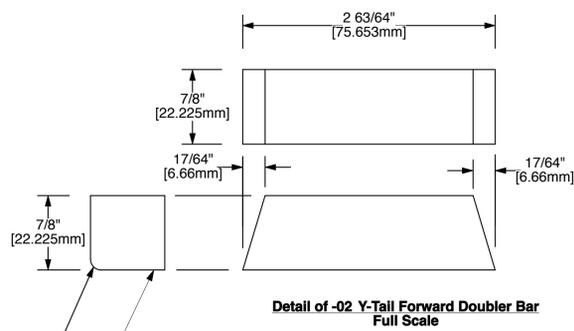


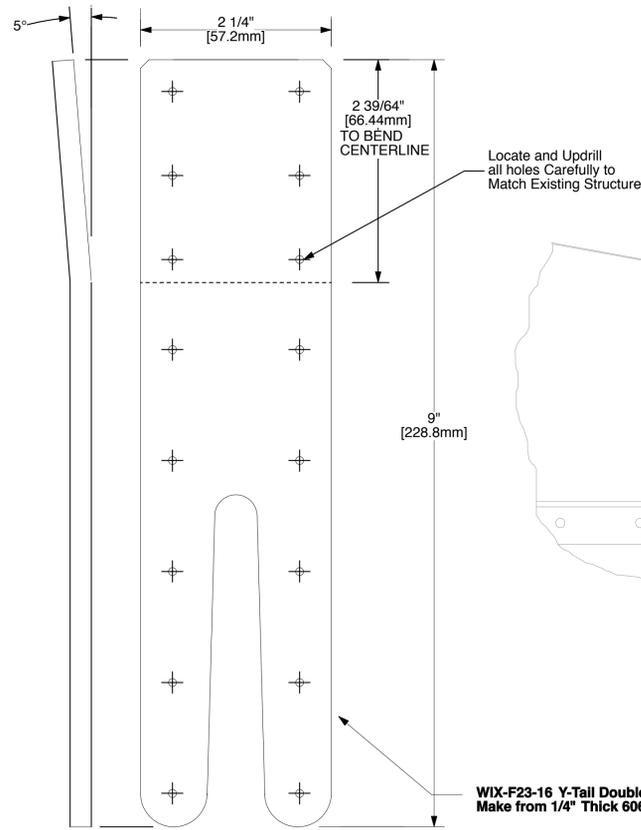
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Revision Letter	Change Description



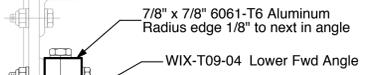
WIX-T07-02 Y-Tail Forward Doubler Bar (Shown)
Make from 7/8" x 7/8" 6061-T6 Aluminum Bar
Qty 2 Req'd

Radius as Req'd to fit radius of WIX-T09-04 Lower Forward Mount Angle



WIX-F23-16 Y-Tail Doubler Strap
Make from 1/4" Thick 6061-T6 Aluminum

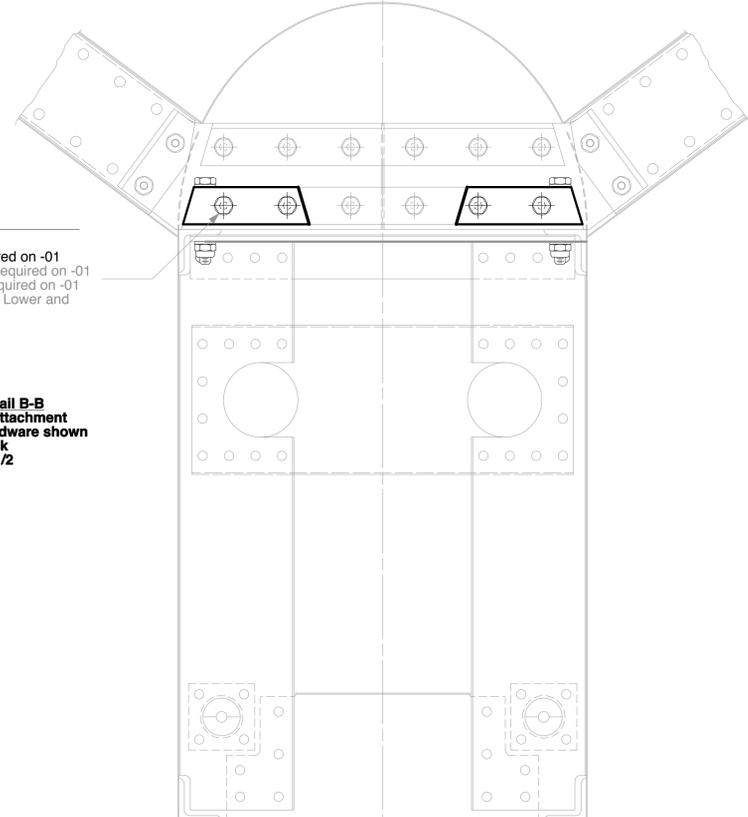
Locate and Updrill all holes Carefully to Match Existing Structure.



