

SERVICE INSTRUCTION no. 2020/01

Repair method of damaged K40Y basket corner

Cause: Damaged basket corner

With reference to: Kubicek Balloons K40 Y basket, S/N 140

Action: Repair of damaged corner

Required material:

Part	Part Number	Quantity
5 mm polyester line, black	3183.00	24 m
Plywood (antislip), birch, waterproof, thickness 21 mm	1554.00	Min. dim. 1,6 x 2,7 m
Cane 8-10 mm	1474.00	Min. 16 pcs
Cable tie 200 x 4,6 mm	714.00	Min. 32 pcs
Rawhide Leather (200 x 1 270 mm)	1517.00	Min. 10 pcs
3 mm polyester line, white	93.00	24 m
Mirelon (l=2 m)	1524.00	5 pcs
Staple 140/19 NR	1518.00	1 pack K40Y
Nail 1.25x20	504.00	Min. 8 pcs
M6x65 Carriage bolt, zinc plated	2979.00	Min. 40 pcs
M6 Locknut low profile, zinc plated	1489.00	Min. 40 pcs
Washer 6.4/18, large, zinc plated	511.00	Min. 40 pcs
Silicone sealant	1083.00	1 tube

- For repair may be used only spare parts bought directly from Kubicek Balloons, except plywood.
- Plywood semi product must have all listed parameters:
 - Birch wood
 - Antislip surface
 - Waterproof
 - Thickness 21 mm

