



Northern Airframes LLC

Document no.: II591078

Revision Level: A

Date: 08-01-08

INSTALLATION INSTRUCTIONS
WELD-ON FLOAT FITTING PART NUMBER AF59078

1. Remove fabric from the area around the cluster at Fuselage Station (F.S) 69.88 to gain access for installation of the fitting.
2. Remove paint from the area affected and prepare surface for welding. Be sure no flammable material is in the area to be welded.
3. Align appropriate fitting (L.H or R.H) centerline with the centerline of the lower longeron and F.S 69.88 centerline as shown in drawing #AF69470, and clamp securely in place.
4. Weld as indicated in note 3 above, and in drawing #AF69470, the aft fuselage fittings are located at the tubing cluster at F.S 69.88, as measured from the aircraft firewall. The fittings are to be welded along the edges to all the tubing it makes contact with, and where holes have been provided for three rosette welds Welding must be accomplished as follows:
 - A. The AF59078 assembly is to be TIG, MIG or oxyacetylene welded to the aircraft fuselage.
 - B. All welding shall conform to AC 43:13-1B, unless otherwise indicated.
 - C. Wire brush welded area.
5. Finish:

After welding, the fittings and surrounding area must be suitably protected from the effects of corrosion.

 - A. Unless otherwise specified by drawing #AF69470, the fittings and surrounding area shall be primed and finished as specified below.
 - B. Epoxy Primer suitable for steel.
 - C. Finish Painting:

If finish painting is required, the parts may be finished by spraying with enamel lacquer or synthetic paint of aircraft quality appropriate to the color scheme of the aircraft.



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INSTRUCTIONS FOR CONTINUED AIR WORTHINESS

I. Description of Modification:

This modification is the installation of a weld-on float fitting instead of the original Piper bolt-on float fittings.

II. Annual Inspection Requirements:

Visually inspect weld-on float fittings for cracking, corrosion and wear on bolt and attachment block.

III. Other Inspection Requirements:

Inspect attachment bolts whenever installing floats on aircraft.

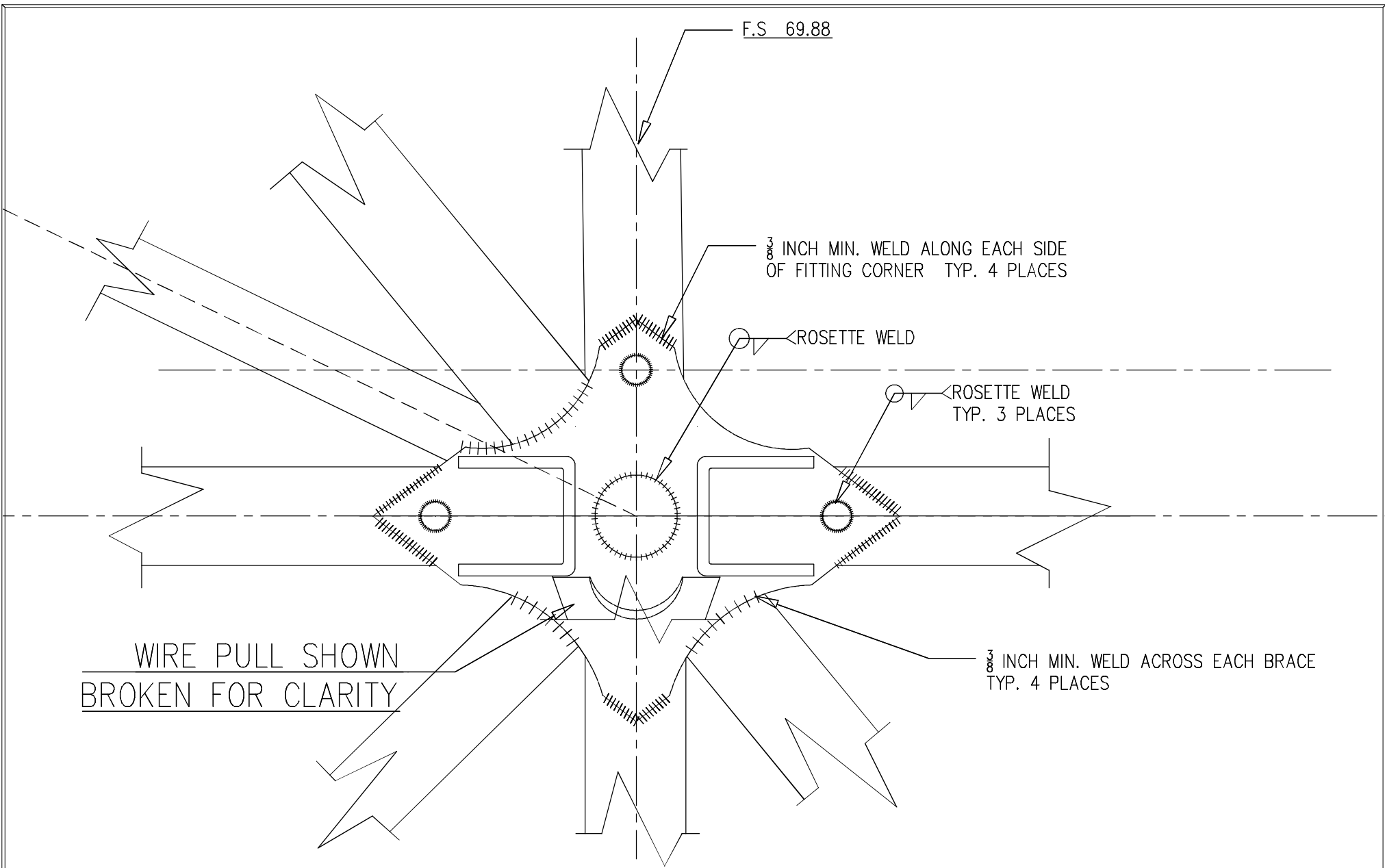
IV. Airworthiness Limitations:

The Airworthiness Limitations section is FAA approved and specifies maintenance required under Sections 43.16 and 91.403 of the Federal Aviation Regulations unless an alternative program has been FAA approved.

There are no Airworthiness Limitations for this modification.

V. Revisions:

Revisions for the INSTRUCTIONS FOR CONTINUED AIR WORTHINESS will be distributed to operators by means of direct notification using records of who each STC is issued to. These records are kept by the manufacture.



WIRE PULL SHOWN
BROKEN FOR CLARITY

A	5/12/2008	REDRAWN USING AUTO CAD COMPANY NAME CHANGED	GKN
ORG.	11/28/2005	N/A	UNK
NO.	DATE	REVISIONS	BY

SCALE:
NOT TO SCALE

WELD ON FLOAT FITTING INSTALLATION

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NORTHERN AIRFRAMES LLC
CHUGIAK, ALASKA 99567

DWG:	UNK	CHECK:	N/A	APPROVED:	N/A
DATE:	11/28/2005	DATE:	N/A	DATE:	N/A

DRAWING NUMBER
AF69470