



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

SERVICE LETTER 212

2100/2350 SERIES BONDED STIFFENER CORROSION

Aircraft Makes/Model(s):	Float Model(s):	Compliance: Mandatory	By: MAB
Piper PA-12, PA-18, PA-19 American Champion 8GCBC Aviat Husky A-1, A-1A, A-1B, A-1C-180, A-1C-200 Textron Aviation 170A, 170B, 172 Series, 175 Series	2100 and 2350 Series	Part Number: 1011445	Approved: SDW
		Date: 7/24/2020	Revision: A

LOG OF REVISIONS

Revision	Description	Date
A	Initial release	7/24/2020

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

EFFECTIVITY:

This service letter applies to Piper models PA-12, PA-18, PA-19, American Champion model 8GCBC, Aviat Husky models A-1, A-1A, A-1B, A-1C-180, A-1C-200, and Textron Aviation models 170A, 170B, 172 Series, and 175 Series with Wipline 2100 floats (see serial number effectivity below) or Wipline 2350 floats (see serial number effectivity below) installed per STC SA00901CH, STC SA00713CH, STC SA00763CH, STC SA00637CH, STC SA00804CH, or STC SA00674CH.

Float Model	S/N Start	S/N Stop
2100	21659	21998
2350	23097	23180

COMPLIANCE:

Mandatory compliance

BACKGROUND:

Stiffeners and skins are showing signs of corrosion in the locations where the stiffeners are glued to the float bottom 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 the stiffener and the stiffener will need to be removed for further inspection and repaired or corrosion has spread through the skins: 1-2 man-hours per stiffener removed.

WARRANTY INFORMATION:

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

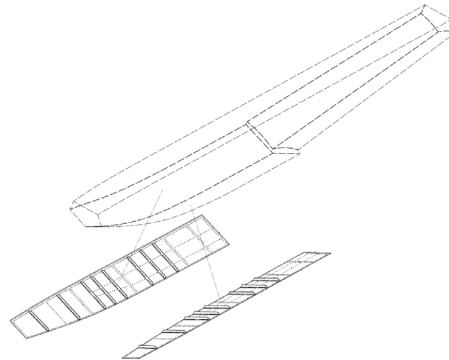
1700 Henry Ave - Fleming Field (KSGS), South St. Paul, MN 55075

Phone: 651.451.1205 | Fax: 651.457.7858

www.wipaire.com

TECHNICAL DATA:

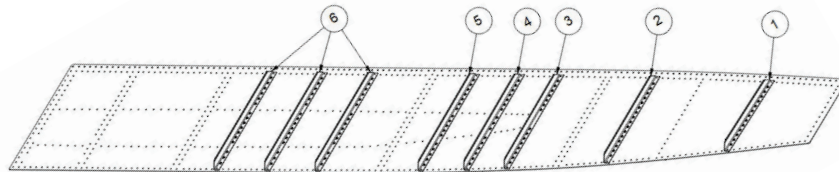
Copies of this service letter, associated service kit (if applicable), float service manual, and float parts manual are available by contacting Wipaire customer service.



2100 Float Forward Bottom Skins & Stiffeners

PARTS LIST (ORDER DESIRED PARTS INDIVIDUALLY FOR 2100 LEFT HAND FWD BOTTOM SKIN)

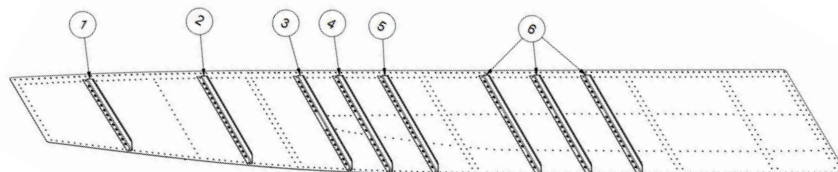
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011412	STIFFENER, BOTTOM SKIN, FWD
2	1	1011413	STIFFENER, BOTTOM SKIN, FWD
3	1	1011414	STIFFENER, BOTTOM SKIN, FWD
4	1	1011416	STIFFENER, BOTTOM SKIN, FWD
5	1	1011418	STIFFENER, BOTTOM SKIN, FWD
6	3	1011420	STIFFENER, BOTTOM SKIN, FWD



