



WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES
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SERVICE LETTER NUMBER 169

8750 PYLON NUTPLATE CORROSION

By: MAB	Aircraft Makes/Model(s): Cessna 208 Cessna 208B	Float Model(s): 8750A	Note(s): Mandatory Compliance Service Letter P/N 1008954
Approved: SDW			
Date: 9/5/2019			
Rev: C			

FAA approval has been obtained for technical data in this publication that affects STC or TSO design compliance.

EFFECTIVITY:

This service letter applies to: Cessna 208 and Cessna 208B with Wipline 8750 Amphibious Floats installed prior to August 4, 2016 per STC SA1311GL.

COMPLIANCE:

Mandatory compliance

BACKGROUND:

The current MS21059L08 steel nutplates on the pylon assemblies may have corrosion and need to be replaced with MS21060L08 stainless steel nutplates. Corrosion may extend further onto the skins, drag strut channels, main pylon struts and other areas and further disassembly may be needed to remove the corrosion.

COMPLIANCE METHOD:

Install the parts included in this service letter in accordance with the Work Instruction section of this service letter. Floats and pylons may be removed from aircraft in order to gain easier access to the nutplates that are being replaced.

NOTE: It is highly recommended to perform the repairs in this service letter in conjunction with Service Letter 177 and Service Letter 197 to maximize pylon strength performance and reduce the risk of further damage.

APPROXIMATE SHOP HOURS:

Replacing the current steel nutplates for the stainless steel nutplates with the floats attached to the aircraft will take approximately 12 hours per pylon. More time will be needed if corrosion extends further than the nutplates.

WARRANTY INFORMATION:

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

TECHNICAL DATA:

Copies of this service letter, associated service kit, float service manual, and float parts manual are available at www.wipaire.com.

See photos and figures below for details to aid in performing this modification.

See Table 1 below for a list of parts included in the service kit.

For basic float model maintenance information, see applicable Wipaire service manual at www.wipaire.com.

For basic float model parts information, see applicable Wipaire parts manual at www.wipaire.com.

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ITEMS PROVIDED IN SERVICE KIT (PYLON SET)

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1008970	Forward Inboard Drill Tooling
2	2	1008955	Drill Tooling
3	4	1008949	Nutplate Strip Assembly
4	2	1008967	Inboard Pylon Nutplate Strip Assembly
5	2	1008969	Outboard Pylon Nutplate Strip Assembly
6	18	MS21060L08	8-32 Stainless Steel Nut Plate
7	138	AN526C832R8	Truss Head Machine Screw
8	138	NAS1515-H-08L	#8 Nylon Washer
9	24 in.	9903-13-36	Barrier Tape

TABLE 1

REQUIRED PRODUCT LIST:

1. Axalta Corlar 13550S corrosion-resistant epoxy primer (or equivalent) and activator
2. PPG Aerospace PR-1422 B-2 sealer or equivalent
3. Cleaning solution
4. Henkel Alodine 1132 Pen

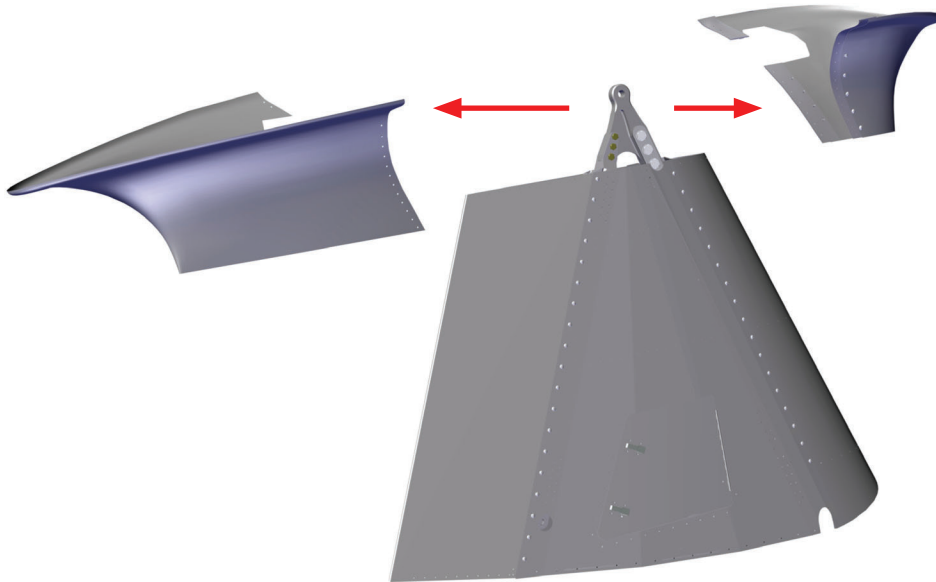
Reference the following documents for instruction pertaining to inspection and repair when completing the following tasks:

