

**\*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](mailto: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

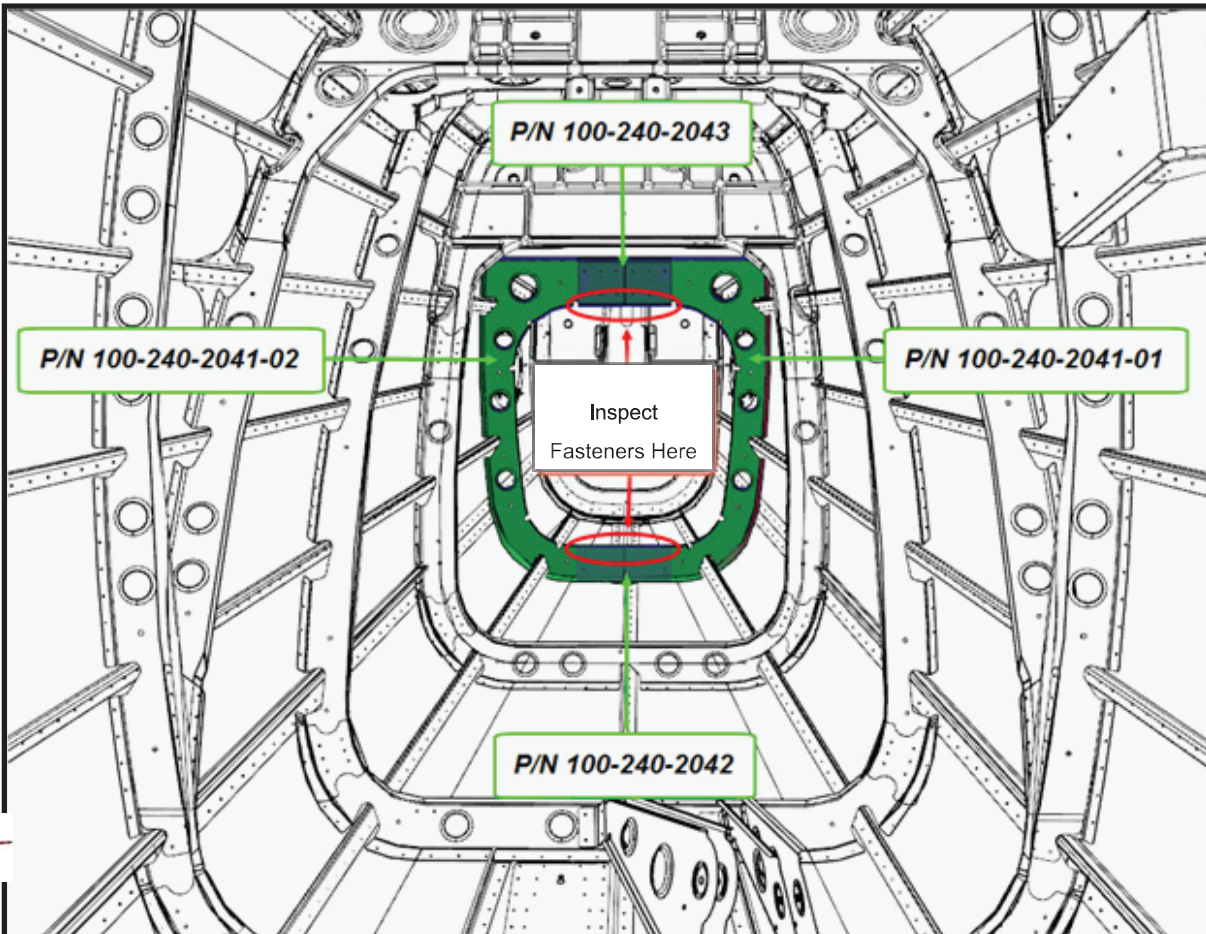
Remove the AFT fuselage access panel on the back side of the AFT fuselage located on both sides of the aircraft as shown in *Figure 1-1*.



