

TITLE

EXHAUST - EXHAUST SHROUD IMPROVEMENT

EFFECTIVITY**MODEL**

208

208B

SERIAL NUMBERS

20800001 thru 20800678

208B0001 thru 208B5643

The equivalent of this service document has been incorporated on production airplanes 208: 20800679 and ON, and 208B: 208B5644 and ON.

REASON

The exhaust shroud may have developed a crack. If a crack has developed a field repair is available to repair the cracked exhaust shroud.

DESCRIPTION

This service document provides parts and instructions to remove the affected area of the exhaust shroud and install a new strap to the exhaust shroud.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at a scheduled maintenance period or inspection.

A service document published by Textron Aviation may be recorded as *completed* in an aircraft log only when the following requirements are satisfied:

- 1) The mechanic must complete all of the instructions in the service document, including the intent therein.
- 2) The mechanic must correctly use and install all applicable parts supplied with the service document kit. Only with written authorization from Textron Aviation can substitute parts or rebuilt parts be used to replace new parts.
- 3) The mechanic or airplane owner must use the technical data in the service document only as approved and published.
- 4) The mechanic or airplane owner must apply the information in the service document only to aircraft serial numbers identified in the *Effectivity* section of the document.
- 5) The mechanic or airplane owner must use maintenance practices that are identified as acceptable standard practices in the aviation industry and governmental regulations.

No individual or corporate organization other than Textron Aviation is authorized to make or apply any changes to a Textron Aviation-issued service document or flight manual supplement without prior written consent from Textron Aviation.

Textron Aviation is not responsible for the quality of maintenance performed to comply with this document, unless the maintenance is accomplished at a Textron Aviation-owned Service Center.

APPROVAL

Textron Aviation received FAA approval for the technical data in this publication that changes the airplane type design.

July 26, 2023

CAB-78-03
Page 1 of 9

Textron Aviation Customer Service, P.O. Box 7706, Wichita, KS 67277, U.S.A. 1-316-517-5800

This document contains technical data and is subject to U.S. export regulations. This information has been exported from the United States in accordance with export administration regulations. Diversion contrary to U.S. law is prohibited. ECCN: 9E991

FLIGHT CREW OPERATIONS

No Changes

CONSUMABLE MATERIAL

You must use the consumable materials that follow, or their equivalent, to complete this service document.

NAME	NUMBER	MANUFACTURER	USE
Color Chemical Film Treatment	Alodine 1132 Touch n Prep Pen	Commercially Available	To protect bare aluminum surface.
Type I Class B Sealant	U470638	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To bond the strap to the shroud.
Isopropyl Alcohol		Commercially Available	To clean metal surfaces prior to bonding.
Corrosion Resistant Primer		Graco Supply Company 2056 S. Edwards Ste. C Wichita, KS 67213	To cover the bare metal surfaces of the exhaust shroud.

TOOLING

No specialized tooling is required to complete this service document.

WEIGHT AND BALANCE INFORMATION

Negligible

REFERENCES

Cessna Model 208 Series Maintenance Manual

Model 208 Series Structural Repair Manual

PUBLICATIONS AFFECTED

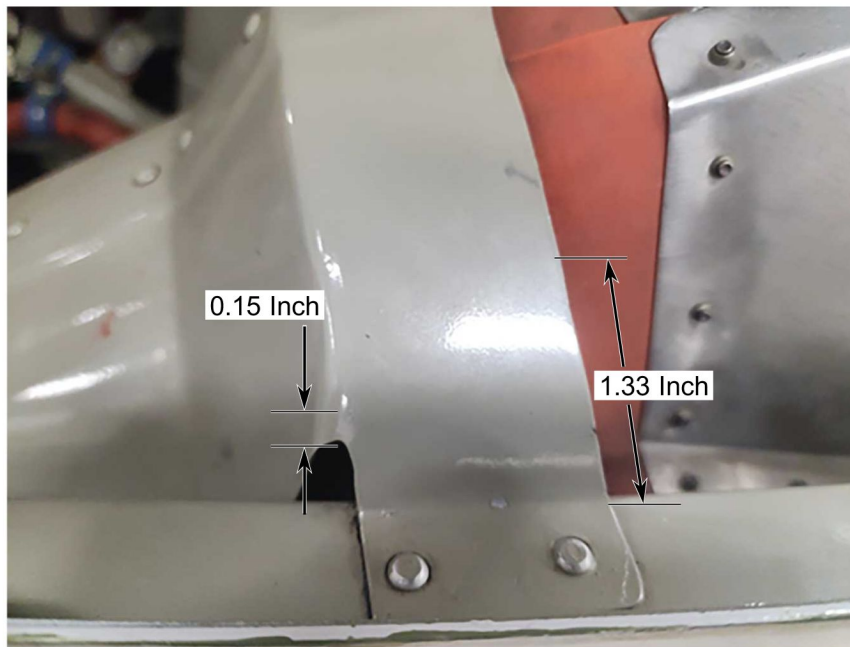
Cessna Model 208 Series Illustrated Parts Catalog

