

TITLE

EQUIPMENT/FURNISHINGS - ANNOUNCEMENT OF IPECO SB480-25-01 CARRIER AND BRAKE IMPROVEMENT FOR PASSENGER SEATS

EFFECTIVITY**MODEL**

Super King Air B300

SERIAL NUMBERS

FL-1234, FL-1235, FL-1236, FL-1238, FL-1243

REASON

There have been reports of the passenger seat's motion and brake engagement being loose. IPECO has issued Service Bulletin 480-25-01, Carrier & Brake Improvement, that addresses carrier motion and brake engagement looseness.

DESCRIPTION

IPECO is providing service to complete the modification at a Textron authorized service facility. If IPECO has completed the modification on your airplane there should be a Certificate of Conformance. If you have a Certificate of Conformance, make sure the aircraft records are updated and a copy of the completed record of compliance to the maintenance tracking system provider. If you do not have a Certificate of Conformance, contact a Textron authorized service facility to schedule your airplane for service.

- LH SEAT 3A480-0007-(***)-(*)
- RH SEAT 3A480-0008-(***)-(*)

FL-1234 Seat Serial Numbers	FL-1235 Seat Serial Numbers	FL-1236 Seat Serial Numbers	FL-1238 Seat Serial Numbers	FL-1243 Seat Serial Numbers
IW10702	IW10680	IW10718	IW10732	IW10790
IW10703	IW10681	IW10719	IW10733	IW10791
IW10704	IW10682	IW10720	IW10734	IW10792
IW10705	IW10683	IW10721	IW10735	IW10793
IW10706	IW10684	IW10722	IW10736	IW10794
IW10707	IW10685	IW10723	IW10737	IW10795
IW10708	IW10686	IW10724	IW10738	IW10796
IW10709	IW10687	IW10725	IW10739	IW10797

COMPLIANCE

INFORMATIONAL. This service document is for informational purposes only.

CONSUMABLE MATERIAL

No specialized consumable materials are required to complete this service document.

TOOLING

No specialized tooling is required to complete this service document.

October 6, 2021

MTL-25-03
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REFERENCES

IPECO Service Bulletin SB480-25-01, dated 26 March, 2021.

PUBLICATIONS AFFECTED

None

ACCOMPLISHMENT INSTRUCTIONS

NA

MATERIAL INFORMATION

NA



SERVICE BULLETIN

EQUIPMENT / FURNISHINGS

PASSENGER COMPARTMENT

**CARRIER & BRAKE
IMPROVEMENT**

KINGAIR AIRCRAFT
SERVICE BULLETIN NUMBER
480-25-01
ISSUE 1

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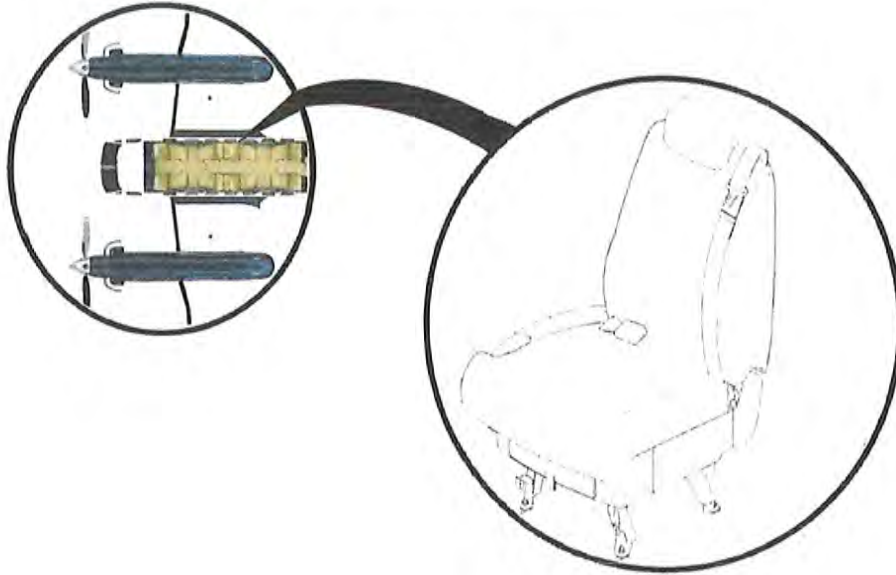
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IPECO HOLDINGS LTD. REGISTERED IN ENGLAND AND WALES, COMPANY NO. 00672443



SERVICE BULLETIN

SERVICE BULLETIN NO.
480-25-01



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SERVICE BULLETIN

1. Planning Information

A. Effectivity

The Kingair aircraft which have Ipeco passenger seats with the part numbers and seat serial numbers that follow:

<u>Seat</u>	<u>Part Number</u>
LH SEAT	3A480-0007-(***)-(*)
RH SEAT	3A480-0008-(***)-(*)

Seat serial numbers:

IW10680	IW10702	IW10718	IW10732	IW10790
IW10681	IW10703	IW10719	IW10733	IW10791
IW10682	IW10704	IW10720	IW10734	IW10792
IW10683	IW10705	IW10721	IW10735	IW10793
IW10684	IW10706	IW10722	IW10736	IW10794
IW10685	IW10707	IW10723	IW10737	IW10795
IW10686	IW10708	IW10724	IW10738	IW10796
IW10687	IW10709	IW10725	IW10739	IW10797

B. Concurrent Requirements

This is not applicable.

C. Classification

Mandatory.

D. Reason

This Service Bulletin introduces product improvements to ensure that the carriers motion and the brakes engagement is optimal. This is to address reports of looseness in service.

