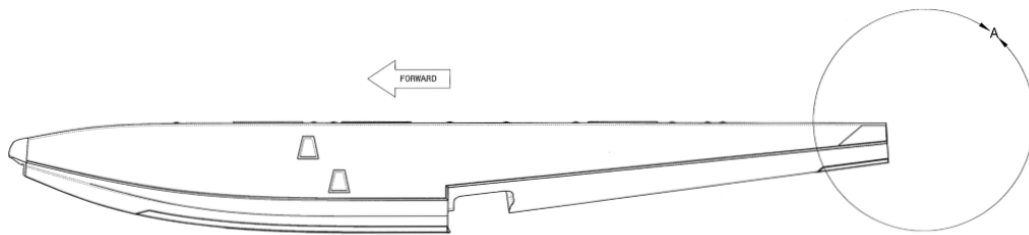


SERVICE LETTER SL45 65-17800

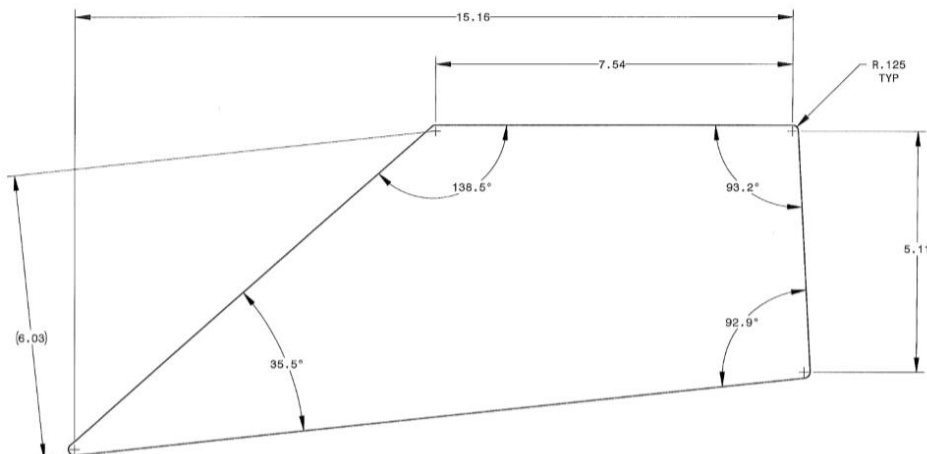


1. **Release Date:** 03/27/2019
2. **Service Letter No.:** SL45 65-17800
3. **Reason for Change:** Optional installation of protective panel for docking and mooring operations.
4. **Part/Assembly No.:** 65-17800, 65-17801
5. **Float Model Affected:** 6650 or 6750
6. **Disposition of Product in Field:** NA
7. **Compliance:** **Mandatory** **Recommended** **Optional**
8. **Approval:** All information provided is in accordance with approved data.
9. **Corrective Action:** NA
10. **Time Required:** 1 hour (does not include prime and paint options)
11. **Payments to customer:** None. Call (208) 448-0400 for Parts Department

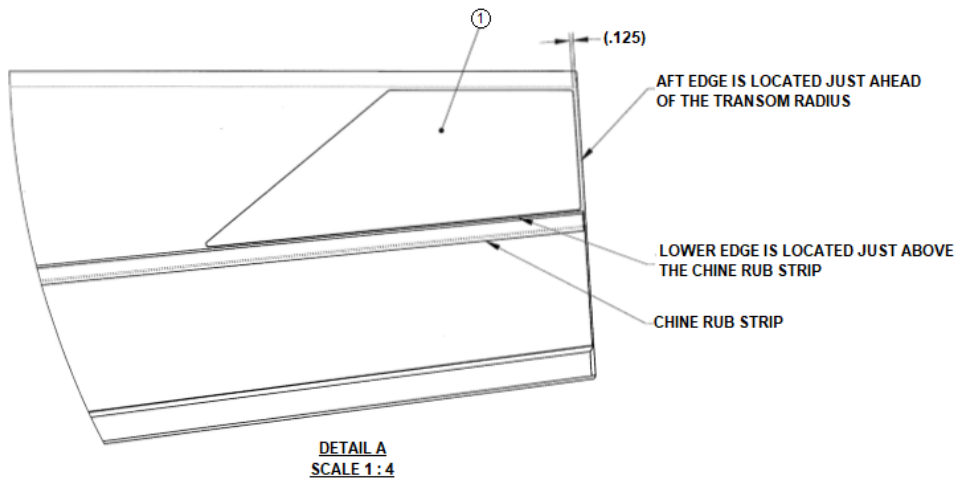
1. 65-17800 scuff panel installation, similar for all locations. Left hand, outboard side is shown. All other locations are similar. (See below—6650 shown)