ACCOMPLISHMENT INSTRUCTIONS

1. Prepare the airplane for maintenance.
 - A. Make sure that the airplane is electrically grounded.
 - B. Make sure that all switches are in the OFF/NORM position.
 - C. Disconnect electrical power from the airplane.
 - (1) Disconnect external electrical power.
 - (2) Disconnect the airplane battery.
 - D. Attach maintenance warning tags to the battery and external power receptacle that have **"DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS"** written on them.
2. Open the right engine door.
3. (Refer to Figure 1, Sheet 1.) Make a measurement on the 2652022-7/-103 Shroud as follows:
 - A. Temporarily put the 2652034-6S Strap onto the 2652022-7/-103 Shroud.
 - B. On the forward edge of the 2652022-7/-103 Shroud, measure and mark 1.33 Inch from the inboard edge of the 2652022 Stringer with a marker.

- C. From the radius of the aft edge of the 2652022-7/-103 Shroud, measure and mark 0.15 Inch where the mark would meet with the 2652034-6S Strap with a marker.

A113693



NOTE: The dimensions are not drawn to scale but are shown for clarity.

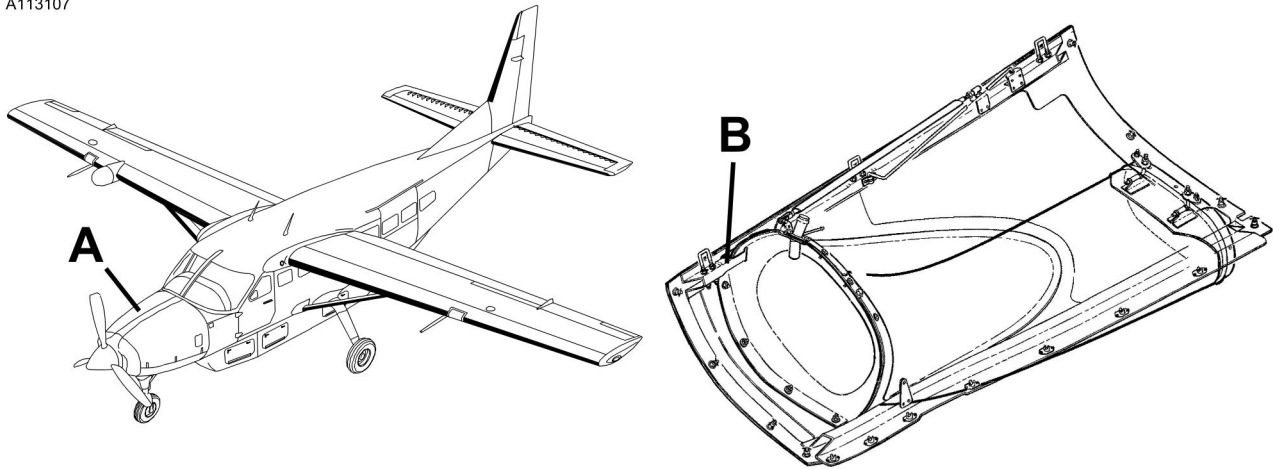
- D. Remove the 2652034-6S Strap and connect the two measurements on the 2652022-7/-103 Shroud with a marker.
4. Make sure that any cracks and/or drill stops are below the drawn line on the 2652022-7/-103 Shroud.
- A. If the cracks and/or drill stops are below the marked line, go to Step 5.
- B. If the cracks and/or drill stops are above the marked line contact Team Structures at 316-517-6061 or at structures@txtav.com, then go to Step 12.
5. Remove the right lower cowl panel. (Refer to the Model 208 Maintenance Manual, Chapter 71, Engine Cowling and Nose Cap - Maintenance Practices.)
6. Remove the Secondary Exhaust Duct. (Refer to the Model 208 Maintenance Manual, Chapter 78, Primary and Secondary Exhaust Duct - Maintenance Practices.)
7. (Refer to Figure 1, Sheet 2.) Remove the cracked area of the 2652022-7/-103 Shroud as follows:
- A. Remove the two rivets that attach the 2652022-7/-103 Shroud to the 2652022 Stringer. (Refer to the Model 208 Series Structural Repair Manual, Chapter 51, Fasteners.)
- B. Remove and discard the cracked area of the 2652022-7/-103 Shroud.
- C. Remove all ragged edges of the 2652022-7/-103 Shroud.
- D. Round all corners of the 2652022-7/-103 Shroud.
- E. Apply Color Chemical Film Treatment to all bare metal.
- F. Apply Corrosion Resistant Primer to all exposed bare metal.
8. (Refer to Figure 1, Sheet 3.) Install the 2652034-6S Strap as follows:
- A. (Refer to Figure 2, Sheet 1.) Modify the 2652034-6S Strap as shown in Figure 2, Sheet 1.

