

MANDATORY SERVICE BULLETIN**NUMBER:** SB-031**REVISION:** A**DATE:** 09/17/2010**SUBJECT:** AFT FUSELAGE; SIDE FRAME FASTENER INSPECTION**EFFECTIVITY:**

KODIAK 100 Series Aircraft Serial Numbers:

- 100-0001 thru 100-0039

SUMMARY:

Quest Aircraft Company LLC. is mandating a one-time inspection to the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) of the AFT fuselage to ensure the installation of twelve (12) fasteners. These fasteners reinforce the attachment of the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and the top and bottom frame splices (*P/N 100-240-2043* and *P/N 100-240-2042*).

ACTION:

Perform the inspection and fastener installation (required) in accordance with this Service Bulletin within the time frame listed.

AFFECTED PARTS:

- 100-240-2041-01 (Side Frame, AFT Fuselage)
- 100-240-2041-02 (Side Frame, AFT Fuselage)
- 100-240-2042 (Bottom Frame Splice)
- 100-240-2043 (Top Frame Splice)

FAA APPROVED:

The following inspection and possible installation of fasteners to the AFT fuselage described in this Service Bulletin has shown compliance with the acceptable Federal Aviation Regulations and is FAA approved.

COMPLIANCE:

This Service Bulletin must be completed on or before the next 100 hour, annual inspection, or scheduled maintenance. Whichever occurs first.

INDUSTRY SUPPORT INFORMATION:

N/A

WEIGHT AND BALANCE:

The procedure contained in this Service Bulletin does not alter the weight and balance of the aircraft.

MANPOWER:

The instructions contained in this Service Bulletin will take approximately:

- Inspection: 0.2 hours
- Installation of fasteners: 1.0 hours (if required)

CONTINUED ON NEXT PAGE...

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CREDIT and WARRANTY INFORMATION:

Quest Aircraft Company will reimburse for the cost of this inspection up to \$37.50 for aircraft still under Factory Warranty. For reimbursement, send Quest Aircraft Company a copy of the inspection and the N-number of the aircraft on which the inspection was accomplished. Send or e-mail the information in attention to:

*Quest Customer Service
 Service Notification Compliance Feedback (SB-031)
 1200 Turbine Dr.
 Sandpoint ID, 83864
 Phone: 1-866 263-1112 or 1-208 263-1111
 E-mail: customercare@questaircraft.com*

COMPLETION:

Record the work completed in the KODIAK 100 Maintenance Log Books.

ACCOMPLISHMENT INSTRUCTIONS:

Accomplishment Instructions are listed in the next section of this Service Bulletin.

LOG OF CHANGES

Revision:	Date:	Description of Change:
A	09/17/10	Initial Release

ATTACHED DOCUMENTS

Document #:	Date:	Document Title:
N/A	N/A	N/A

SPECIAL SAFETY INSTRUCTIONS

N/A

PARTS, TOOLS, AND EQUIPMENT

The following parts, tools, and equipment listed below are required to complete the instructions contained within.

Parts and Tools Included in this Service Kit:

Part Number	Description	Quantity
N/A	N/A	N/A

Special Tools Required that are **NOT** Provided in this Service Kit:

Tool Name	Tool Duty
N/A	N/A

1. INSPECTION

1.1 AFT FUSELAGE ACCESS PANEL REMOVAL

Remove the AFT fuselage access panel on the back side of the AFT fuselage located on both sides of the aircraft as shown in *Figure 1-1*.



Perspective of
Illustration

Figure 1-1: AFT Fuselage Access Panel.

1.2 VISUAL INSPECTION

Prepare aircraft for inspection using the procedures defined in the KODIAK Maintenance Manual. Visually inspect the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*), and the top and bottom frame splice (*P/N 100-240-2043* and *P/N 100-240-2042*) looking for the fasteners (*P/N MS20470AD-4*) indicated in *Figure 2-1* and *Figure 2-2*. If the subject fasteners are present no further action is required; proceed to *Section 3*. If the fasteners (*P/N MS20470AD-4*) are not present; proceed to *Section 2*.

