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SERVICE LETTER 252

Extended Baggage Sight-Gauge Hole and Reservoir-Fill Access Panel Modification

Aircraft Makes/Model(s):	Modification:	Compliance: Optional	By: MAS
Textron Aviation 208, 208B	Extended Baggage	Part Number: 1012340	Approved: DRH
		Date: 2/22/2024	Revision: B

LOG OF REVISIONS

Revision	Description	Date
A	Initial release	4/11/2023
B	Changed Cover 1011196 to 1011916 and changed Cover 1011195 to 1011915. Changed description of ADTECH Filler p/n 655936-658979 to quart instead of gallon. Added Activator p/n 9T00-A to touch-up paint. Added optional equivalent hand operated applicator gun.	2/22/2024

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 model 208 and 208B Caravans with Extended Baggage installed per STC SA04388CH.

COMPLIANCE:

Optional Compliance

BACKGROUND:

Due to obsolescence/discontinuation of Hydraulic Pumps 8A09000-031 and 1004397, many owners are opting to upgrade to the new Hydraulic Pump 1011404 (Wipaire Service Letter 216) or Hydraulic Pump 1011436 (Wipaire Service Letter 218). To accommodate the new hydraulic pump assemblies, this service letter adds additional sight-glass port and larger fill-port access to existing Extended Baggage Cargo assemblies.

COMPLIANCE METHOD:

Install parts per work instructions in this service letter.

APPROXIMATE SHOP HOURS:

Performing the work instructions will take approximately 13 labor hours to complete per baggage compartment modification.

WARRANTY INFORMATION:

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

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.

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www.wipaire.com

Order Parts Individually As Needed			
ITEM	QTY	PART NUMBER	DESCRIPTION
WIPAIRE TOOLING			
1	1	1012335	TEMPLATE, EXTENDED BAGGAGE VIEW HOLE
2	1	1012334	TEMPLATE, EXTENDED BAGGAGE ACCESS HOLE
THREADED INSERT			
1	8	NAS1833-08-250	8-32 THREADED INSERT, OPEN END, 0.250" LENGTH
2	1	EC-2815	ADHESIVE (200 ML)
EDGE FILL *			
1	1 GALLON	648699-648708	FILLER, ADTECH MICRO-ULTRA 15-3 WHITE BMS5-136D TYPE II, CLASS I SPEC FLAME-RETARDANT POLYESTER FILLER / FAIRING PASTE, GALLON KIT
OR			
2	1 QUART	655936-658979	FILLER, ADTECH MICRO-ULTRA 15-3 WHITE BMS5-136D TYPE II, CLASS I SPEC FLAME-RETARDANT POLYESTER FILLER / FAIRING PASTE, QUART KIT
TOUCH-UP PAINT			
1	1 QUART	CG257	PAINT, WHITE, SATIN PLUS (SCAN)
2	1 QUART	9T00-A	ACTIVATOR
ASSEMBLY			
1	1	1011916	COVER, EXTENDED BAGGAGE, HYDRAULIC ACCESS
2	1	1011915	COVER, EXTENDED BAGGAGE, FILL
3	12	AN526C832R8	SCREW, TRUSS HEAD MACHINE, 8-32 THREAD, 1/2" LENGTH, NON-STRUCTURAL, CORROSION RESISTANT
4	1	1011917	PLACARD, HYDRAULIC ACCESS

Note: Reference Wipaire Document 1006932 Honeycomb Panel Procedures for approved structural adhesives, edge fill products, bonding procedures, and edge filling procedures if needed. Contact Wipaire Customer Service for a free digital copy.

Work Instructions

1. Remove floor covering and clear Hydraulic access panel.
2. Remove the extended baggage compartment from the aircraft. Refer to Wipaire installation drawing 1008423.