- B. Hand form the modified 2652034-6S Strap, as required, to match the contour of the 2652022-7/-103 Shroud to be within 0.05 inch of each other.
 - C. Match drill the two holes of the 2652022 Stringer to two Number 30 (0.1285 inch diameter) holes into the modified 2652034-6S Strap.
 - D. Place the modified 2652034-6S Strap onto the inboard side of the 2652022-7/-103 Shroud.
 - E. Drill the five Number 30 (0.1285 inch diameter) holes through the 2652022-7/-103 Shroud and the modified 2652034-6S Strap.
 - F. Debur all drilled holes.
 - G. Countersink the five holes to 100 Degree x 0.128 Inch Diameter , on the inboard side, of the modified 2652034-6S Strap.
 - H. Apply Color Chemical Film Treatment to all bare metal.
 - I. Apply Corrosion Resistant Primer to all exposed bare metal.
 - J. Clean the modified 2652034-6S Strap and the 2652022-7/-103 Shroud surfaces with Isopropyl Alcohol. (Refer to the Model 208 Maintenance Manual, Chapter 20, Standard Practices - Airframe, General Solvents/Cleaners - Maintenance Practices.)
 - K. Apply U470638 Sealant onto the inboard side of the 2652022-7/-103 Shroud and the opposite side of the countersunked holes of the modified 2652034-6S Strap and the 2652022-7/-103 Shroud. (Refer to the 208 Maintenance Manual, Chapter 20, Standard Practices - Airframe, Solvents, Sealants, and Adhesives - Description and Operation.)
 - L. Place and align the holes of the modified 2652034-6S Strap onto the inboard side of the 2652022-7/-103 Shroud
 - M. Install the five MS20426AD4-4 Rivets into the modified 2652034-6S Strap and through the 2652022-7/-103 Shroud. (Refer to the Model 208 Series Structural Repair Manual, Chapter 51, Fasteners.)
- NOTE:** The installation of the rivets must clear the primary exhaust duct.
- N. Install the two NAS1738B4-2 Rivets into the modified 2652034-6S Strap and the 2652022 Stringer. (Refer to the Model 208 Series Structural Repair Manual, Chapter 51, Fasteners.)
- 9. Clean off any excess sealant using Isopropyl Alcohol.
 - 10. Install the Secondary Exhaust Duct. (Refer to the Model 208 Maintenance Manual, Chapter 78, Primary and Secondary Exhaust Duct - Maintenance Practices.)
 - 11. Install the right lower cowl panel. (Refer to the Model 208 Maintenance Manual, Chapter 71, Engine Cowling and Nose Cap - Maintenance Practices.)
 - 12. Close the right engine door.
 - 13. Remove the maintenance warning tags and connect the airplane battery.
 - 14. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

NOTE: Textron Aviation recommends that compliance with all service documents is reported to a maintenance tracking system provider.

- Complete a record of compliance. (Maintenance Transaction Report, Log Book Entry, or other record of compliance.)
- Put a copy of the completed record of compliance in the airplane logbook.
- Send a copy of the completed record of compliance to the maintenance tracking system provider used.

