



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

Subject: Wire Routing Improvements

ATA-Code: 24-00

Labor: 20.0 Hours

Effectivity: K003 – K021

Affected Model(s): E1000, E1000 GX

Due: The next annual inspection.

Compliance: Mandatory

Recurrence: No

1 BACKGROUND AND PURPOSE:

This Service Bulletin has been created to ensure that the aircraft electrical wiring interconnect system meets best practices.

2 REFERENCES:

Epic E1000 Airframe Maintenance Manual, PN SK05000000
Epic E1000 Wiring Manual, PN SK05000002
AC43.13-1B
Aircraft Electrical Wiring Interconnect System (EWIS) Best Practices Rev. 2.0

3 WARRANTY:

For aircraft under warranty, parts and labor will be covered by Epic Aircraft, LLC if the work is performed within the compliance period and at an Authorized E1000 Service Center.

4 APPROVAL:

The engineering aspects of this service document have been shown to comply with the applicable Federal Aviation Regulations and are FAA approved.

5 REVISION:

B – If the original issue of this service bulletin was complied with, compliance with steps (10), (11.x), and (18) is required. If revision A of this service bulletin was complied with, no further action is required.

- Corrected Issued date.
- Added Approval and Revision Sections.
- Added steps to remove and install wing tips.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 1 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
 Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

6 TOOLS:

<u>No.</u>	<u>Description</u>	<u>Qty</u>	<u>Epic Aircraft Supplied</u>	<u>Customer Supplied</u>
1.	Common Hand Tools	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>

7 PARTS/MATERIALS:

<u>No.</u>	<u>Part Number</u>	<u>Description</u>	<u>Qty</u>	<u>Epic Aircraft Supplied</u>	<u>Customer Supplied</u>
1.	2000 FR 13	Roundit 2000	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2.	2000 FR 19	Roundit 2000	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
3.	2000 FR 25	Roundit 2000	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.	2000 FR 38	Roundit 2000	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
5.	2000 NX 16	Roundit 2000	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
6.	MIL-T-43435B	Black, Waxed Lacing Cord	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
7.	SL4-0025-ER0201	Grommet Edging/0.069-0.090 thick, 0.277 wide, Black	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
8.	Plexus MA300	Adhesive	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>
9.	81N2598	Wire Tie Holder	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 2 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
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8 INSTRUCTIONS:

1. Set the BATT 1 and BATT 2 switches to OFF.
2. Disconnect external electrical power from the airplane (refer to the E1000 AMM PN SK05000000, chapter 24-40).
NOTE: This Service Bulletin is to be performed with the aircraft opened for access for the annual inspection.
3. Remove PFD 1, PFD 2, and the MFD (refer to the E1000 AMM PN SK05000000, chapter 34-40).
4. Remove the Left, Right, Climate, and Test Switch panels (refer to the E1000 AMM PN SK05000000, chapter 24-60)
5. Remove the left and right circuit breaker panels (refer to the E1000 AMM PN SK05000000, chapter 24-60)
6. Remove the pressure bulkhead access panel (refer to the E1000 AMM PN SK05000000, chapter 21-30).
7. Remove the upper and lower crew finish panels (refer to the E1000 AMM PN SK05000000, chapter 25-10).
8. Remove the upper and lower passenger finish panels (refer to the E1000 AMM PN SK05000000, chapter 25-20).
9. Remove the engine cowling (refer to the E1000 AMM PN SK05000000, chapter 71-10).
10. Remove the left- and right-wing tips (refer to the E1000 AMM PN SK05000000, chapter 57-30).
11. Inspect the following areas for damaged wiring. Repair any damage found and install chafe protection at each location as follows:

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 3 of 59

a. Instrument Panel – Left and Right Circuit Breaker Panels

Location: Left and right circuit breaker panels (Removed from Aircraft).

W/D: WK24600002

Harness: HK25100007 & HK25100011

Action: Add Roundit to exposed bare wires; Add edge protection to sharp metal edges to protect wire(s) to prevent chafing.

NOTE: Right panel shown, left is opposite.

Before:



Chafe hazard.

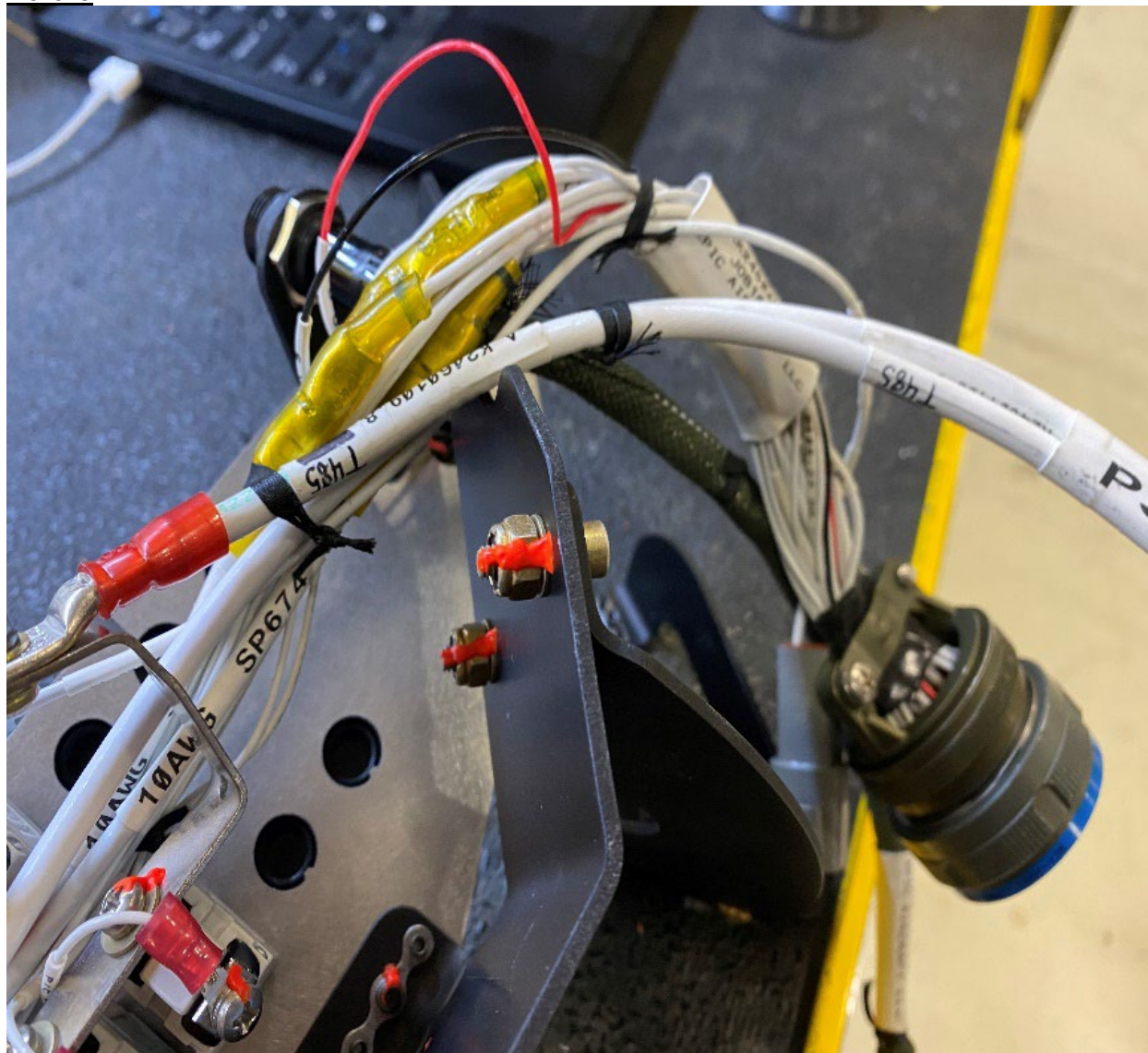
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 4 of 59



Service Bulletin SB-0025

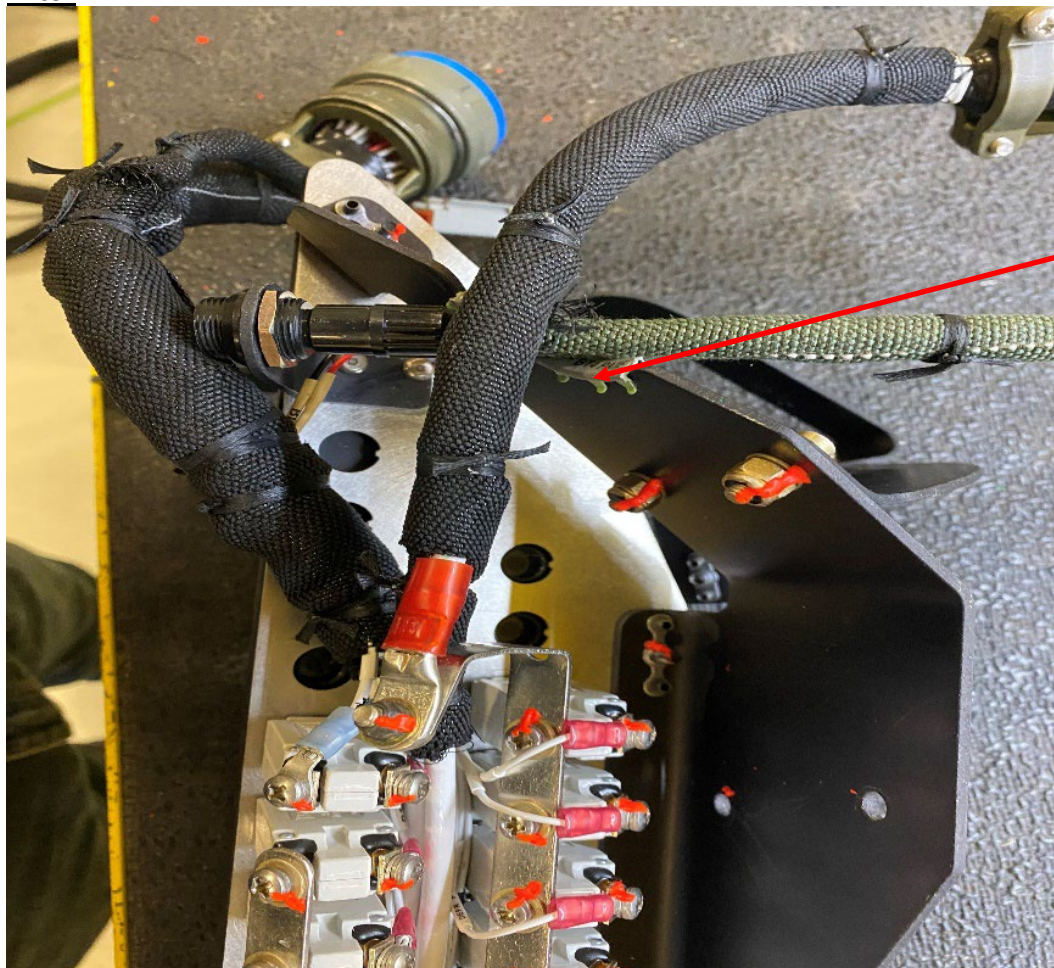
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Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 5 of 59

After:



Add edge protection here.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 6 of 59

b. Instrument Panel - Left and Right Circuit Breaker Panels

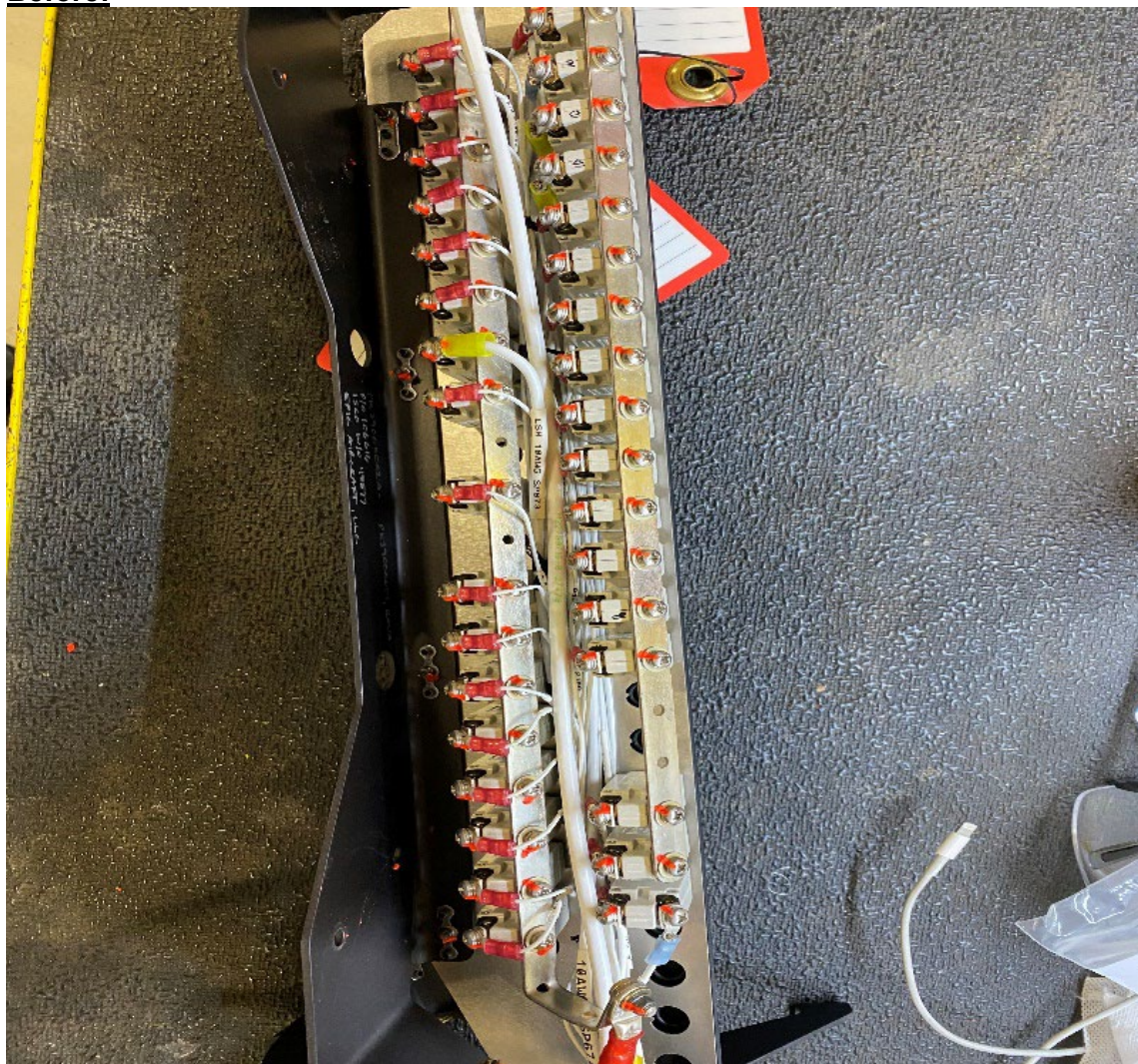
Location: Left and Right Circuit Breaker Panels (Removed from Aircraft).