- AC43.13-1B or later FAA approved revision guidelines
- Structural Repair Manual for Wipline Aluminum Floats Wipaire part number 1008274

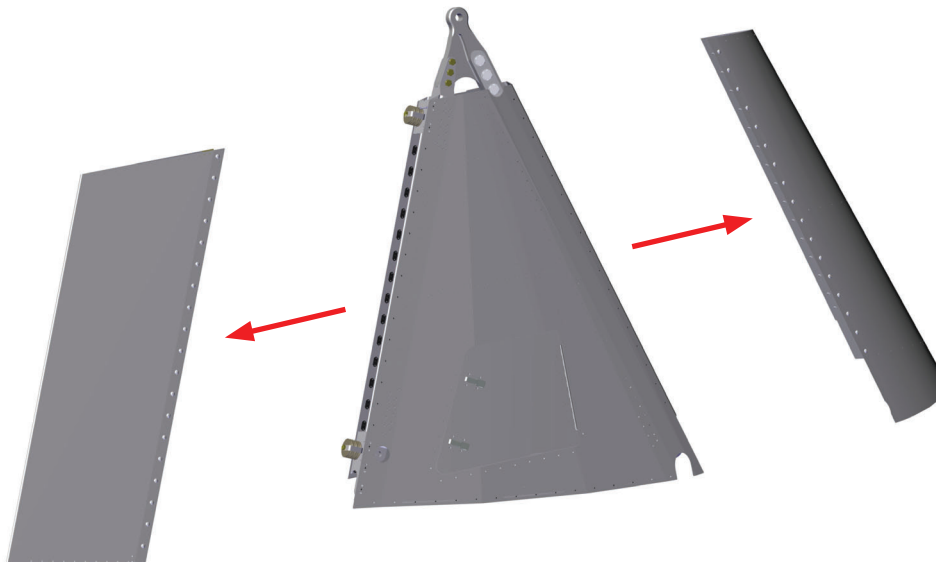
WORK INSTRUCTION

Showing work instruction for RH Pylon Assembly only. Perform same procedure to LH Pylon Assembly using the following instruction for reference only.

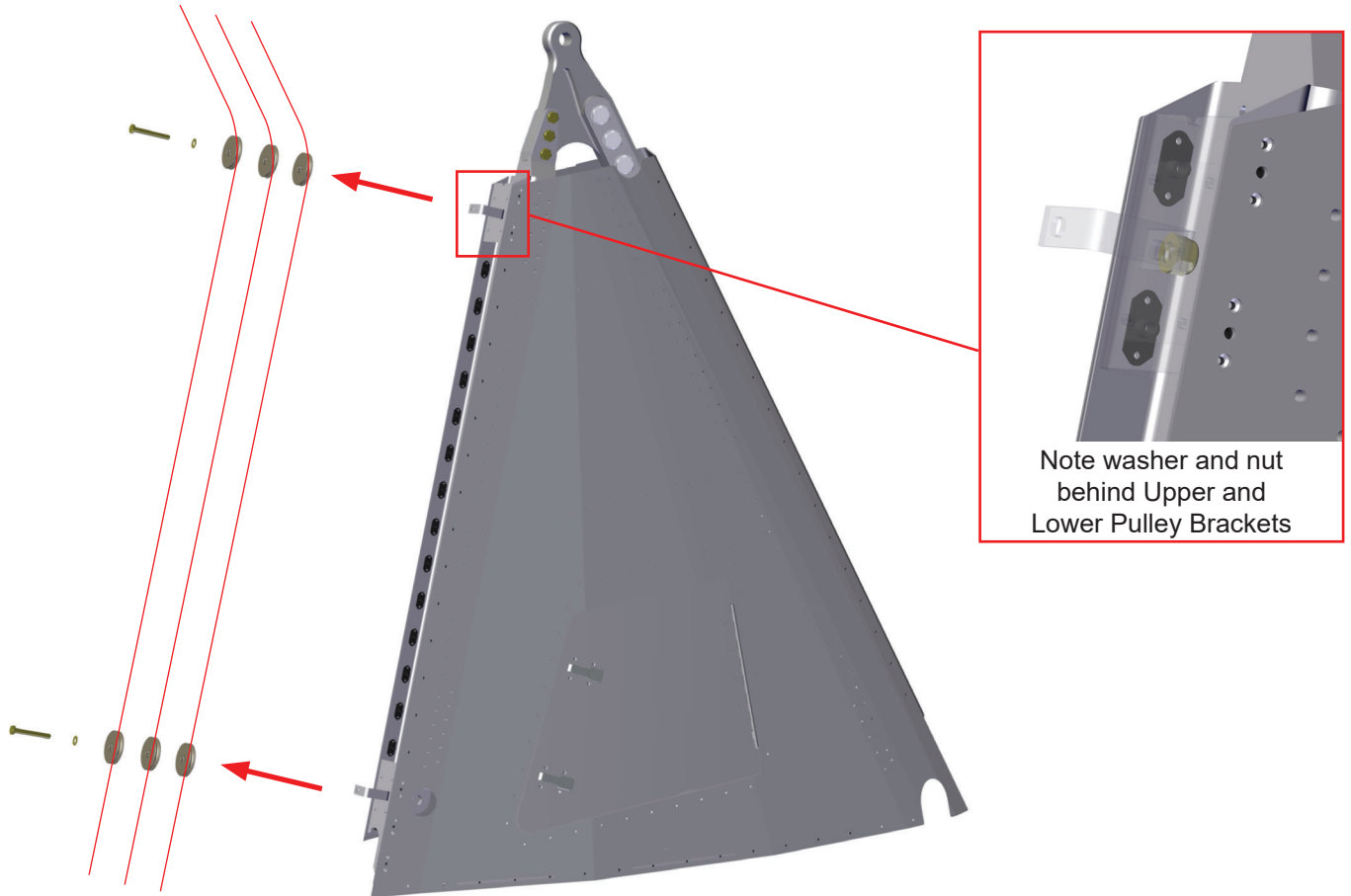
1. Remove pylon fairing assembly. Set hardware aside for use during reinstallation