A113107



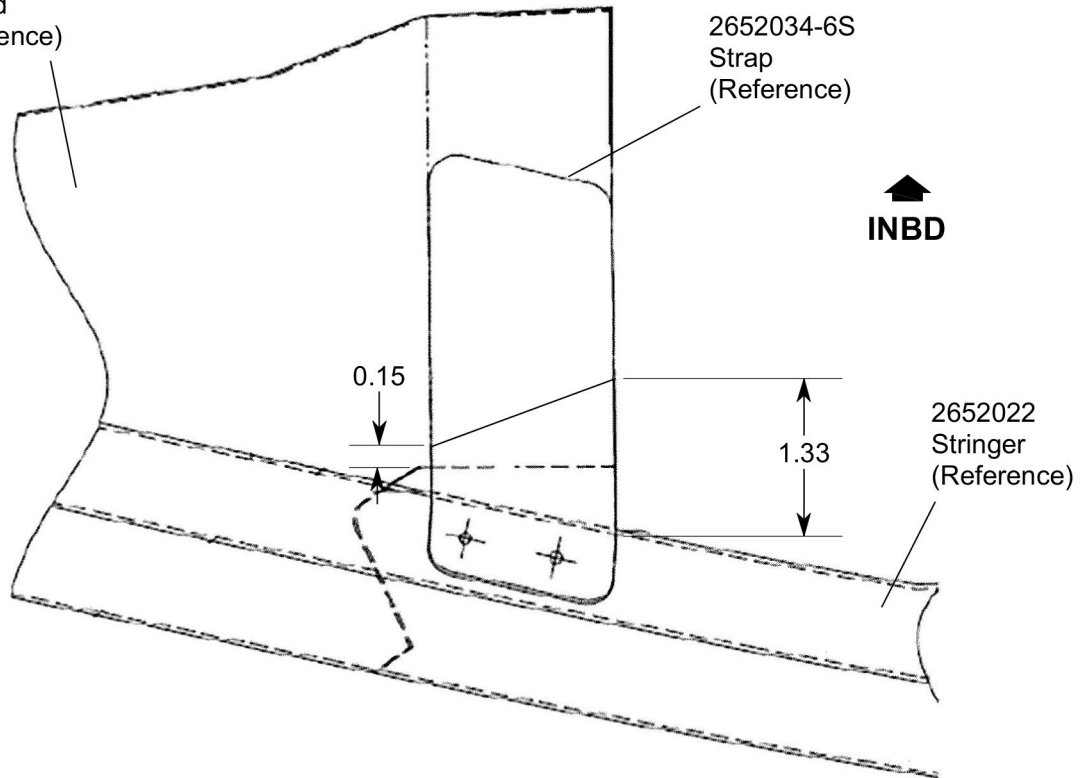
DETAIL A

(View Looking at Right Lower Cowl)

2652022-7/-103
Shroud
(Reference)

2652034-6S
Strap
(Reference)

↑
INBD



DETAIL B

(View Looking at Exhaust Shroud)

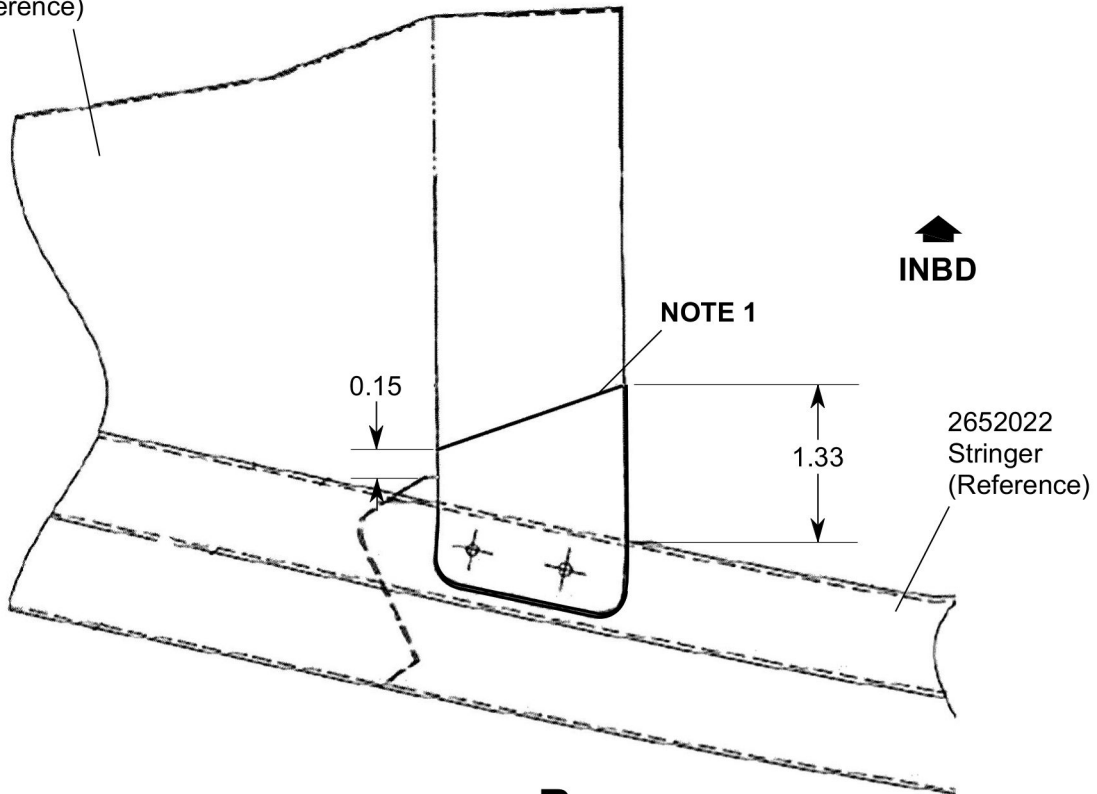
NOTE: All dimensions are in inches.