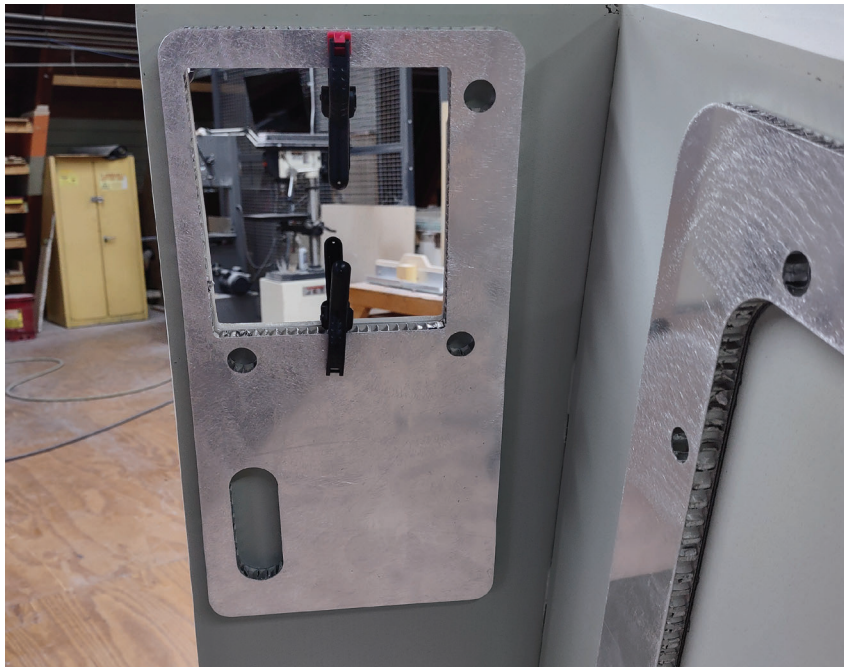
3. Using provided templates 1012335 & 1012334, mark where new openings need to be located.



3a. From the outside of the baggage area, use 2 picks to locate the 2 existing threaded inserts that were used to hold the hydraulic access panel on. They should be the lowest aft insert and the most aft insert that are used to locate the position of the 1012334 template. Mark the inside edge of the template.



3b. Use clamps to hold the 1012335 template in position. This template will be lined up with the edges of the existing access hole. The small oval shaped hole should face in the most outward position. Mark the inside edge of the oval template.

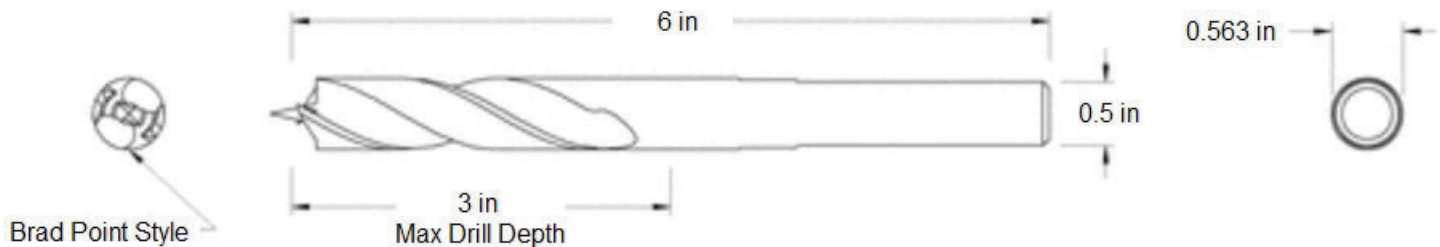


3c. Using a drill bit the same size as the template holes, transfer all holes from both templates into the baggage honeycomb. Drill new holes for the inserts needed for access cover panel. Recommend 9/16 brad type drill bit to keep holes centered. See next page for specific drill information.



Drill Bit for Precise Holes in Wood

Uncoated High-Speed Steel, 9/16" Size



System of Measurement	Inch
Material	Uncoated High-Speed Steel
Size	9/16"
Decimal Size Equivalent	0.5625"
Overall Length	6"
Maximum Drilling Depth	3"
Shank	
Type	Round
Size	1/2"
Bit Style	Spiral Flute
Point Style	Brad
Flute Direction	Right Hand
For Use On	Wood
Individual/Set	Individual
RoHS	Not Compliant
REACH	Not Compliant

4. Remove templates. Cut out the new opening on the line marked from the inside of the template with a reciprocating saw or similar tool. (Recommend 18T blades).