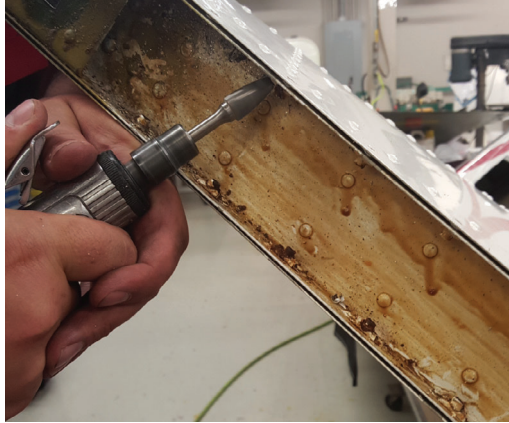
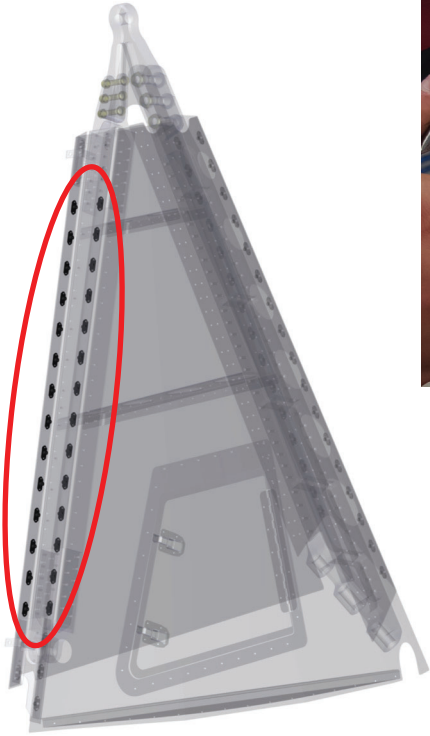
2. Remove leading edge and trailing edge pylon skins



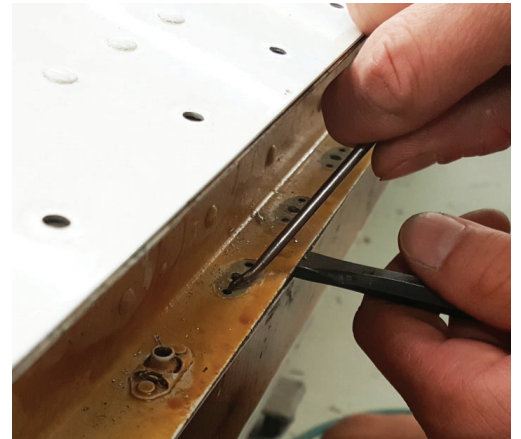
3. Relieve tension on water rudder retract and steering cables, label the cable position, and remove pulleys. Set hardware aside for use during reinstallation