2610T1031

Figure 1. Exhaust Shroud Strap Installation (Sheet 1)

A113108

2652022-7/-103
Shroud
(Reference)



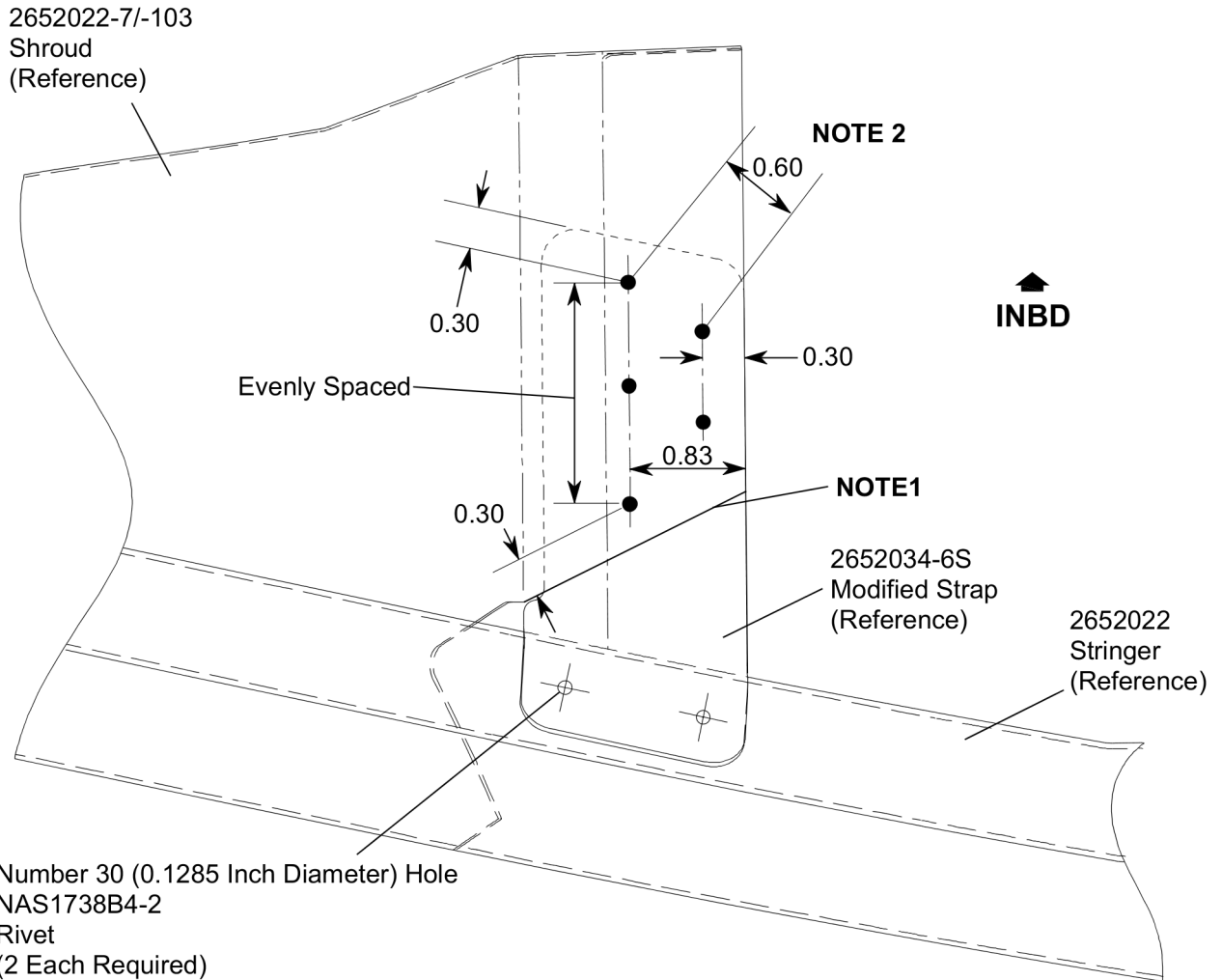
DETAIL B
(View Looking at Exhaust Shroud)