E. Description

This Service Bulletin introduces instructions that change:

- The carriers
- The brakes
- The cable routing.



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F. Compliance

When the workshop maintenance facility is available.

G. Approval

This Service Bulletin contains no modification information that revises the approved configuration and therefore does not require governmental or other regulatory agency approval.

H. Manpower

Approximately 2 man-hours for each seat is necessary to do the procedures in this Service Bulletin.

I. Weight and Balance

This is not applicable.

J. Electrical Load Data

This is not applicable.

K. Software Accomplishment Summary

This is not applicable.

L. References

Component Maintenance Manual SM1060 (25-20-53).

M. Other Publications Affected

This is not applicable.

N. Interchangeability of Parts

This is not applicable.



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2. Material Information

A. Material Cost and Availability

The part numbers that are necessary to do the procedures in this Service Bulletin are shown in Section 2.C. These parts are available free of charge.

For information about lead time and availability of parts, operators can contact Ipeco Holdings Ltd or an Ipeco-approved repair organization.

An order must contain the information that follows:

- The title and part number
- The quantity required
- The name of the Airline/Operator
- The part number of the seat
- The serial number of the seat.

Operators who are not included in the regions below can send an order to:

Ipeco Holdings Ltd
Sales Department
Aviation Way
Southend-on-Sea
SS2 6UN
United Kingdom
Telephone: +44 1702 549371
Email: sales@ipeco.com

Operators in the Americas region can send an order to:

Ipeco Inc
2275 Jefferson Street
Torrance
California 90501
USA
Telephone: +1 310-783-4700
Email: sales@ipecoinc.com

Operators in the Greater China region can send an order to:

Ipeco Service Centre (Hong Kong) Ltd
21st Floor
Nan Dao Commercial Building
359-361 Queen's Road Central
Hong Kong
China
Telephone: + 852 2543 8039
E-Mail: sales@ipeco.com.hk



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Operators in the South East Asia, Oceania and Japan region can send an order to:

Ipeco Singapore Pte Ltd
690 West Camp Road #08-01/02/03/04
JTC Aviation Two
Singapore 797523
Telephone: + 65 6932 1555
Email: sales@ipeco.com.sg

B. Industry Support Information

The procedures in this Service Bulletin are included in the Ipeco warranty.

C. Material Necessary for Each Component

Table 1

Item No.	Part Number	Description	Quantity	Note
1	2A480-0373	BRAKE MECHANISM ASSEMBLY-LONGITUDINAL	1*	LH Seat
2	2A480-0374	BRAKE MECHANISM ASSEMBLY-LONGITUDINAL	1*	RH Seat
3	N1500-0018APP	CIRCLIP	1	
4	0658-025-00	BEARING LINEAR BALL BUSHING	2	
5	1A480-0311	BEARING CARRIER FWD-AFT	1*	LH Seat
6	1A480-0312	BEARING CARRIER FWD-AFT	1*	RH Seat
7	H14-3	LOCK NUT	4	
8	PV289	GROMMET-OPEN (or use OR24X6.5 as alternative)	2	
9	3A480-0699	SHIM – FWD/AFT BRAKE	2	
10	3A500-1369	SET SCREW – BALL END	1	
11	026-275	NUT	1	
12	1062	CABLE TIE	2	

***Note: Check effectivity code in CMM for appropriate part.**

D. Material Necessary for Each Spare

This is not applicable.

E. Re-identified Parts / Existing Parts Accountability

There are no re-identified parts or existing parts accountability.

F. Consumables

Consumables required (equivalents sourced locally can be used):

- Loctite 222 (threadlock adhesive).

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3. Accomplishment Instructions

Note 1: Item numbers shown thus (*-**), refer to items from the Component Maintenance Manual 25-20-53. As an example, (1-30) refers to figure 1, item 30.

Note 2: Item numbers shown thus (*), refer to items from Table 1.

Note 3: Parts that are removed are to be kept unless specified differently.

Note 4: It is the responsibility of the personnel who will complete this Service Bulletin to make sure that the seat upholstery and plated parts haven't sufficient protection during the embodiment of the Service Bulletin. Standard protective materials such as stiff brown paper, bubble wrap, soft cloth etc can be used to prevent damage to seat upholstery and plated parts.

1. Disengage the pan fairing assembly (1-45E, 1-45F, 1-45G, 1-45H, 1-45J, 1-45K, 1-50E, 1-50F, 1-50G, 1-50H, 1-50J, 1-50K) from fairing mounting brackets (3-15, 3-35, 3-55, 3-60, 3-80) and (6-20, 6-100, 6-115, 6-130) on the basic seat assembly (1-165, 1-170) and pan structure assembly (4-25, 4-30) as shown in figure 1.