W/D: WK24600002

Harness: HK25100007, HK25100011

Action: Bundle loose wires using tie string in several locations.

Before:



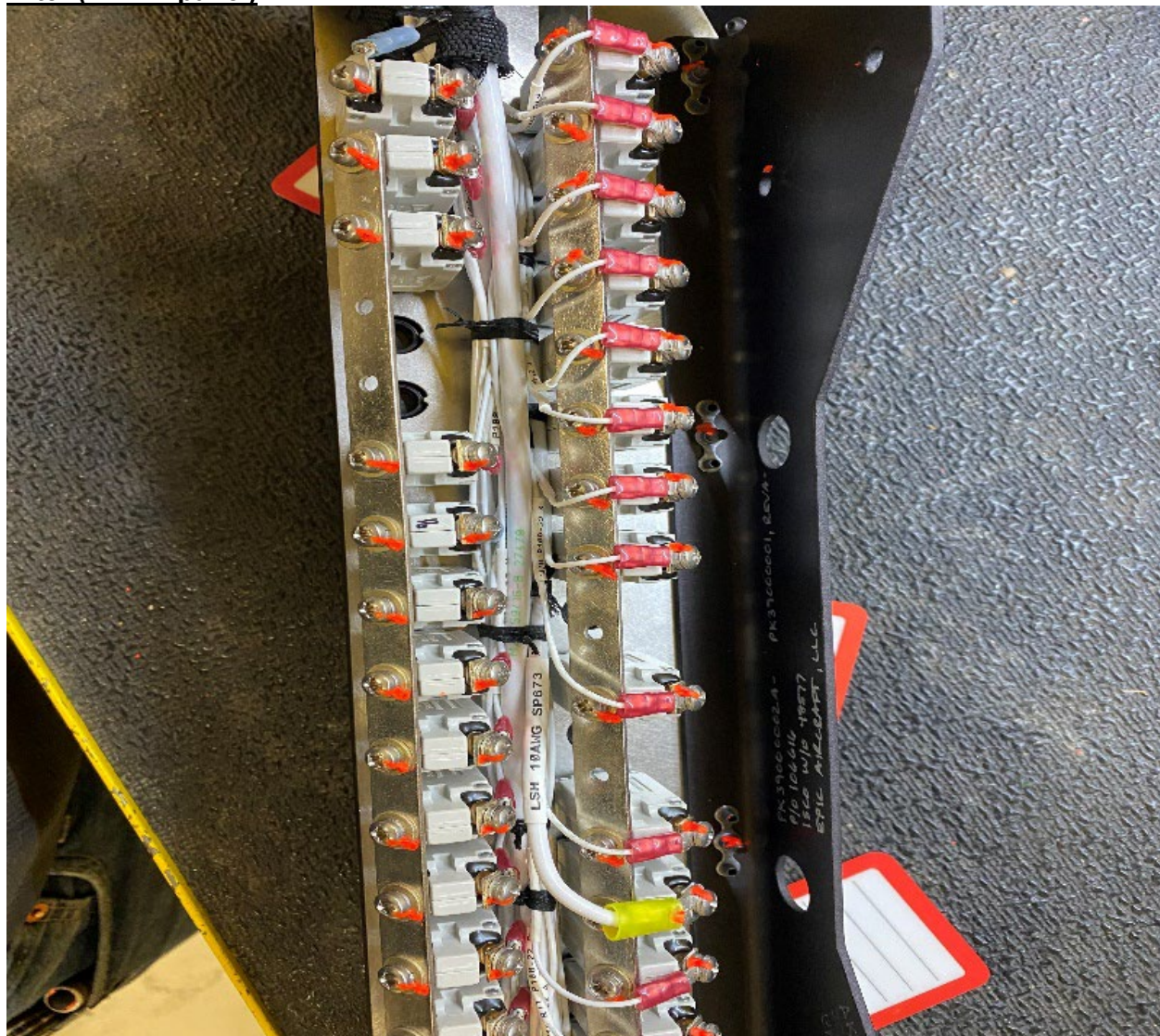
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 7 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

After (LH CB panel):



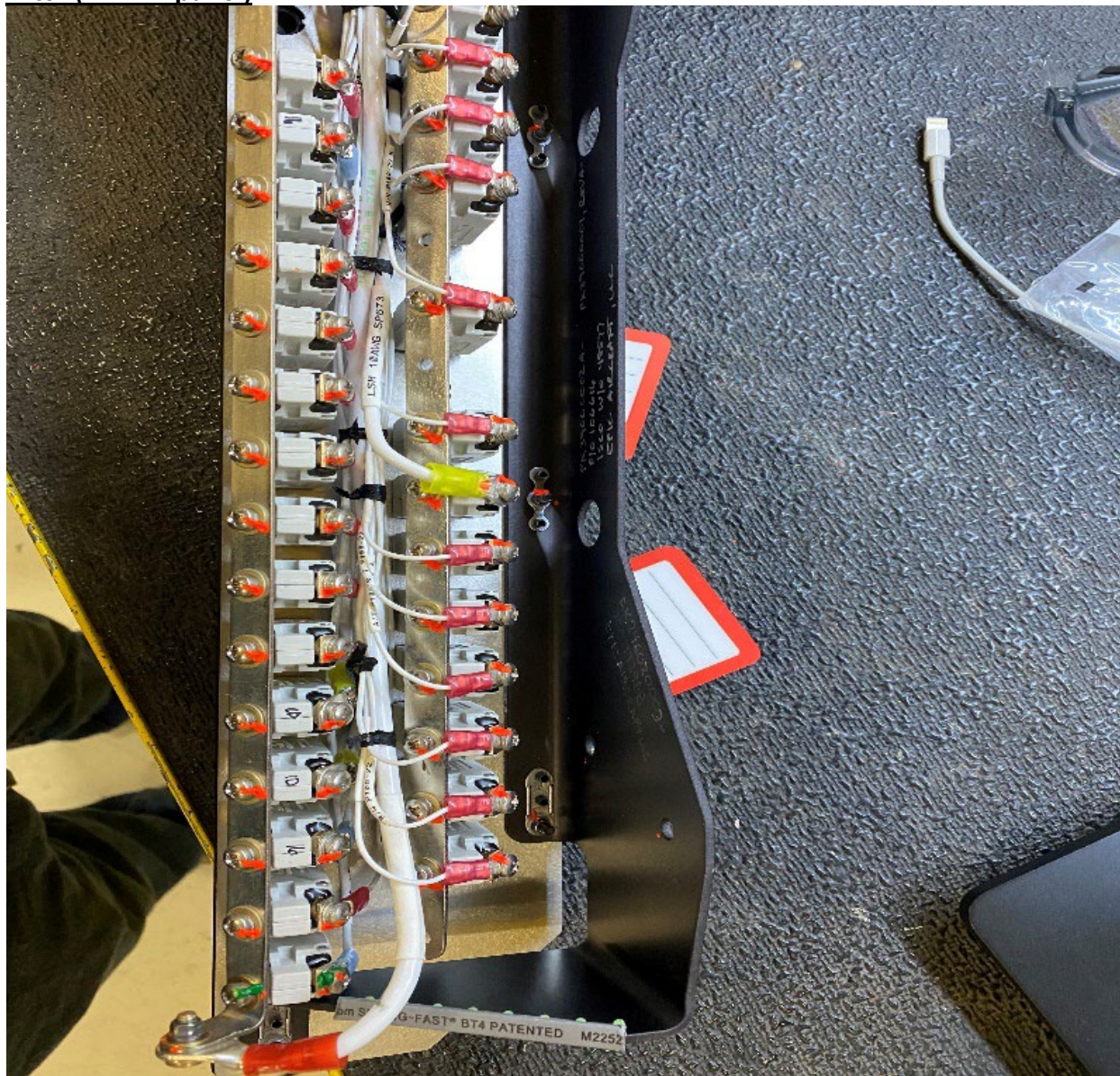
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 8 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

After (RH CB panel):



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 9 of 59

c. Instrument Panel - Left and Right Circuit Breaker Panels

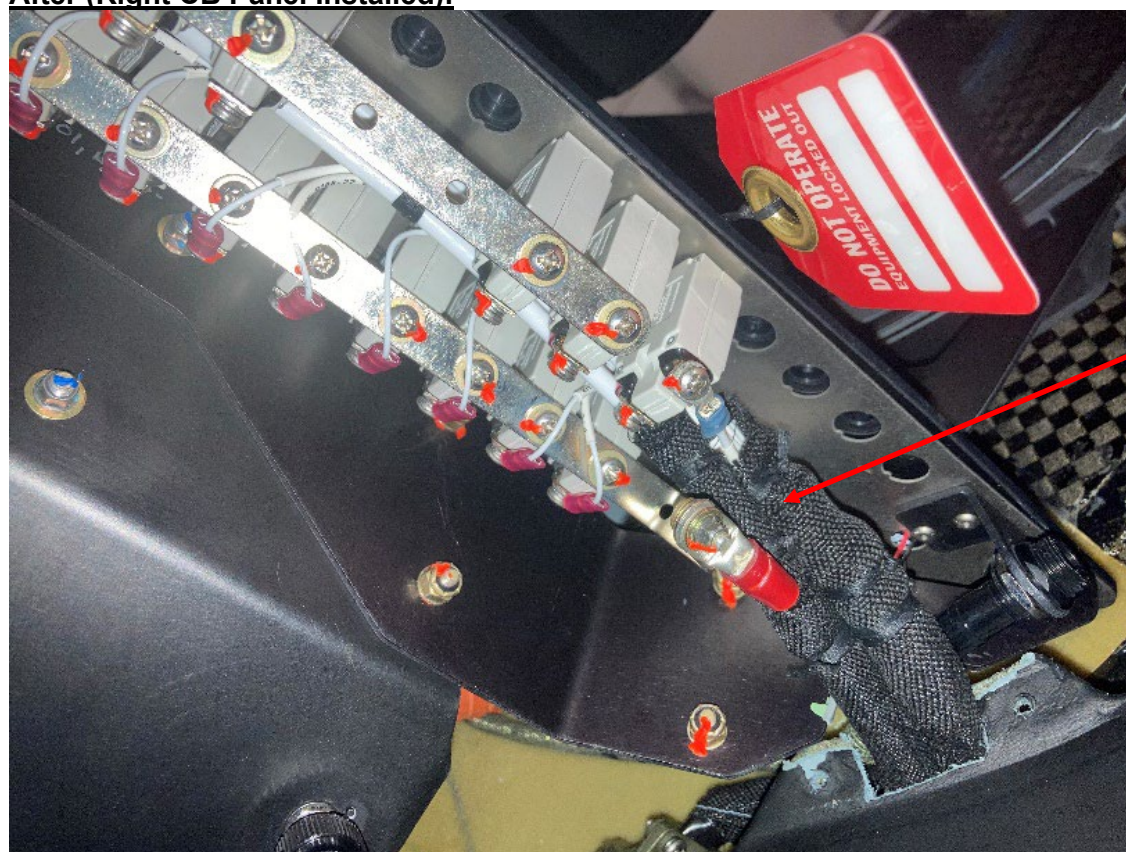
Location: Right Circuit Breaker Panel (Installed in Aircraft).

W/D: WK24600002

Harness: HK25100007, HK25100011

Action: Install Roundit on right circuit breaker panel wiring.

After (Right CB Panel Installed):



Install Roundit.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 10 of 59

Location: Left Circuit Breaker Panel (Installed in Aircraft).

W/D: WK24600002

Harness: HK25100007, HK25100011

Action: Install Roundit on left circuit breaker panel wiring.

After (Left CB Panel Installed):



Install Roundit.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 11 of 59

d. Underfloor – Ground Wires

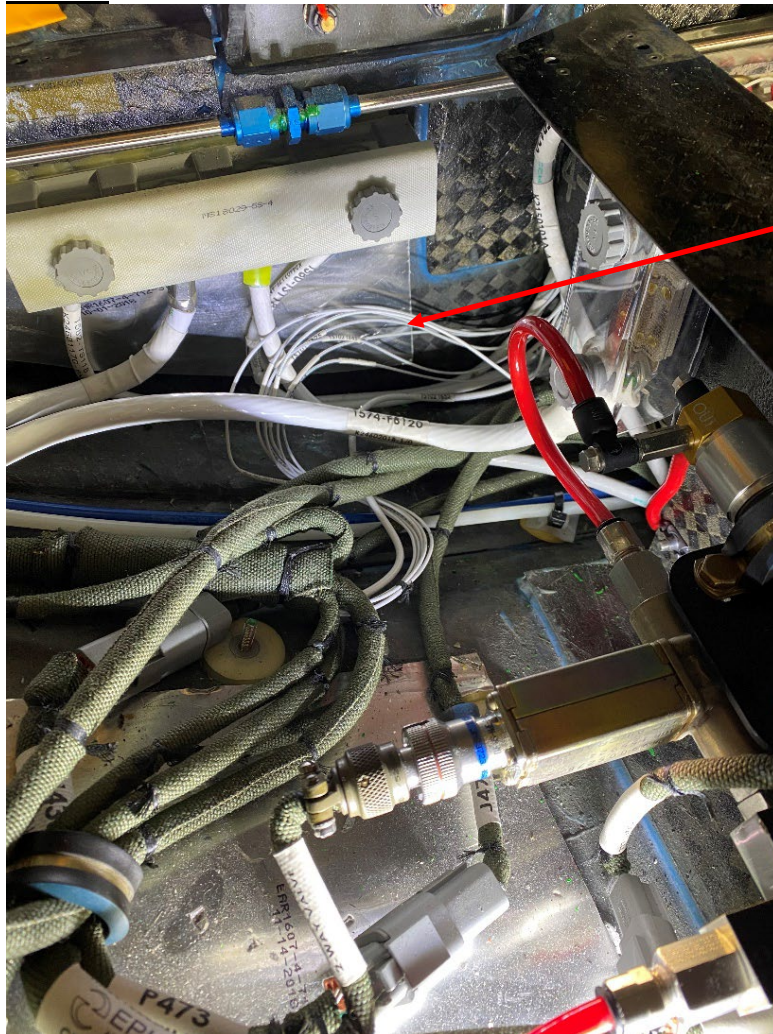
Location: Left underfloor.

