



WIPLINE FLOATS • SKIS • MODIFICATIONS • AIRCRAFT SALES  
AVIONICS • INTERIOR • MAINTENANCE • PAINT REFINISHING

## SERVICE LETTER 193

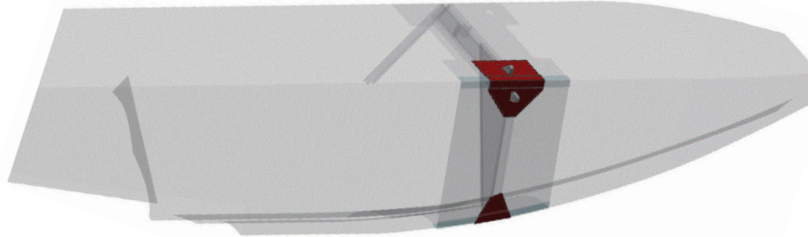
### 10000 FORWARD ATTACH POINT DOUBLER INSTALLATION

<b>Aircraft Makes/Model(s):</b>	<b>Float Model(s):</b>	<b>Compliance:</b> Optional	<b>By:</b> MAB
AT-802 AT-802A	10000A	<b>Part Number:</b> 1009986	<b>Approved:</b> SDW
		<b>Date:</b> 11/7/2019	<b>Revision:</b> B

### LOG OF REVISIONS

Revision	Description	Date
A	Initial release	4/15/2019
B	Updated parts, work instructions, and images	11/7/2019

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



#### EFFECTIVITY:

This service letter applies to Air Tractor models AT-802 and AT-802A with Wipline 10000A Fire Boss Amphibious Float serial numbers 10211A/10212A and prior installed per STC SA01795CH.

#### COMPLIANCE:

Optional compliance

#### BACKGROUND:

The aft bulkhead at the forward attachment point has smoking rivets due to excessive movement, cracking on the bottom of the aft bulkhead panel is possible.

#### COMPLIANCE METHOD:

Install provided parts as shown in the Work Instruction section of this service letter.

#### APPROXIMATE SHOP HOURS:

Installing the forward attach point doubler will take approximately 8 labor hours to install 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 at [www.wipaire.com](http://www.wipaire.com).

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[www.wipaire.com](http://www.wipaire.com)

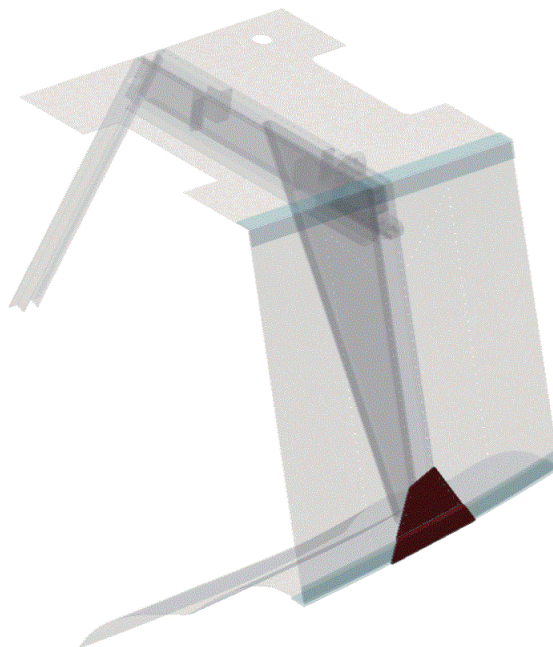
**ITEMS PROVIDED IN SERVICE KIT 1009986-01 (1 SET OF FLOATS)**

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011117	DOUBLER, STRUT ATTACH POINT, FWD, TOP, LF, 10000
2	1	1011118	DOUBLER, STRUT ATTACH POINT, FWD, TOP, RF, 10000
3	1	1011119	DOUBLER, STRUT ATTACH POINT, FWD, BOTTOM, LF, 10000
4	1	1011120	DOUBLER, STRUT ATTACH POINT, FWD, BOTTOM, RF, 10000
5	110	LS5931A72	FILLER WASHER, #5 RIVET
6	2	AN25-52A	BOLT, CLEVIS, 5/16-24 THREAD, 2-7/8" GRIP, 3-19/64" LENGTH
7	2	MS21083N5	NUT, 5/16-24 THREAD LOW HEIGHT, STEEL, NYLON INSERT, 250 DEGREE
8	2	10A02035-001	FITTING, LOWER, FRONT STRUT (REV E OR LATER)
9	6	AN5-33A	BOLT, STEEL, 5/16-24 THREAD, 2.938" GRIP, 3.469" OVERALL LENGTH
10	6	MS21044N5	NUT, HEX LOCKING NYLON INSERT STEEL CAD 2, 5/16-24
11	14	NAS1149F0532P	WASHER, CARBON STEEL, TO FIT DIA 5/16", LIGHT THICKNESS