AN4-17A Bolt, 2 Required on -01
AN960-416 Washer, 4 Required on -01
AN365-428 Nut, 2 Required on -01
Locate per pilot holes in Lower Attach Angle
Note: Clamp stack tightly together when drilling to avoid burrs from forming between parts while drilling

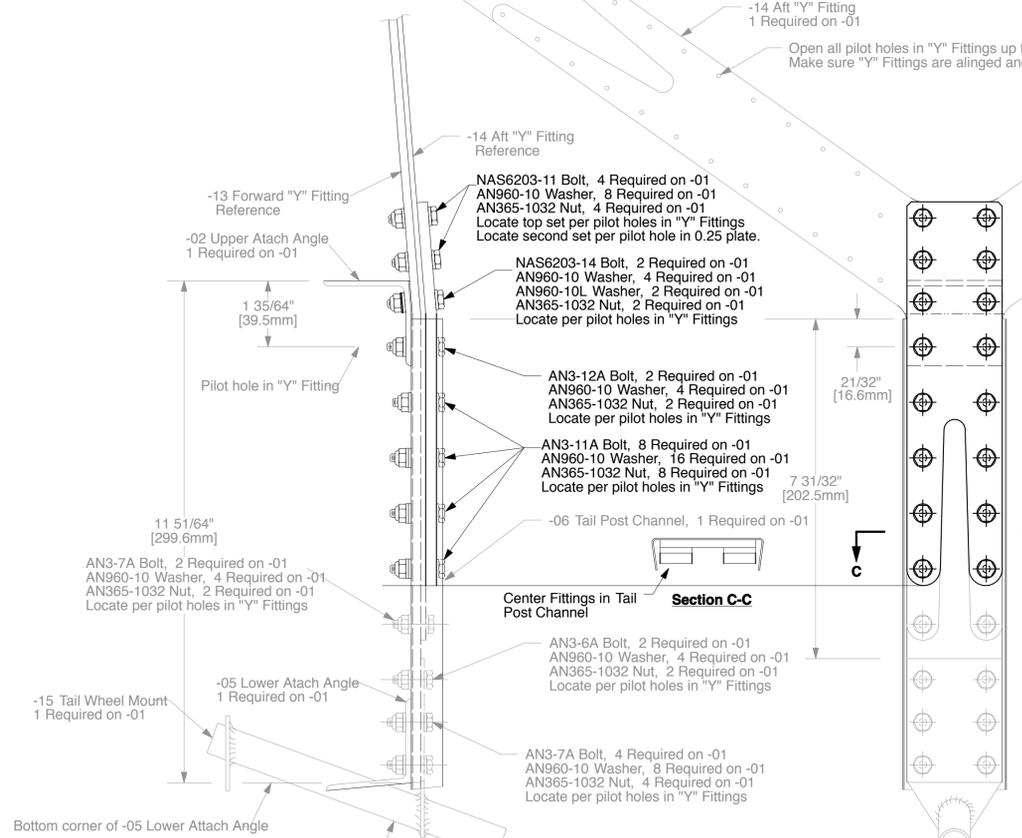
AN3-16A Bolt, 4 Required on -01
AN960-10 Washer, 6 Required on -01
AN365-1032 Nut, 4 Required on -01
Locate per pilot holes in Lower and Upper Attach Angles

WIX-T07 Detail B-B Forward Spar Attachment
New Parts and Hardware shown in Black
Scale: 1/2



