



Service Bulletin SB-0053

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

Subject: Emergency Door Rigging Inspection

ATA-Code: 52-20

Labor: 2 hours

Effectivity: K003-K045

Affected Model(s): E1000, E1000 GX

Due: As soon as practical

Compliance: Required

Recurrence: No

1 BACKGROUND AND PURPOSE:

The purpose of this Service Bulletin is to verify proper installation and function of Emergency door escape latch.

2 REFERENCES:

Epic E1000 Aircraft 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 APPROVAL:

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

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 1 of 9



Service Bulletin SB-0053

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5 TOOLS:

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

6 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.	AK52201001	Assy, Hinge, Top Latch, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2.	PK52201010	Lever, Top Latch, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3.	PK52201014	Hinge Plate, Top Latch, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4.	PK52201012	Pull Pin, Top Latch, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
5.	PK11300040	Placard, Lever, Top Latch, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
6.	PK52201011	Spacer, Hinge, Emergency Escape	A/R	<input checked="" type="checkbox"/>	<input type="checkbox"/>
7.	CR3213-4-06	Cherry Uni-head Rivet, Aluminum ø1/8 x .474	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>
8.	CR3212-4-02	Cherry C'sunk Rivet Aluminum ø 1/8 x .224	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>
9.	CR3212-4-06	Cherry C'sunk Rivet, Aluminum Ø 1/8 x .474	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>

<u>Issued</u>	<u>Revised</u>	<u>Revision</u>	<u>Page</u>
09-27-2023	N/A	Original release	Page 2 of 9



Service Bulletin SB-0053

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7 **INSTRUCTIONS:**

1. Remove emergency door handle access panel.
2. Using an inspection mirror inspect the hinge for damage and correct installation as follows:
 - a. Make sure the emergency escape top latch hinge (located behind the emergency exit handle) is installed properly and aligns with perimeter of emergency escape hinge spacer as shown in Figure 2.
 - b. Make sure there is no damage of any kind to the hinge, including but not limited to: cracks, bending or distortion of the hinge plates, or loose or missing rivets.
 - c. If any damage is found, and/or the hinge is not installed correctly, proceed to step 3.
 - d. If no damage is found and the hinge is installed correctly, proceed to step 4.
3. Remove Emergency Door from aircraft and put in a safe place as to not damage the door or interior panel (refer to Epic E1000 Aircraft Maintenance Manual, PN SK05000000, chapter 52-20).
 - a. Repair/replace as follows:
 - i. If there is any damage to the hinge, replace the hinge with a new AK52201001 assembly.
 - ii. If handle rivets are loose, remove and replace with CR3213-4-06.
 - iii. If the hinge is not installed in the correct orientation, remove the rivets, install the hinge in the correct orientation, and install 3x new CR3213-4-06 and CR3212-4-02 as seen in Figure 3.
 - b. Reinstall the emergency exit door and proceed to step 4 (refer to Epic E1000 Aircraft Maintenance Manual, PN SK05000000, chapter 52-20).
4. Check fitment of door pins as follows:
 - a. Support emergency door to prevent movement.
 - b. Disengage door locking pins by pulling interior emergency door handle to the maximum open position, do not force the mechanism once it has reached its stop.
 - c. With the emergency door handle in the fully disengaged position, verify a minimum clearance of .020 exists between the door pins, and the fuselage mounted pin bracket. If clearance is demonstrated, Door removal is not required.
5. Repeat steps a-c with the exterior door handle, verifying proper operation.

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 3 of 9



Service Bulletin SB-0053

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

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Note: If pins do not disengage the fuselage mounted bracket, slight force can be applied to the bracket to provide needed clearance to remove door. This is only allowed while performing this service bulletin.

6. If the door does not meet minimum clearance when operating the interior or exterior handle, proceed to step 7, if it meets the requirements, then this service bulletin is completed, record compliance in the maintenance logbooks per step 11.

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 4 of 9



Service Bulletin SB-0053

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7. Adjust door rigging as follows:

- a. Remove the emergency exit door (refer to Epic E1000 Aircraft Maintenance Manual, PN SK05000000, chapter 52-20).
- b. Remove the roll pins.
- c. Adjust the door pin washer stack to 4 washers.

Note: if 4 washers do not operate correctly contact Epic Customer Support via email customersupport@epicaircraft.com or call 541-237-7272 for further instructions.

- d. Reinstall the roll pins.
- e. Adjust cable as follows
 - i. Loosen (break torque as needed to allow play in cable, do not remove completely) the two cable clamps holding the cable to the door.
 - ii. Loosen jam nuts on cable.
 - iii. Adjust cable end nearest the top latch to pull slack out of the cable.
 - iv. Apply tension on the cable with a hand while torquing the jam nuts (torque to 120-140 in/lbs).
 - v. Torque cable clamps to 20-25 in/lbs.

