Service Instruction SI-0008

Technical Portions FAA Approved

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

Subject: Main Landing Gear Up-lock Contact

ATA-Code: 32-10

Labor: 4.0

Effectivity: K004

Affected Model(s): E1000

Due: Before the next flight.

Compliance: Recommended ☐ Mandatory ☒

Recurrence: No

1 BACKGROUND AND PURPOSE:

It has been found that the up-lock hooks have made contact with the MLG forks while complying with SB-0003

This Service Instruction provides the procedure to repair damage caused by this condition.

2 REFERENCES:

Epic E1000 Airframe Maintenance Manual, PN SK05000000

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 TOOLS:

No.	Description	Qty	Epic Aircraft Supplied	Customer Supplied
1.	Common Hand Tools	A/R	☐	☒

5 PARTS/MATERIALS:

No.	Part Number	Description	Qty	Epic Aircraft Supplied	Customer Supplied
1.	MIL-DTL-5541	Conversion Coating	A/R	☐	☒
2.	MIL-PRF-23377	Primer	A/R	☐	☒

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6 INSTRUCTIONS:

A) Measure the damage.

1) Using a dial indicator zeroed on the surface adjacent to the damage, measure the depth at its deepest point.

Note: Zero the dial indicator in an area with the paint and primer removed.

- If the damage is 0.026” or less, proceed with the repair.

- If the damage is greater than 0.026” contact Epic Aircraft.

B) Blend the damage out to a 40:1 slope.

Example: Damage that measures 0.015” in depth will require a blend-out distance of 0.600” for a total repair area of 1.200”

C) Apply a conversion coating to the repair as follow:

Caution: Abrasives containing iron such as steel wool, iron oxide, rouge, or steel wire are prohibited for all cleaning operations. Treated parts that have become soiled shall be cleaned with materials that will remove the soil without damaging the base metal, the part, or the conversion coating.

a) Prior to coating, the base metal shall be mechanically or chemically cleaned using 225S (phosphoric acid) cleaner diluted with 2 parts water, such that a water break-free surface is obtained after rinsing. While the aluminum surface is still wet, rinse thoroughly with clear water or wipe with a clean damp cloth. Allow surface to air dry or wipe dry with a clean cloth.

b) Apply chemical conversion coating conforming to MIL-DTL-5541 to cleaned aluminum non-electrolytically by spray, brush, or immersion for two to five minutes. Apply only an amount that can be coated and rinsed before the solution dries. Flush surface with cold water, or mop with a damp synthetic sponge rinsed occasionally in clean water. Allow surface to dry before painting.

Note: Chemical conversion coating (chromic acid) per MIL-DTL-5541 is amber in color and is not to be diluted.

D) Prime with Type I, Class C1 or C2 epoxy primer conforming to MIL-PRF-23377.

E) Paint the repaired area (refer to the Epic E1000 Airframe Maintenance Manual, PN SK05000000, Chapter 51-20).

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7 WEIGHT AND BALANCE:

Negligible

8 PUBLICATIONS AFFECTED:

N/A

9 RECORD COMPLIANCE:

Make appropriate entry in airplane maintenance records.

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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 Instruction.

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: _____