**WORK INSTRUCTION**

**BOTTOM DOUBLER INSTALLATION**

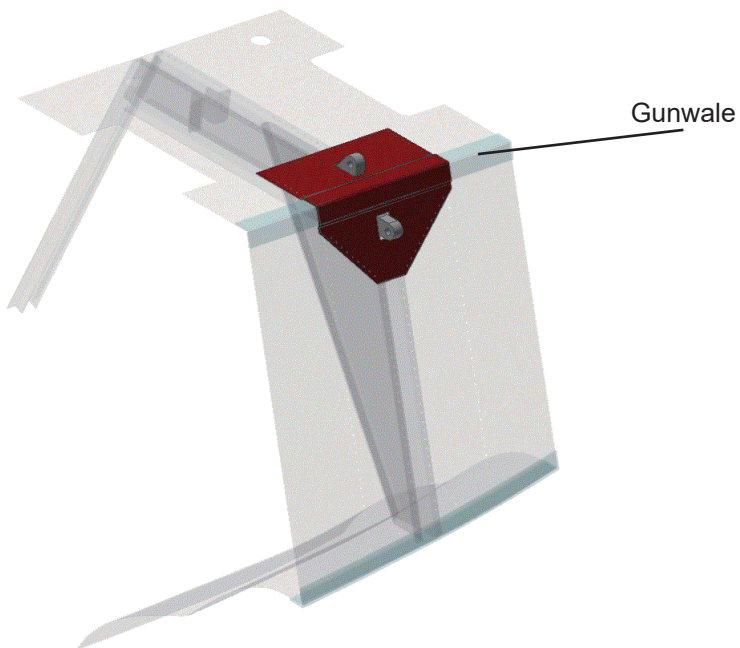
1. Place bottom doubler on float skin and determine which rivets need to be removed.
2. Remove vertical rivets on bulkhead behind doubler installation location.
3. Remove flush rivets on bottom chine line behind area doubler will be installed.
4. Place bottom doubler against float skin and align with vertical rivets.
5. Cleco in place and drill any additional holes with #30 drill bit. Countersink doubler along chine where required.
6. Install filler washers in chine to fill in countersink.
7. Wet install with PR-1422 B2 sealant or equivalent and correct size rivets.



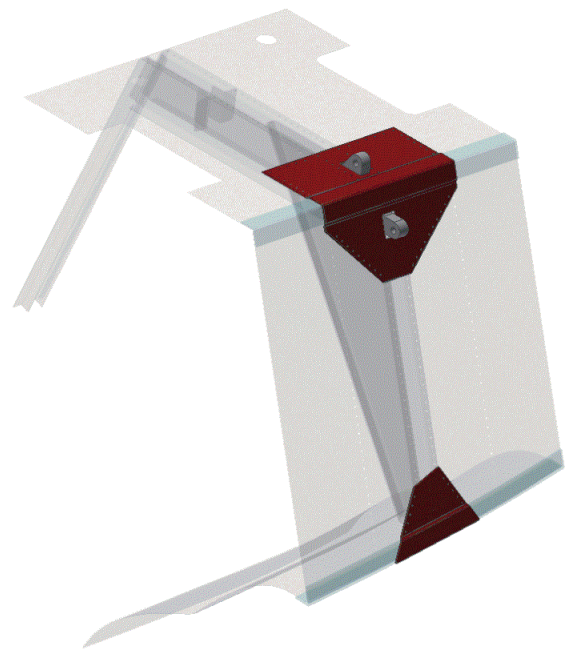
**Bottom Doubler 1011119 or 1011120**

## TOP DOUBLER INSTALLATION

1. Hoist and support aircraft, secure aircraft and floats so the spreader bar and forward strut can be removed.
2. Remove spreader bar and forward strut.
3. Installation of the top doubler will start at the top skin and work around the gunwale and down the side skin, this will help ensure proper fit.
4. Place the top doubler over the fittings and determine which rivets need to be removed, making sure to leave proper edge distance. If the gunwale has a questionable edge distance, leave the rivet.
5. Use the filler washer in the countersunk holes in the gunwale. Countersink the doubler along the gunwale.
6. Cleco the doubler to the top deck first and work down around the gunwale to ensure a good fit. Existing rivet holes will need to be back drilled into the doubler.
7. Countersink rivets that will interfere with strut fittings around the top deck fitting.
8. With all rivet holes drilled, the doubler can be installed wet with PR-1422 sealant or equivalent and correct size rivets.
9. Remove the bottom strut fitting and replace it with the new 10A02035-001, replacing hardware too, bottom bolt will be the AN25-52A Clevis Bolt installed with the head closest to the gunwale.
10. Prime and paint as required.



**Top Doublers 1011117 or 1011118**



**Top and Bottom Doublers**

## Aircraft Closing & Return to Service

1. Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire Service Letter 193.