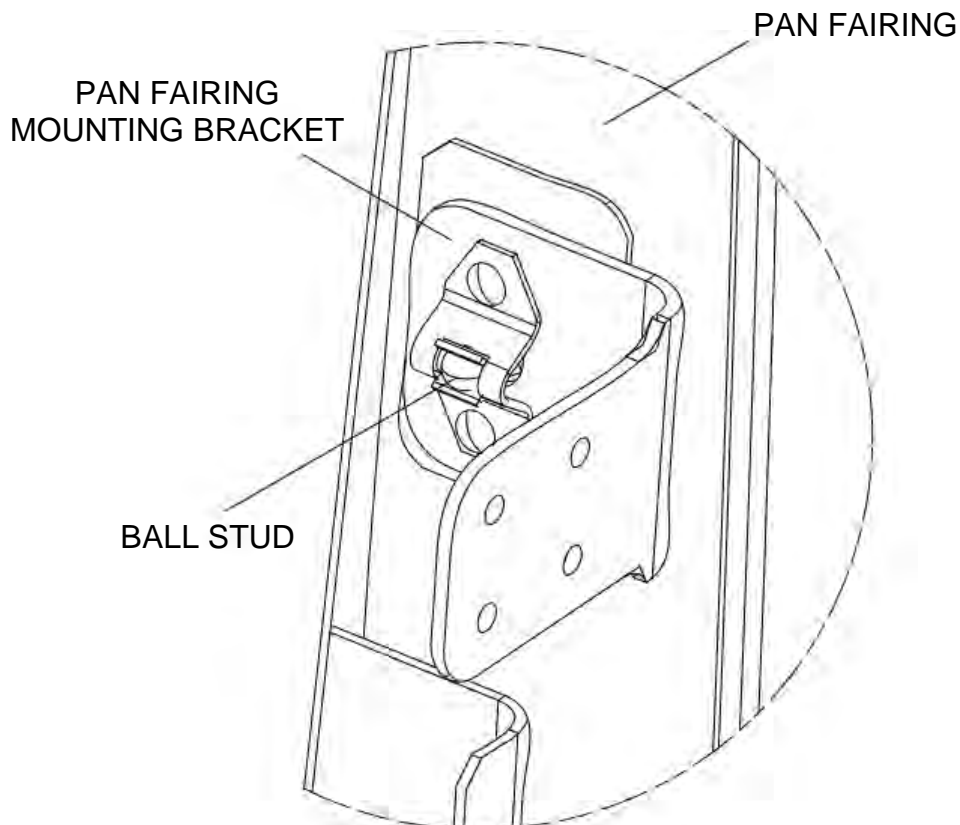


FIGURE 1

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2. Pull the pan cushion assembly (1-15F, 1-15G, 1-15H, 1-15J, 1-15K, 1-20E, 1-20F, 1-20G, 1-20H, 1-20J, 1-20K) upward to release it from the fastening strips and then remove.

CAUTION: USE A SUPPORT TO HOLD THE UPPER SEAT ASSEMBLY (3-5, 3-10).

3. Disconnect the upper seat assembly (3-5, 3-10) from the base turntable and mechanism assembly (3-105, 3-110) as follows:
 - a. Remove one bolt (3-65), two washers (3-70) and one lock nut (3-75).
 - b. Remove the rear pan fairing mounting bracket (3-55, 60).
 - c. Remove one bolt (3-85), two washers (3-90) and one lock nut (3-95).
 - d. Remove the rear pan fairing mounting bracket (3-80).
 - e. Remove one grommet (7-245) and one spacer (7-250) from the longitudinal tube (7-255).
 - f. Remove one longitudinal tube (7-255).
 - g. Rotate the upper seat assembly (3-5, 3-10) from the base turntable and mechanism assembly (3-105, 3-110) as shown in figure 2.