NOTE 1: Remove the bolded area below the marked line of the 2652022-7/-103 Shroud.

NOTE 2: All dimensions are in inches.

Figure 1. Exhaust Shroud Strap Installation (Sheet 2)

A113109



NOTE: All Dimensions are in Inches.

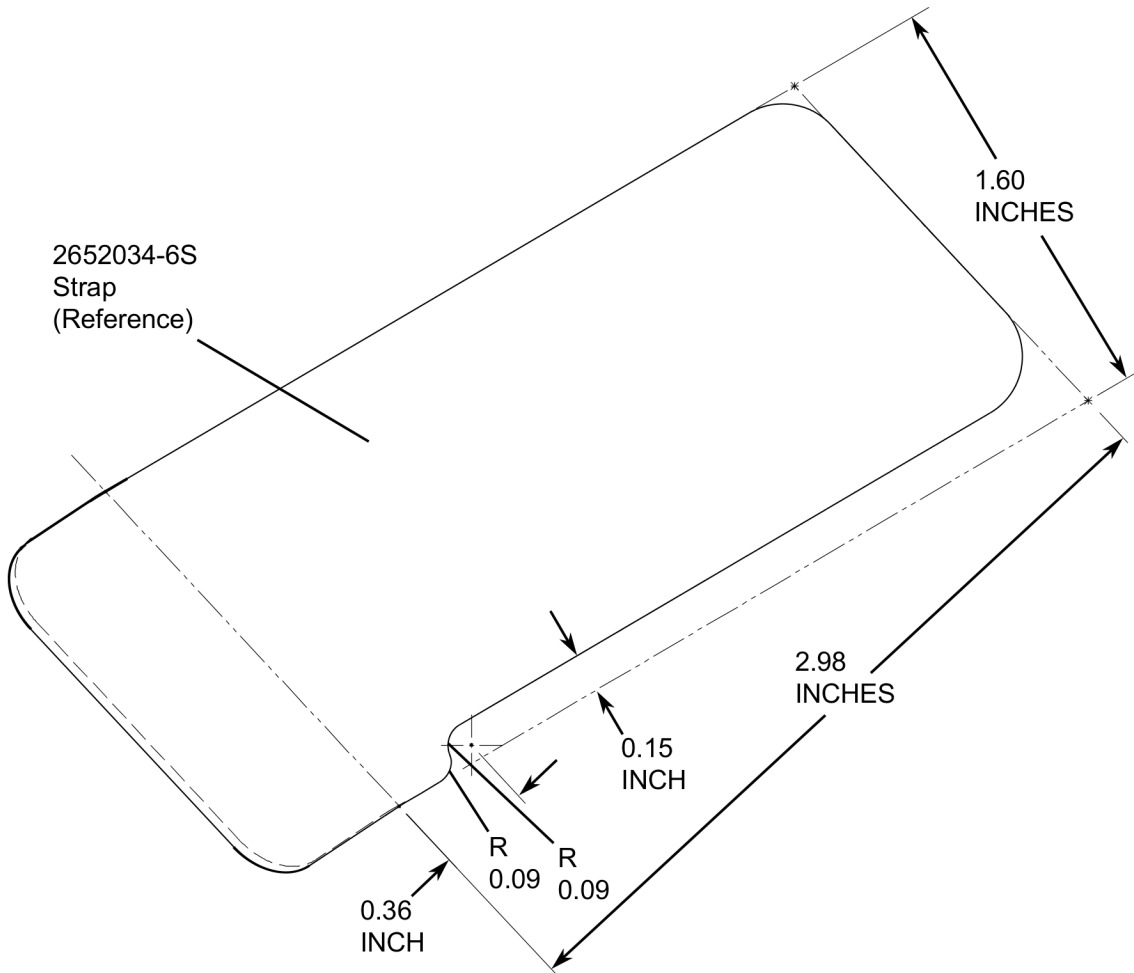
NOTE 1: View of the 265022-7/-103 Shroud After Trimming.