4. Remove (28) nutplates (circled) as shown



Grind or drill off rivet tails

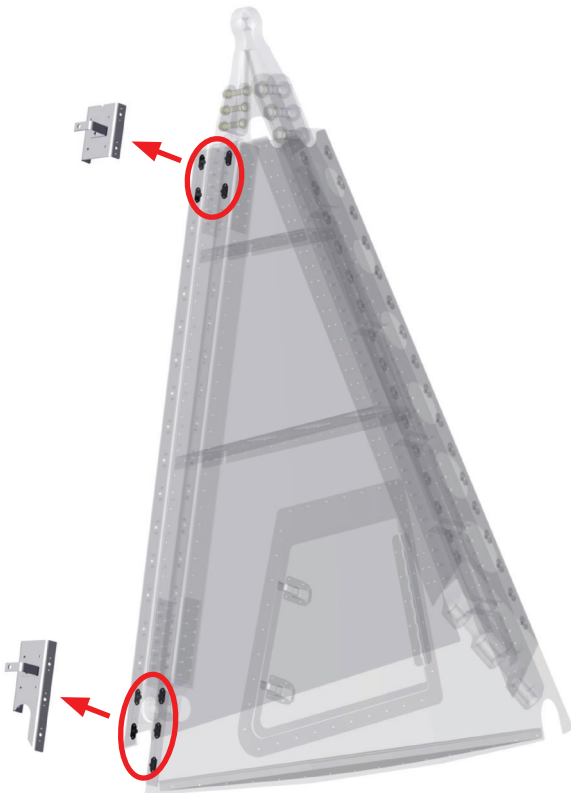


Pry off nutplate and remove rivet heads



Remove aluminum chips between the skin and the channel

5. Remove the remaining (9) nutplates that attach the upper and lower pylon pulley brackets by backdrilling through existing holes with a #40 drill bit



Remove nut to gain access to rivet locations



Remove rivet heads and aluminum chips between the skin and the channel

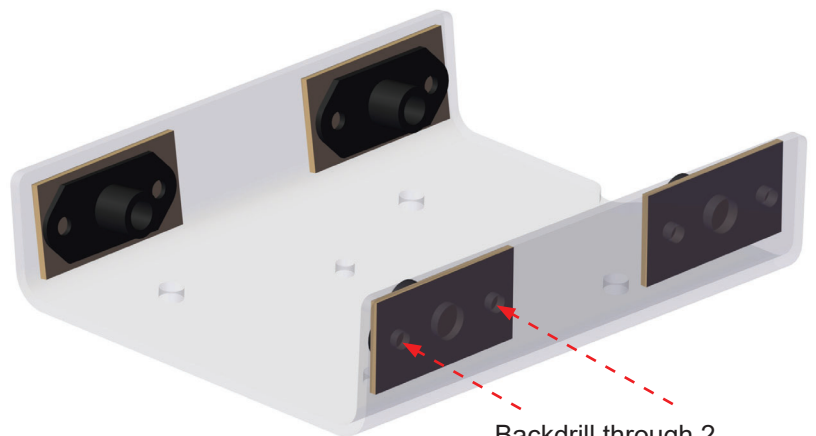
6. Clean applicable surfaces and inspect pylon for corrosion. Lap joints, machinings, skins, and all areas with dissimilar contacting metal should be checked thoroughly. Remove all corrosion or replace corroded components per AC43.13-1B or later FAA approved revision guidelines and the Structural Repair Manual for Wipline Aluminum Floats Wipaire part number 1008274. Apply Alodine to all bare metal



7. Apply Axalta Corlar 13550S corrosion-resistant epoxy primer or equivalent (activated) to removed nutplate locations as shown and allow to dry

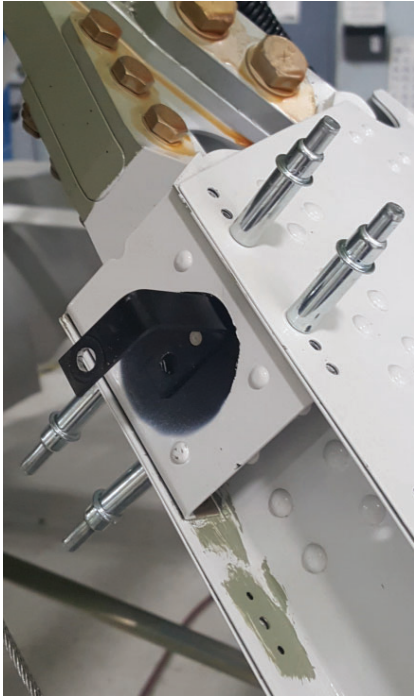


8. Apply a 1 inch piece of 9903-13-36 barrier tape to (4) MS21060L08 stainless steel nutplates and backdrill through tape in the locations shown



Backdrill through 2
hole locations shown
in all 4 pieces of tape

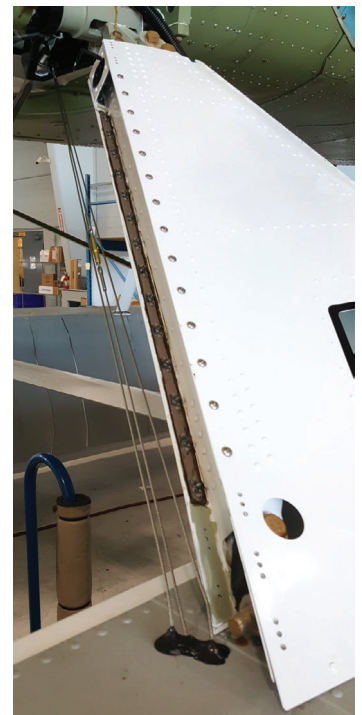
9. Position upper pulley bracket and stainless steel nutplates inside of drag strut channel with clecos and install through drag strut channel with rivets MS20426AD3-4.5



