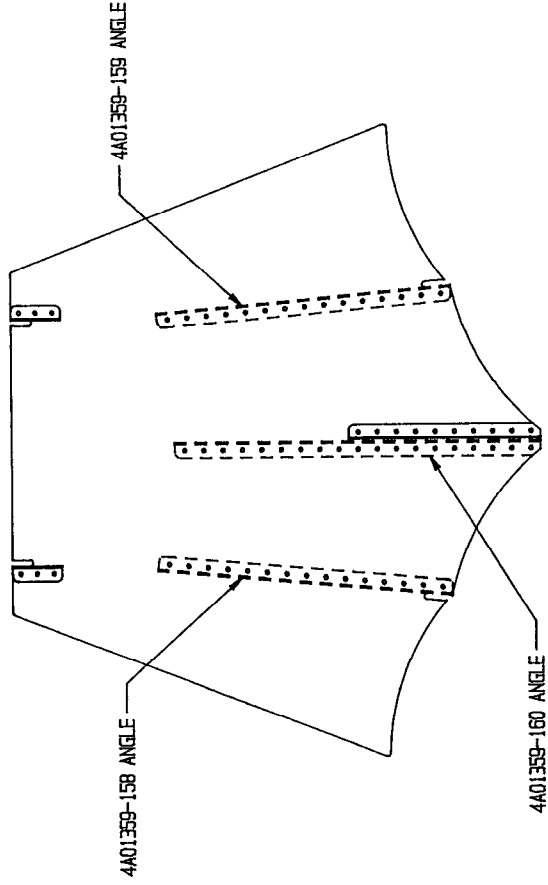
SHEET 2

REV.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. LOCATE 4401359-160 ANGLE ADJACENT TO EXISTING ANGLE. MARK #10 DIA. HOLE FROM EXISTING ANGLE TO NEW ANGLE. DRILL #10 DIA. HOLE IN 4401359-160 ANGLE, MATCH DRILL (.27) #30 DIA. HOLES FROM ANGLE THRU BULKHEAD. RIVET TO BULKHEAD WITH AN470A04 RIVETS.
3. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.
4. DRILL OUT 3" LONG ANGLE AT BOTH SISTER KEELS.
5. LOCATE 4401359-158 AND -159 ANGLE OVER EXISTING HOLES FROM 3" ANGLE. MATCH DRILL #30 DIA. HOLES (14) FROM 4401359-158 & -159 THRU BULKHEAD. SECURE ANGLES TO BULKHEAD WITH AN470A04 RIVETS.
6. MATCH DRILL #21 DIA. HOLES FROM SISTER KEEL THRU -158 AND -159 ANGLES, SECURE WITH AN470A05 RIVETS.

NOTE:
SEAL BETWEEN ALL ANGLES BEFORE RIVETING .



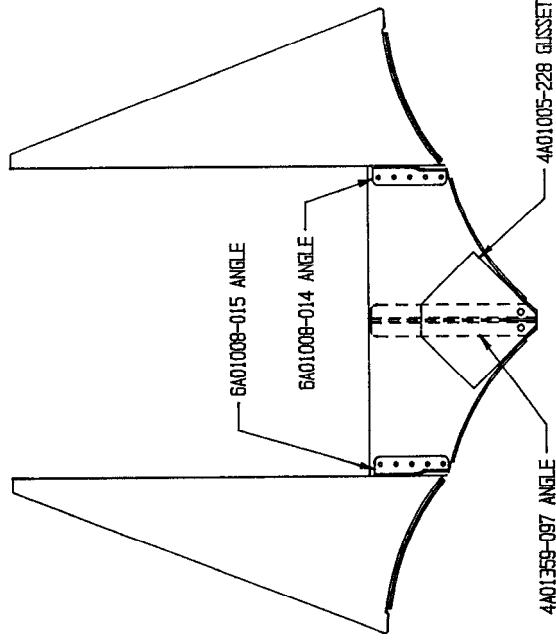
MODIFICATION TO #5 BULKHEAD

SHEET 3

REV.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. LOCATE 6A01359-097 ANGLE ADJACENT TO EXISTING ANGLE. MARK #10 DIA. HOLE FROM EXISTING ANGLE TO NEW ANGLE. DRILL #10 DIA. HOLE IN 6A01359-097 ANGLE, MATCH DRILL (9) #30 DIA. HOLES FROM ANGLE THRU BULKHEAD.
3. LOCATE 4A01005-228 GUSSET ON OPPOSITE SIDE OF BULKHEAD. DRILL OUT EXISTING RIVETS IN BULKHEAD UNDER GUSSET SO AS TO FIT FLAT TO BULKHEAD. LOCATE GUSSET APPROX. AS SHOWN AND MATCH DRILL #30 DIA HOLE FROM BULKHEAD THRU GUSSET.
4. RIVET 4A01005-228 GUSSET AND 6A01359-097 ANGLE TO BULKHEAD WITH AM470A04 RIVETS.
5. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.
6. DRILL OUT EXISTING RIVETS HOLDING BULKHEAD TO SISTER KEEL.
7. LOCATE 6A01008-014 AND -015 ANGLE TO SISTER KEEL, MATCH DRILL #30 DIA. HOLES (9) FROM ANGLES TO BULKHEAD. SECURE WITH AM470A04 RIVETS.
8. MATCH DRILL #21 DIA. HOLE FROM SISTER KEEL THRU ANGLE. SECURE WITH AM470A05 RIVETS.



