

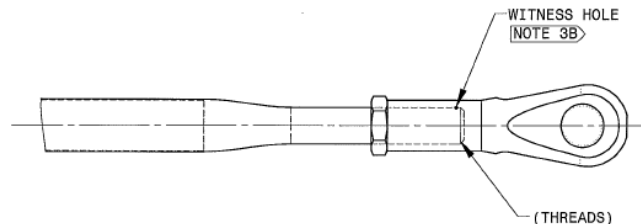
1. **Date:** 02/09/2017
2. **Service Letter No.:** SL23 66-12020
3. **Reason for Change:** Explicit instructions to properly adjust tie rods.
4. **Part/Assembly No.:** 66-12020
5. **Float Model Affected:** 6650
6. **Disposition of Product in Field:** NA
7. **Approval:** All information provided is in accordance with approved data.
8. **Corrective Action:** Informational Only
9. **Time Required:** Less than 1 hour
10. **Payments:** None

No Parts Kit Required

Instructions for Tie Rod Adjustments:

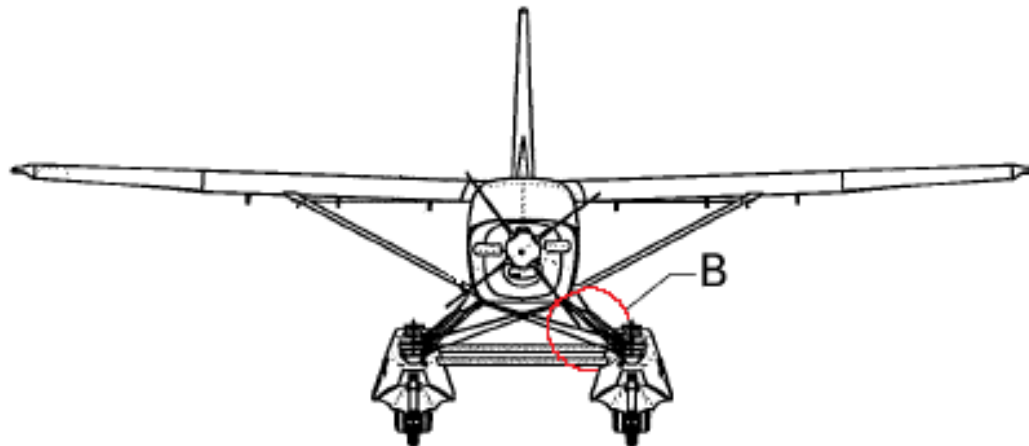
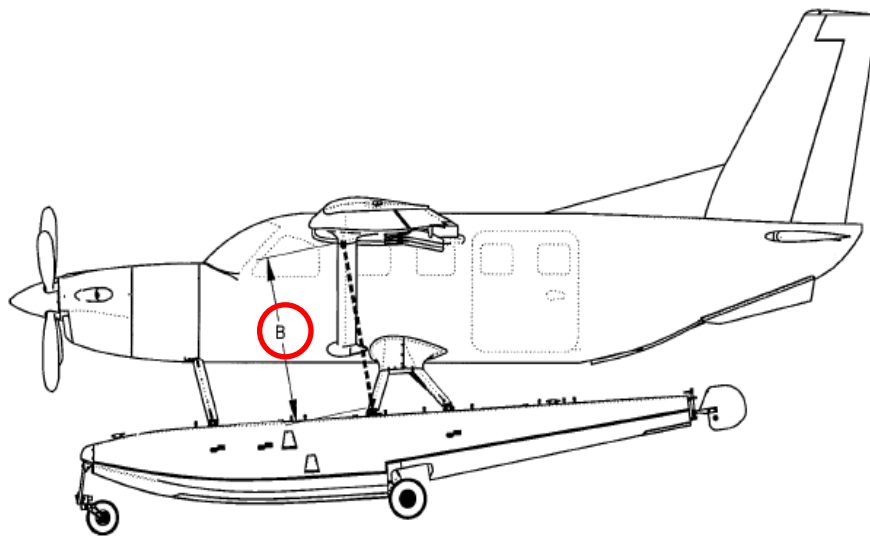
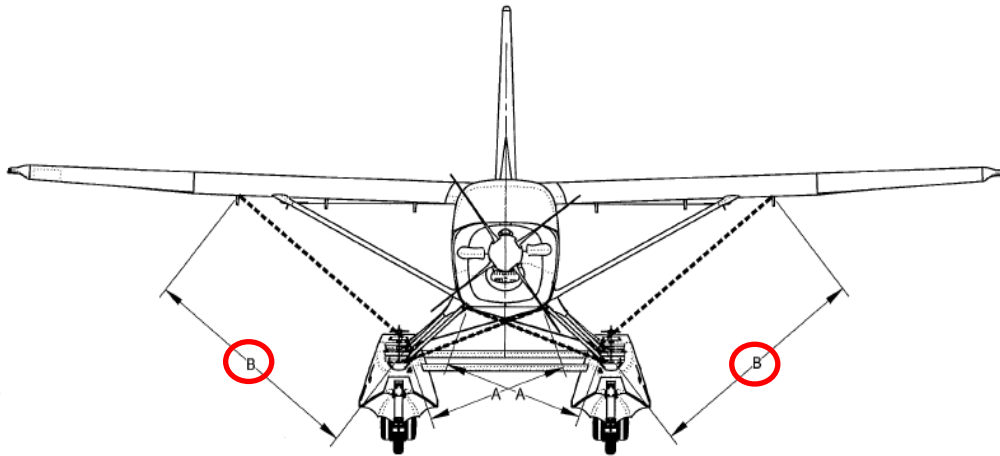
NOTE: APPLY MARINE GRADE ANTI-SIEZE, SUCH AS LOCTITE MARINE GRADE ANTI SIEZE 8023, OR SIMILAR TO ALL THREADED PORTIONS