W/D: WK34500001

Harness: HK25100006

Action: Bundle and install chafe protection on loose ground wires going to ground block TS101 & TS102.

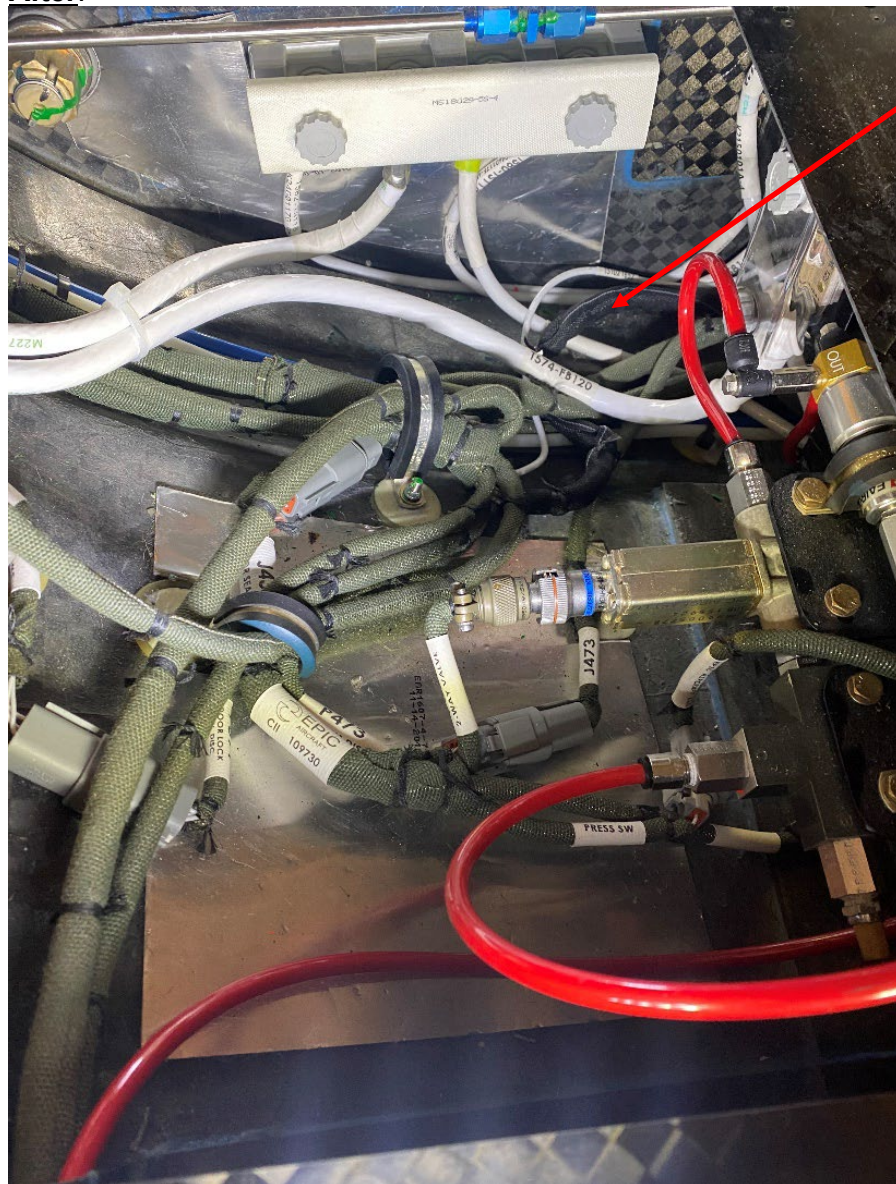
Before:



Loose ground wires.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 12 of 59

After:



Install Roundit.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 13 of 59

e. Instrument Panel - Main Cabin Harness

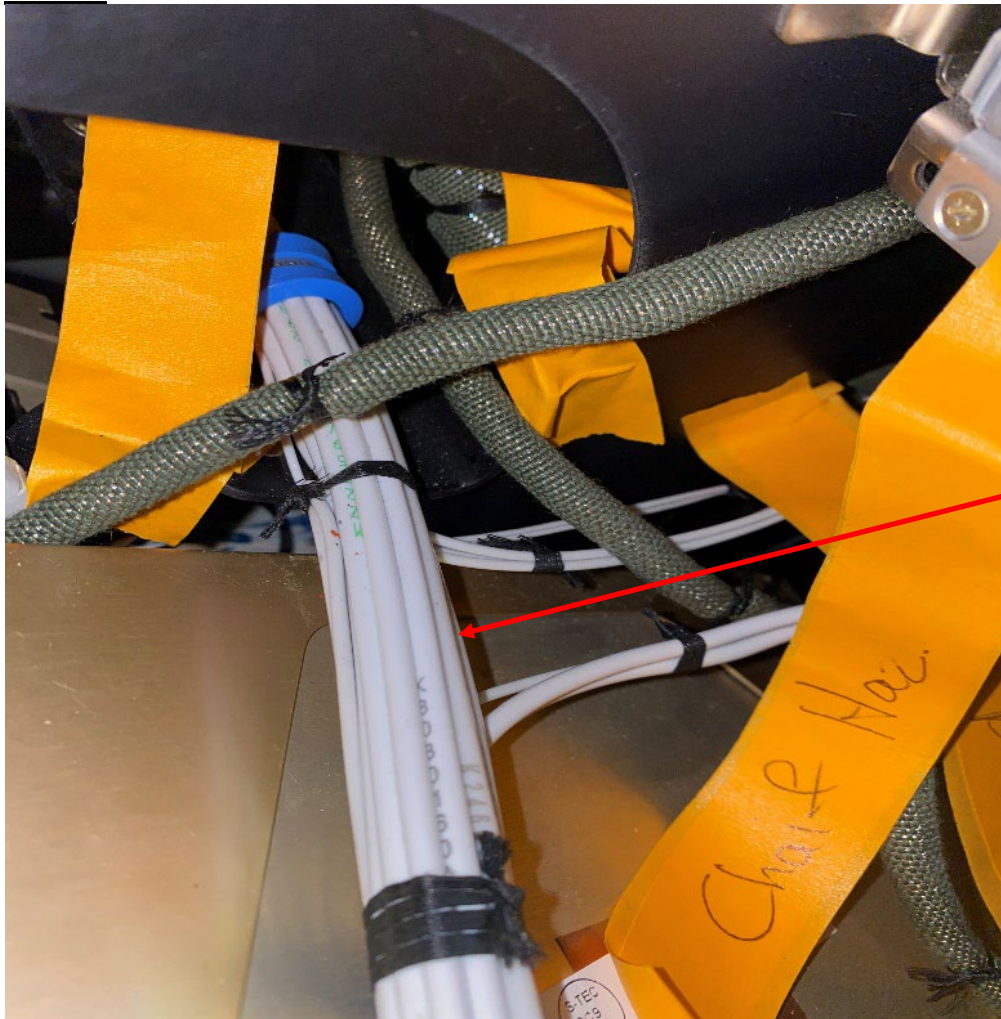
Location: Harness Assy, Main Cabin, Instrument Panel

W/D: Multiple

Harness: HK25100011

Action: Wires in the forward trough, behind both PFD's & MFD, along the front of the instrument panel, need Roundit on the 10 AWG harnesses and surrounding wires.

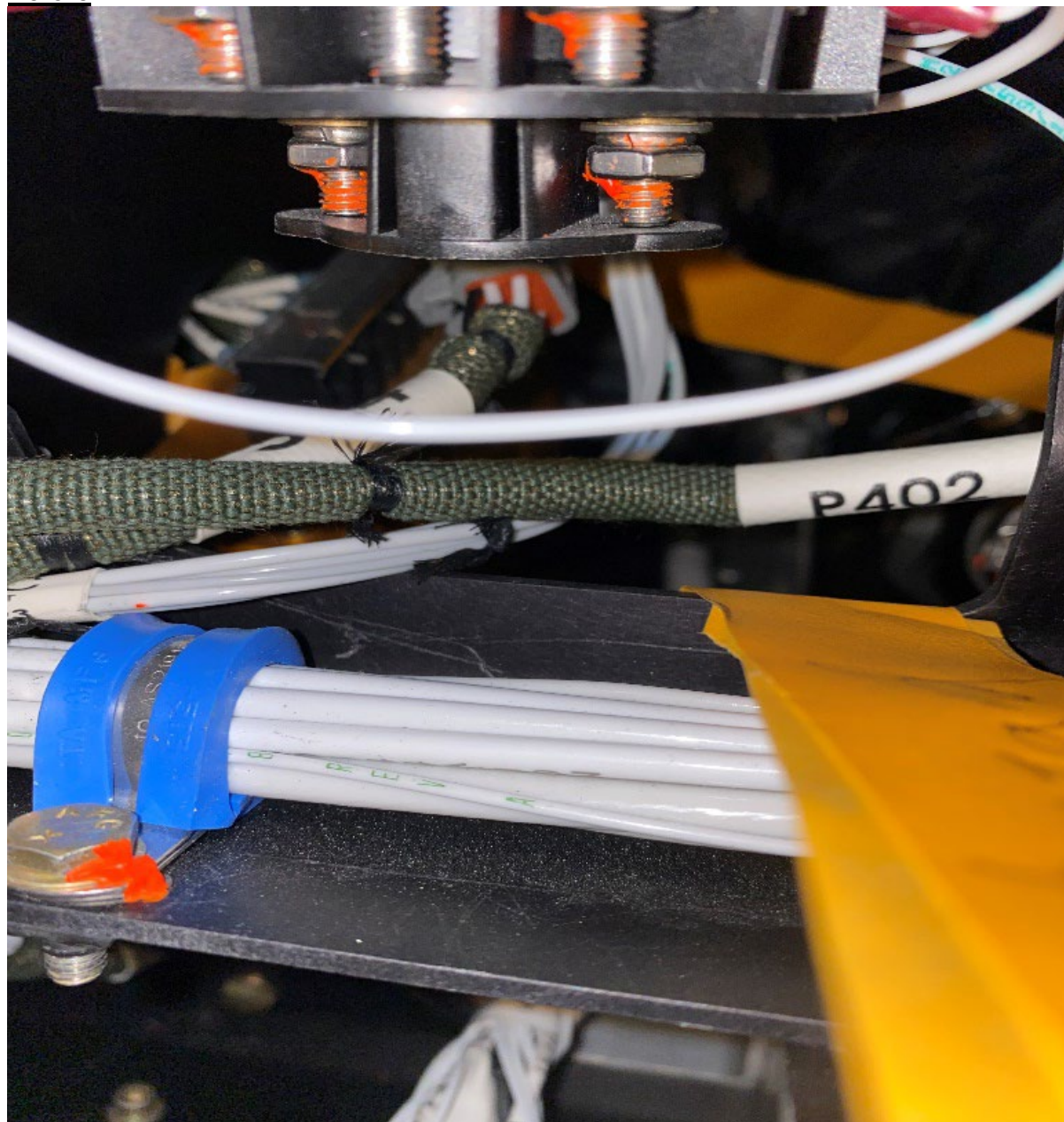
Before:



Exposed harness.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 14 of 59

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 15 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

After:



Install Roundit.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 16 of 59

f. Instrument Panel – 12 VDC Converter

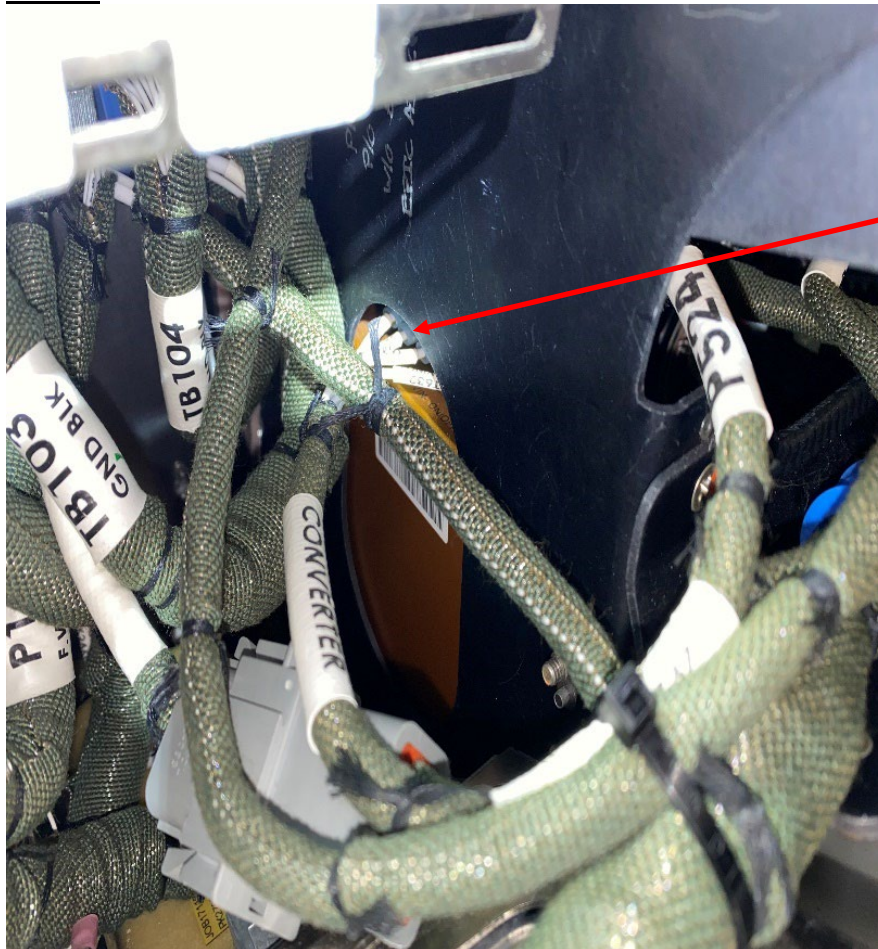
Location: 12 VDC Converter wiring

W/D: WK24600006

Harness: HK25100011

Action: Add edge protection on the exposed metal edges where harness crossed over to the converter.