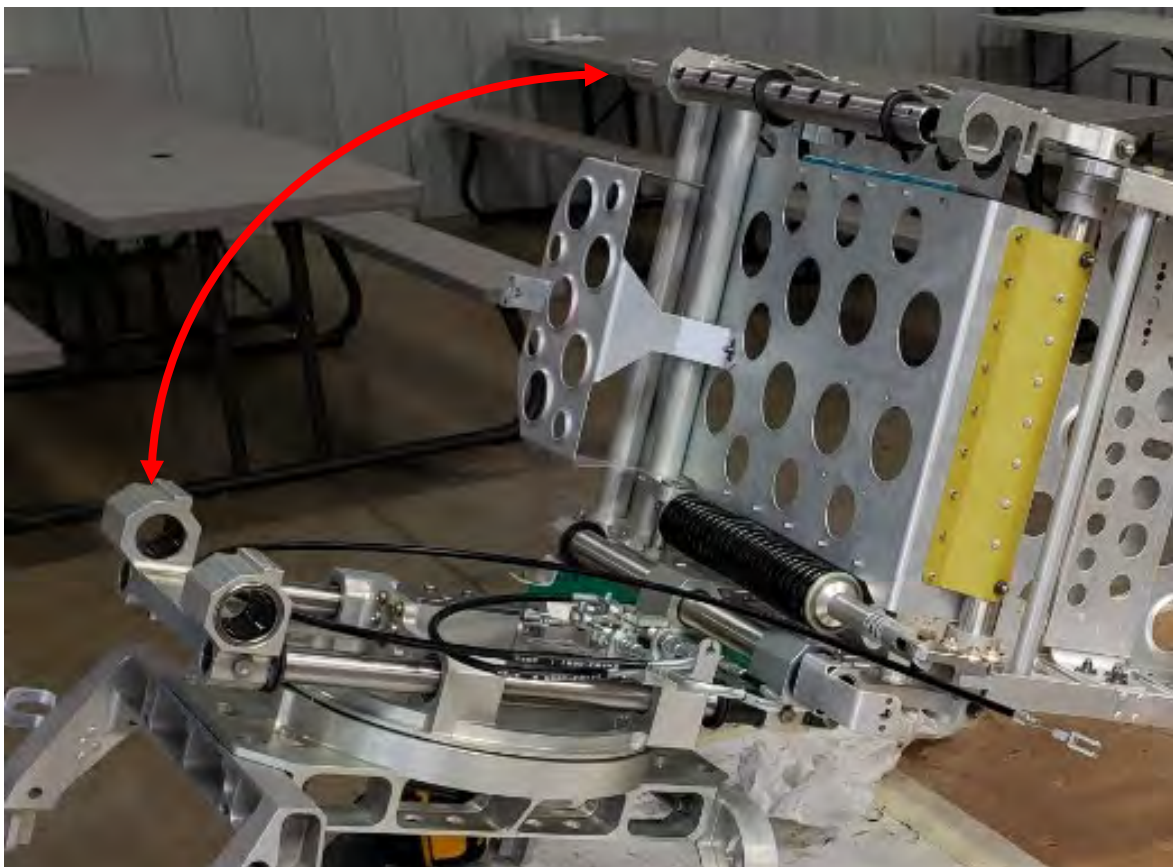


FIGURE 2

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- h. Discard two lock nuts (3-75, 3-95), one grommet (7-245) and one spacer (7-250).
4. Remove the brake mechanism assembly-longitudinal (6-150, 6-155) from the outboard pan side member (6-245, 6-250) as follows:
 - a. Remove the slic pin (3-115) and the circlip from the cable - longitudinal lock (7-20) as shown in figure 3.

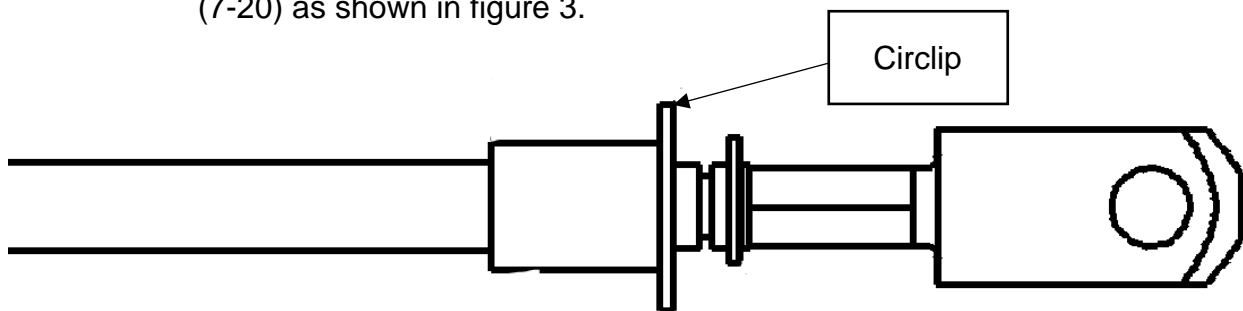


FIGURE 3

- b. Disconnect the longitudinal lock cable (7-20).
 - c. Remove two screws (7-220) and two washers (7-225) from the longitudinal serrated bar (7-215).
 - d. Remove the longitudinal serrated bar (7-215).
NOTE: If present, remove any shims.
 - e. Remove four screws (6-160).
 - f. Remove the brake mechanism assembly-longitudinal (6-150, 6-155).
 - g. Discard the brake mechanism assembly-longitudinal (6-150, 6-155).
5. Remove the forward/ aft ward bearing carrier (7-265, 7-270) from the turntable & mechanism assembly base (7-1, 7-1A) as follows:
 - a. Remove one screw (7-235) and one washer (7-240) from the lateral serrated bar (7-230).
 - b. Remove two bolts (7-275), two lock nuts (7-280) and four washers (7-285).
 - c. Remove the forward/ aft ward bearing carrier (7-265, 7-270) and two linear ball bushing bearings (7-260) as shown in figure 4.
 - d. Discard two lock nuts (7-280), the forward/ aft ward bearing carrier (7-265, 7-270) and two linear ball bushing bearings (7-260).

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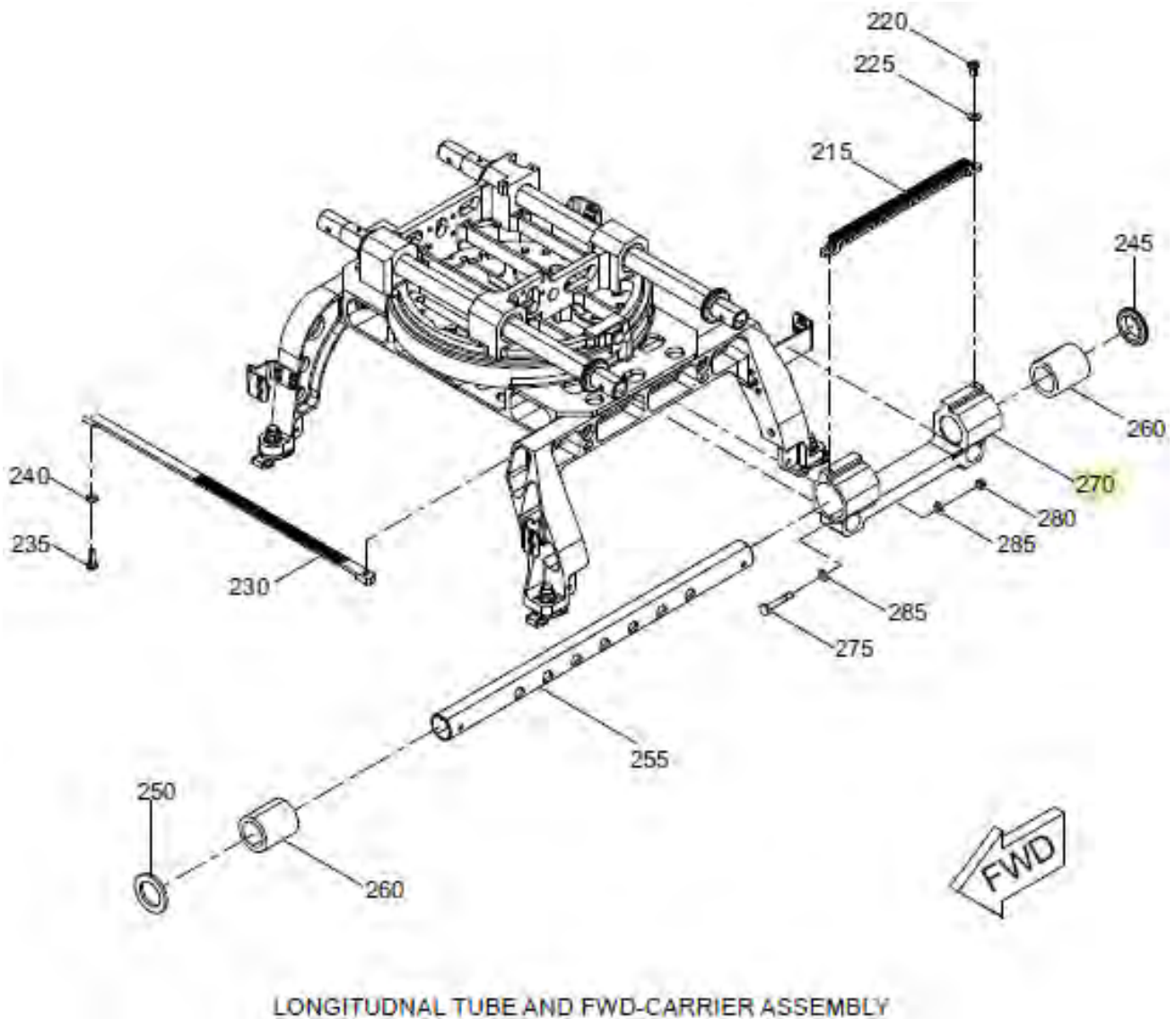