Condition before repair



Fig. 1: Condition of basket corner before floor disassembly

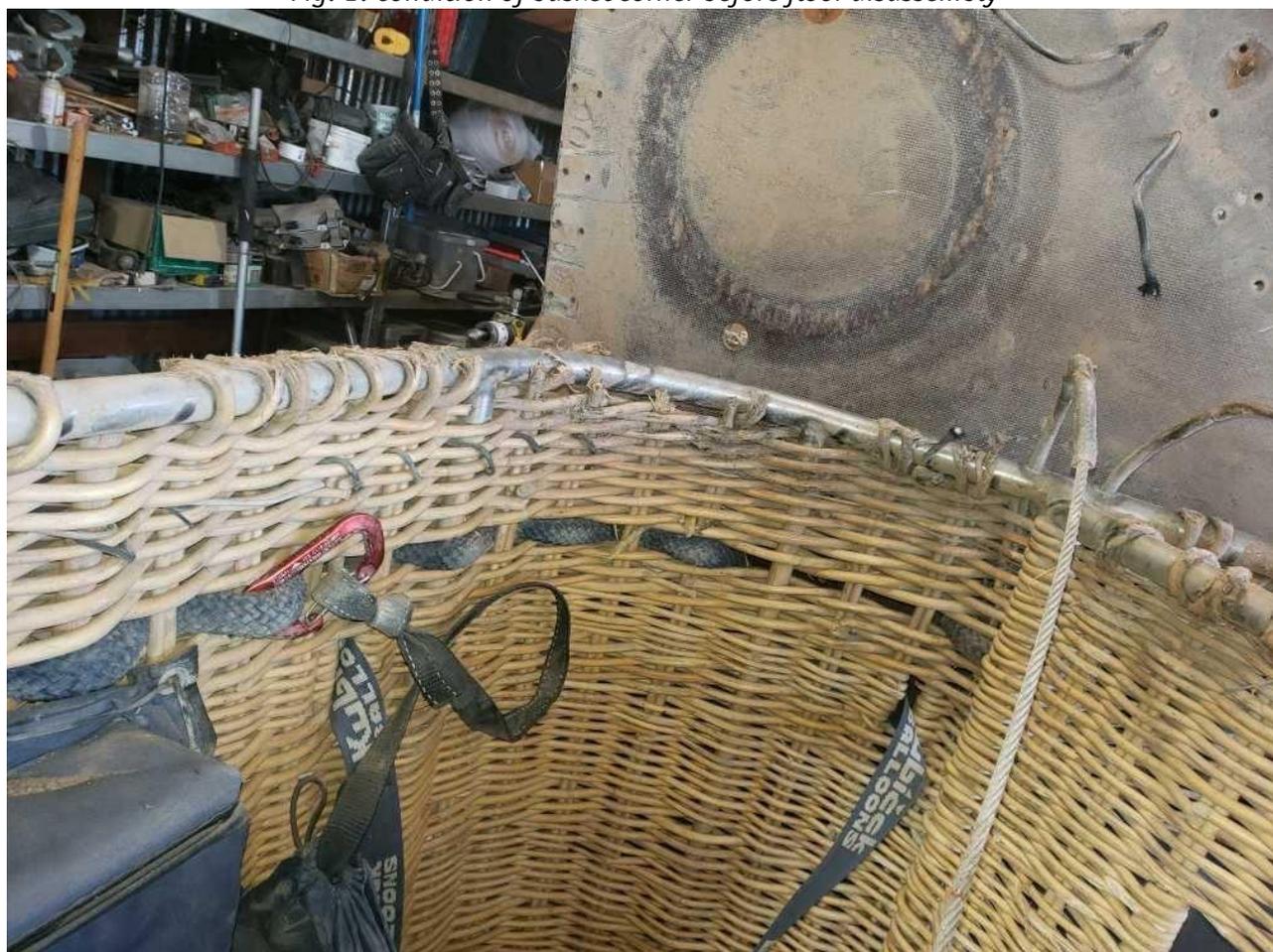


Fig. 2: Condition of basket corner after floor disassembly

From provided pictures was find out, that damage of basket corner is limited only to 8 pairs of wickers (stakes). 6 pairs are missing lower part (around lower frame) completely. 2 wickers (stakes) pairs have major damage of lower part, which should be repaired as well.



Fig. 3: Condition of rest of basket after floor disassembly

Method of repair:

For easier, safer work and better manipulation, we recommend putting wickers into water at least one day before start of repair.

Repair contains cutting damaged wickers (each from pair in different height, please see *Fig. 4*). Damaged wicker parts must be extracted from basket corner and replaced by spare wicker pieces, placed back into woven wall, to replace of damaged ones. New wickers must be inserted fully into weave, to maintain as small gap between old and new piece, as possible.