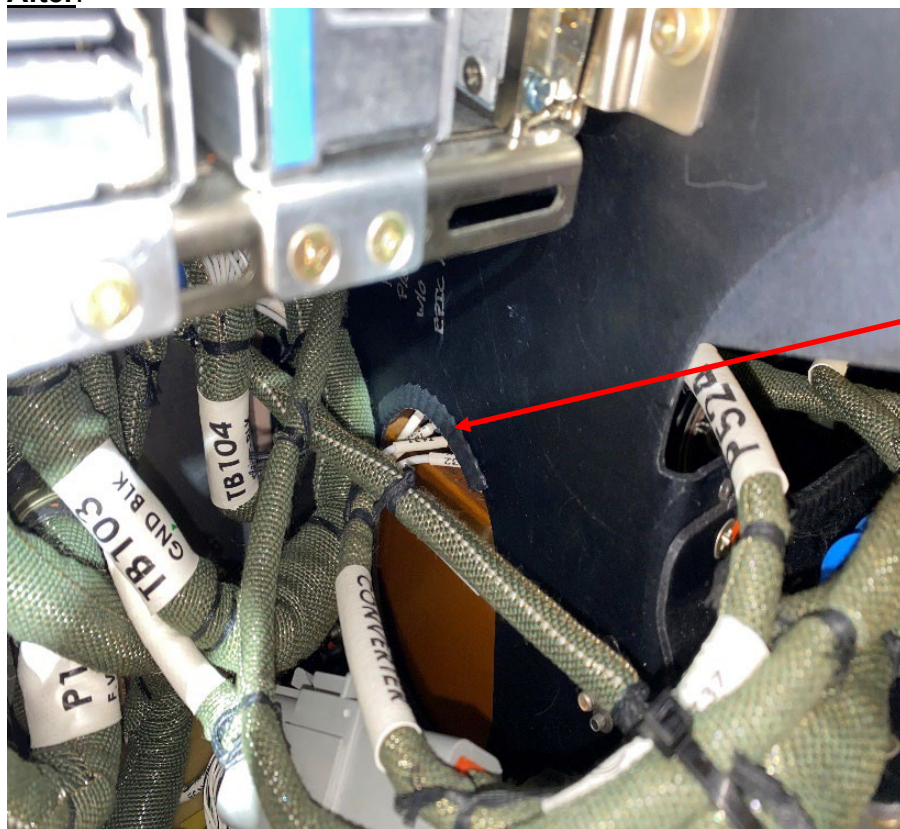
Before:



Chafe hazard.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 17 of 59

After:



Add edge protection.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 18 of 59

g. Instrument Panel – Test Switch Panel Assembly

Location: Test Switch Assy Panel (Removed from aircraft.)

W/D: WK77400001

Harness: -

Action: Add Roundit to protect bare wires.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 19 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 20 of 59

h. Instrument Panel – Right Switch Panel Assembly

Location: Right Switch Assy Panel (Removed from aircraft.)

W/D: WK30102001

Harness: -

Action: Add Roundit to protect bare wires, right switch panel.

Before:



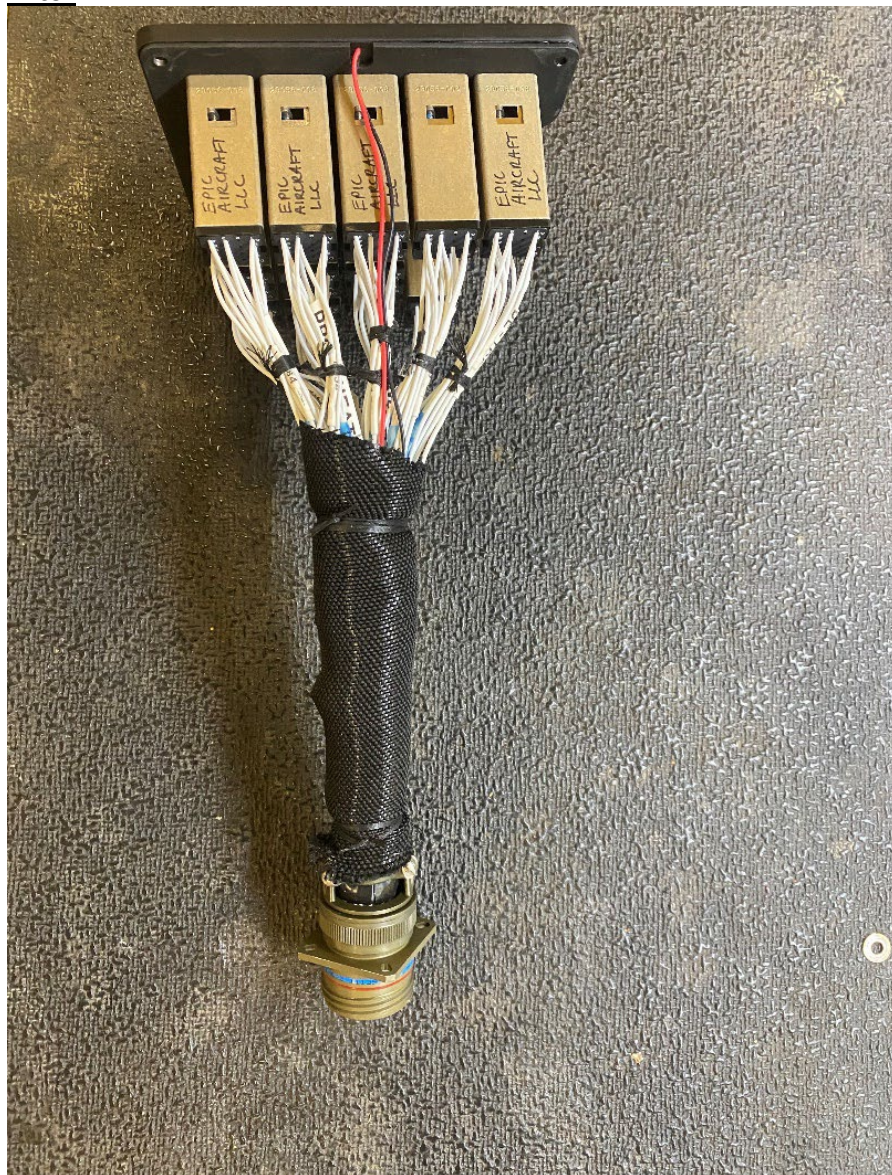
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 21 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 22 of 59

i. Instrument Panel – Climate Panel Assembly

Location: Climate Panel Assy (Removed from aircraft.)

W/D: WK21002001

Harness: -

Action: Add Roundit to protect bare wires.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 23 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 24 of 59

j. Instrument Panel – Left Switch Panel Assembly

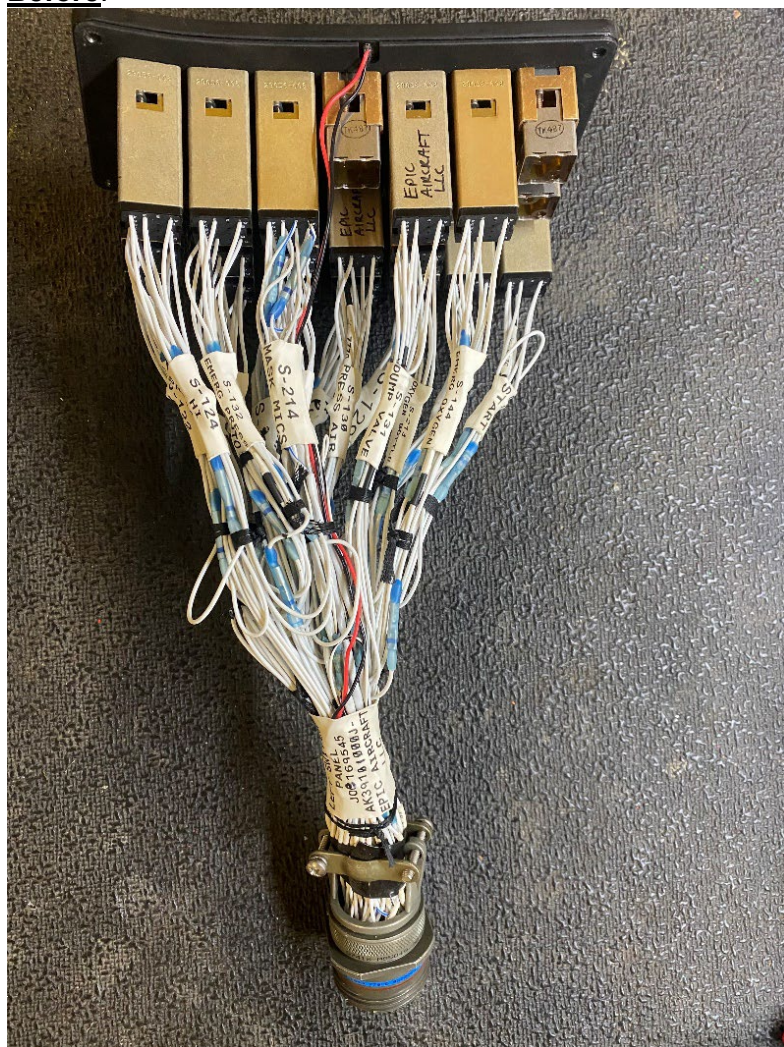
Location: Left Switch Panel Assy. (Removed from aircraft.)

W/D: WK24600002

Harness: AK39101000

Action: Add Roundit to protect bare wires.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 25 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 26 of 59

k. Windows

Location: Cabin Windows – Harnesses routed near stand-offs.

W/D: HK25100055

Harness: AK53503000

Action: Use tie mounts for window harness; DO NOT use sidewall panel stand-offs for routing/securing. Re-route wire harness to intended tie mount.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 27 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 28 of 59

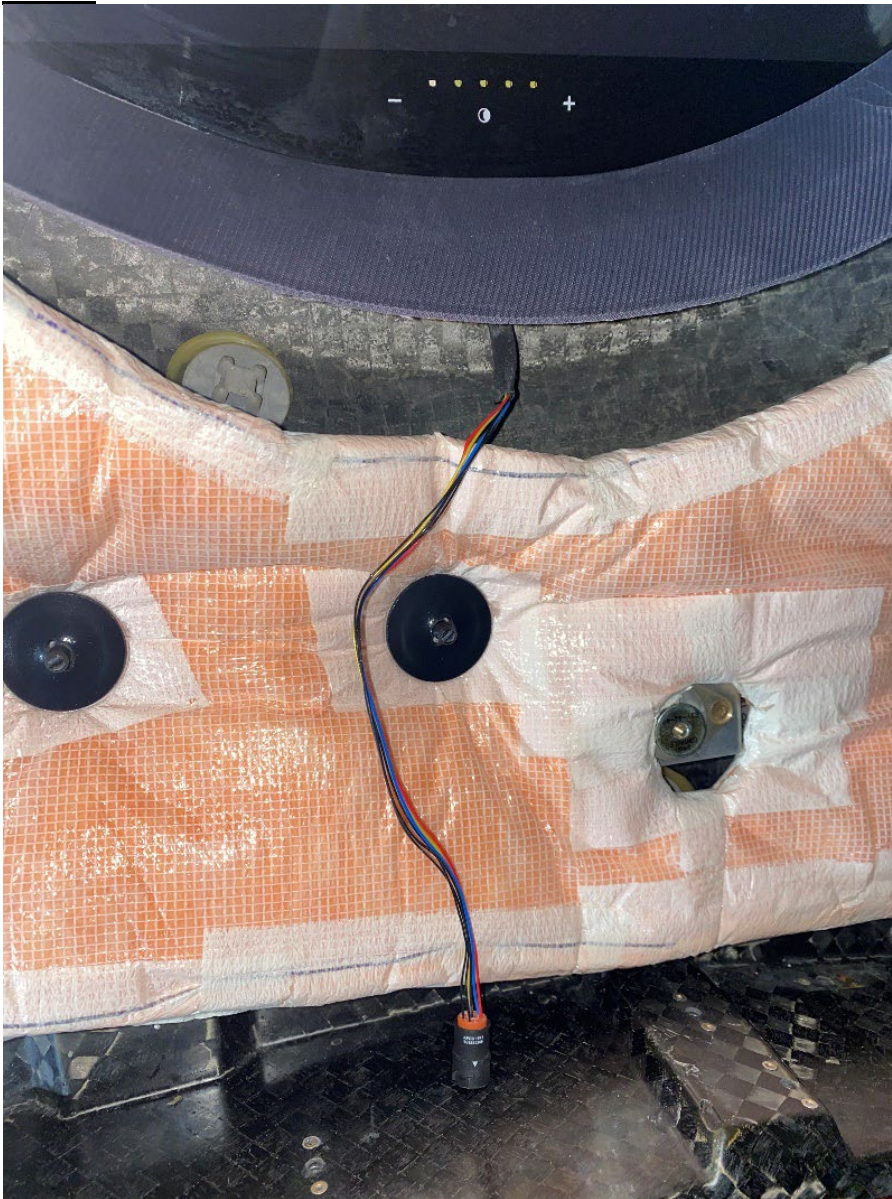
Location: Cabin Windows – Window Dimmer Wiring.

W/D: WK44600005

Harness: HK25100053

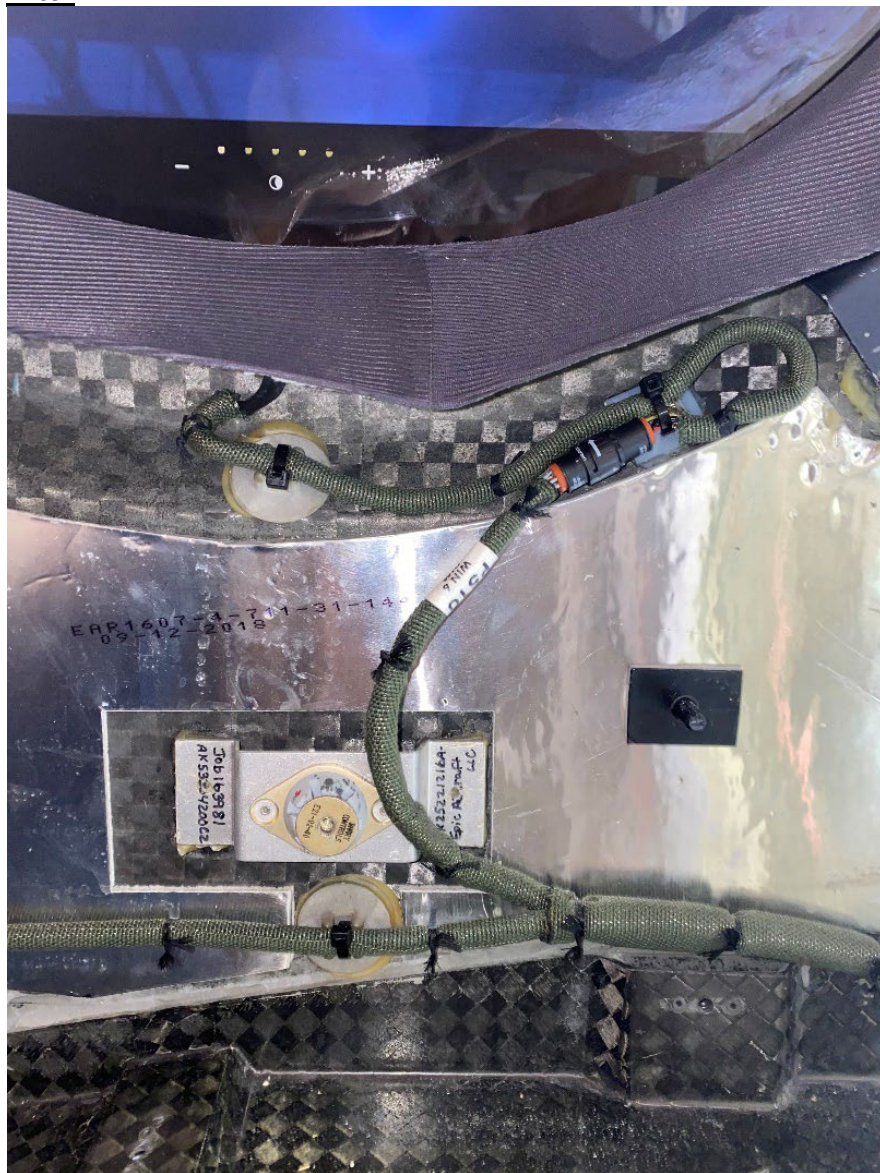
Action: Add Roundit to all windows dimmer wires.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 29 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 30 of 59

I. Co-Pilot's Armrest – COAX Cables

Location: Co-pilot's armrest.