*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.*

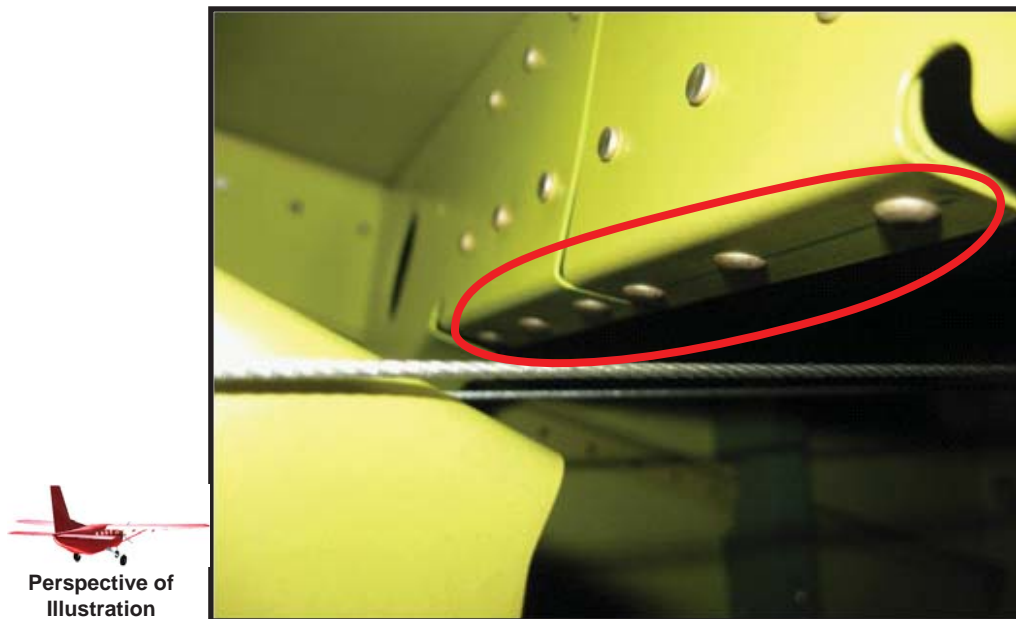
## 2. INSTALLATION

### 2.1 COMPONENT REMOVAL AND FRAME PREPARATION

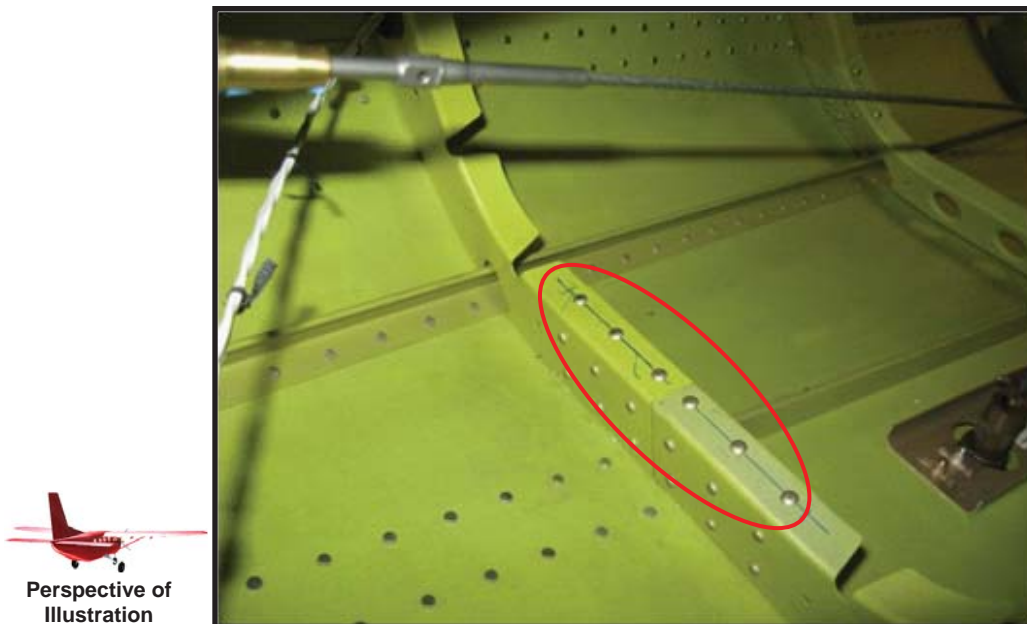
1. Prepare aircraft for inspection using the procedures defined in the KODIAK Maintenance Manual.
2. Remove the AFT bulkhead panel (*P/N 100-730-0107* or *P/N 100-730-0109*) by loosening the camlocks securing the panel to the aircraft.
3. Locate the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) 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