Putty knife or similar tool
used between outer skin
and pulley brackets to
maintain proper countersunk
rivet installation

Drag Strut Channel

10. Apply PPG Aerospace PR-1422 B-2 sealer or equivalent to (2) 1008949 nutplate strip assemblies and install each one where shown

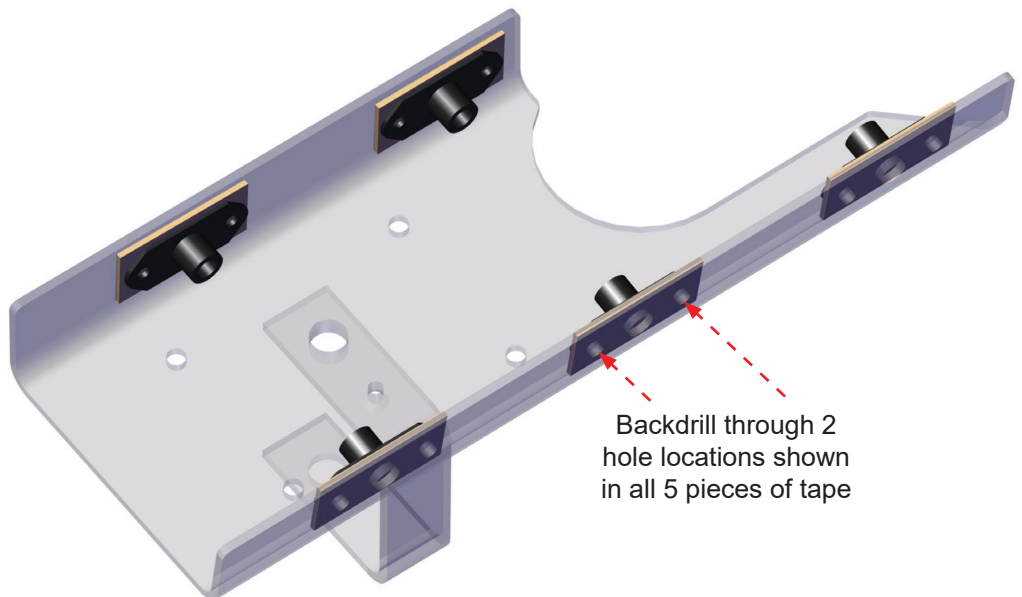


Temporarily install AN526C832R8
screws while sealer sets

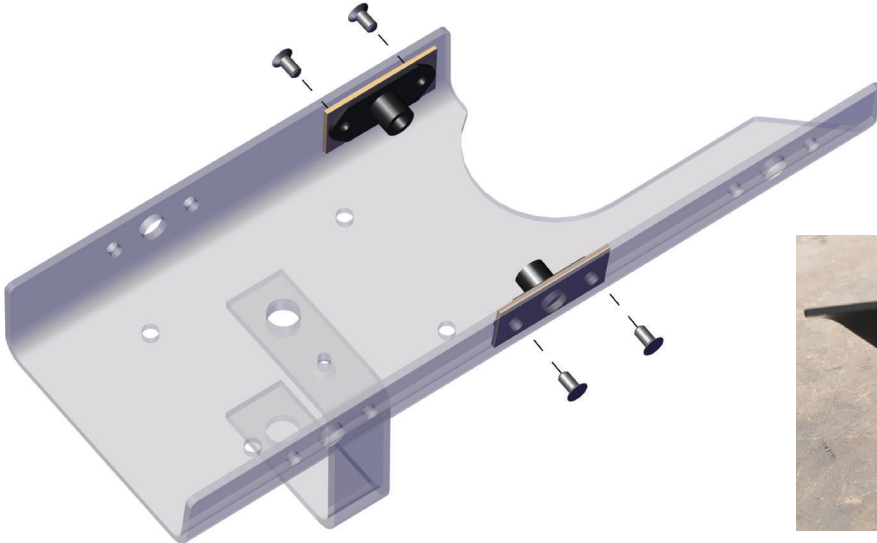
11. Seal edges of nutplate strip assemblies with excess, previously applied sealer that seeped out from under the nutplate strip. Apply more if needed to cover all gaps between the nutplate strip and the drag strut channel



12. Apply a 1 inch piece of 9903-13-36 barrier tape to (5) MS21060L08 nutplates and backdrill through tape in the locations shown