1. Assure balanced fuel load in wings; empty is preferred.

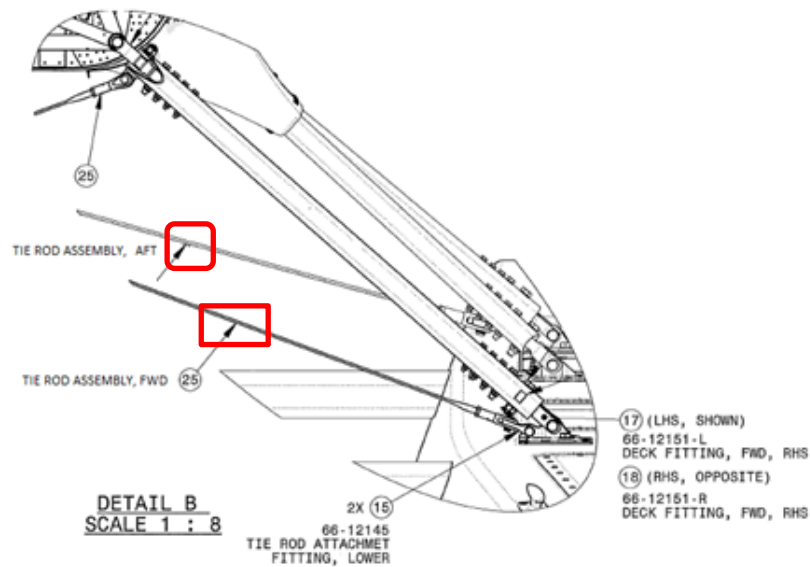


2. Assure even thread insertion in clevis ends. Minimum thread shall be evident past the witness hole.
3. FWD tie rod lengths, pin to pin, shall match (LHS and RHS).
4. AFT tie rod lengths, pin to pin, shall match (LHS and RHS).

5. Position of the mid deck fitting to wing strut tie down shall match within 1" LHS to RHS. [Ref Dimension B, (see below) using like points of reference for each side].



6. Tension of the **FWD wires** such that a 15 lb. force at the center of the wires and perpendicular to the flat of the wire, deflects the wire .200-.300 inches.
7. Tension of the **AFT wires** such that a 50 lb. force at the center of the wires and perpendicular to the flat of the wire, deflects the wire .100-.150 inches.



8. Assure that the streamlined shape is oriented with the airstream. Tighten the jam nuts. (FWD: 270 to 300 in. per lb.) (AFT: 600 to 780 in. per lb.)
9. Insert chafe protection such as leather, Teflon or nitrile sheet or tubing of about 1 in. length, located between wires at intersections. Secure with weather resistant lace, or cable ties. Heavy wall heat shrink (Polyolefin) is acceptable.
10. For re-installation or for used tie rods: lengths shall not exceed nominal length $\pm .13$ " when measured in the free, uninstalled condition.
 - 66-12192 FWD tie rod max free length not to exceed 73.13"
 - 66-12196 AFT tie rod max free length not to exceed 74.63"

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