



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

SERVICE LETTER 211

3000/3450 SERIES BONDED STIFFENER CORROSION

Aircraft Makes/Model(s):	Float Model(s):	Compliance: Mandatory	By: MAS
Textron Aviation 180, 182,185, 206 Maule M-6-235, M-7-235, -B, -C, M-7-260, -C, M-7-420A, -AC, MT-7- 235, MT-7-260, MX-7-235	3000 and 3450 Series	Part Number: 1011440	Approved: DRH
		Date: 4/17/2023	Revision: B

LOG OF REVISIONS

Revision	Description	Date
A	Initial release	6/30/2020
B	Clarified Method B description and instructions.	4/17/2023

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

EFFECTIVITY:

This service letter applies to Textron Aviation models 180, 182,185, 206 and Maule models M-6-235, M-7-235, -B, -C, M-7-260, -C, M-7-420A, -AC, MT-7-235, MT-7-260, MX-7-235 with Wipline 3000 floats (see serial number effectivity below) or Wipline 3450 floats (see serial number effectivity below) installed per STC SA01320CH, STC SA01156CH, STC SA01412CH, STC SA01272CH, or STC SA01185CH.

Float Model	S/N Start	S/N Stop
3000	30155	30284
3450	34203	34314

COMPLIANCE:

Mandatory compliance

BACKGROUND:

Stiffeners and skins are showing signs of corrosion in the locations where the stiffeners are glued to the float side skins.

COMPLIANCE METHOD:

Inspect stiffeners and skins and, if required, install new stiffeners per the Work Instruction section of this service letter.

APPROXIMATE SHOP HOURS:

- Method A - No corrosion or minimal superficial corrosion is present: 8 man-hours per float.
- Method B - Corrosion is visible around and/or under the stiffener. The stiffener will need to be removed for replacement: 1-2 man-hours per stiffener removed.

WARRANTY INFORMATION:

Warranty expires March 1, 2022. Contact Wipaire customer service for details.

1700 Henry Ave - Fleming Field (KSGS), South St. Paul, MN 55075

Phone: 651.451.1205 | Fax: 651.457.7858

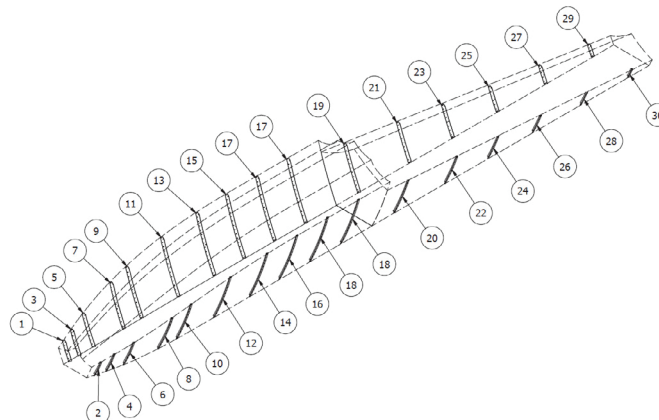
www.wipaire.com

TECHNICAL DATA:

Copies of this service letter, associated service kit (if applicable), float service manual, and float parts manual are available by contacting Wipaire customer service.

PARTS LIST (ORDER DESIRED PARTS INDIVIDUALLY)

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011150	STIFFENER, SIDE SKIN, LH
2	1	1011151	STIFFENER, SIDE SKIN, RH
3	1	1011152	STIFFENER, SIDE SKIN, LH
4	1	1011153	STIFFENER, SIDE SKIN, RH
5	1	1011154	STIFFENER, SIDE SKIN, LH
6	1	1011155	STIFFENER, SIDE SKIN, RH
7	1	1011156	STIFFENER, SIDE SKIN, LH
8	1	1011157	STIFFENER, SIDE SKIN, RH
9	1	1011158	STIFFENER, SIDE SKIN, LH
10	1	1011159	STIFFENER, SIDE SKIN, RH
11	1	1011160	STIFFENER, SIDE SKIN, LH
12	1	1011161	STIFFENER, SIDE SKIN, RH
13	1	1011162	STIFFENER, SIDE SKIN, LH
14	1	1011163	STIFFENER, SIDE SKIN, RH
15	1	1011164	STIFFENER, SIDE SKIN, LH
16	1	1011165	STIFFENER, SIDE SKIN, RH
17	1	1011166	STIFFENER, SIDE SKIN, LH
18	1	1011167	STIFFENER, SIDE SKIN, RH
19	1	1011168	STIFFENER, SIDE SKIN, LH
20	1	1011169	STIFFENER, SIDE SKIN, RH
21	1	1011170	STIFFENER, SIDE SKIN, LH
22	1	1011171	STIFFENER, SIDE SKIN, RH
23	1	1011172	STIFFENER, SIDE SKIN, LH
24	1	1011173	STIFFENER, SIDE SKIN, RH
25	1	1011174	STIFFENER, SIDE SKIN, LH
26	1	1011175	STIFFENER, SIDE SKIN, RH
27	1	1011176	STIFFENER, SIDE SKIN, LH
28	1	1011177	STIFFENER, SIDE SKIN, RH
29	1	1011178	STIFFENER, SIDE SKIN, LH
30	1	1011179	STIFFENER, SIDE SKIN, RH



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

1. Prepare floats for inspection and remove all top deck access covers.
2. Depending on the outcome of inspection, make repairs as instructed:

Method A - No corrosion or minimal superficial corrosion is present.

- Perform Work Instruction - Method A below.



Method B - Corrosion is visible around and/or under the stiffener. The stiffener will need to be removed for replacement.

- Perform Work Instruction - Method B below.



METHOD A

Perform if no corrosion or minimal superficial corrosion is present.

1. Do not remove stiffener. Clean, alodine and prime any visible corrosion found on the interior of the side skin or the stiffener.
2. Seal the sides of stiffener with PR 1422-B2 or equivalent.

METHOD B

Perform if corrosion is visible around and/or under the stiffener.

1. Each stiffener is attached to the gunwall and chine with 2 to 3 rivets and adhesive. Remove rivets, if stiffener does not come off easily, use a heat gun on skin exterior to soften the adhesive (do not exceed 200°F) and remove each stiffener showing signs of corrosion.
2. Remove any corrosion on side skins and clean. Make sure to not remove any more material than necessary.
3. In some cases, there may be a pinhole through the skin, in which case, it is acceptable to drill it out and install a #4 rivet.
4. Alodine and prime cleaned surface.
5. Fit up replacement stiffener to skin, picking up existing stiffener rivet locations. Ensure proper edge distance per AC 43.13-1B. Mark and remove any interfering existing rivets.

NOTE: Stiffener may have to be moved forward or aft one rivet to line up better.

6. Backdrill side skin to match rivet rows in stiffener.
7. Generously apply PR 1422-B2 or equivalent and attach the stiffeners to the side skin.

NOTE: Use enough sealant so that when stiffener is pressed to the side skin, excess sealant seeps out along both sides of the entire stiffener. Rivet stiffeners to side skins at the top and bottom.

8. Rivet stiffeners to side skins, gunwall, and chine. Match previously installed rivet type at gunwall and chine. Use MS20470AD4 rivets for side skin locations.
9. Paint as desired.

AIRCRAFT CLOSING AND RETURN TO SERVICE

1. Reinstall top deck access covers.
2. Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire service letter 211.