FIGURE 4

6. Remove the set screw from the turntable & mechanism assembly base (7-1, 7-1A) as follows:
 - a. Remove the set screw on the bottom of the lateral brake mechanism assembly (7-40) as shown in figure 5.
 - b. Discard the set screw.

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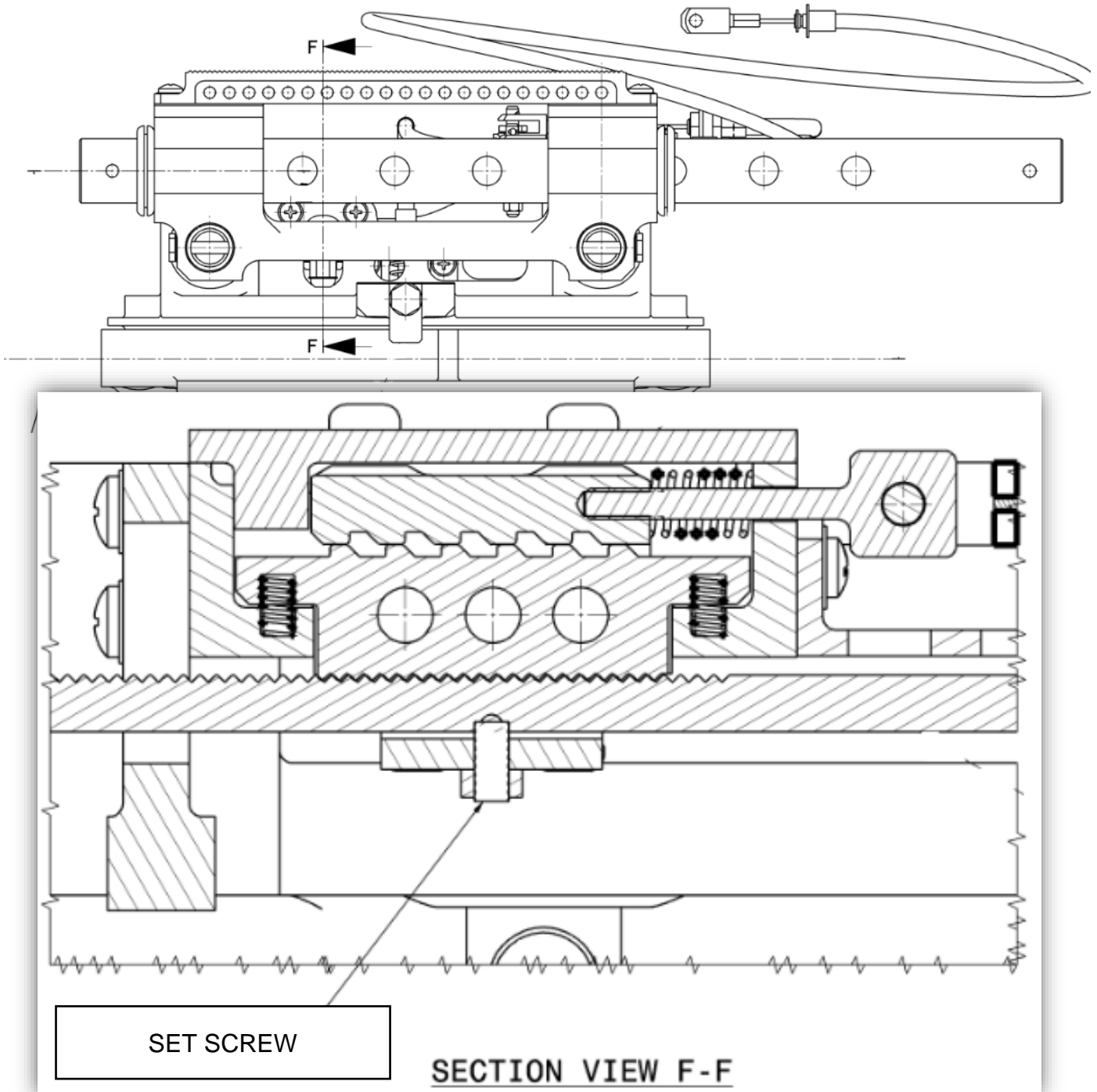


