

MANDATORY SERVICE BULLETIN**NUMBER:** SB-010 **AMENDMENT 1****DATE:** 06/09/2009**SUBJECT:** FUSELAGE; VERTICAL TAIL BOLT INSPECTION **AMENDMENT 1****SUMMARY**

QUEST AIRCRAFT RECOMMENDS THAT EACH OPERATOR EXAMINE THIS SERVICE LETTER IMMEDIATELY.

CONCURRENT REQUIREMENTS

None

BACKGROUND

This is an amendment to SB-010 for the mandatory Vertical Tail Bolt Inspection of the KODIAK 100. Quest has discovered that the washer part number callout in the previous Service Bulletin was incorrect and is reissuing work instructions with the correct part numbers identified.

ACTION

Quest is mandating a one-time inspection of the 8 vertical tail bolts that connect the vertical tail to the aircraft using the instructions contained in this Service Bulletin.

EFFECTIVITY

Kodiak Aircraft Serial Numbers 100-0001 thru 100-0009

COMPLIANCE

Quest Aircraft recommends that this inspection be completed within 10 operating hours after receipt of this Service Bulletin.

INDUSTRY SUPPORT INFORMATION

None

MANPOWER

The instructions contained in this Service Bulletin will take approximately one hour to complete.

COMPLETION

Upon completion of this Service Bulletin, enter the maintenance performed into the appropriate aircraft maintenance records.

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MANDATORY SERVICE BULLETIN

**SB-010 Vertical Tail Bolt Inspection
AMENDMENT**

INSPECTION INSTRUCTIONS

BOLT INSPECTION

Task

Instruction

1

Remove the tail cone and the aft bulk head as described in the **KODIAK Maintenance Manual**.

Locate the **8** vertical tail attachment bolts.

See **Figure 1** for assistance in identifying these 8 bolts within the vertical tail. **Figure 2** shows a close-up view of the bolts that must undergo inspection.

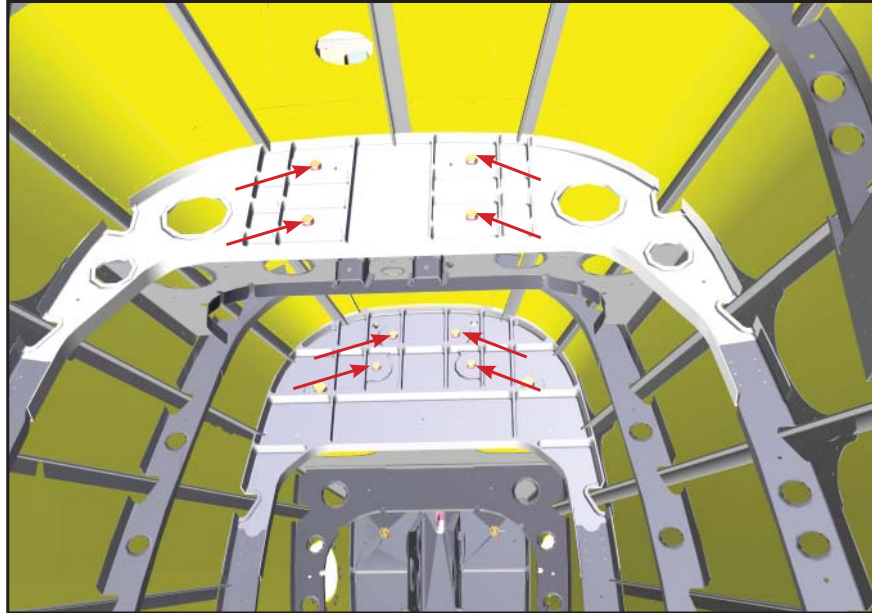


Figure 1 - Bolt Locations

2



Figure 2 - Outside View of Aftmost Bolts with Tail Cone Removed

BOLT INSPECTION

Task	Instruction
3	Inspect the bolts using the procedure defined in Step 3a below.
3a	<p>Inspect each bolt by measuring the thread distance between the top of the castellated nut and the end of the bolt. The bolt (P/N NAS6605D9) needs to have 0.1 inch or less thread showing. If the amount of threads showing amounts to more than 0.1 inch, it is then necessary to remove the nut and install one or two washers (P/N NAS1149F0563P, NAS1149F0532P, NAS1149F0516P) to achieve 0.1 inch or less thread showing. If washers are added, torque nut to 100 to 140 in-lbs.</p> <p>Note: At least one thread should be exposed.</p> <div data-bbox="446 510 1313 1077" data-label="Image"></div> <p data-bbox="597 1083 1166 1115">Figure 3 - Correct Torque of Vertical Tail Bolt</p> <p>If a new lock nut is required, the locknut P/N is MS17825-5. Do not reuse the cotter pins if they were removed to add washers.</p> <p>NOTE: Cotter pin part number is (P/N MS24665-134).</p>
4	Annotate work completed in the KODIAK log books.