W/D: WK34100003, WK3450001, WK34502001

Harness: AK53506000

Action: Add tie mounts at two locations for COAX antenna wires installed in the co-pilot's armrest.

Before:



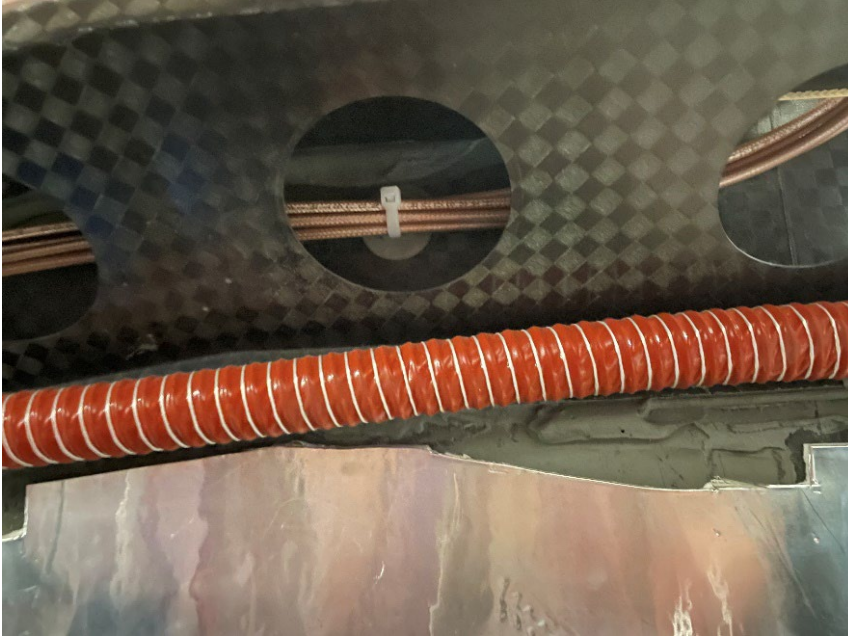
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 31 of 59



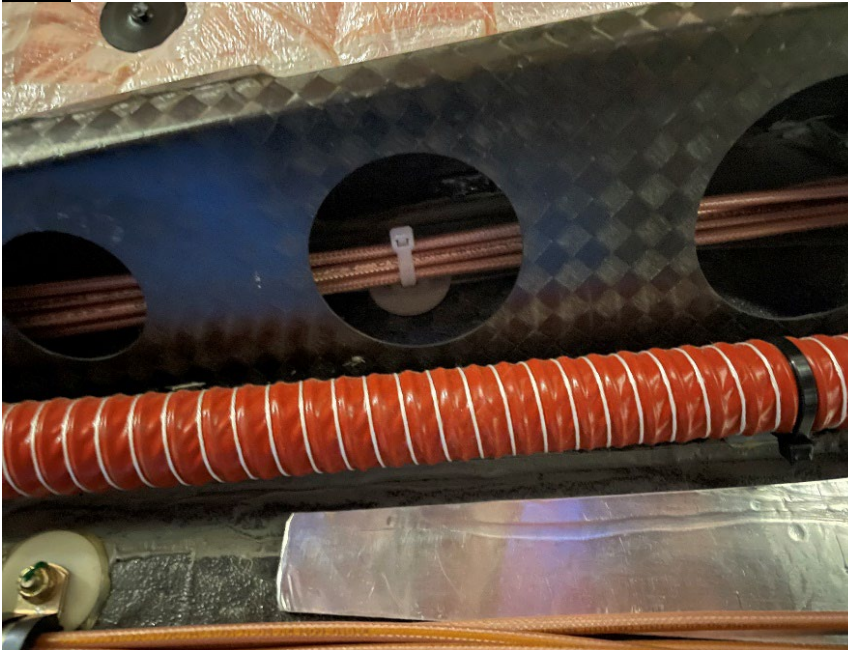
Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
Phone: 541-318-8849 ♦ Fax: 541-382-5125 ♦ Web: www.epicaircraft.com

After:



After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 32 of 59

m. Pilot's Floorboard – Electrical Connector

Location: Under pilot's floorboard.

W/D: WK22102001

Harness: HK25102011

Action: Secure connector under pilot's floorboard away from moving linkage using a tie mount as shown.

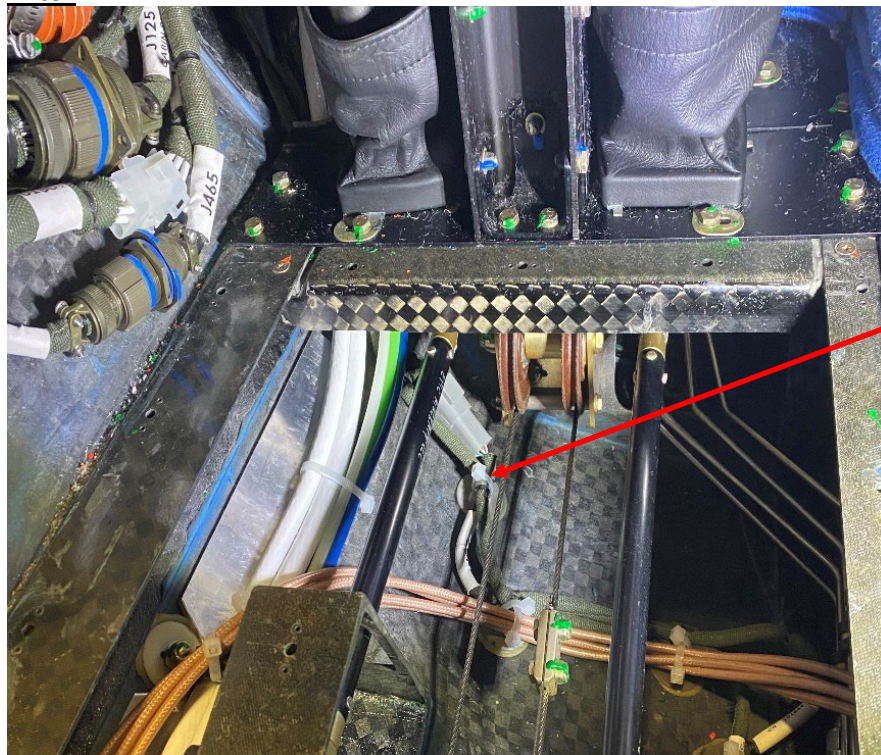
Before:



Contact with linkage.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 33 of 59

After:



Install tie mount as shown to keep the electrical connector away from the linkage.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 34 of 59

n. Vertical Stabilizer

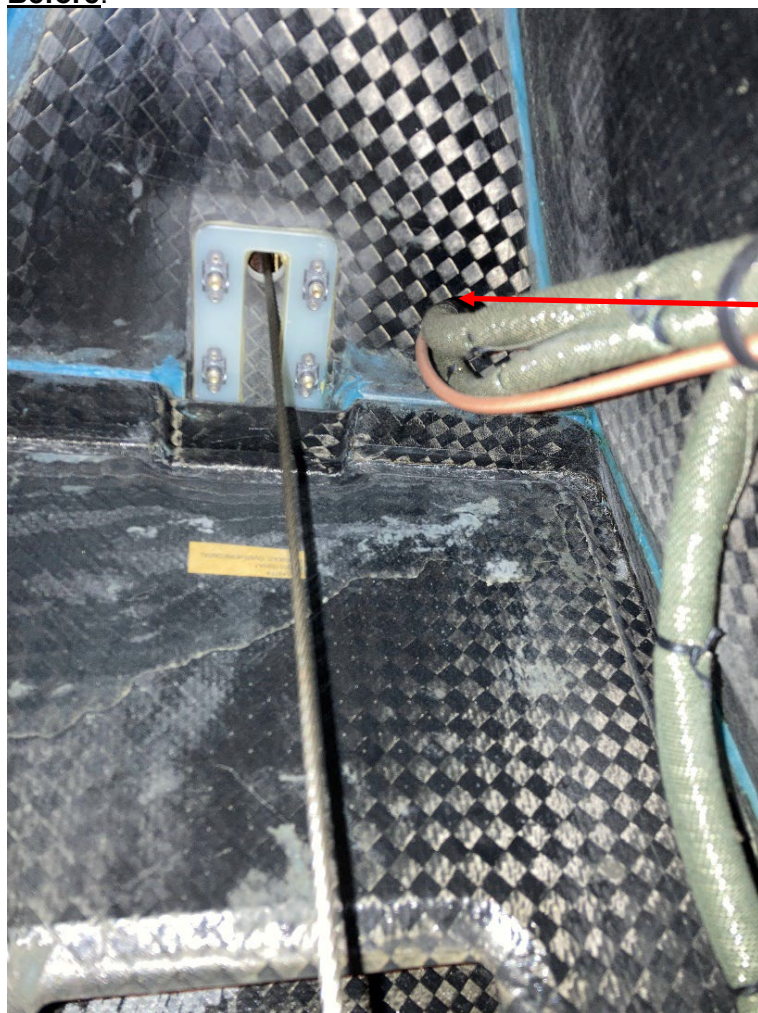
Location: Vertical Stabilizer, Forward

W/D: -

Harness: HK23005337

Action: Install edge protection at the pass-through hole.

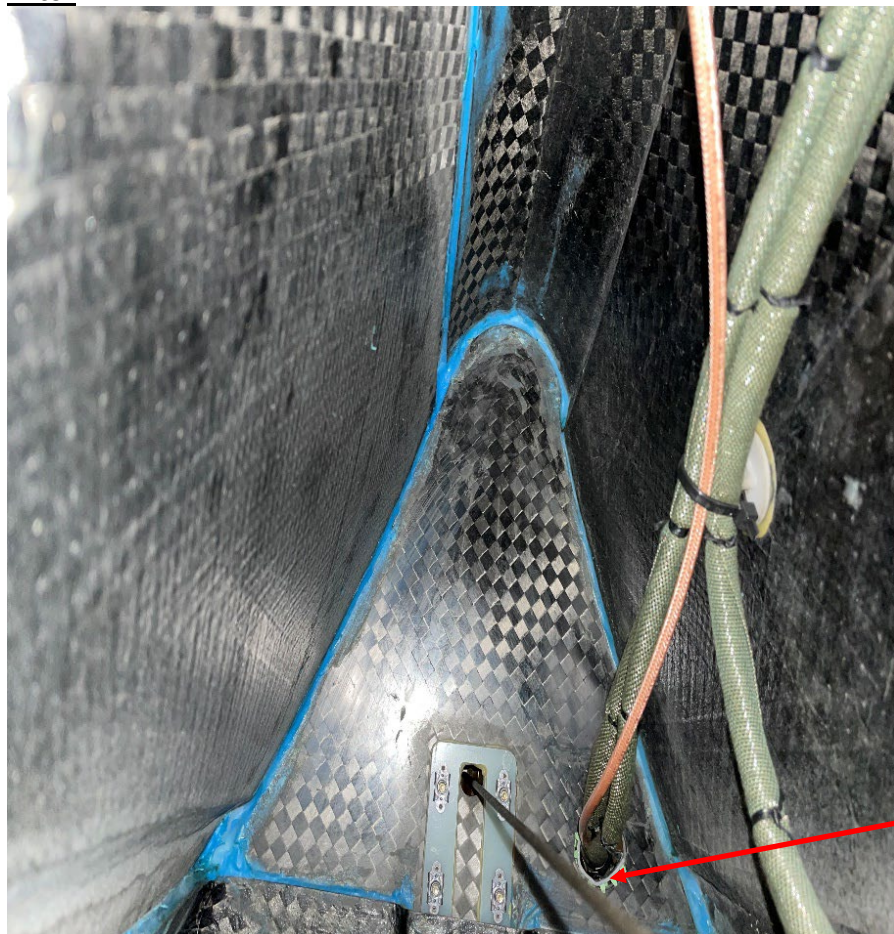
Before:



Chafe hazard.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 35 of 59

After:



Add edge protection.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 36 of 59

o. Empennage – Autopilot Servos

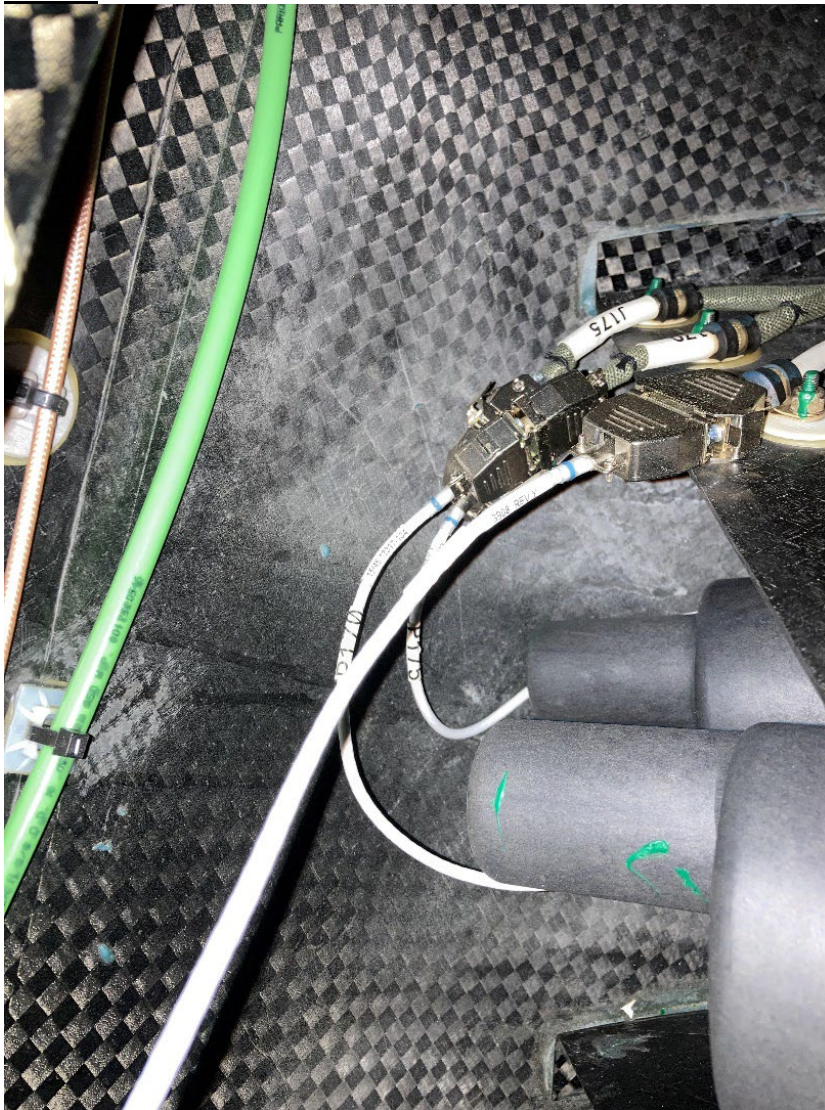
Location: Aft autopilot servos.