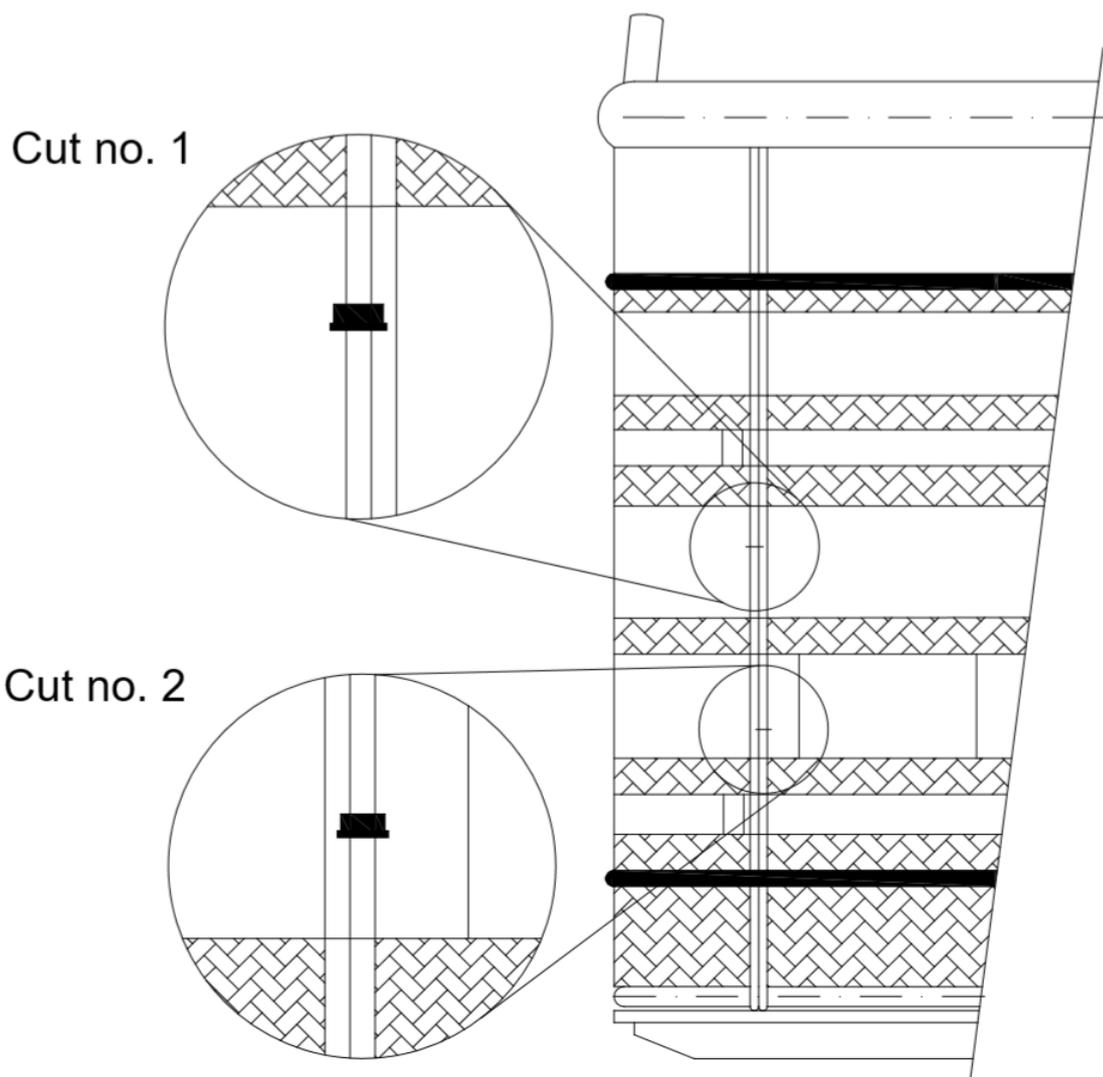


Fig. 4: Where to cut wickers

After replacing old damaged wickers, is necessary to tighten together new and old wickers at least at four points in different heights (please see *Fig. 5*). Tightening should be made in places, where