

DATE: December 4, 1996

SERVICE KIT: #22

SUBJECT: Rear strut-aft float attachment

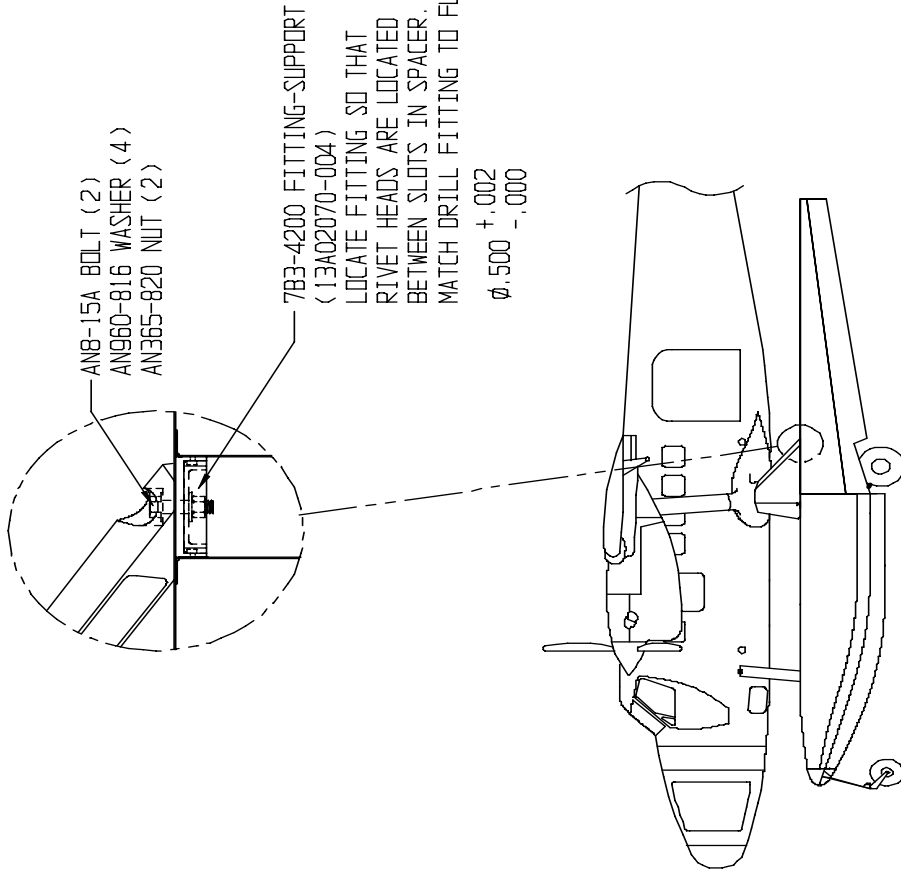
MODEL: DeHavilland Twin Otter with Wipline 13000 Floats.

<u>Item</u>	<u>Quantity</u>	<u>Part No.</u>	<u>Description</u>
1.	2	7B3-4200 (13A02070-004)	Fitting-support
2.	2	AN8-15A	Bolt
3.	4	AN960-816	Washer
4.	2	AN365-820	Nut
5.	1	7B3-4201	Drawing
6.	1	No. 36	Service Letter

Instructions: Install above parts according to Installation Drawing 7B3-4201.

SERVICE KIT #22

REVISIONS		
REV	DESCRIPTION	DATE



INSTALLATION PROCEDURE

NOTE: MODIFY ONE FLOAT AT A TIME

1. REMOVE INSPECTION COVERS, 1 ON EACH FLOAT IN AREA OF DRAG STRUT ATTACH BOLT, SEE VIEW.
2. REMOVE DRAG STRUT ATTACH BOLT, ONE FLOAT AT A TIME.
3. POSITION FITTING IN FLOAT, THRU INSPECTION COVER, CENTER FITTING UNDER HOLE AND USE .50 TRANSFER PUNCH TO MARK HOLE LOCATION.
4. REMOVE FITTING, CHECK HOLE LOCATION, AND CLEARANCE FOR HARDWARE ON INSIDE OF FITTING. HOLE MAY NOT BE CENTERED ON FITTING, BECAUSE OF EXISTING RIVET CLEARANCE.
5. DRILL AND REAM HOLE, AS CALLED OUT.
6. INSTALL FITTING AND HARDWARE, INSPECT.
7. REINSTALL INSPECTION COVER

MATERIAL:		TOLERANCES	
FINISH:		DR	±.015
NAME	DATE	APPD	±.005
RM	11/21/96		
TITLE: SERVICE KIT #22		SCALE: NO. 783-4201	
WIPAIRE INC		REV	
8520 RIVER ROAD, INVER GROVE HEIGHTS, MN. 55076			