W/D: WK22100001

Harness: HK25100004

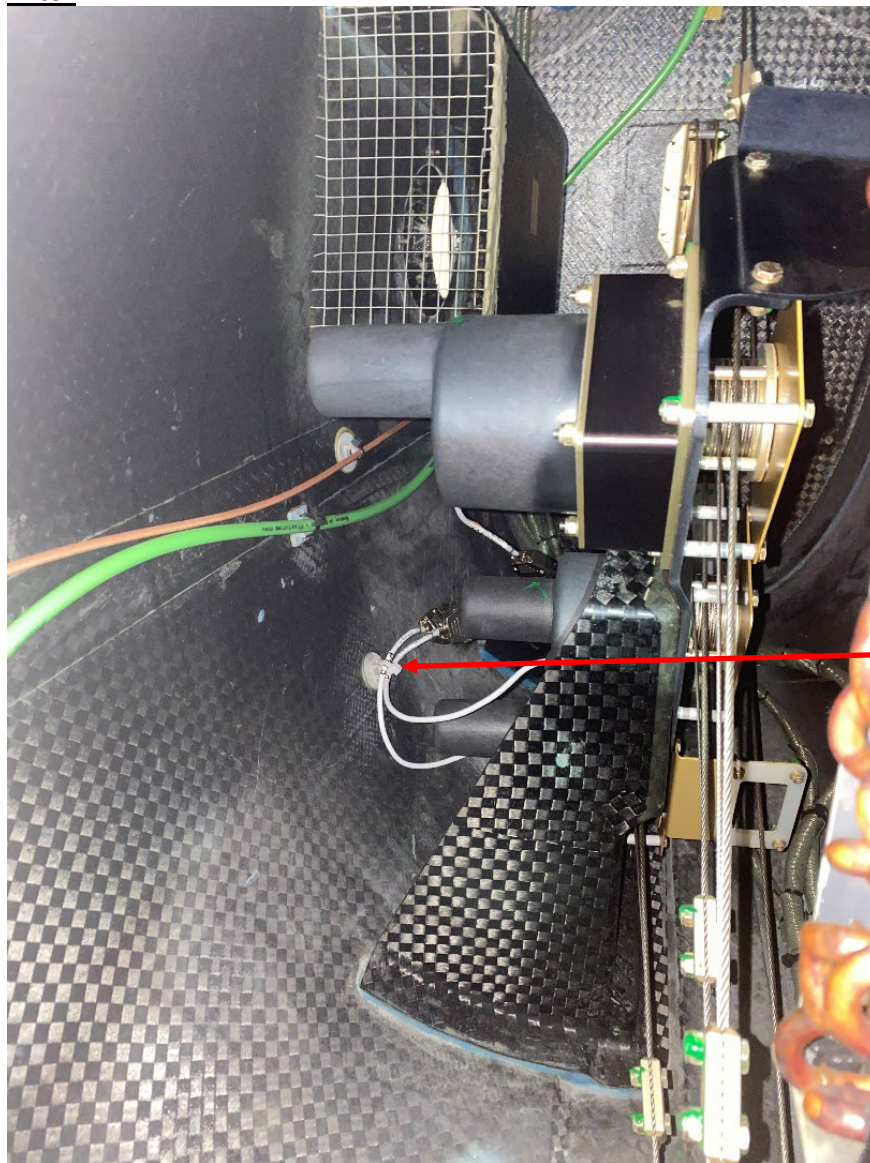
Action: Add tie mount to secure loose wires.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 37 of 59

After:



Add tie mount as shown.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 38 of 59

p. Vertical Stabilizer – Magnetometers

Location: Connectors above the Magnetometers.

W/D: WK34100001, WK34102001

Harness: HK25100003

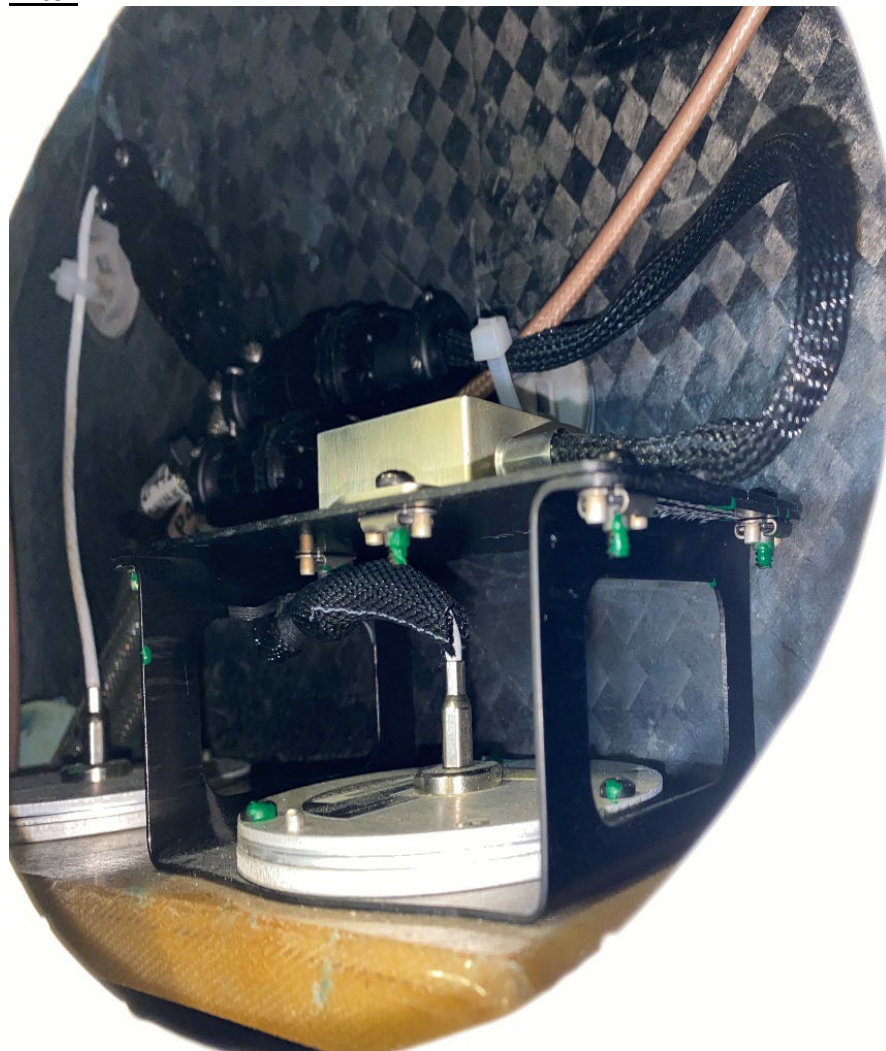
Action: Add 3 more tie mounts for the 3 connectors along with existing single point tie mount.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 39 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 40 of 59

q. Underfloor – Ground Wires

Location: Right cabin underfloor.

W/D: WK33200001

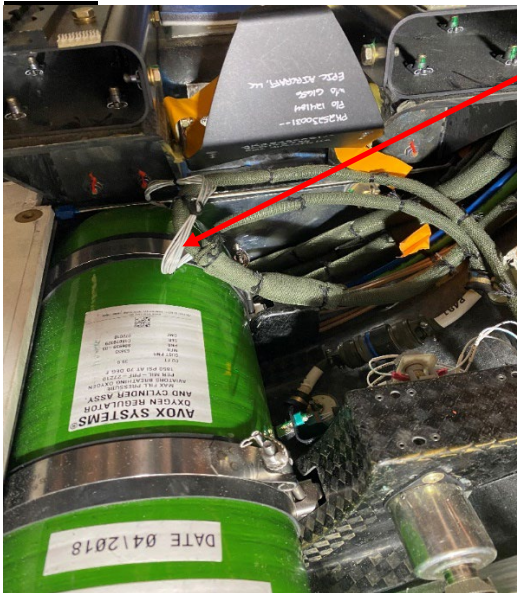
Harness: HK25100037

Action: Install Roundit on ground wire bundle up to the TS101/102 ground block.

Before:



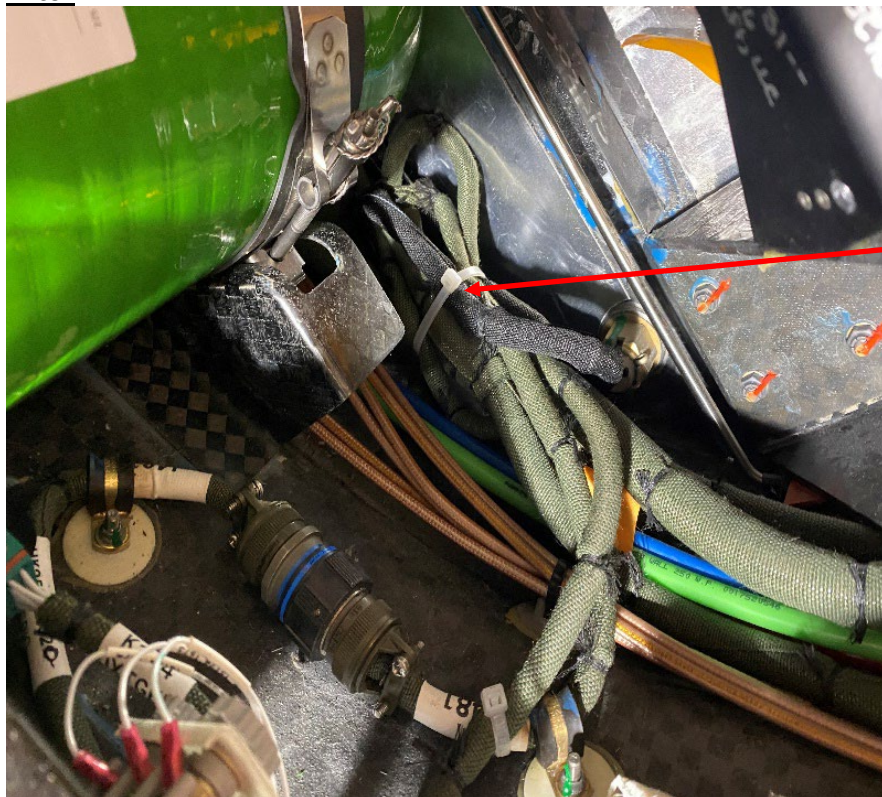
Before:



Ground wires.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 41 of 59

After:



Install Roundit
and route with
other harnesses
using a tie-wrap.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 42 of 59

r. Empennage – Aft Bulkhead, Right Side

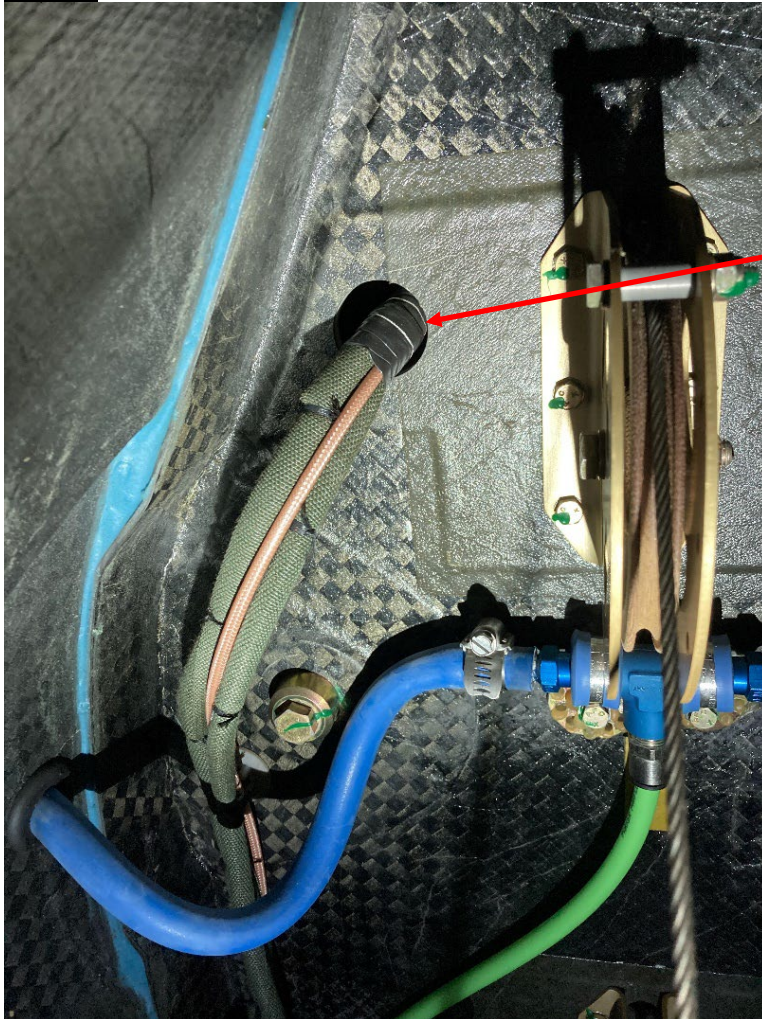
Location: Right side of upper elevator pulley.

W/D: -

Harness: -

Action: Install edge protection at the pass-through hole.