FIGURE 5

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7. Change cable connections as follows:
 - a. Remove the slic pin (7-25) from the cable splitter assembly (7-120, 7-125).
 - b. Disconnect the lateral brake cable (7-10A) from the cable splitter assembly (7-120, 7-125).
 - c. Disconnect the longitudinal lock cable (7-20) from the cable splitter assembly (7-120, 7-125) and install the longitudinal lock cable (7-20) in the lateral brake cables (7-10A) position as shown in figure 6.
 - d. Install the lateral brake cable (7-10A) in the longitudinal lock cables (7-20) position as shown in figure 6.
 - e. Install slic pin (7-25) to the cable splitter assembly (7-120, 7-125).

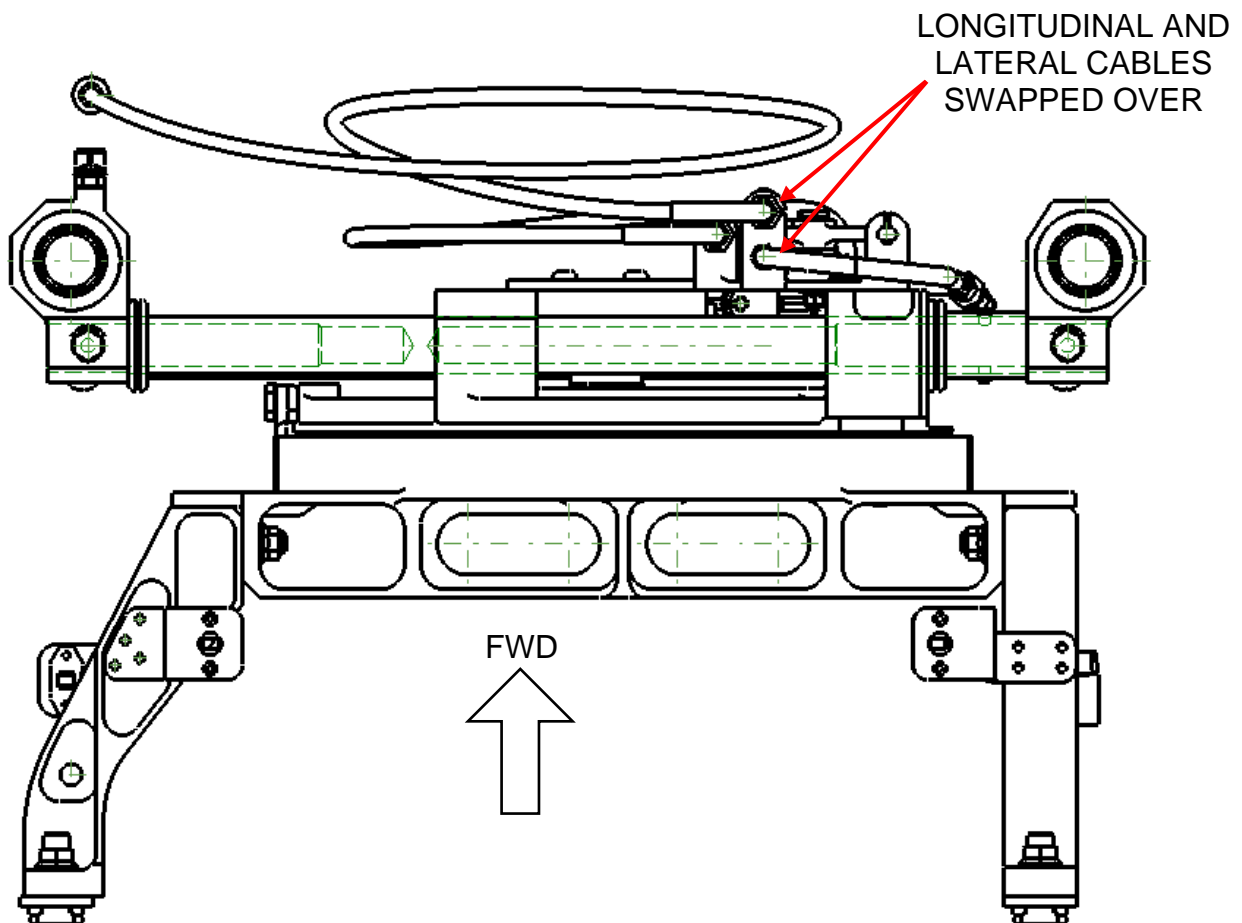


FIGURE 6

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8. Change the recline unit cable routing as follows:
 - a. Disconnect the cable from the connector on the mechanical control (2-160).
 - b. Route the mechanical control cable (2-160) under the bearing carrier fwd/aft (7-290, 7-295), upward and between the rear lateral tube (7-330) and the lateral serrated bar (7-230) as shown in figure 7.
 - c. Connect the cable to the connector on the mechanical control (2-160).