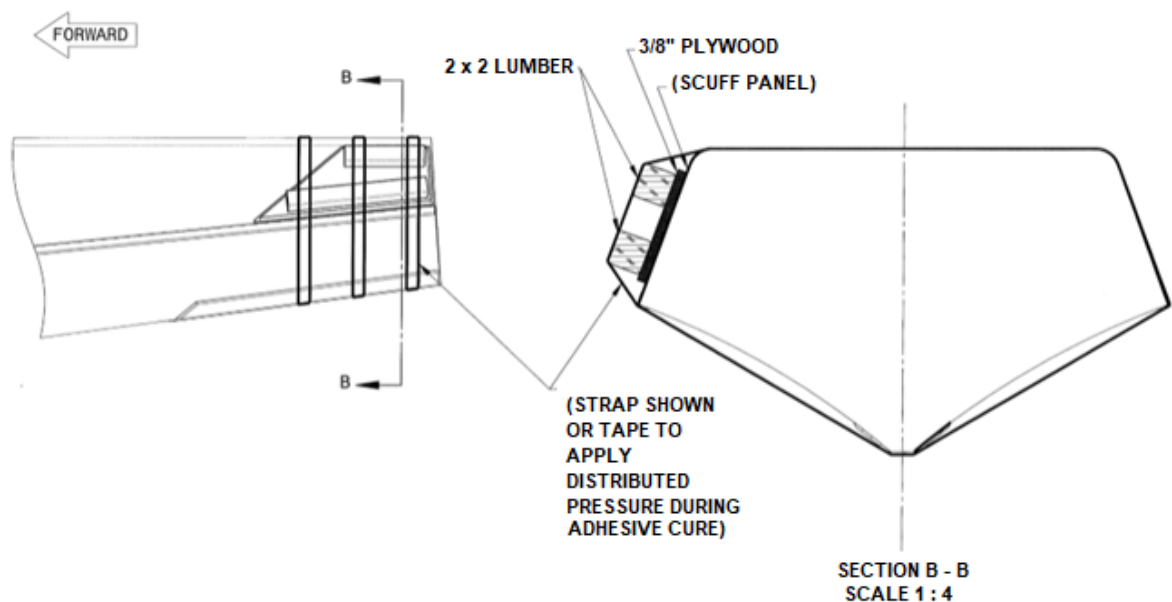
2. 65-17801 (Scuff Panel) is used for both LHS and RHS floats.



3. Installation is generally only applied to the outboard sides, such as LHS installation applied to the outboard side of the left float hull. This does not prohibit installation to inboard sides if needed.
4. Locate the panel as shown near the transom of the hull and above (not touching) the chine rub strip. Use a marking device to trace the outline for preparation.



5. Prepare float hull area for bonding:
 - Thoroughly clean and lightly sand gel coat with 400 grit sand paper. (Mask the gel coated area of the float to avoid spreading the sanding output outside the lines.)
 - Avoid sanding the chine rub strip, or mask it.
 - Clean with acetone and allow to fully dry.
6. Bond 65-17801 scuff panel using Sika-Flex 292, Plexus MA425, or 3M 5200 adhesive. Use a 1/8" toothed trowel to spread adhesive evenly across entire plate.
7. Apply even pressure to the panel, assuring excess bonding agent at edges of the scuff plate. It may be helpful to strap or construct a leverage device across the panel during curing process. This will help with applying a more evenly distributed pressure.





CAUTION:

Some strapping devices, such as ratcheting tie-down devices, may allow excessive force to be applied. Apply only as much force as needed to hold the panel securely during bond curing period. Do not apply excessive force, or damage to the float hull may occur.

- 8. Excess adhesive may be removed or filleted. No adhesive gaps or voids are acceptable around any edges. (This will allow unwanted water to penetrate, which could freeze later or perhaps cause a disbond.)

Parts Kit for 1 float

Item No.	Qty	Part Number	Description	Comments
1	1	65-17801	Scuff panels, Aerocet Model 6650 Floats	
2	1	292 or 292i	Urethane adhesive/sealant	Per Drawing Notes

Parts Kit for set of floats

Item No.	Qty	Part Number	Description	Comments
1	2	65-17801	Scuff panels, Aerocet Model 6650 Floats	
2	1	292 or 292i	Urethane adhesive/sealant	Per Drawing Notes

Recommended Tools

Description
1/8" toothed trowel
2 x 2 lumber
3/8" plywood
Clean up supplies

Rev	Date	Summary of change	Authorized by
I/R	08/30/2018	Initial Release	LM

-END-