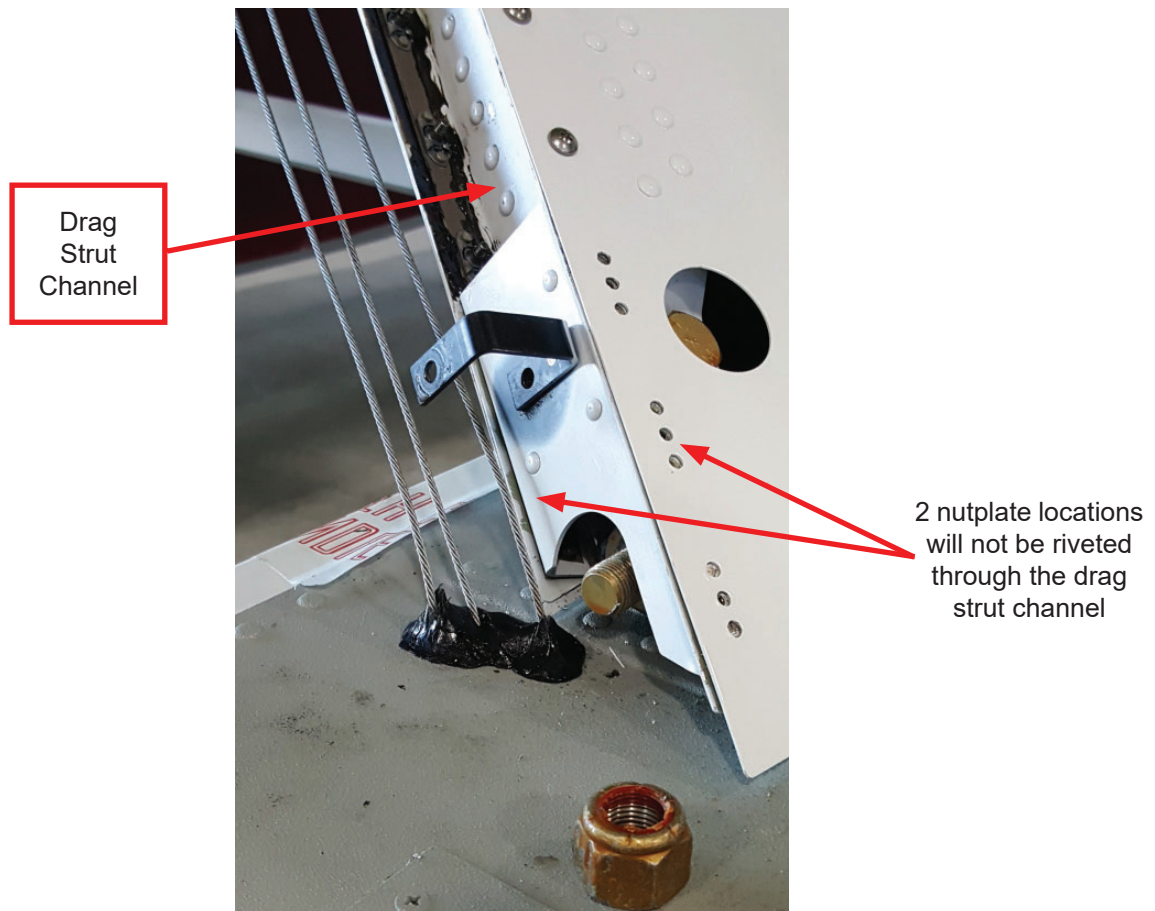


13. Install (2) MS21060L08 stainless steel nutplates onto lower pulley bracket with rivets MS20426AD3-4



14. Position lower pulley bracket and nutplates inside of drag strut channel with clecos and install through drag strut channel with rivets MS20426AD3-4.5

NOTE: Do not rivet where nutplates had already been installed in previous step



15. Position and secure 1008955 drill template as shown and drill out existing nutplates using a #40 drill bit



16. Position and secure 1008970 drill template as shown and drill out existing nutplates using a #40 drill bit

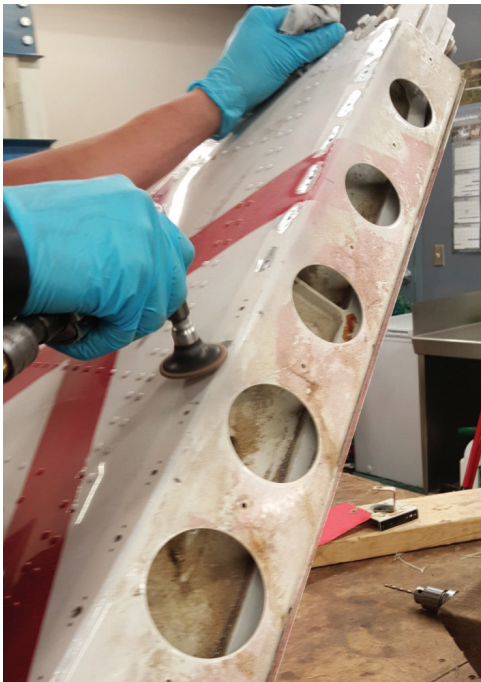
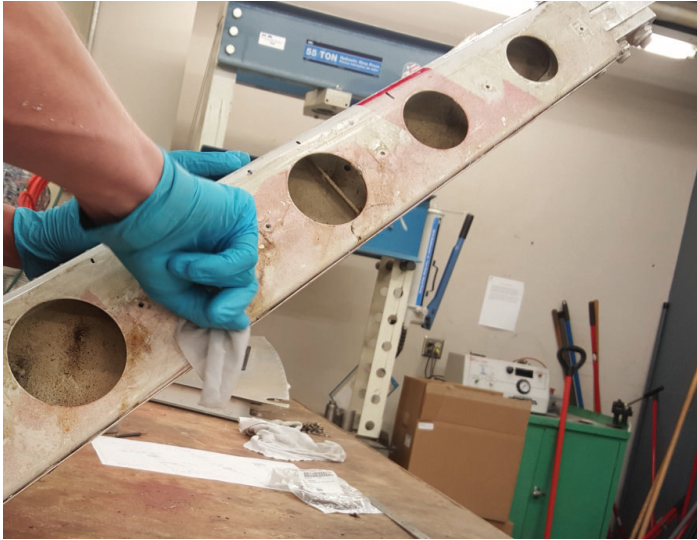