isn't strength type of weaving. For tightening use Cable ties 200x4,6 mm (714.00).

Process of reassembly must be made with compliance with assembly pictures below (*Fig. 7 – 11*).

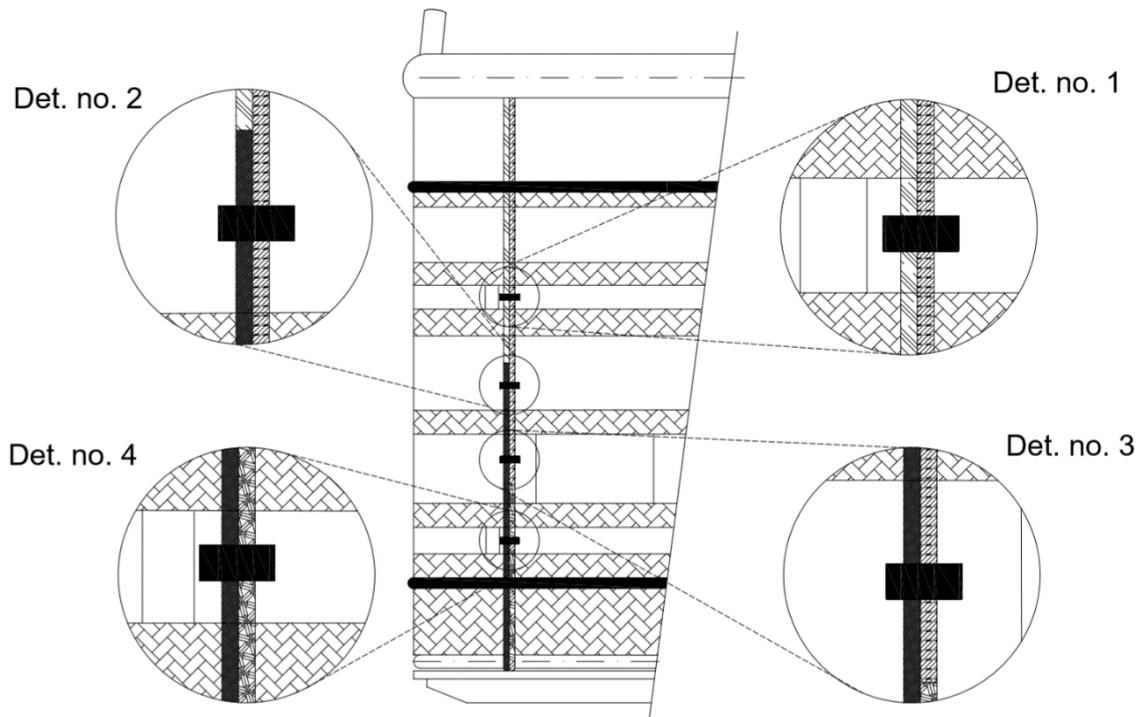
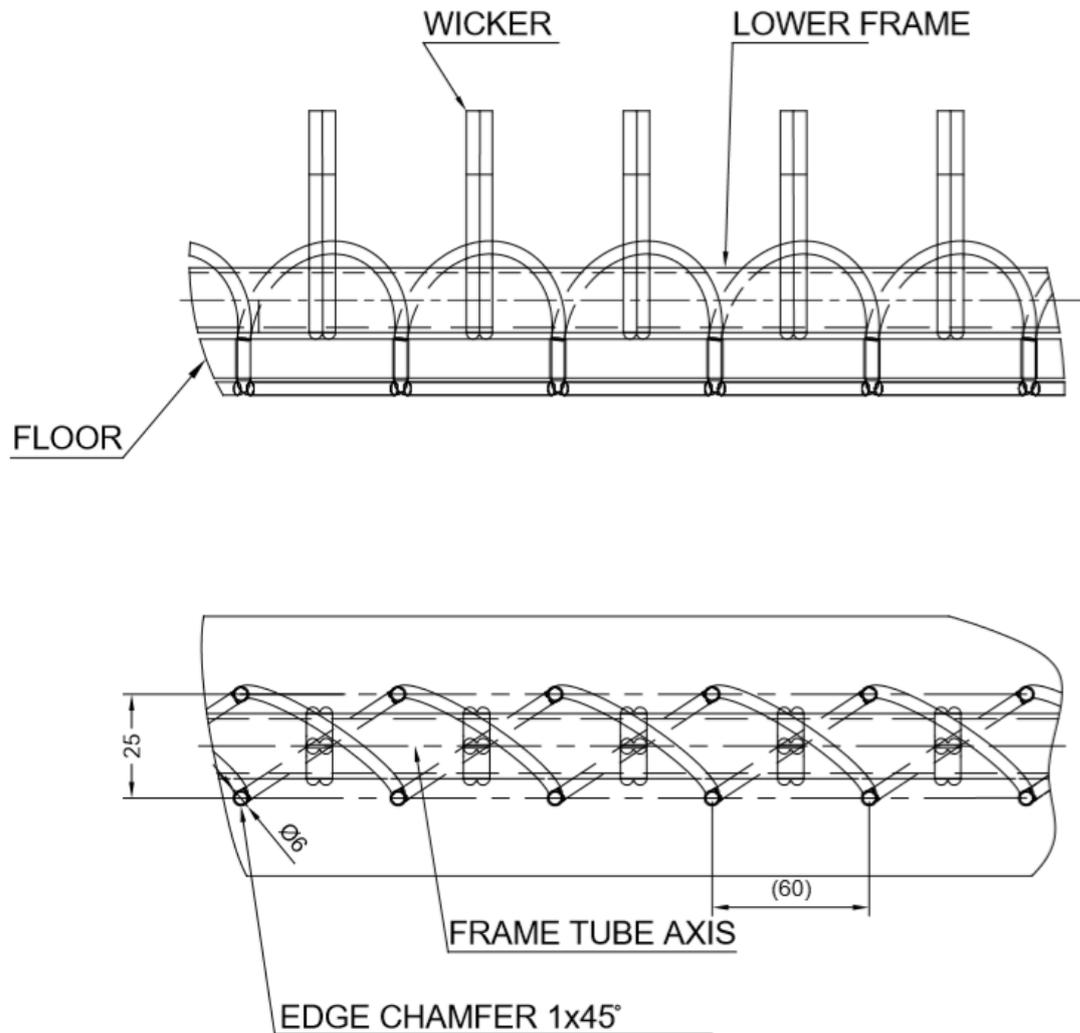