MODIFICATION TO #6 BULKHEAD

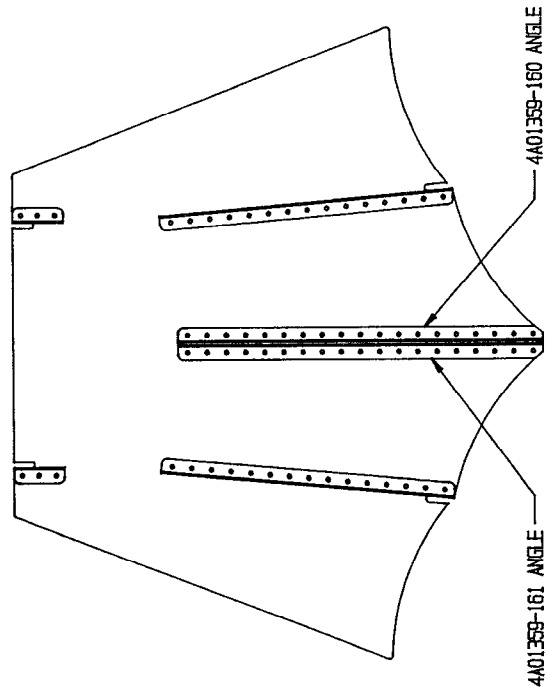
SHEET 4

REV.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. REMOVE EXISTING ANGLE FROM BULKHEAD AT KEEL.
3. LOCATE 4A01359-160 ANGLE OVER HOLES FROM REMOVED ANGLE. MATCH DRILL #30 DIA. HOLES (19) FROM -160 ANGLE THRU BULKHEAD. LOCATE 4A01359-161 ANGLE ADJACENT TO 4A01359-160 ANGLE. MATCH DRILL FROM -161 ANGLE (28) #30 DIA. HOLES. MARK #10 DIA. HOLE IN KEEL TO -160 AND -161 ANGLE AND DRILL TO #10. SECURE 4A01359-160 AND -161 TO BULKHEAD WITH AN470A04 RIVETS.
4. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.

NOTE:
SEAL BETWEEN ALL ANGLES BEFORE RIVETING .



MODIFICATION TO #7 BULKHEAD (SEAPLANE)

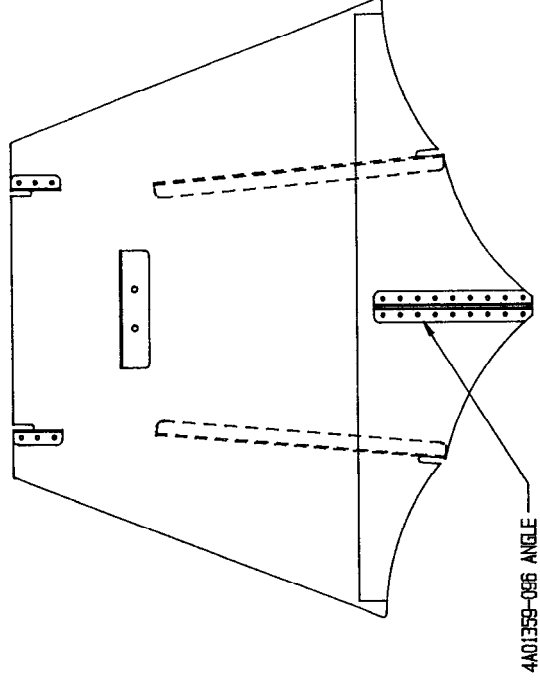
SHEET 5

REV.

INSTRUCTIONS:

1. REMOVE BOLT IN MAIN KEEL SECURING BULKHEAD ANGLE TO KEEL.
2. LOCATE 4401359-096 ANGLE ADJACENT TO EXISTING ANGLE. MATCH DRILL (9) #30 DIA. HOLES FROM -096 ANGLE THRU BULKHEAD. LOCATE AND DRILL #10 DIA. HOLE FROM MAIN KEEL THRU -096 ANGLE. SECURE 4401359-096 ANGLE TO BULKHEAD WITH AN470ADK RIVETS.
3. RE-ATTACH MAIN KEEL BOLT TO BULKHEAD.

NOTE:
SEAL BETWEEN ALL ANGLES BEFORE RIVETING .



MODIFICATION TO #7 BULKHEAD (AMPHIBIAN)

SHEET 6

REV.