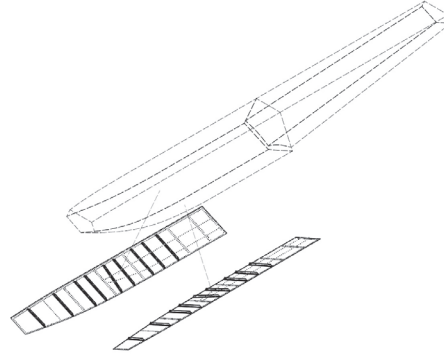
2100 Left Hand Forward Bottom Skin

PARTS LIST (ORDER DESIRED PARTS INDIVIDUALLY FOR 2100 RIGHT HAND FWD BOTTOM SKIN)

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011412	STIFFENER, BOTTOM SKIN, FWD
2	1	1011413	STIFFENER, BOTTOM SKIN, FWD
3	1	1011415	STIFFENER, BOTTOM SKIN, FWD
4	1	1011417	STIFFENER, BOTTOM SKIN, FWD
5	1	1011419	STIFFENER, BOTTOM SKIN, FWD
6	3	1011421	STIFFENER, BOTTOM SKIN, FWD



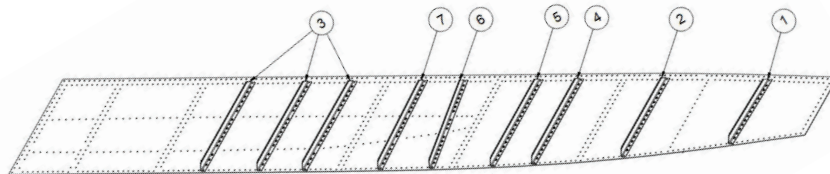
2100 Right Hand Forward Bottom Skin



2350 Float Forward Bottom Skins & Stiffeners

PARTS LIST (ORDER DESIRED PARTS INDIVIDUALLY FOR 2350 LEFT HAND FWD BOTTOM SKIN)

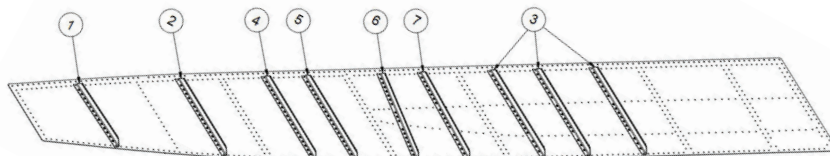
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011412	STIFFENER, BOTTOM SKIN, FWD
2	1	1011413	STIFFENER, BOTTOM SKIN, FWD
3	3	1011420	STIFFENER, BOTTOM SKIN, FWD
4	1	1011424	STIFFENER, BOTTOM SKIN, FWD
5	1	1011425	STIFFENER, BOTTOM SKIN, FWD
6	1	1011426	STIFFENER, BOTTOM SKIN, FWD
7	1	1011428	STIFFENER, BOTTOM SKIN, FWD



2350 Left Hand Forward Bottom Skin

PARTS LIST (ORDER DESIRED PARTS INDIVIDUALLY FOR 2350 RIGHT HAND FWD BOTTOM SKIN)

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1011412	STIFFENER, BOTTOM SKIN, FWD
2	1	1011413	STIFFENER, BOTTOM SKIN, FWD
3	3	1011421	STIFFENER, BOTTOM SKIN, FWD
4	1	1011424	STIFFENER, BOTTOM SKIN, FWD
5	1	1011425	STIFFENER, BOTTOM SKIN, FWD
6	1	1011426	STIFFENER, BOTTOM SKIN, FWD
7	1	1011429	STIFFENER, BOTTOM SKIN, FWD



2350 Right Hand Forward Bottom Skin

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 the stiffener, and the stiffener will need to be removed for further inspection and repaired or corrosion has spread into the skins.

- 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 bottom skin or the stiffener.
2. Seal the sides of stiffener with PR 1422-B2 or equivalent.

METHOD B

Perform if corrosion is visible around the stiffener or if corrosion has spread more than 50% of skin thickness for a total length of more than 20% of the stiffener length through the skins.

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 bottom 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 backdrill through the pinhole and through the stiffener to 1/8" and install a rivet.
4. Alodine and prime cleaned surface.
5. Fit up replacement stiffener to skin, 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 bottom skin to match rivet rows in stiffener.
7. Generously apply PR 1422-B2 or equivalent and attach the stiffeners to the bottom skin.

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

8. Rivet stiffeners to bottom skins.
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 212.