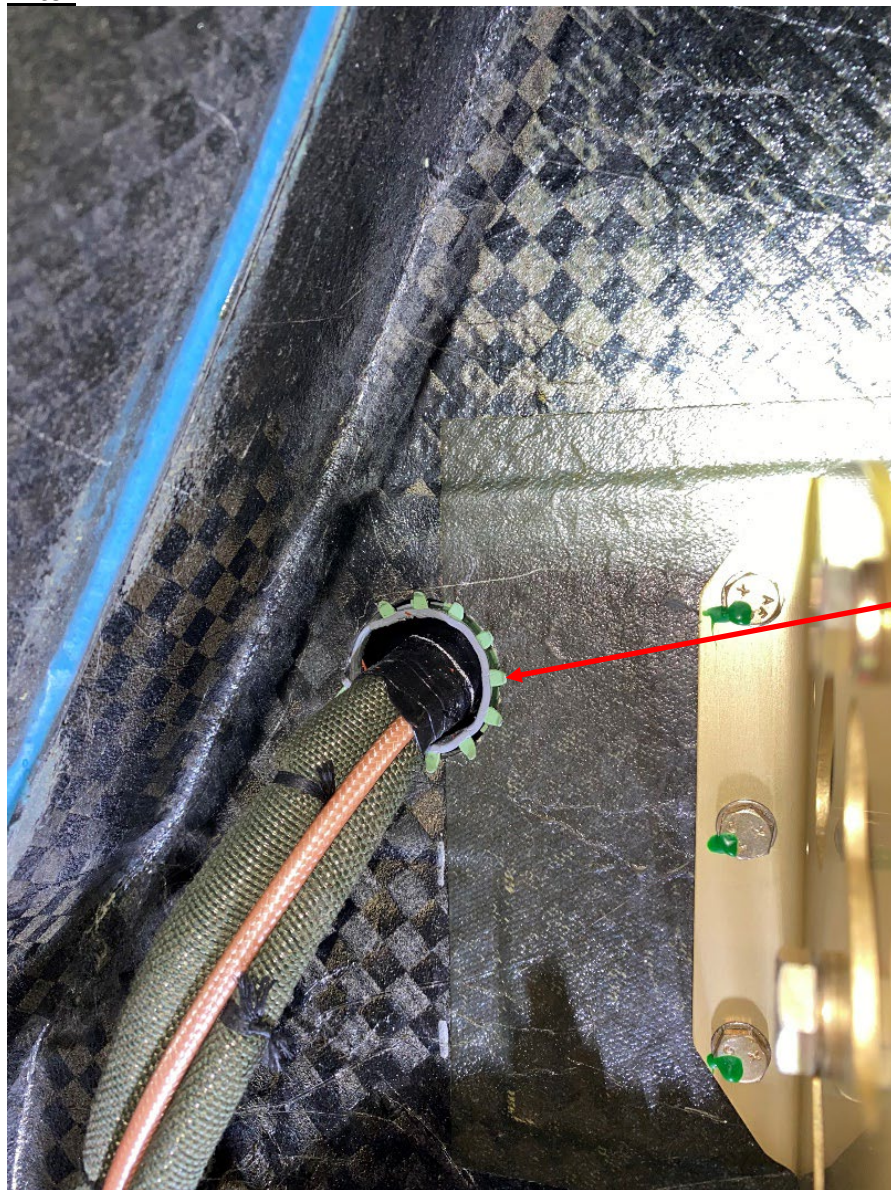
Before:



Chafe hazard.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 43 of 59

After:



Add edge protection.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 44 of 59

s. Fuselage – Cabin Door

Location: Door Sensors (Entrance)

W/D: WK52700001

Harness: HK25100047

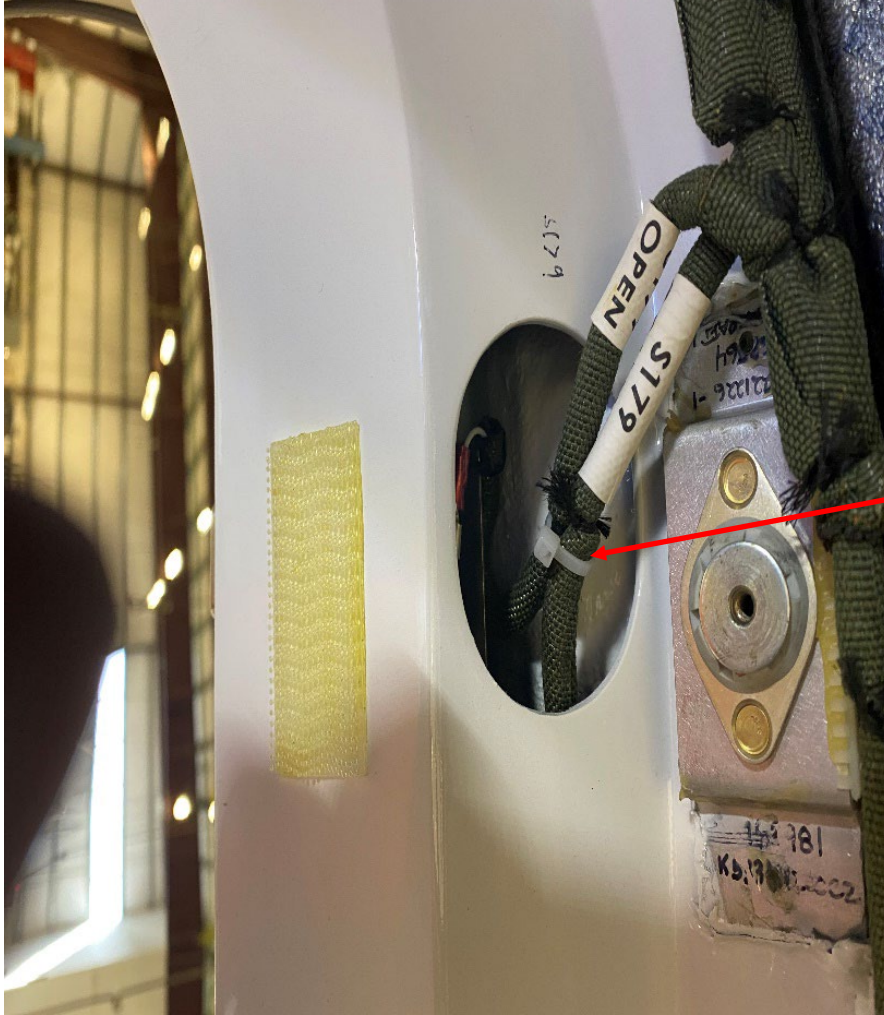
Action: Added tie straps to help secure wires for door sensors, at 8 different locations around the doorway

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 45 of 59

After:



Add tie straps at
8 door switches.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 46 of 59

t. Wing Tip Fuel Sensors

Location: Left and Right Wing Tips

W/D: WK28400001

Harness: HK25100016

Action: Install tie mount to prevent the harness and connector from contacting the nutplates. Re-clock the terminals on the fuel probe and install tie mount to secure the harness on the wing rib.

Before:



Chafing hazard.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 47 of 59

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 48 of 59

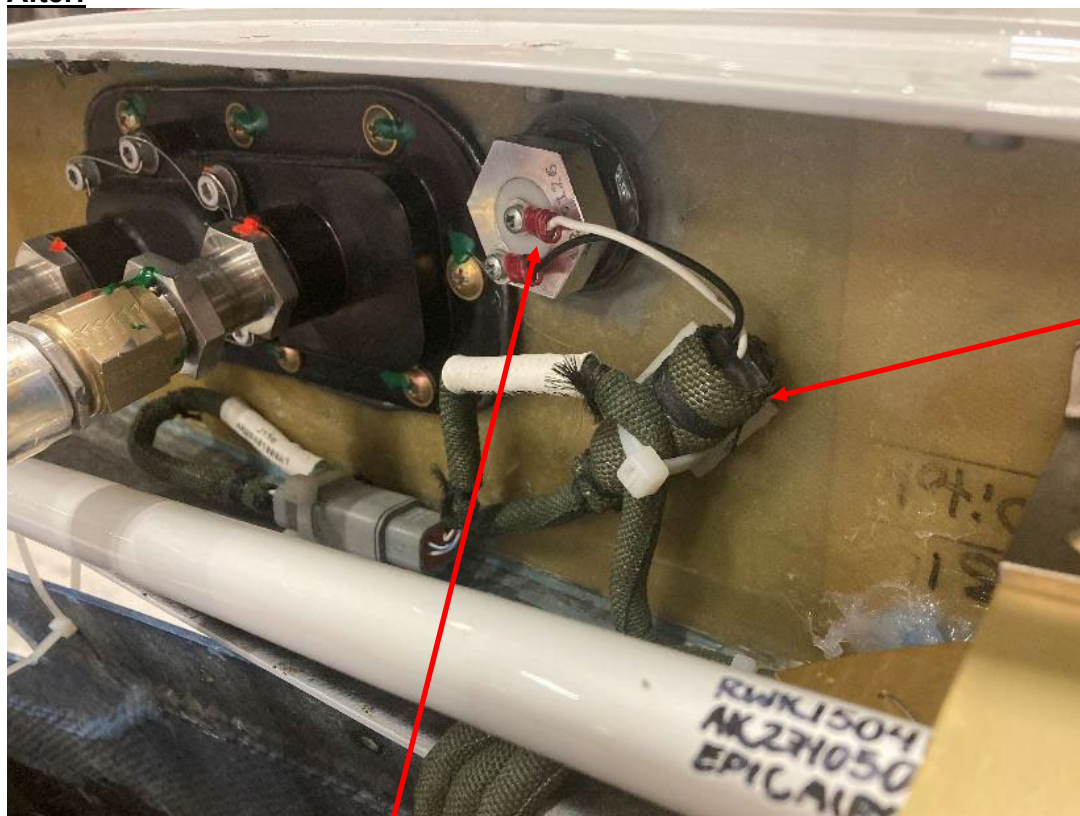
After:



Install tie mount to prevent the connector and harness from contacting the nutplates.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 49 of 59

After:



Re-clock
terminals.

Install tie mount
to secure the
harness to the
wing rib.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 50 of 59

u. Firewall Forward – Fuel Flow Sensor

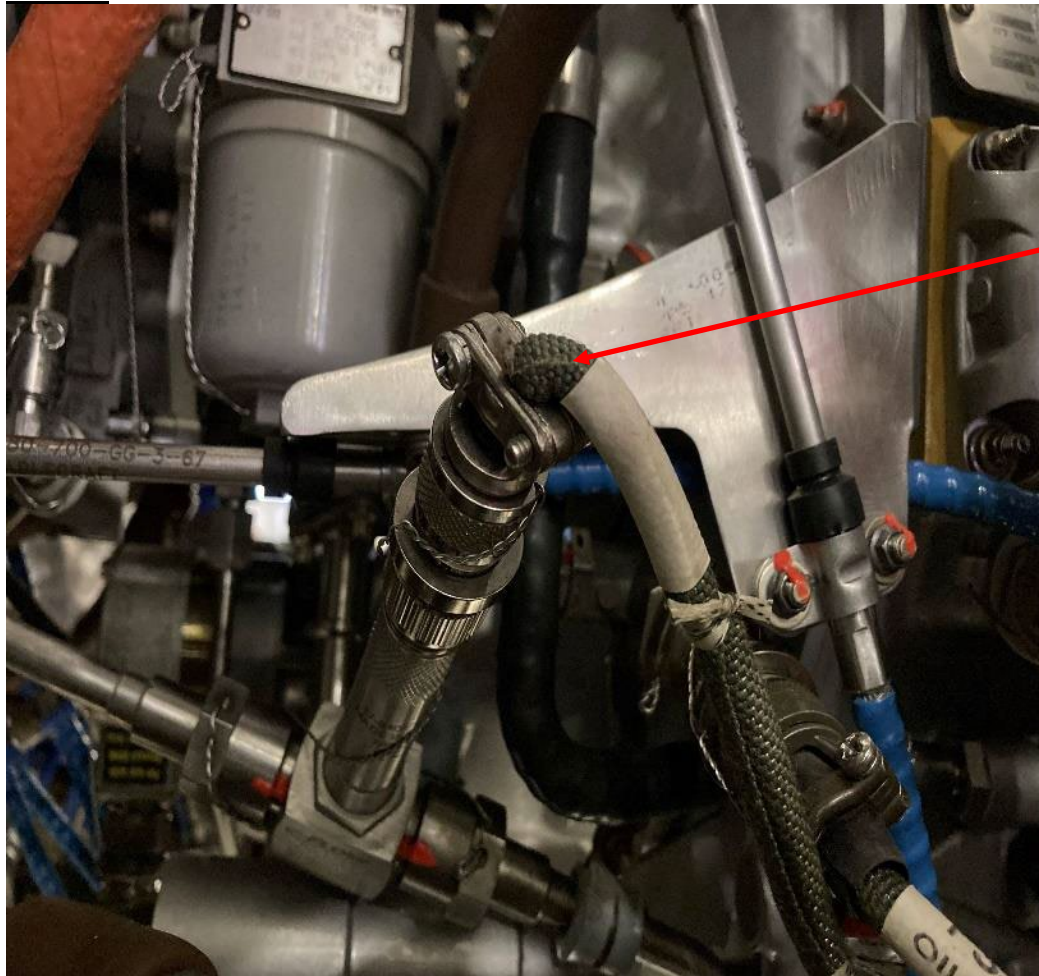
Location: Engine – Aft right side.

W/D: WK77400001

Harness: HK25100018

Action: Re-rout harness as shown to relax tight bend.

Before:



Excessive
bend.