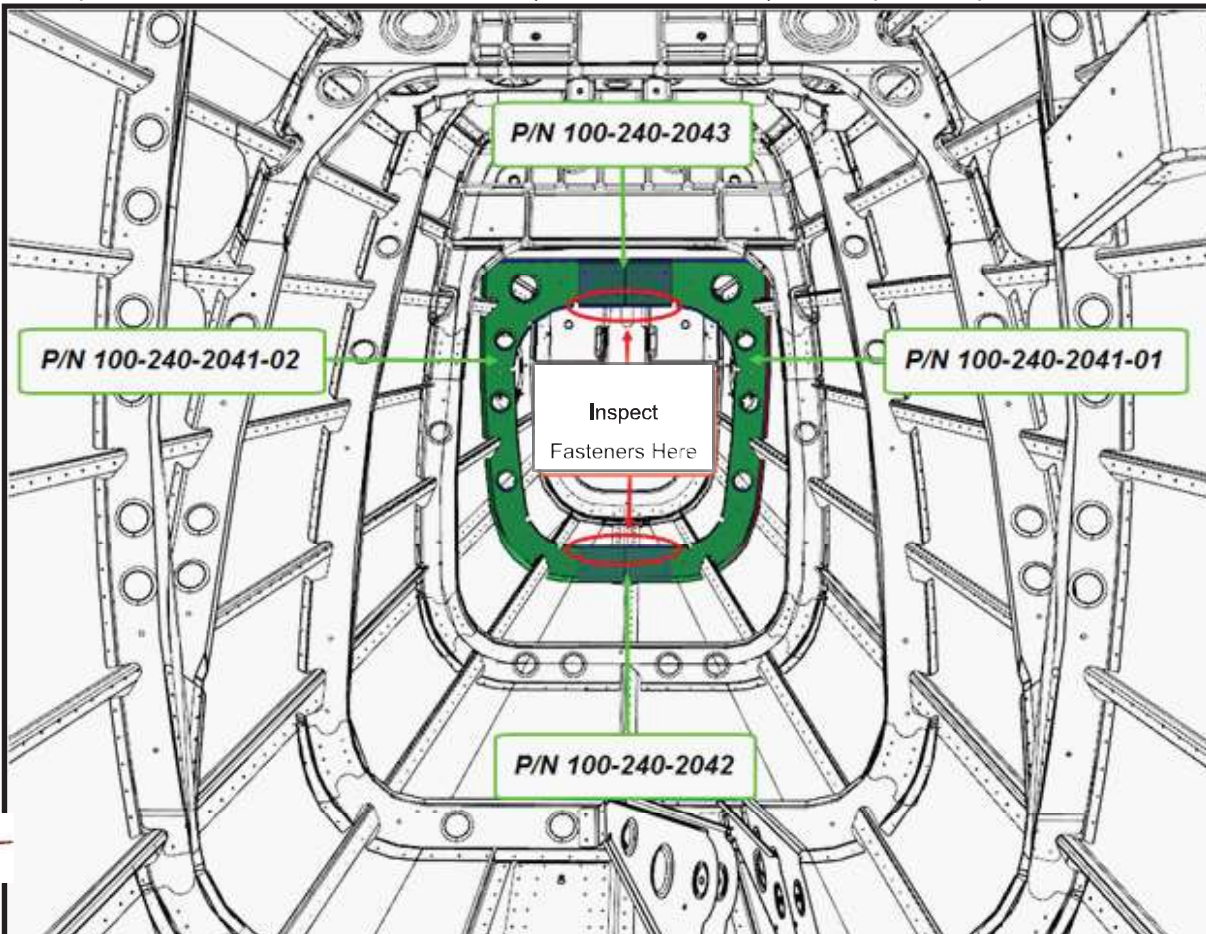


Figure 1-2 Frame location for fastener installation.

2. INSTALLATION

2.1 COMPONENT REMOVAL AND FRAME PREPARATION

1. Prepare aircraft for inspection using the procedures defined in the KODIAK Maintenance Manual.
2. Remove the AFT bulkhead panel (*P/N 100-730-0107* or *P/N 100-730-0109*) by loosening the camlocks securing the panel to the aircraft.
3. Locate the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and bottom frame splice (*P/N 100-240-2042*) indicated in *Figure 1-2* drill the locations to "0.128-0.134" diameter holes as shown in *Figure 2-3*. in accordance with standard industry practices.
4. Locate the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and top frame splice (*P/N 100-240-2043*) indicated in *Figure 1-2* drill the locations to "0.128-0.134" diameter holes as shown in *Figure 2-3*. in accordance with standard industry practices.

