

MANDATORY**MTL-53-03****TITLE**

FUSELAGE - CROSS TIE FASTENER INSPECTION AT FUSELAGE STATION 158.00

EFFECTIVITY**MODEL**

B300

SERIAL NUMBERSFL-1161 thru FL-1200, FL-1202 thru FL-1241,
FL-1243**REASON**

During inspection it was found that the rivets might not have been installed in the left and right cross ties located on fuselage station 158.00 (FS 158.00).

DESCRIPTION

This service document provides parts and instructions to complete a visual inspection for missing rivets and if necessary, install rivets.

COMPLIANCE

MANDATORY. This service document must be accomplished at the next 200-hour or 12-month 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.

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 1201	Textron Aviation Parts & Distribution 7121 Southwest Boulevard Wichita, KS 67215	To treat bare aluminum surface.

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

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TOOLING

No specialized tooling is required to complete this service document.

REFERENCES

Beechcraft Super King Air B300/B300C Fusion Maintenance Manual

Beechcraft Structural Inspection and Repair Manual

PUBLICATIONS AFFECTED

None

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. Remove the passenger compartment upholstery and equipment as necessary to gain access to FS 158.00. (Refer to the Maintenance Manual, Chapter 6, Airplane Stations - Description and Operation, Figure 1 for FS 158.00 location.)

NOTE: FS 158.00 is located in front of the first cabin window.

3. (Refer to Figure 1, Sheets 1, and 2.) Inspect FS 158.00 for correct rivet installation.
 - A. Compare the left and right side of the aircraft to the illustration and identify locations that are missing rivets.

NOTE: Maximum spacing between two rivets is 8D from one rivet center to next rivet center (8-times rivet diameter, 1/8" diameter x 8 = 1").
Minimum spacing between two rivets is 4D from one rivet center to next rivet center (4-times rivet diameter, 1/8" diameter x 4 = 1/2").
 - B. If rivets are missing, go to Step 4.
 - C. If all rivets are installed, go to Step 5.
4. (Refer to Figure 1, Sheets 1, and 2.) Install missing rivets as follows:
 - A. Identify the center location for any missing rivet.

NOTE: Maximum spacing between two rivets is 8D from one rivet center to next rivet center (8-times rivet diameter, 1/8" diameter x 8 = 1").
Minimum spacing between two rivets is 4D from one rivet center to next rivet center (4-times rivet diameter, 1/8" diameter x 4 = 1/2").
Edge distance for rivets being installed is standard 2D from edge to center of rivet hole (2-times rivet diameter, 1/8" diameter x 2 = 1/4").
 - B. Drill a Number 30 (0.1285 inch diameter) hole at the identified locations.
 - C. Debur all drilled holes.
 - D. Make sure all rivet shavings are removed.
 - E. Apply Color Chemical Film Treatment to all bare metal.

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- F. Install a 132369AD4-5 Rivet into all drilled holes. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)
5. Install and complete an operational check of all passenger compartment upholstery and equipment that was disconnected or removed to gain access to FS 158.00.
6. Remove the maintenance warning tags and connect the airplane battery.
7. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

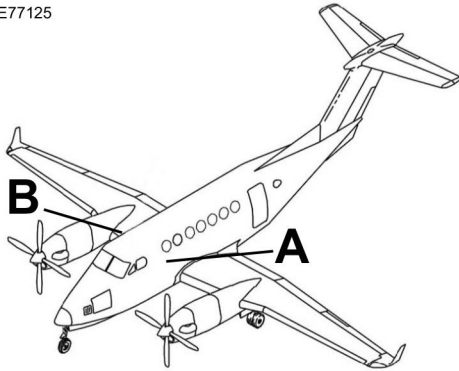
NOTE: Textron Aviation recommends that compliance with all service documents is reported to a maintenance tracking system provider.

- 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.