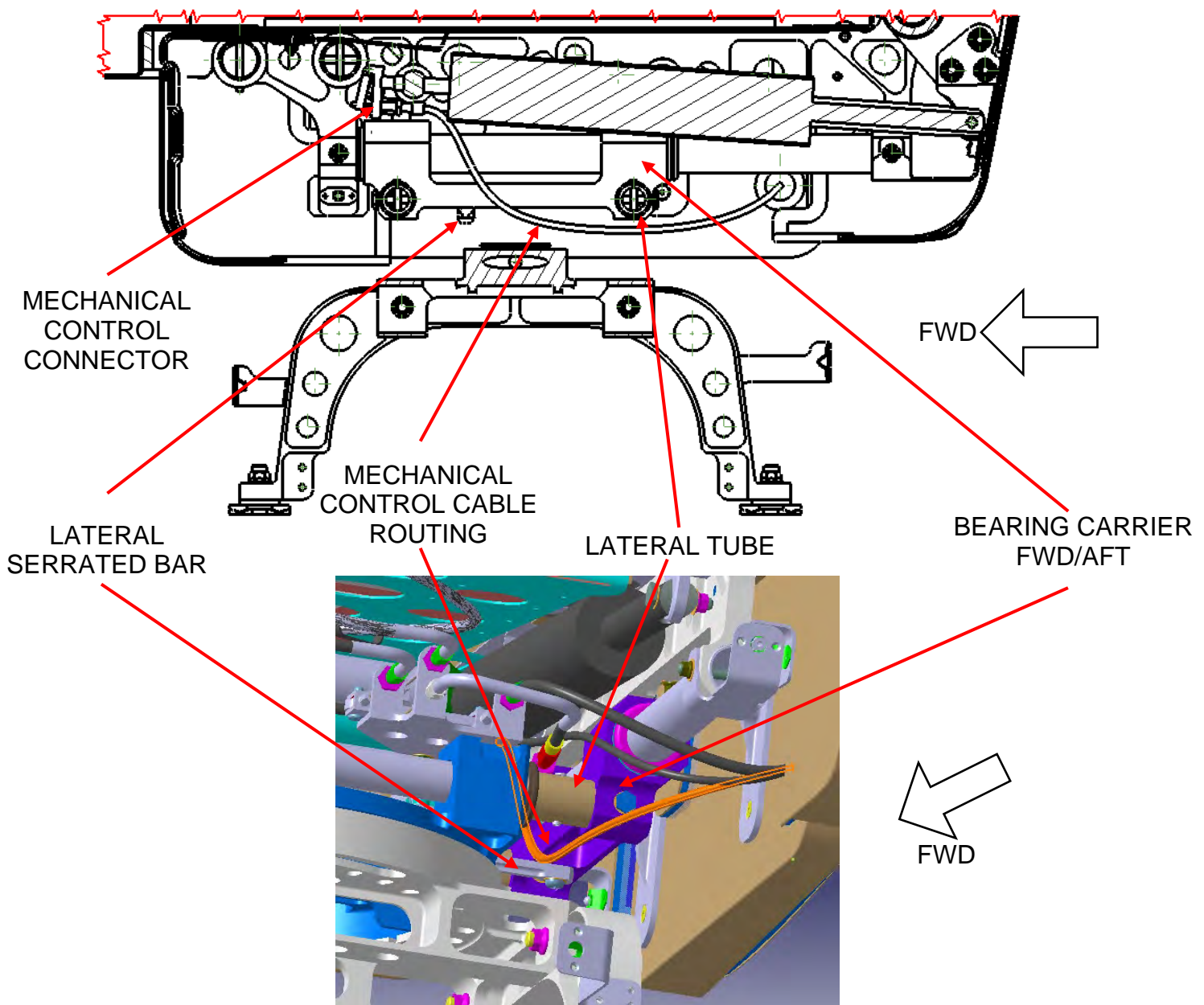


FIGURE 7



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9. Install the brake mechanism assembly-longitudinal (1, 2) to the outboard pan side member (6-245, 6-250) as follows:
 - a. Attach the brake mechanism assembly-longitudinal (1, 2) to the outboard pan side member (6-245, 6-250) with four screws (6-160)
 - b. Connect the longitudinal lock cable (7-20) to the brake mechanism assembly-longitudinal (6-150, 6-155) with one slic pin (3-115) and one circlip (3).

10. Connect the upper seat assembly (3-5, 3-10) to the base turntable and mechanism assembly (3-105, 3-110) as follows:
 - a. Put two linear ball bearing bushes (4) into the forward/ aft bearing carrier (5, 6).
 - b. Attach the forward/ aft bearing carrier (5, 6) to the lateral tube (7-330) with four washers (7-285), two lock nuts (7) and two bolts (7-275).
 - c. Rotate the upper seat assembly (3-5, 3-10) to the base turntable and mechanism assembly (3-105, 3-110).
 - d. Put the longitudinal tube (7-255) into the forward/ aft bearing carrier (5, 6) through two linear ball bearing bushes (4).
 - e. Put two grommets (8) into the side of the longitudinal tube (7-255), position one grommet (8) to replace of the spacer (7-250).
 - f. Attach the lateral serrated bar (7-230) to the two forward/ aft bearing carrier (5, 6) with one washer (7-240) and one screw (7-235).
 - g. Attach the longitudinal serrated bar (7-215) to the forward/ aft bearing carrier (5, 6) with two washers (7-225) and two screws (7-220).

NOTE: Use fwd/aft brake shim (9) as necessary to ensure brake operates correctly.
 - h. Attach the rear pan fairing mounting bracket (3-80) to the upper seat assembly (3-5, 3-10) with two washers (3-90), one bolt (3-85) and one nut (7).
 - i. Attach the rear pan fairing mounting bracket (3-55, 3-60) to the upper seat assembly (3-5, 3-10) with two washers (3-70), one bolt (3-65) and one nut (7).

