



<b>SERVICE LETTER NUMBER 120</b>			
<b>TITLE: Bushing repair for forward, lower center fuselage bow tie mounting plate</b>			
BY: KMT	ACFT MAKE/MODEL(S):	FLOAT MODEL(S):	NOTE(S):
APP: KMT	Viking DHC6 -100, -200	13000	Optional compliance
DATE: 12-Apr-11	and -300		for repair purposes.
REV: A			

FAA APPROVAL HAS BEEN OBTAINED FOR TECHNICAL DATA IN THIS PUBLICATION THAT AFFECTS STC OR TSO DESIGN COMPLIANCE

**EFFECTIVITY:**

All Manufacturers Serial Number (MSN) Viking DHC-6-100, -200, and -300 equipped with Wipaire, Inc. model 13000 seaplane or amphibian twin floats.

SERVICE LETTER P/N: 1005290 for ECN 10076

COMPLIANCE: Optional, for repair purposes

**BACKGROUND:**

Certain Viking DHC-6-100, -200, and -300 aircraft have exhibited slight bearing wear on part number (P/N) 13A02078-002, bow tie mounting plate. This plate is riveted to the fuselage skin at the center lower forward jury strut mount. The center hole in this part receives the boss on P/N 13A02469-01. This boss is used to carry shear loads and may be slightly deformed or worn for high-time float equipped airframes.

**COMPLIANCE METHOD:**

Compliance is achieved through completion of the instructions in the Technical Data section of this service letter.

**APPROX. SHOP HOURS:**

The functions outlined by this service bulletin will take approximately 6 hr. to accomplish.

**WARRANTY INFORMATION:**

This service letter does not include any warranty parts or labor. This service letter is intended to support operators' repair activity only.

**FOLLOW UP ACTIONS:**

After completion of procedures in the Technical Data section:

1. Make an aircraft logbook entry in accordance with 14 CFR Part 43, or in accordance with your local Civil Aviation regulations, referencing accomplishment of the repair procedures in this service letter.

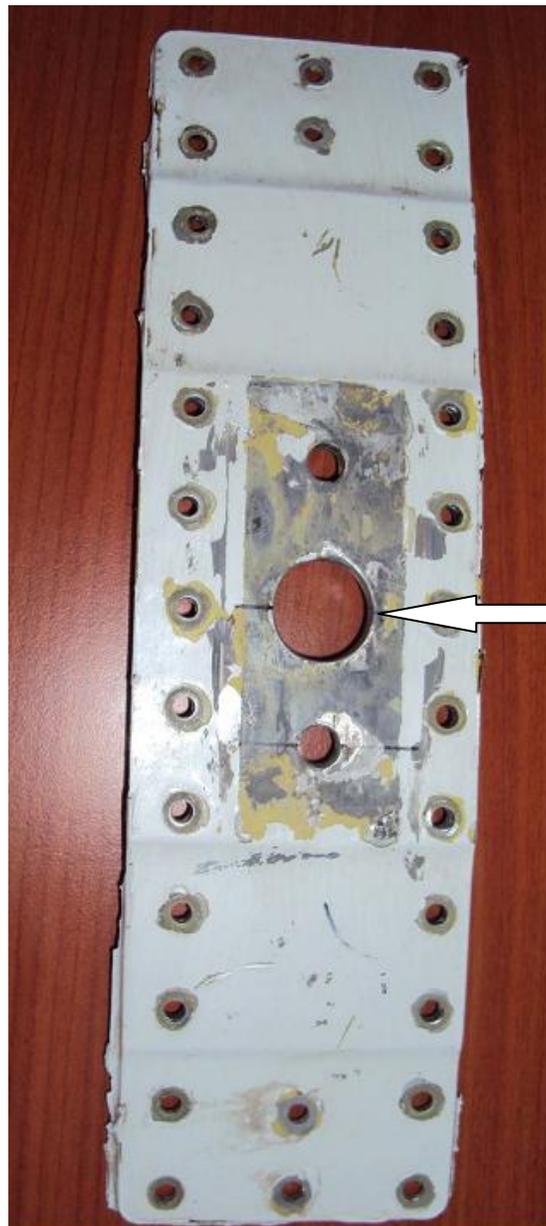
NOTES: (none)

**TECHNICAL DATA:**

Complete the following tasks:

1. Gather necessary technical data:
  - a. Installation drawing number 7D1-3008, revision E or later.
  - b. Installation, fuselage reinforcements, bulkhead 111, drawing number 7D1-3010, revision A or later.
  - c. Latest copy of this SL 120, available on [www.wipaire.com](http://www.wipaire.com).
  - d. Service manual for DHC-6 on 13000 floats, available on [www.wipaire.com](http://www.wipaire.com)
2. Inspect aircraft:
  - a. Support aircraft forward fuselage by hoisting at least the forward fuselage, or sling lift the entire aircraft.
  - b. Remove the forward center strut and fuselage eyebolt fitting, see drawing 7D1-3008, detail A.
  - c. Remove the two forward flying wires.
  - d. Remove bow tie fitting P/N 13A02469-001. This will provide complete access to the fitting attachment plate.
  - e. Inspect the center 1.0 inch diameter hole lower forward center bow tie attachment plate P/N 13A02078-002. See drawing 7D1-3010, view A.
  - f. Determine, using a caliper, the roundness condition of the hole in the attachment plate.





Out of round  
maximum 0.200  
inches diameter, this  
hole

Fig. 1 – P/N 13A02078-002, bow tie attachment plate, as removed from aircraft

### END ###