Fig. 5: Details of connection between old and new wickers

Dimensions of floor and attachment points must be copied from existing floor, minimal dimensions of semi-finished floor are 1,6 x 2,7 m. Plywood used for floor must be from birch, waterproof and antislip, with thickness 21 mm.

After manufacturing floor, it will be attached to lower frame as it is shown on Fig. 7 with black polyester line (diameter 5 mm).

ASSEMBLY OF FLOOR TO FRAME



USE BLACK POLYESTER LINE, dia. 5mm

Fig. 7: Floor assembly

FLOOR COVER

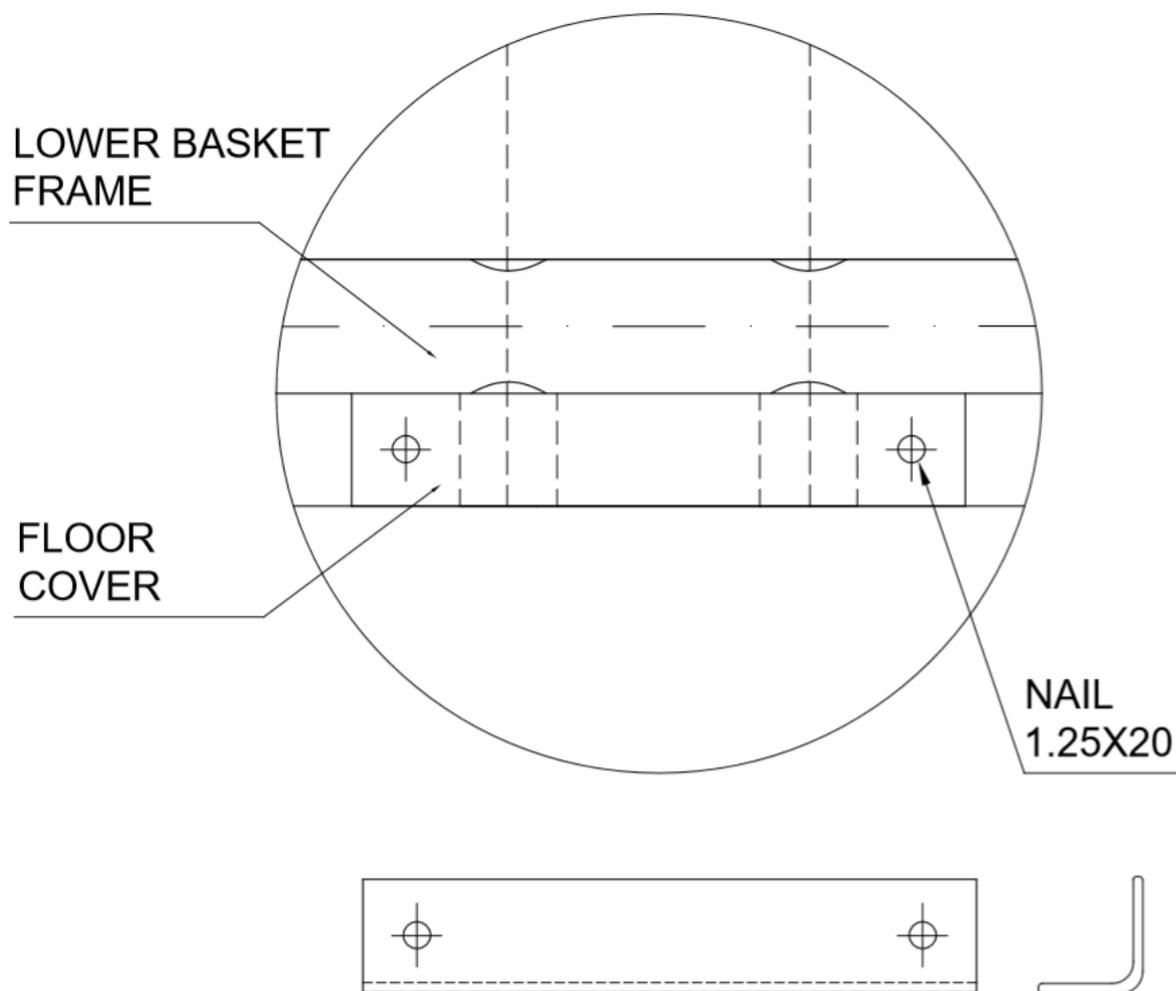
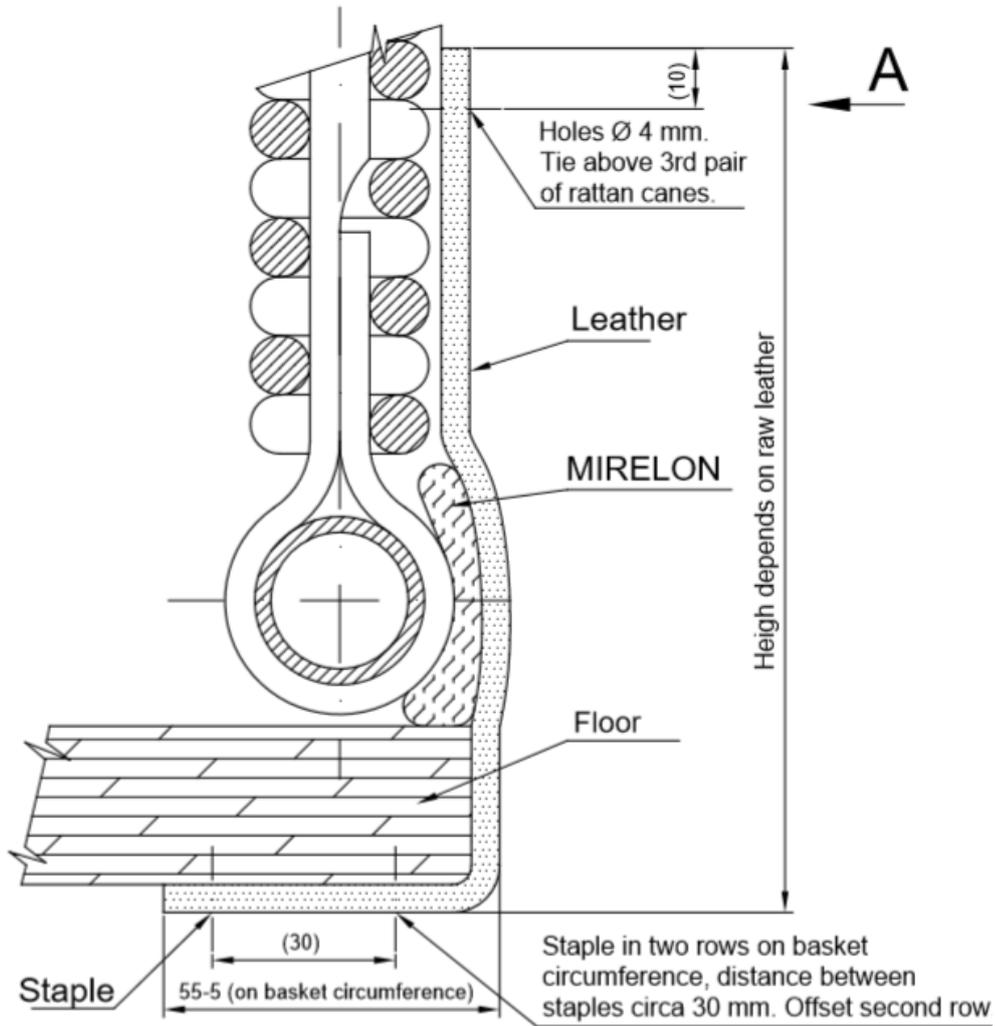