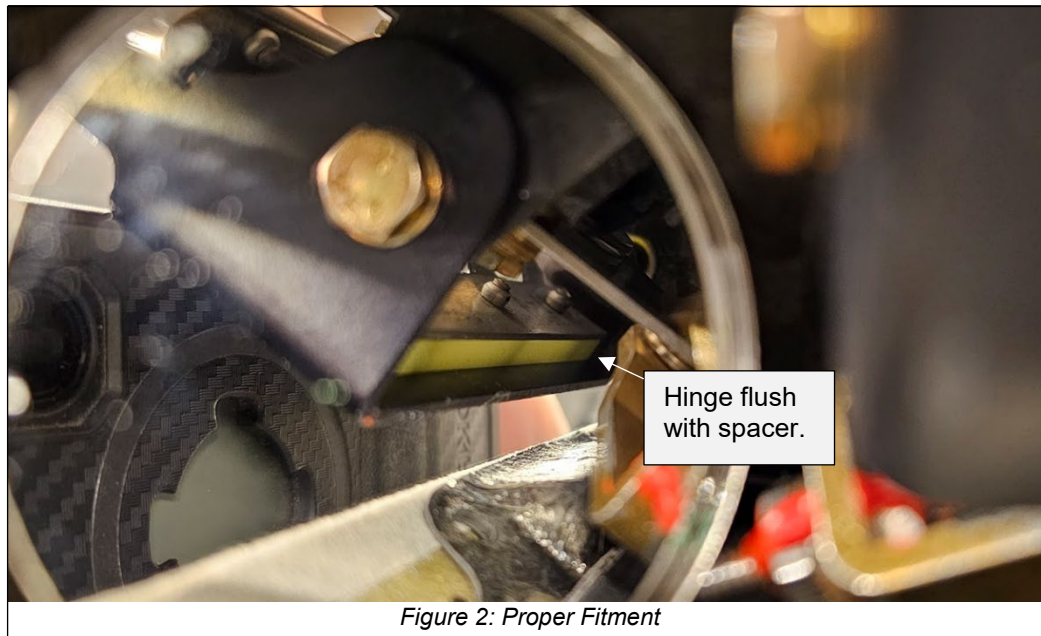
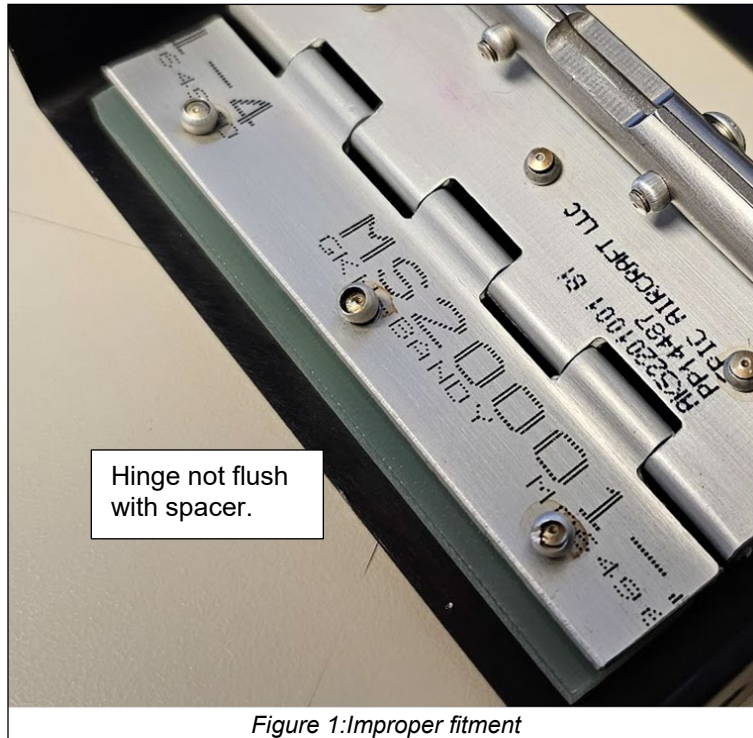
Note: With exterior door handle opened fully, verify no contact between cable termination and cable sheath at upper cable end location.

- f. Reinstall the emergency exit door and repeat step 4 and 5 with all interior panels installed (refer to Epic E1000 Aircraft Maintenance Manual, PN SK05000000, chapter 52-20).