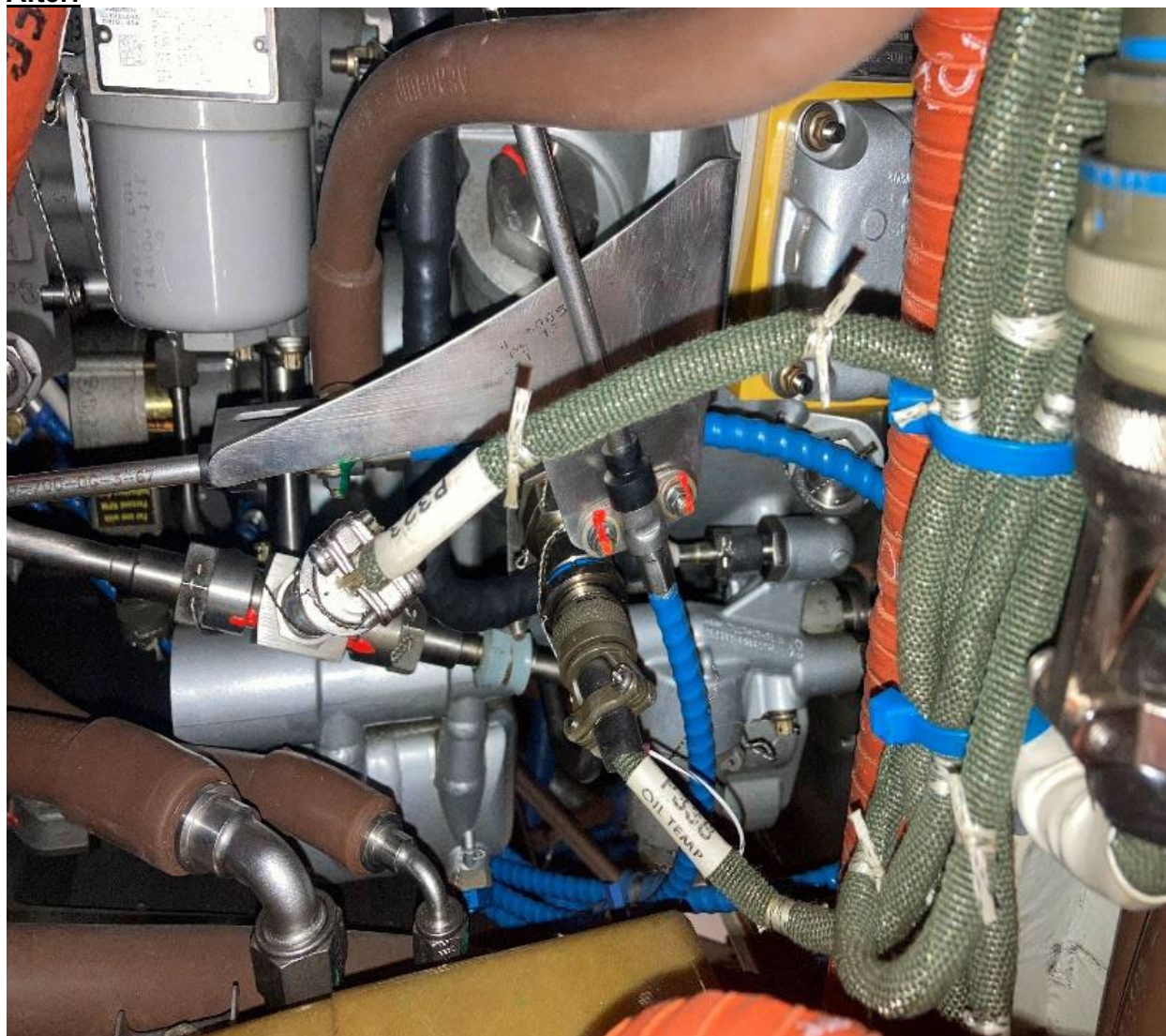
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 51 of 59



Service Bulletin SB-0025

Epic Aircraft, LLC ♦ 22590 Nelson Road ♦ Bend OR 97701
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After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 52 of 59

v. Firewall Forward – MCU

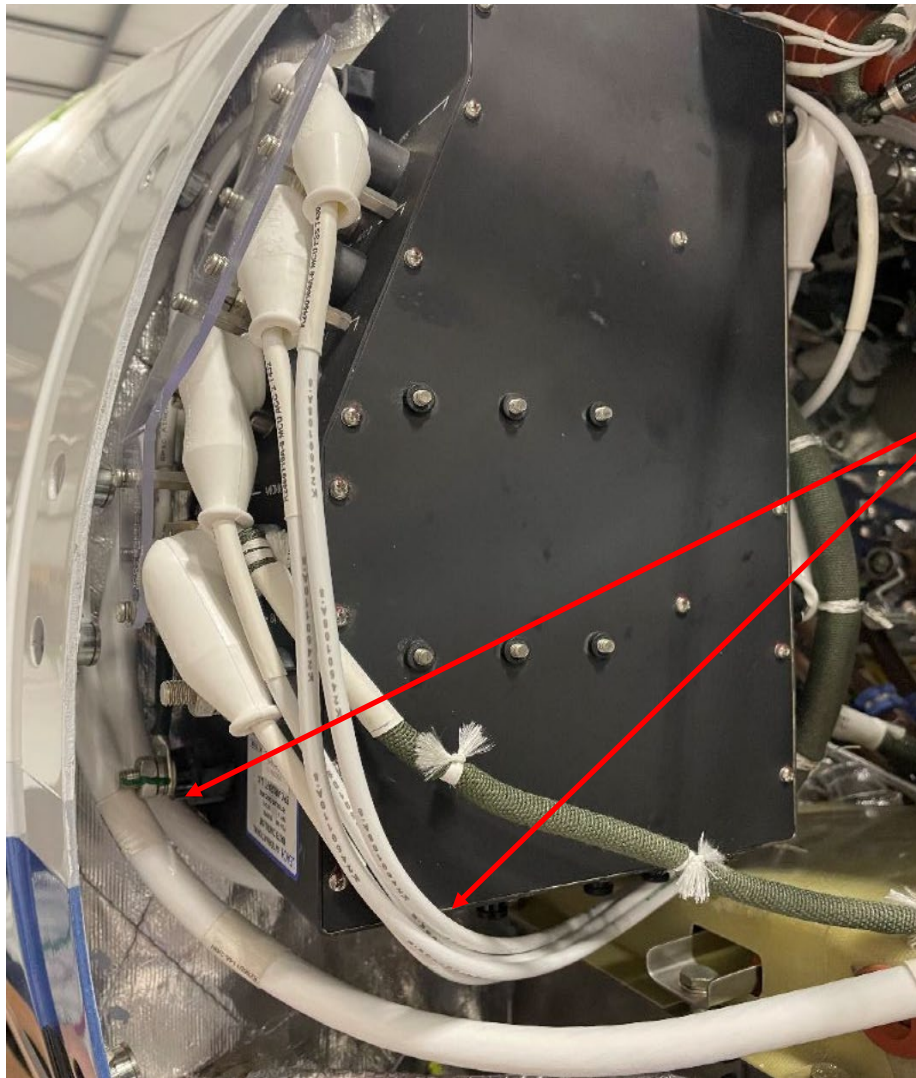
Location: Right forward firewall.

W/D: -

Harness: -

Action: Install Roundit on power wires to prevent damage from MCU case and ground stud.

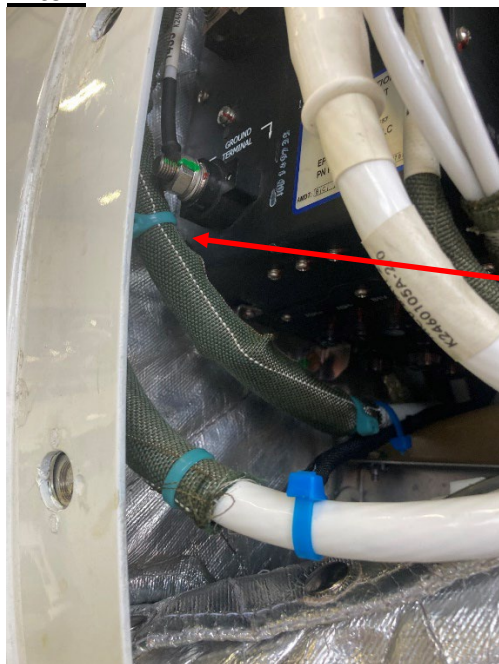
Before:



Chafe hazard.

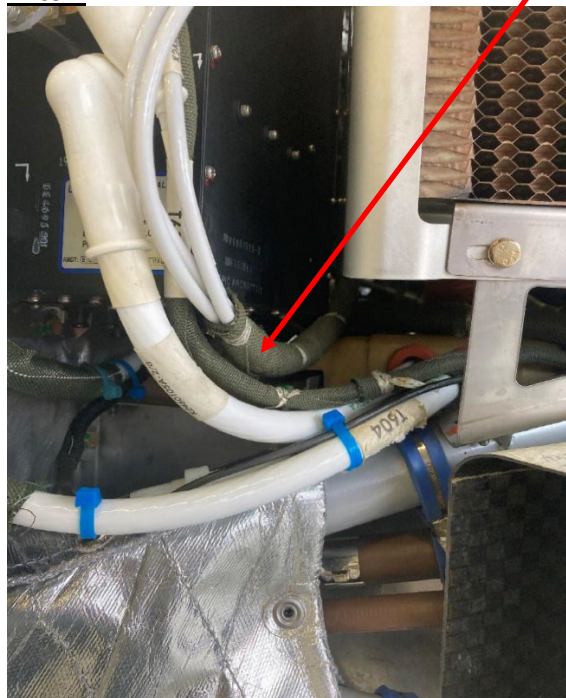
Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 53 of 59

After:



Install Roundit

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 54 of 59

w. Cockpit – Center Pedestal

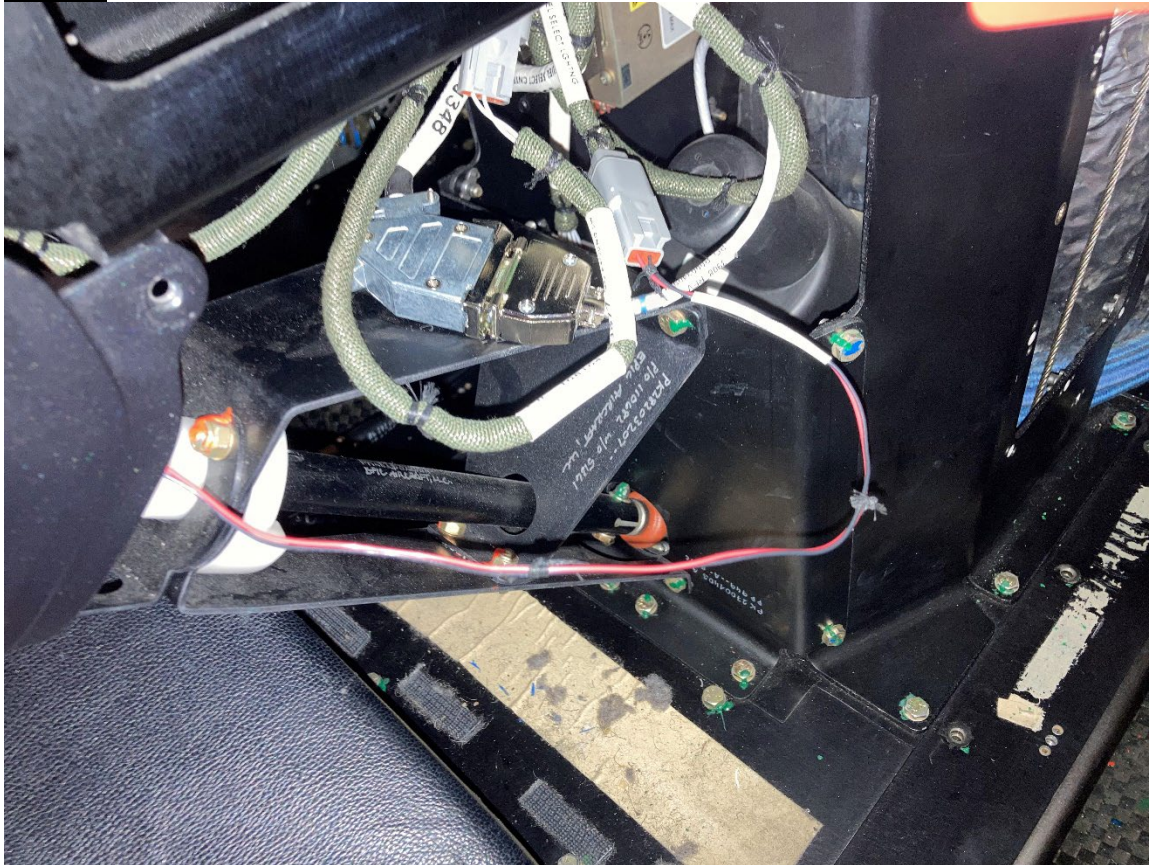
Location: Center pedestal with pedestal panel removed.

W/D: -

Harness: -

Action: Use tie wraps and tie mounts to secure the wire harnesses and connectors in the pedestal away from the fuel selector mechanism.

Before:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 55 of 59

After:



Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 56 of 59

x. Landing/Anti-Collision Light Harnesses

Location: Left- and Right-Wing Tips

W/D: WK33400001

Harness: HK25100015/HK25100016

Action: Make sure all zip tie mounts for the landing/anti-collision light harnesses are securely bonded to the wing tip. Re-bond if needed.

Inspect:



Zip Tie Mounts

Left Side Shown, Right Side Opposite

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 57 of 59



Service Bulletin SB-0025

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12. Install PFD 1, PFD 2, and the MFD (refer to the E1000 AMM PN SK05000000, chapter 34-40).
13. Install the Left, Right, Climate, and Test Switch panels (refer to the E1000 AMM PN SK05000000, chapter 24-60).
14. Install the left and right circuit breaker panels (refer to the E1000 AMM PN SK05000000, chapter 24-60).
15. Install the pressure bulkhead access panel (refer to the E1000 AMM PN SK05000000, chapter 21-30).
16. Install the upper and lower crew finish panels (refer to the E1000 AMM PN SK05000000, chapter 25-10).
17. Install the upper and lower passenger finish panels (refer to the E1000 AMM PN SK05000000, chapter 25-20).
18. Install the left- and right-wing tips (refer to the E1000 AMM PN SK05000000, chapter 57-30).
19. Install the engine cowling (refer to the E1000 AMM PN SK05000000, chapter 71-10).
20. Connect external electrical power to the airplane (refer to the E1000 AMM PN SK05000000, chapter 24-40).
21. Set the BATT 1 and BATT 2 switches to ON.
22. Operationally check all removed components.
23. Set the BATT 1 and BATT 2 switches to OFF.
24. Disconnect external electrical power from the airplane (refer to the E1000 AMM PN SK05000000, chapter 24-40).

9 **WEIGHT AND BALANCE:**

Negligible

10 **PUBLICATIONS AFFECTED:**

N/A

11 **RECORD COMPLIANCE:**

Make appropriate entry in airplane maintenance records.

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 58 of 59



Service Bulletin SB-0025

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Appendix A: Compliance Letter

Please complete and mail this form to Customersupport@epicaircraft.com

This is to certify that I have completed the work in accordance with the Epic Aircraft, LLC Service Bulletin.

Aircraft Owner Information:

Date: _____ Aircraft Serial Number: _____ Aircraft Reg. Number: _____

Owner's Name: _____

Maintenance Entity Information

Name of Shop Performing the work: _____

Name of Person(s) Performing inspection and/or work: _____

Phone Number: _____ Email: _____

Issued	Revised	Revision	Page
1/5/2022	02/21/2023	B	Page 59 of 59