NOTE 2: The 0.60 inch dimension is the minimum distance that is allowed.

Legend	
●	Number 30 (0.1285 Inch Diameter) Hole Counter Sink 100 Degree X 0.128 Inch Diameter MS20426AD4-4 Rivet (5 Each Required)

Figure 1. Exhaust Shroud Strap Installation (Sheet 3)

A113310



DETAIL A
(Modified Strap)

NOTE: All Dimensions are in Inches.

Figure 2. Exhaust Strap Modification (Sheet 1)

MATERIAL INFORMATION

Order the kit below to install this modification.

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
CAB-78-03	1	Kit , consisting of the following parts:		
MS20426AD4-4	5	Rivet	N/A	Install
NAS1738B4-2	2	Rivet	N/A	Install
2652034-6S	1	Strap	N/A	Install
CAB-78-03	1	Instructions		

* Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document. Phone at 1-800-835-4000 (Domestic) or 1-316-517-5603 (International).

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

TITLE

EXHAUST - EXHAUST SHROUD IMPROVEMENT

TO:

Cessna Model 208 and 208B Aircraft Owner

REASON

The exhaust shroud may have developed a crack. If a crack has developed a field repair is available to repair the cracked exhaust shroud.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at a scheduled maintenance period or inspection.

LABOR HOURS

WORK PHASE	LABOR-HOURS
Modification	5

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
CAB-78-03	*	*

* Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document. Phone at 1-800-835-4000 (Domestic) or 1-316-517-5603 (International).

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

WARRANTY

This service document is *recommended*. Eligible airplanes may qualify for parts and labor coverage to the extent noted in the *Labor Hours* and *Material Availability* sections of this document.

July 26, 2023

CAB-78-03
Page 1 of 2

Textron Aviation Customer Service, P.O. Box 7706, Wichita, KS 67277, U.S.A. 1-316-517-5800

This document contains technical data and is subject to U.S. export regulations. This information has been exported from the United States in accordance with export administration regulations. Diversion contrary to U.S. law is prohibited. ECCN: 9E991

Eligibility: Airplanes identified within the serial number effectivity of this service document must have active Airframe warranty coverage on the original issue date of this document and the coverage must be active on the day the work is accomplished.

Parts Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities, operators, or other maintenance facilities may submit a claim for the parts required to accomplish this service document as defined in the *Material Availability* section of this document.

Labor Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities rated to perform maintenance on the specific model of Cessna Aircraft may submit a claim for the labor necessary to accomplish this service document as defined in the *Labor Hours* section of this document.

Credit Application: After this service document has been accomplished, a claim must be submitted to Textron Aviation within 30 days of the service document completion. Claims for compliance of this service document are to be filed as a W4 type claim.

Please submit your claim form online at ww2.txtav.com/Parts or email the completed Textron Aviation Claim Form to warranty@txtav.com. If submitted on-line a Return Authorization will be provided. If a paper claim is submitted your claim will be entered into the system and a Return Authorization will be sent to you.

The Return Authorization must accompany any required return parts (see *Material Availability*), to the point of purchase.

Parts to be returned to Textron Aviation Parts Distribution should be forwarded to:

TEXTRON AVIATION INC
CORE RETURNS
201 N GREENWICH RD BLDG 94
Wichita, KS 67206-2558

Expiration: July 26, 2025 (after this date the owner/operator assumes the responsibility for compliance costs)

Textron Aviation reserves the right to void continued airplane warranty coverage for the parts affected by this service document until the service document is accomplished.

NOTE: As a convenience, service documents are now available online to all our customers through a simple, free-of-charge registration process. If you would like to sign up, please visit the Customer Access link at support.txtav.com to register.