MANDATORY

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E77125



Area to Inspect
132369AD4-5
Rivets
(16 Each row,
32 total)

FWD →

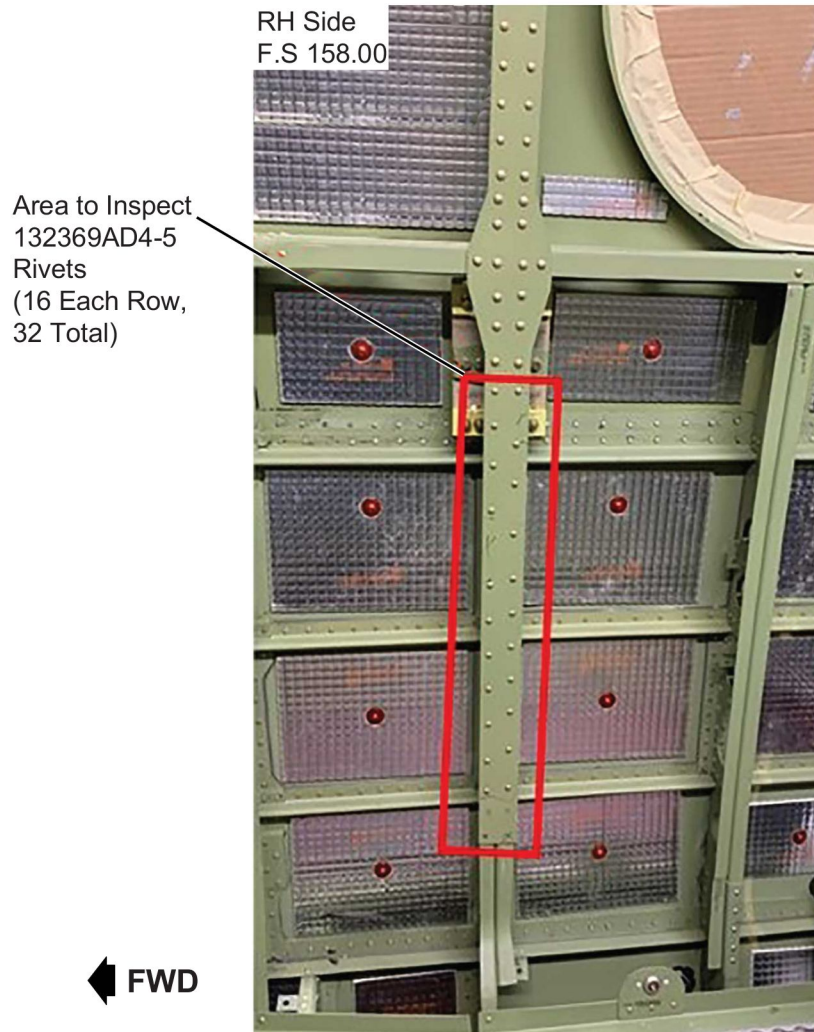
DETAIL A

View Looking Outboard at Left Side FS 158.00

NOTE: This example is showing 8 missing rivets, 4 for each row.

Figure 1. Cross Tie at Fuselage Station 158.00 (Sheet 1)

E77126



DETAIL B

View Looking Outboard at Right Side FS 158.00

NOTE: This example is showing 8 missing rivets, 4 for each row.

Figure 1. Cross Tie at Fuselage Station 158.00 (Sheet 2)

MANDATORY**MATERIAL INFORMATION**

Order the part below to install this modification.

NEW P/N	QUANTITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
132369AD4-5	As Required	Rivet	N/A	Install

* 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

FUSELAGE - CROSS TIE FASTENER INSPECTION AT FUSELAGE STATION 158.00

TO:

Beechcraft Model B300 Aircraft Owner

REASON

During inspection it was found that the rivets might not have been installed in the left and right cross ties located on fuselage station 158.00 (FS 158.00).

COMPLIANCE

MANDATORY. This service document must be accomplished at the next 200-hour or 12-month inspection.

LABOR HOURS

WORK PHASE	LABOR-HOURS
Inspection	50.0
Modification	5.0

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
132369AD4-5	*	*

* 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).

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WARRANTY

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

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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 Beechcraft 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 Parts Distribution
Warranty Administration
285 South Greenwich Road
Bldg B89, Docks 1-4
Wichita, KS 67206
USA

Expiration: January 31, 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 www.txtavsupport.com to register.