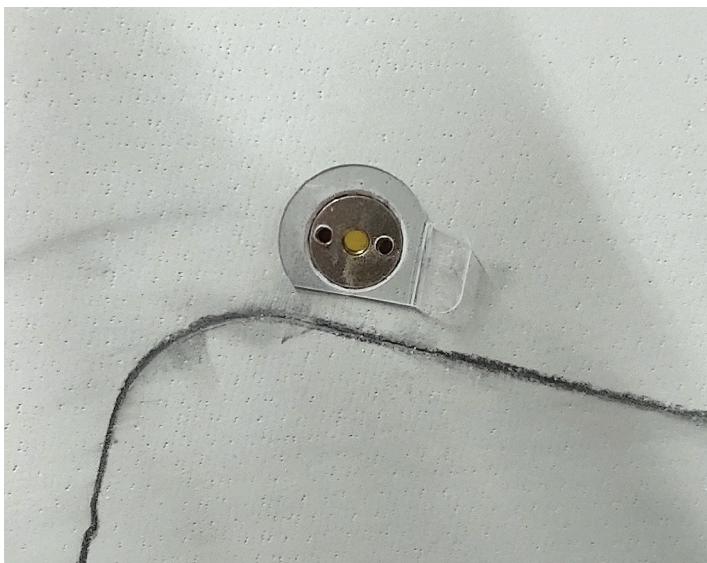


5. Use tape and put over the top of each of the insert holes from the inside of the baggage area. This will help keep the inserts flush inside the baggage area when pushed in from the outside.



6. Place inserts into baggage area from the outside of the box, so the 2 glue holes are facing outside. Fill with glue in one hole until it comes out of the other hole. Wipaire document 1006932 describes multiple structural adhesive options along with compatible applicators. A nozzle-style applicator must be used with this type of insert. A recommended setup is detailed below:

- Adhesive EC-2815 (See next page for info)
- Mixing Nozzle 87982
- Applicator Gun DP200-70 (See next page for info)
- Equivalent hand operated applicator gun at 2:1 ratio)



SULZER

Sulzer Mixpac DP 200 - 200 ml Pneumatic Cartridge Gun

SKU: SULZER MIXPAC DP 200-70-01 Manufacturer Part #: 165860

MIXPAC GUN NEEDS TO BE 2:1 MIX RATIO



Approximate Price as of March 2023
(\$381.00)



cylinders using light pressure on the trigger. Next, attach the mixing nozzle to the cartridge and begin dispensing the adhesive. Scrap the first 4 cc or until you have a uniform color when using a new static mixer. For manual mixing, mix Part B and Part A using proper mixing ratio either 100:40 (B:A) by weight or 100:50 (B:A) by volume. Thoroughly blend the two parts (10-15 seconds after uniform color is obtained). The work life of 20 grams of mixed material at 73°F (23°C) is approximately 60 minutes. Large masses and/or higher temperatures will shorten work life. Only contact pressure is required during curing. Parts must be kept aligned during cure. See product Technical Data Sheet for additional technical information.

LIMITATION OF LIABILITY: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted.



Alternate Option:
Equivalent hand operated
applicator gun at 2:1 ratio



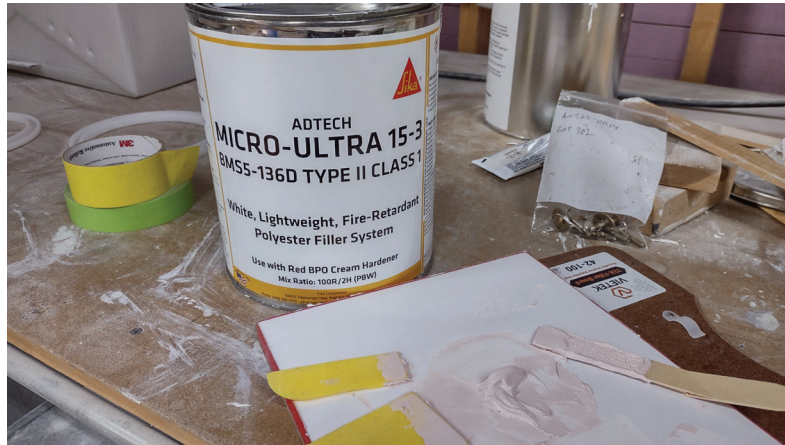
7. On the oval marking from template 1012335, drill two 3/4" holes (one on top and one on bottom) using Unibit. Connect the holes by cutting from one to the other to make an oval shaped cutout. Use Dremel or equivalent to finish edges.



