



Service Instruction SI-0042

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 hours

Effectivity: K029

Affected Model(s): E1000 GX

Due: Before next Flight.

Compliance: Mandatory

Recurrence: No

1 **BACKGROUND AND PURPOSE:**

It has been found that the up-lock hooks have made contact with the MLG forks, damaging the base material of the MLG fork.

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

2 **REFERENCES:**

Epic E1000 Aircraft Maintenance Manual P/N 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 by a properly certificated Airframe and Power Plant mechanic or FAA approved repair station.

4 **TOOLS:**

<u>No.</u>	<u>Description</u>	<u>Qty</u>	<u>Epic Aircraft Supplied</u>	<u>Customer Supplied</u>
1.	Common hand tools	AR	<input type="checkbox"/>	<input checked="" type="checkbox"/>

5 **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.	MIL-DTL-5541	Conversion Coating	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2.	MIL-PRF-23377	Primer	A/R	<input type="checkbox"/>	<input checked="" type="checkbox"/>

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6 INSTRUCTIONS:

1. Measure the damage.
2. Using a dial indicator zeroed on the surface adjacent to the damage, measure the depth at its deepest point.
 - a. If the damage is 0.026" or less, proceed with the repair.
 - b. If the damage is greater than 0.026" contact Epic Aircraft.

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

3. Blend the damage out to a 40:1 slope.
4. Apply a conversion coating to the repair as follow:
5. 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.

6. Prime with Type I, Class C1 or C2 epoxy primer conforming to MIL-PRF-23377.
7. 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 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: _____

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