2.2 FASTENER INSTALLATION

1. Install the six (6) fasteners (*P/N MS20470AD-4*) into the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and top frame splice (*P/N 100-240-2043*), In accordance with standard industry practices,
2. Install the six (6) fasteners (*P/N MS20470AD-4*) into the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and bottom frame splice (*P/N 100-240-2042*), in accordance with standard industry practices.
3. Ensure that any debris from the drilling and installation of the fasteners has been removed from the aircraft.
4. Return the AFT bulkhead panel (*P/N 100-730-0107* or *P/N 100-730-0109*) to the proper position and secure using the camlocks from **Section 2-1 #1**.

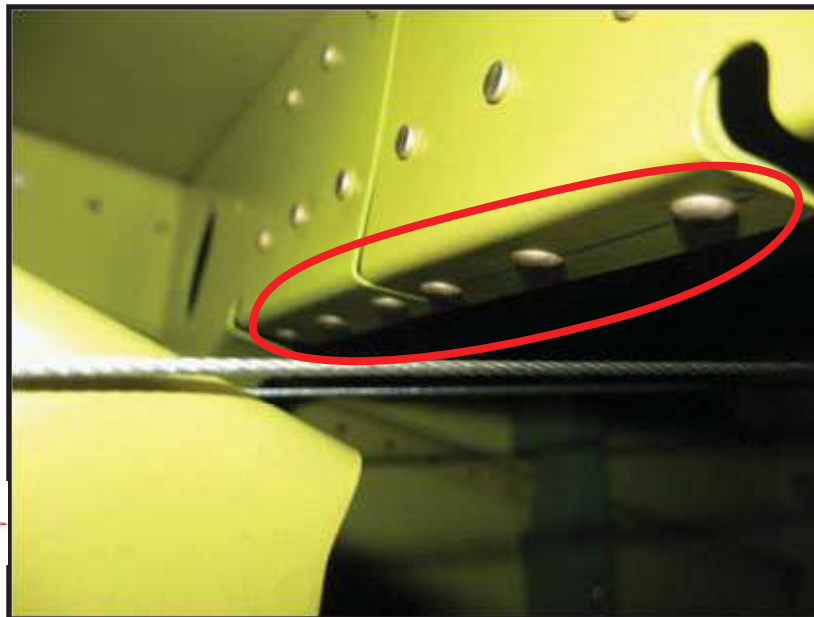


Figure 2-1 Illustrates fasteners through Side Frames and Top Frame Splice.

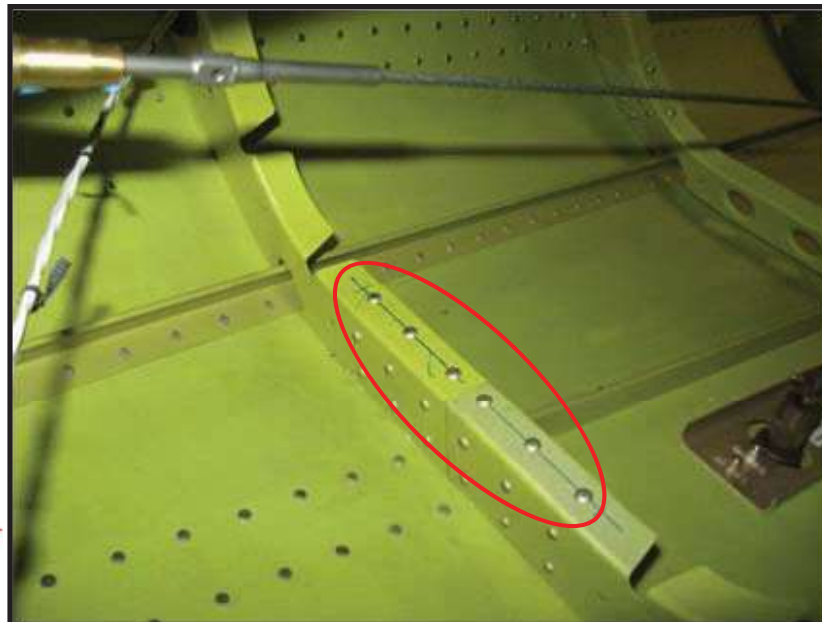


Figure 2-2 Illustrates fasteners through side frames and bottom frame splice.