1008970

NOTE: Orient template
so all holes align with
existing hole locations

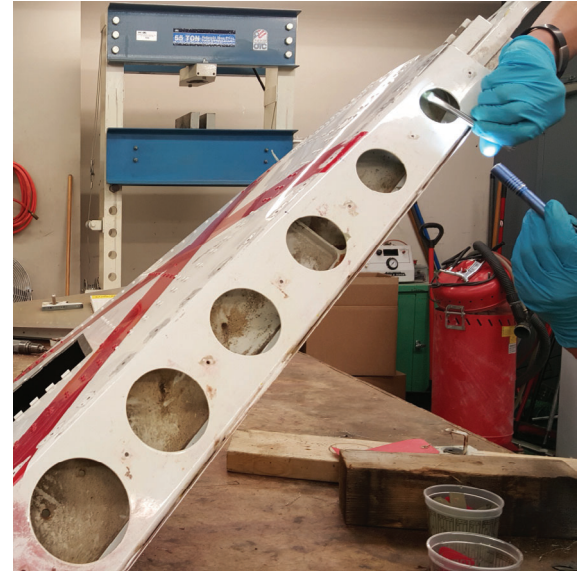
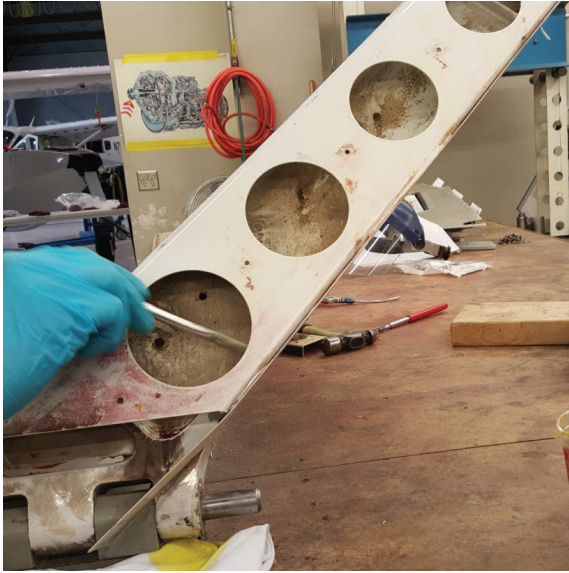


17. Remove nutplates and clean applicable surfaces and inspect pylon for corrosion. Lap joints, machinings, skins, and all areas with dissimilar contacting metal should be checked thoroughly. Remove all corrosion or replace corroded components per AC43.13-1B or later FAA approved revision guidelines and the Structural Repair Manual for Wipline Aluminum Floats Wipaire part number 1008274