Fig. 8: Floor cover assembly

Steel cables covers (floor covers) are attached to floor by nails as shown on Fig. 8.

With floor and floor covers assembled, next step is to attach rawhide leather (must be soaked in advance to be flexible), firstly to rattan canes by 3 mm polyester line. Please remember to leather shriveling (in all directions) during drying and use bigger pieces of leather. To avoid damage of leather by steel tubes of frame, is used MIRELON, which must be on outer side of tubular lower frame, under leather (please see Fig. 9). Next step is to bend leather around floor edge. After bending, leather is stapled to floor in two rows with offset, dimensions are shown of Fig. 9. Excess leather must be cut away. As reference for style of connection between leather pieces, please see Fig. 11, where is shown used basket and how is line tied in leather, however after connection and dry up of leather, holes must be in one line, as shown in Fig. 10.



View A (1 : 1)

Detail of tie between lower leather padding and weave of basket.

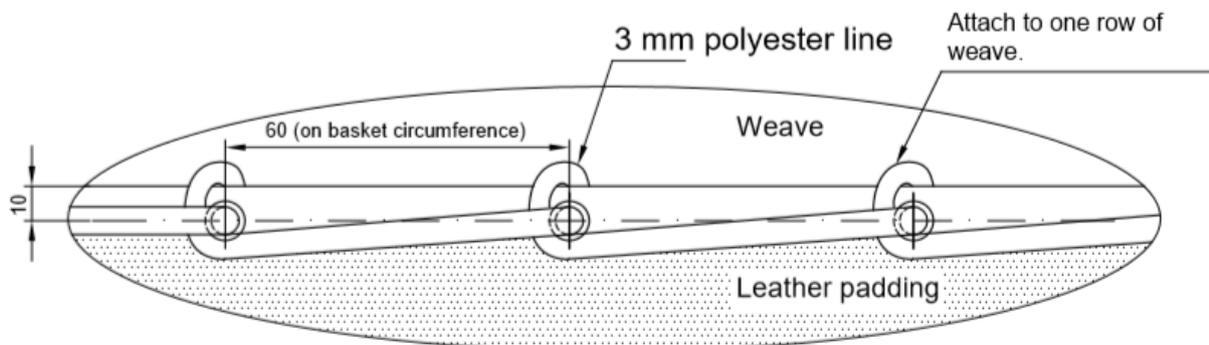


Fig. 9: Leather and MIRELON padding assembly

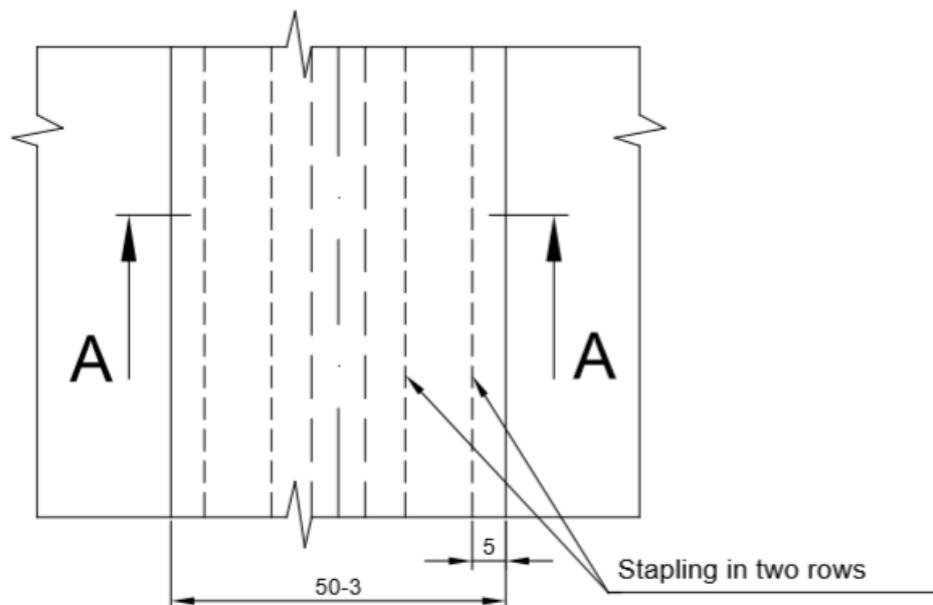


Fig. 10: Connection of two rawhide leathers together



Fig. 11: Connection of two rawhide leathers together (please note, that in picture is used basket and it only represents method of connection, however on new product are holes in both pieces at same line – see Fig. 10). This offset happens, when connected leathers are still wet, because during drying leather is shriveling.

STAPLING STEEL CABLE COVER



A - A

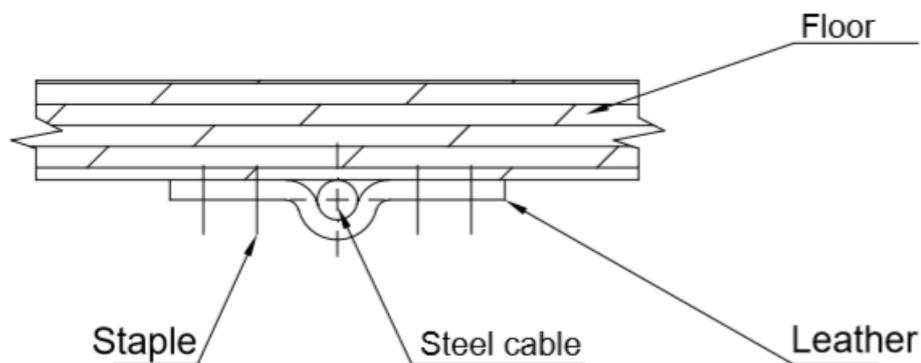


Fig. 12: Stapling steel cable cover

Steel cables must be covered by leather band, which is stapled to floor in two rows on each side (Fig. 12). After covering cables floor runners must be assembled according to Fig. 13 and 14.