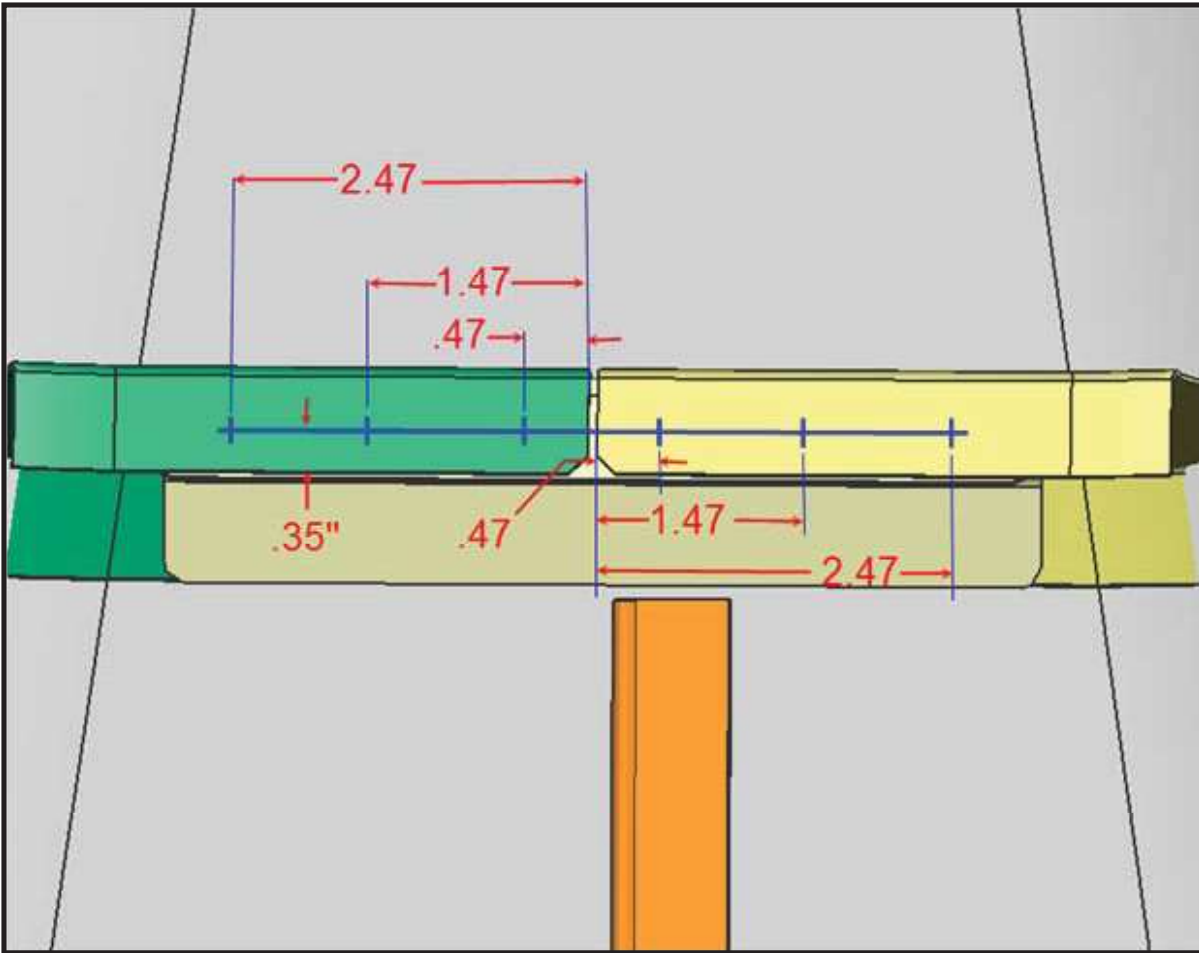


Figure 2-3 Hole Location For Top and Bottom Frame (Bottom Shown and Top Mirrored).

3. REINSTALL ACCESS PANELS

Reinstall all removed access panels.

4. RECORD WORK PERFORMED IN KODIAK LOG BOOK

Upon completion, record all work performed in the KODIAK Log Book.