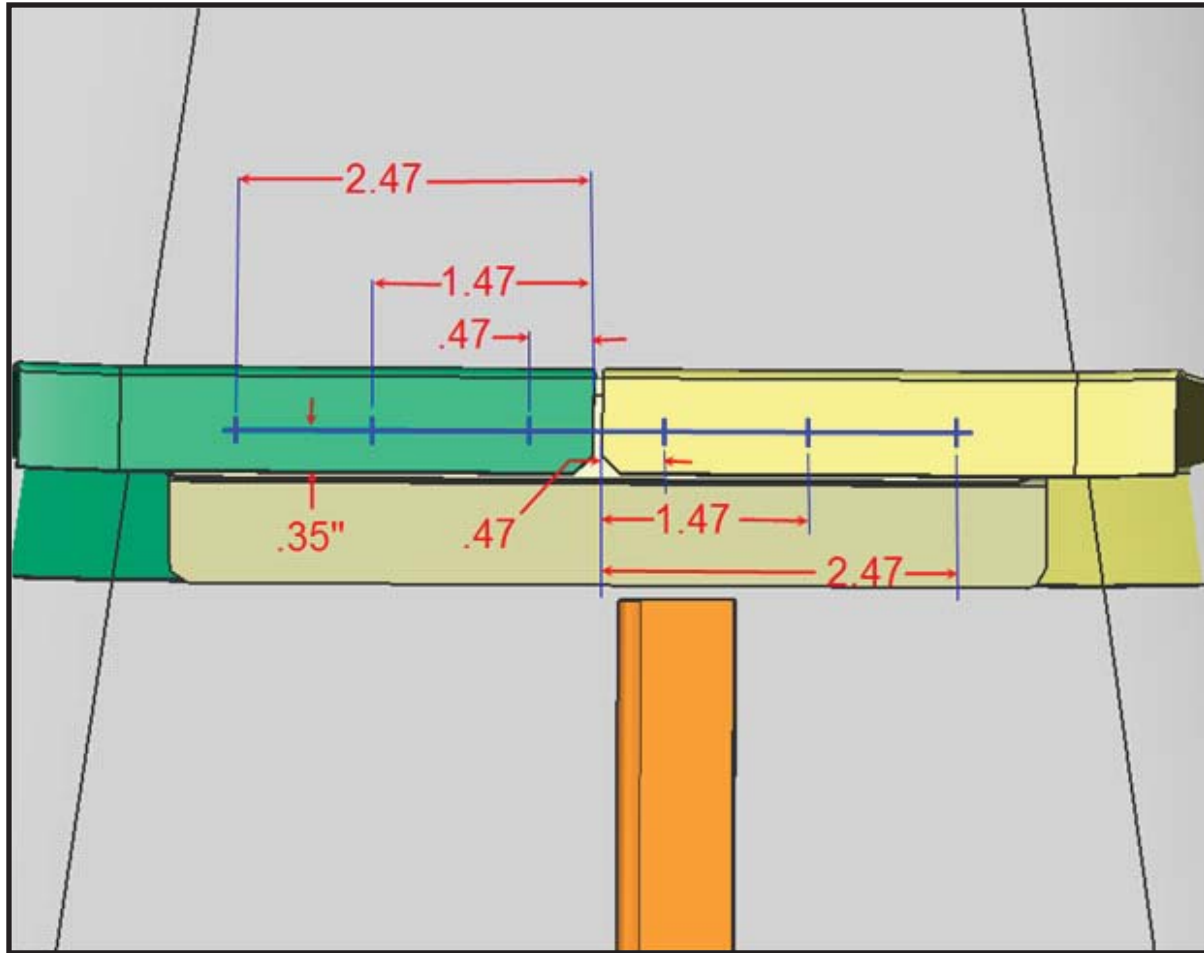
1. Install the six (6) fasteners (*P/N MS20470AD-4*) into the side frames (*P/N 100-240-2041-01* and *P/N 100-240-2041-02*) and top frame splice (*P/N 100-240-2043*), In accordance with standard industry practices,
2. Install the six (6) fasteners (*P/N MS20470AD-4*) into the side frames (*P/N 100-240-2041-01* 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.