LOAD STEEL CABLES

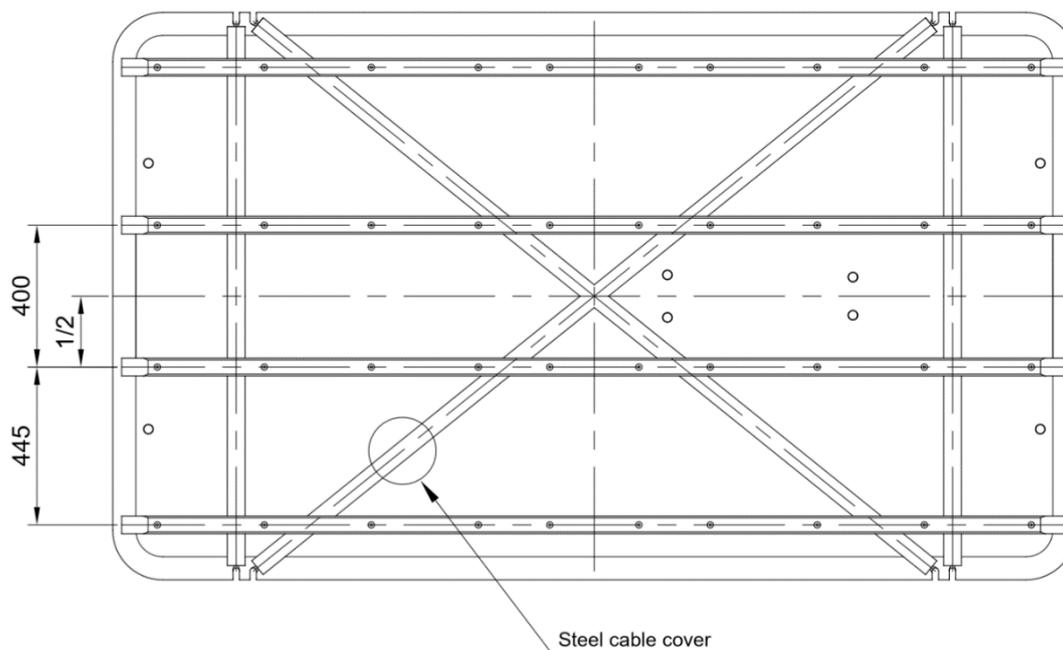


Fig. 13: Load steel cables and floor runner diagram

Floor runner assembly

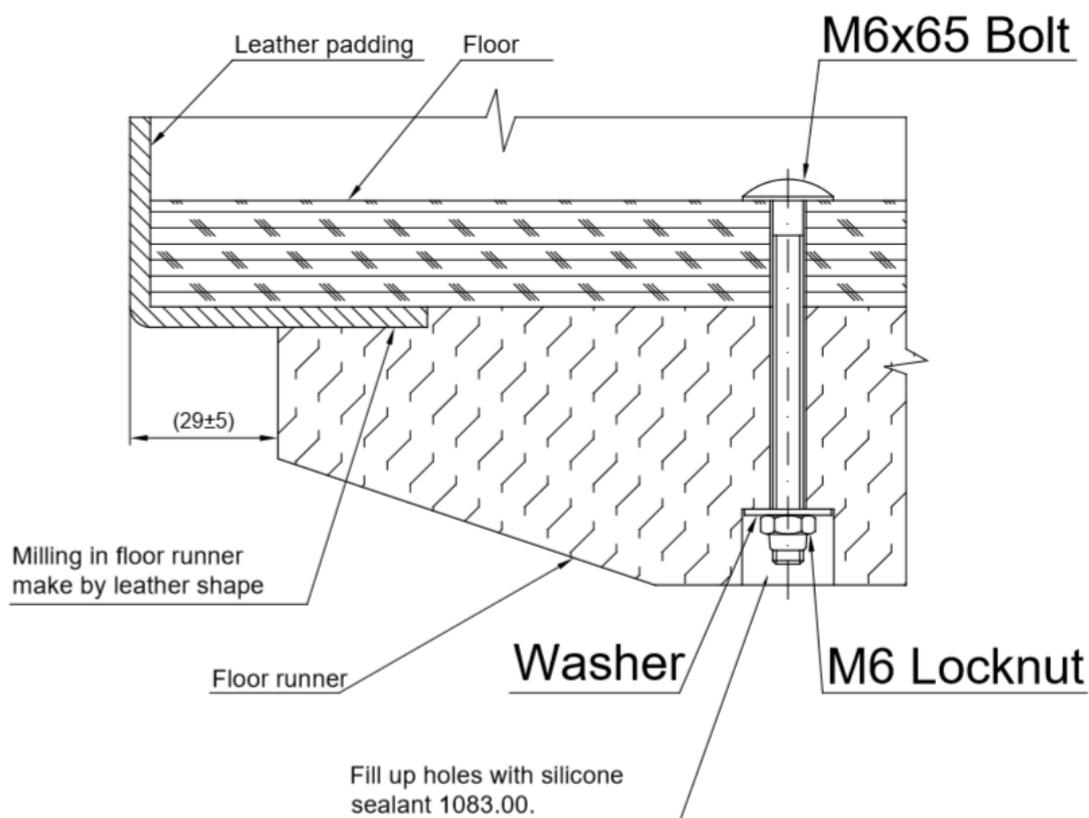


Fig. 14: Load steel cables and floor runner diagram

Whole repair process will be supervised by Kubicek Balloons. Repair station must provide photos from repair process to Kubicek Balloons, for approval of KB, before release to service. Overall view to damaged corner of basket before repair starts, then location of cuts on wickers, process of replacing wickers, tightening of them together, floor attachment, lower leather padding assembly and overall view to whole repaired basket must be presented by photos.

Technical content of this document is approved under the authority of DOA No. EASA.21J.277.

On behalf of BALÓNY KUBÍČEK spol. s r.o.

A handwritten signature in blue ink, appearing to be 'Petr Kubíček'.

Ing. Petr Kubíček, technical director

Datum: **06 February 2020**