Note: Door pin extension is controlled by emergency escape cable assembly, avoid excessive penetration beyond minimum requirement or exterior door handle will lack sufficient throw to disengage pins completely.

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 5 of 9

8 TABLES AND FIGURES:

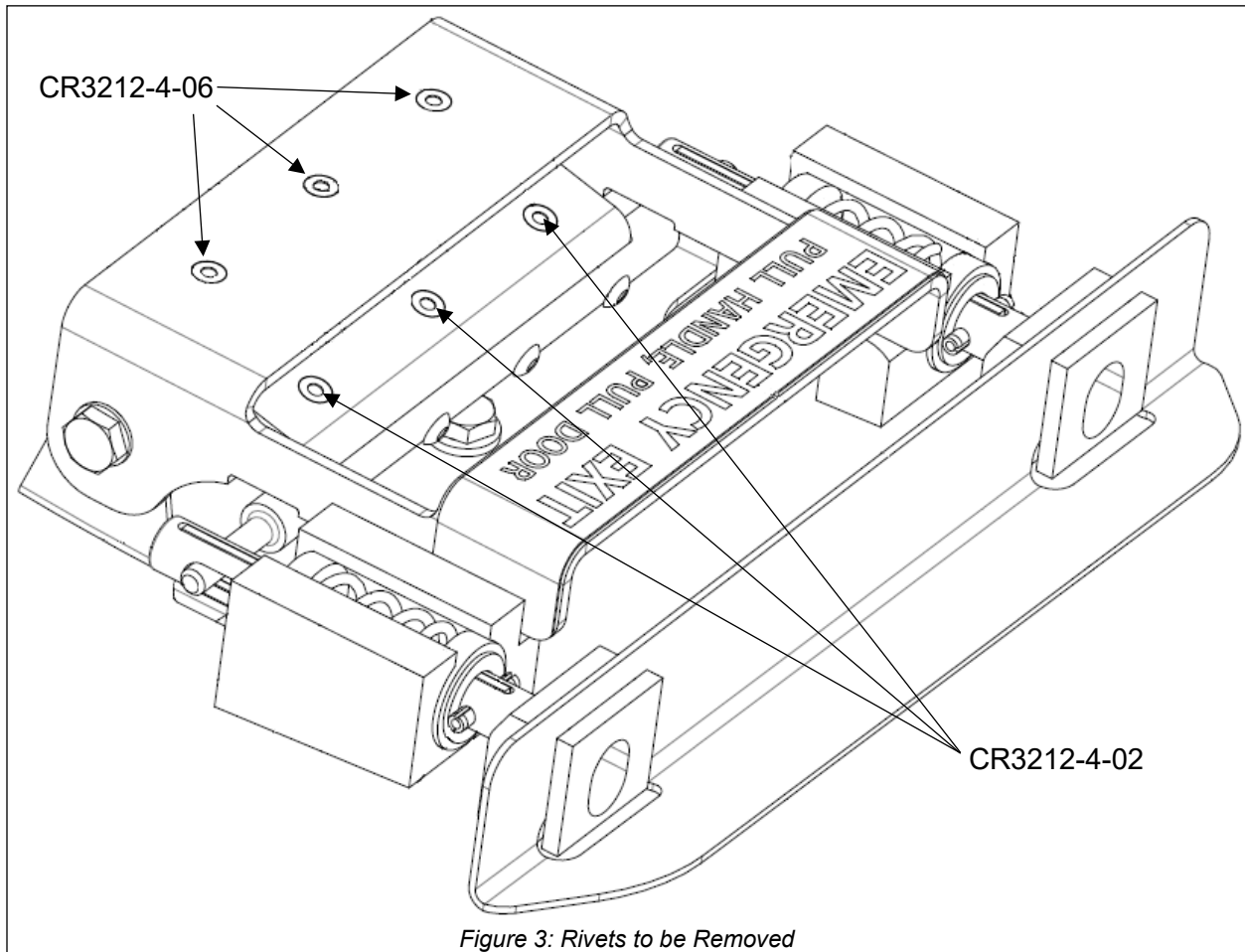


Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 6 of 9



Service Bulletin SB-0053

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Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 7 of 9



Service Bulletin SB-0053

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9 WEIGHT AND BALANCE:

N/A

10 PUBLICATIONS AFFECTED:

Epic E1000 Aircraft Maintenance Manual, PN SK05000000

11 RECORD COMPLIANCE:

Make appropriate entry in airplane maintenance records.

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 8 of 9



Service Bulletin SB-0053

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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: _____

Issued	Revised	Revision	Page
09-27-2023	N/A	Original release	Page 9 of 9