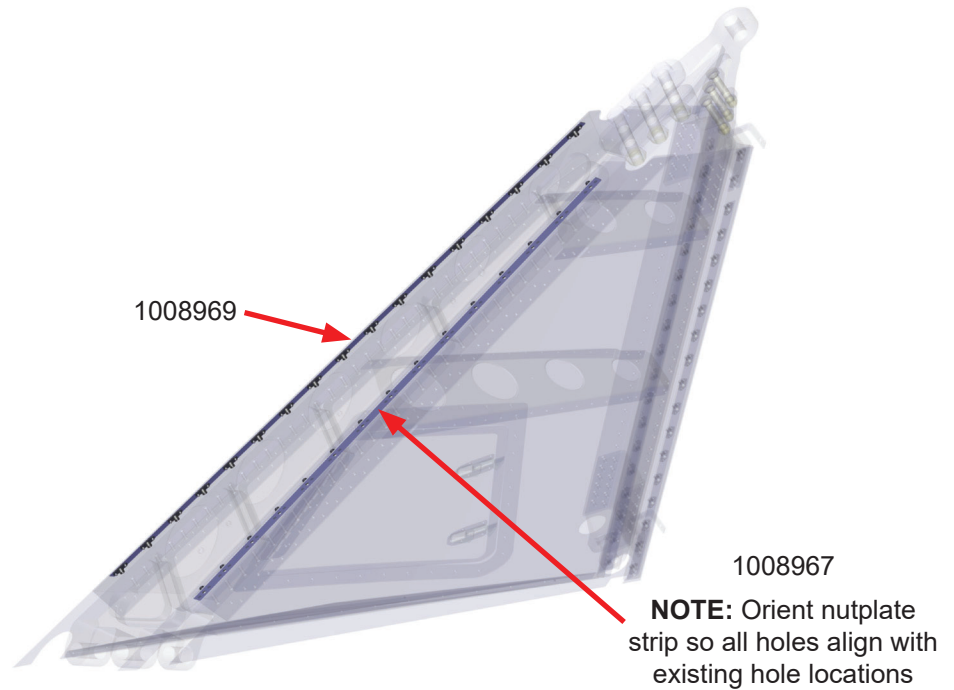


18. Apply Alodine to all bare metal

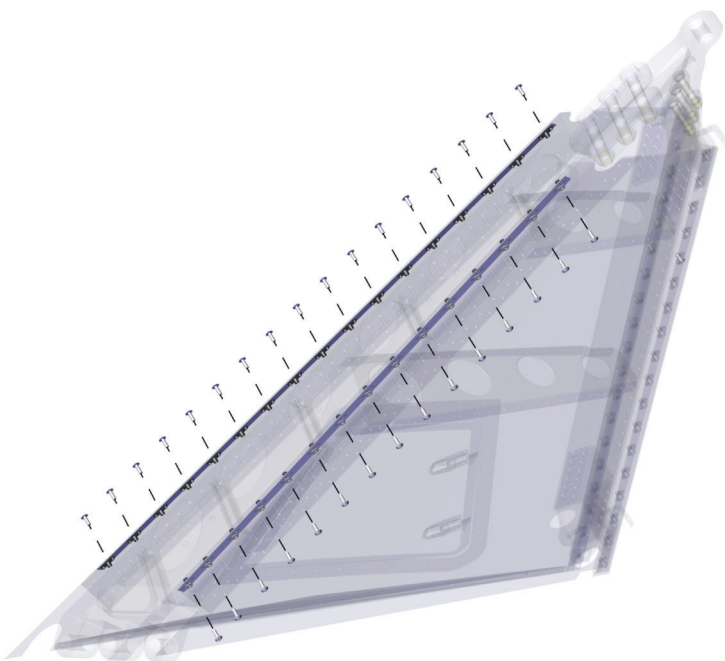
19. Apply Axalta Corlar 13550S corrosion-resistant epoxy primer (activated) to nutplate locations and allow to dry



20. Apply PPG Aerospace PR-1422 B-2 sealer to (1) 1008969 nutplate strip assembly and (1) 1008967 nutplate strip assembly and install each one where shown



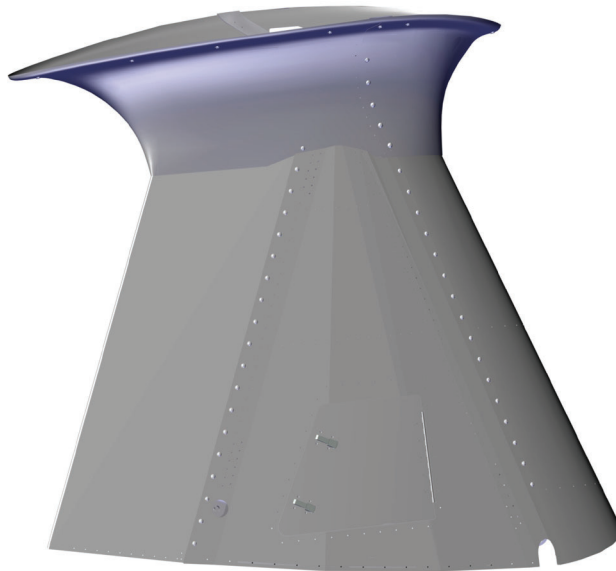
21. Temporarily install AN526C832R8 screws until sealer sets. Seal edges of nutplate strip assemblies with excess, previously applied sealer that seeped out from under the nutplate strip. Apply more if needed to cover all gaps between the nutplate strip and the main strut channel. Allow sealant to dry



22. Reinstall pulleys and rig water rudder retract and steering cables per Wipaire Service Manual PN 1005723
23. Reinstall leading and trailing edge pylon skins using provided (69) AN526C832R8 screws and (69) NAS1515-H-08L nylon washers



24. Reinstall pylon fairing assembly using previously installed hardware



NOTE: Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire Service Letter 169.