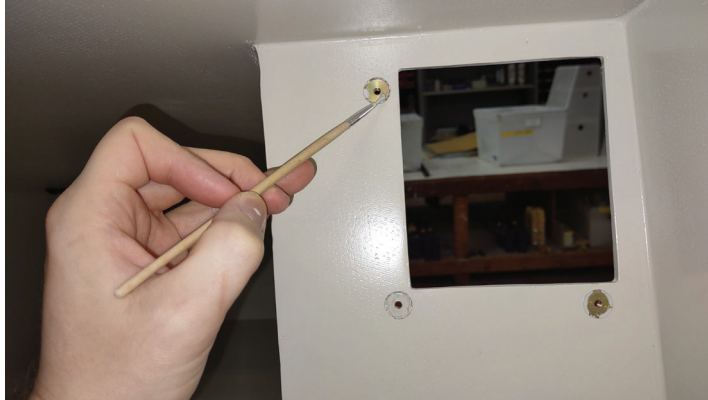
8. Sand all new edges smooth and flat prior to beginning the edge filling process. Push honeycomb core down 1/4" to accept the edge filler.



9. Mix and add edge filler ADTECH Micro-Ultra 15-3 White BMS5-136D Type II, Class I Spec Flame-Retardant Polyester Filler/Fairing Paste or equivalent to all new opened edges, leaving a small 1/16" bump to be sanded smooth once filler has cured, as shown below.



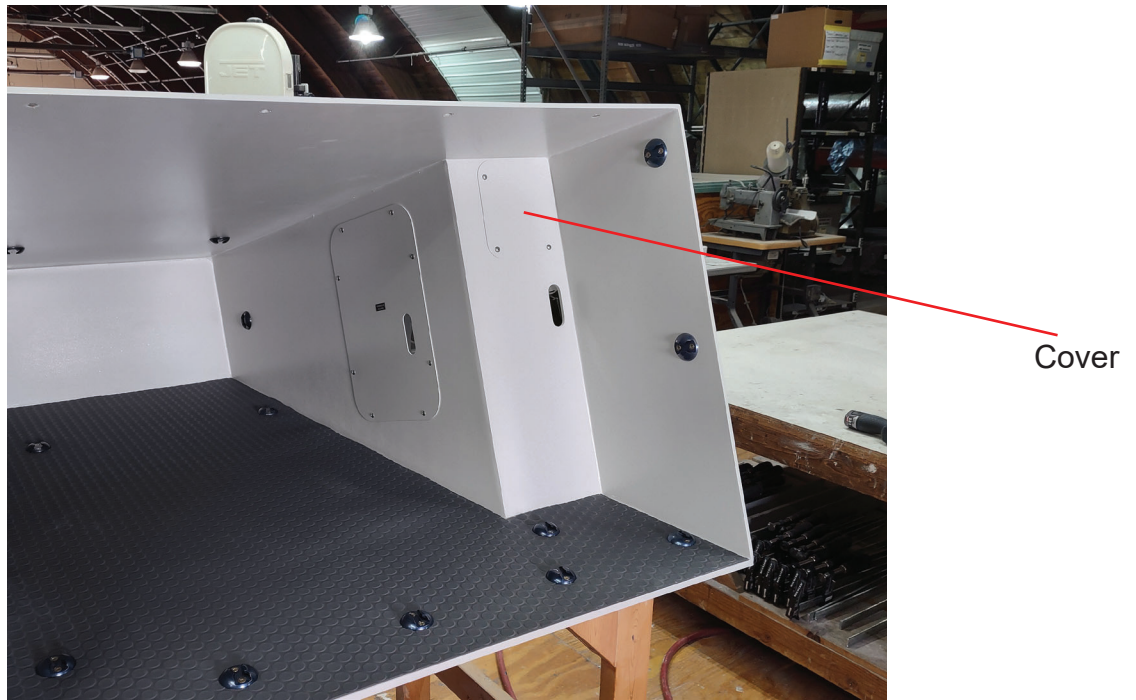
10. Touch up faces of new inserts with paint.



11. Sand all edge filler smooth and use touch up paint with a small paint brush.



12. Reassemble flooring/anchors and install new supplied covers. Reinstall extended baggage to airframe. Refer to Wipaire installation drawing 1008423.



Aircraft Closing & Return to Service

1. Upon completion of inspection, enter information in Aircraft Logbook for completion of Wipaire Service Letter 252.