11. Install set screw – ball end (10) to the turntable & mechanism assembly base (7-1, 7-1A) as follows:
 - a. Install set screw – ball end (10) using threadlock adhesive and one nut (11) to the bottom of the lateral brake mechanism assy (7-40) as shown in Figure 4.
 - b. Tighten set screw – ball end (10) enough to ensure full engagement of teeth between serrated – lateral bar (7-230) and the lateral brake mechanism assy (7-40).

NOTE: Check brake can fully release, and seat moves smoothly without any chattering of the teeth. Loosen set screw – ball end (10) if required.

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12. Attach two cable ties (12) to the pan structure assembly (4-25, 4-30) to secure the fwd/aft cable routing in positions as shown in figure 8.

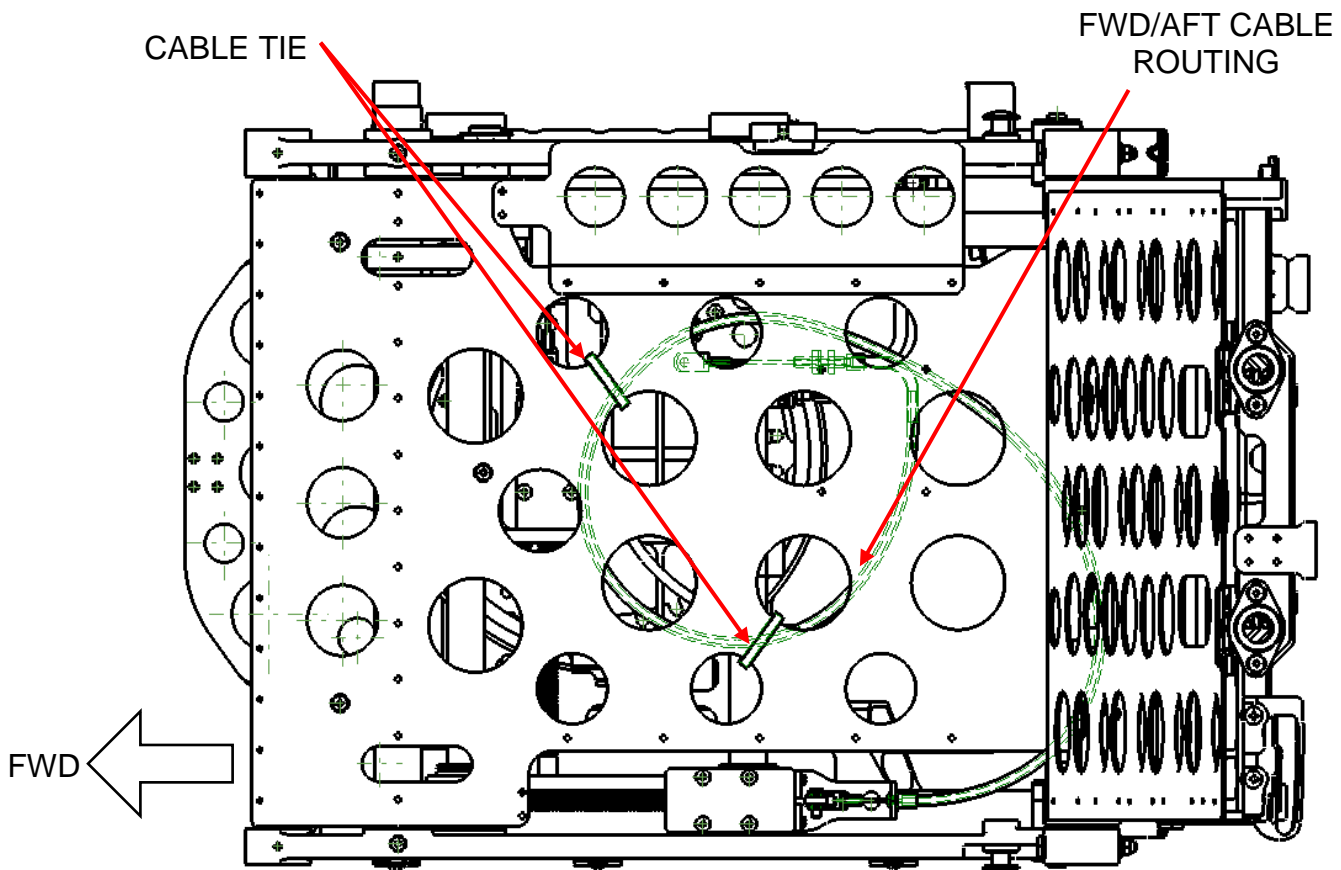


FIGURE 8

13. Position the pan cushion assembly (1-15F, 1-15G, 1-15H, 1-15J, 1-15K, 1-20E, 1-20F, 1-20G, 1-20H, 1-20J, 1-20K) and push down to hold it to the fastening strips to attach.
14. Engage the pan fairing assembly (1-45E, 1-45F, 1-45G, 1-45H, 1-45J, 1-45K, 1-50E, 1-50F, 1-50G, 1-50H, 1-50J, 1-50K) to fairing mounting brackets (3-15, 3-35, 3-55, 3-60, 3-80) and (6-20, 6-100, 6-115, 6-130) on the basic seat assembly (1-165, 1-170) and pan structure assembly (4-25, 4-30).
15. Do a check to make sure that the seat operates correctly. The correct procedure is shown in SUBTASK 25-20-53-200-002-A01.
16. Mark the Service Bulletin number 480-25-01 and issue 1 by vibro-etch or similar method onto the seat identification label (nameplate) which is located on the pan structure assembly (4-30).