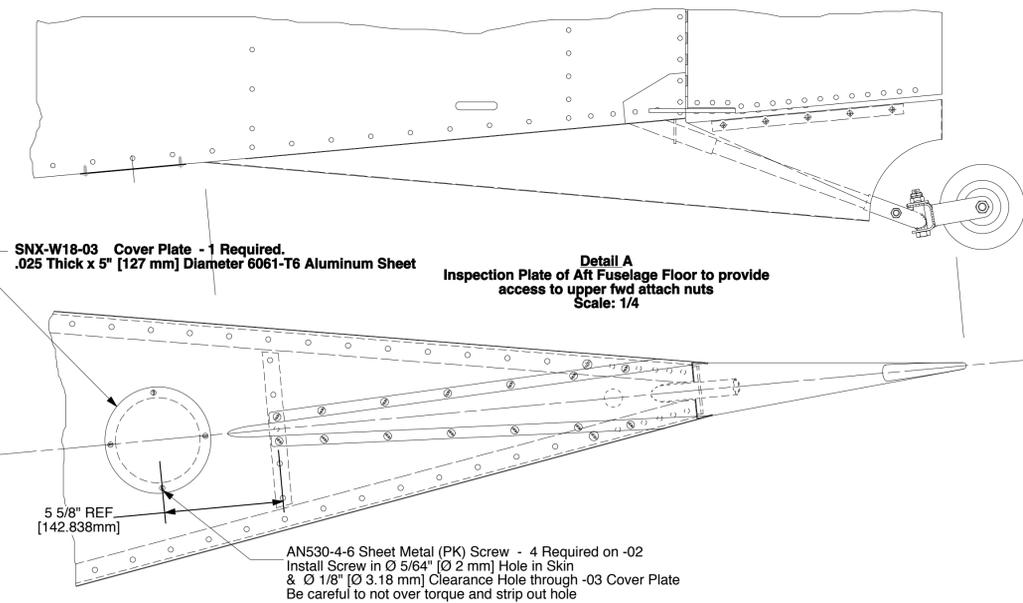
-13 Forward "Y" Fitting
1 Required on -01

-14 Aft "Y" Fitting
1 Required on -01
Open all pilot holes in "Y" Fittings up to Ø 3/32" [Ø 2.4mm] and deburr. Make sure "Y" Fittings are aligned and flat before drilling



-01 WIX-F23-01 Tail Post Assembly
New Parts and Hardware shown in Black
Scale 1:2

Note: The 11 25/32" dimension between the top of the Upper Angle and the bottom corner of the Lower Angle must be held to assure good fit with the Upper and Lower Longersons



SNX-W18-03 Cover Plate - 1 Required.
.025 Thick x 5" [127 mm] Diameter 6061-T6 Aluminum Sheet

Detail A Inspection Plate of Aft Fuselage Floor to provide access to upper fwd attach nuts
Scale: 1/4

AN530-4-6 Sheet Metal (PK) Screw - 4 Required on -02
Install Screw in Ø 5/64" [Ø 2 mm] Hole in Skin & Ø 1/8" [Ø 3.18 mm] Clearance Hole through -03 Cover Plate
Be careful to not over torque and strip out hole

This Service Bulletin details the addition of 3 Aluminum Structural elements to the tail-to-fuselage joint of the Waix.

Parts List supplied with this Service Bulletin:

- WIX-F23-16 Y-Tail Doubler Strap Qty 1
- SNX-W18-01 Inspection Plate Qty 1
- NAS6203-11 Bolt Qty 4
- NAS6203-14 Bolt Qty 2
- AN3-12A Bolt Qty 2
- AN3-11A Bolt Qty 8
- AN960-10 Washer Qty 32
- AN960-10L Washer Qty 2
- AN365-1032 Nut Qty 16
- 7/8" x 7/8" x 6" long Qty 1 (cut to 2 pieces at 2.978" long)

The following views are replaced in the Waix Plans by the Views on this Drawing:
WIX-F23-01 Tail Post Assembly
WIX-T07 View B-B

IMPORTANT NOTE: Remove all rough edges on surfaces on all aluminum parts.

Fwd Block Build Order:

- Note: If you cannot access the nuts on the fwd longeron attach bolts, it will be necessary to cut inspection hole in the aft fuselage floor per Detail A.
1. Fabricate Doubler Bars per full size patterns (no pilot holes in front blocks!)
 2. Remove the WIX-T09-04 Lower Fwd Attach Angle.
 3. Clamp the fwd doubler blocks in place and match drill Qty 3 holes in each block to carefully match the holes in the angle.
 4. Install WIX-T09-04 Lower Fwd Attach Angle and WIX-T07-02 Fwd Doubler Bars as shown in Detail B-B.

Aft Strap Builder Order:

1. Fabricate Doubler Strap and bend per full size pattern.
2. Remove attach bolts shown in black in WIX-F23-01 Tail Post Assembly Detail
3. Bend out aft fuse channel a little for doubler strap to clear rivets on both sides.
4. Match drill holes in WIX-F23-16 Doubler Strap to existing holes in structure.
5. Install WIX-F23-16 Doubler Strap with new hardware.

waix
Service Bulletin #1
Waix Tail-to-Fuselage Attachment

Drawing Scale 1:2 & Noted	Drawing Number WIX-SB-001	Revision N/C
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