

TITLE

EQUIPMENT/FURNISHINGS - TRANSMITTAL OF IPECO SERVICE BULLETIN 480-25-02 FREE PLAY REDUCTION PRODUCT IMPROVEMENT FOR PASSENGER SEATS

EFFECTIVITY

MODEL	SERIAL NUMBERS
B200GT	BY-395, BY-420 thru BY-477
B300	FL-1201, FL-1234 thru FL-1329

REASON

From the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision), introduces a new basic seat assembly, which includes several changes to reduce the free play being reported by operators.

DESCRIPTION

This service document provides parts and instructions to remove and replace the basic seat assembly

COMPLIANCE

DISCRETIONARY. This service document can be accomplished at the discretion of the owner.

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

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

TOOLING

No specialized tooling is required to complete this service document.

June 26, 2024

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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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REFERENCES

Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision)

PUBLICATIONS AFFECTED

Refer to the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision)
Section L: Publications Affected

ACCOMPLISHMENT INSTRUCTIONS

1. Review and fully comply with Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision)
2. 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.

MATERIAL INFORMATION

Refer to the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision)
Material Information

TITLE

EQUIPMENT/FURNISHINGS - TRANSMITTAL OF IPECO SERVICE BULLETIN 480-25-02 FREE PLAY REDUCTION PRODUCT IMPROVEMENT FOR PASSENGER SEATS

TO:

Beechcraft Model B200GT and B300 Aircraft Owner

REASON

From the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision), introduces a new basic seat assembly, which includes several changes to reduce the free play being reported by operators.

COMPLIANCE

DISCRETIONARY. This service document can be accomplished at the discretion of the owner.

LABOR HOURS

Refer to the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision) Section G: Manpower

MATERIAL AVAILABILITY

Refer to the Ipeco Service Bulletin 480-25-02: Free Play Reduction Product Improvement (latest revision) Material Information

WARRANTY

Eligible airplanes exhibiting conditions described in this service document may demonstrate improved operation by incorporation of the work described herein. This service document is to be accomplished at the *discretion* of the owner. Eligible airplanes may qualify for parts and labor coverage to the extent noted in the *Labor Hours* and *Material Availability* sections of this document.

Eligibility: Airplanes identified within the serial number effectivity of this service document must have active Interior 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 should be forwarded to:

TEXTRON AVIATION PARTS DISTRIBUTION
WARRANTY ADMINISTRATION
BLDG P43 DOCK R5
7123 SW BLVD
Wichita, KS 67215

Expiration: June 26, 2026 (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.



SERVICE BULLETIN

EQUIPMENT / FURNISHINGS

PASSENGER COMPARTMENT

FREE PLAY REDUCTION PRODUCT IMPROVEMENT

SERVICE BULLETIN NUMBER

480-25-02

ISSUE 1

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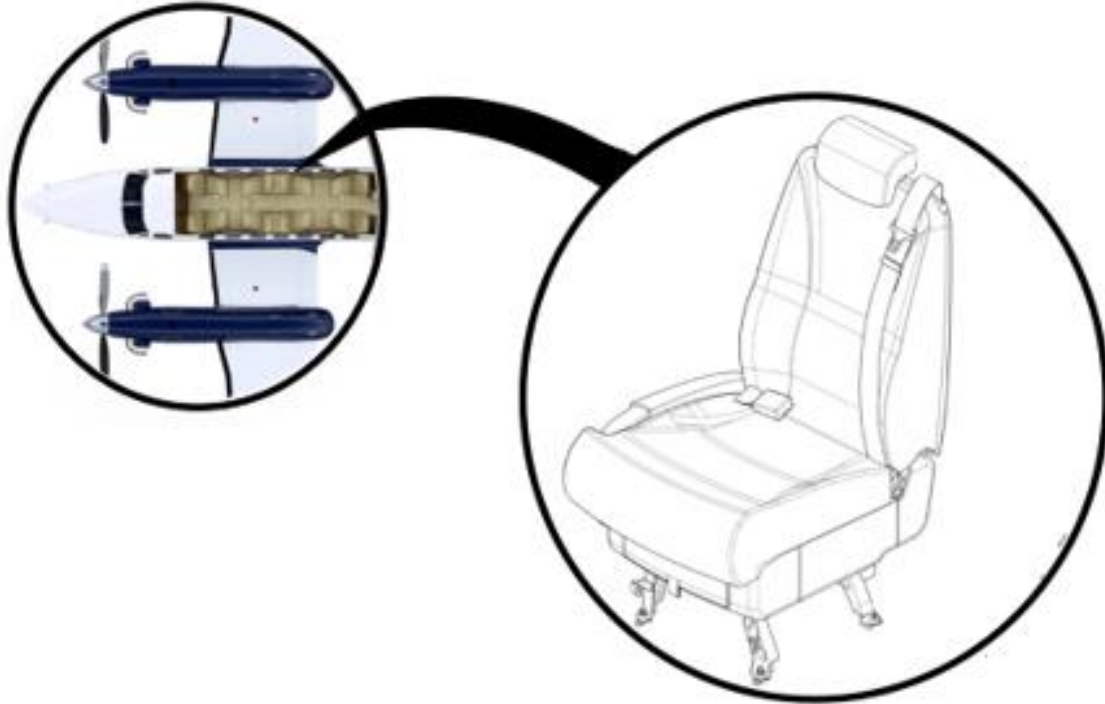
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SERVICE BULLETIN

SERVICE BULLETIN No.
480-25-02



COMPILED BY _____

CHECKED BY _____

TECHNICALLY APPROVED BY _____

COMMERCIALY APPROVED BY _____

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SERVICE BULLETIN

1 Planning Information

A. Effectivity

This Service Bulletin is applicable to the Ipeco passenger seats with the part numbers that follow:

	Ipeco Part Number
LH SEAT	3A480-0007-(***)-(*)
RH SEAT	3A480-0008-(***)-(*)

B. Concurrent Requirements

There are no concurrent requirements for this SB.

C. Reason

This Service Bulletin introduces a new basic seat assembly, which include several changes to reduce the free play being reported by operators.

D. Description

This Service Bulletin gives instructions on how to remove and replace the basic seat assembly.

E. Compliance Recommendation

Operators Discretion.

F. Approval

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

G. Manpower

The procedures in this Service Bulletin will take approximately 3-man hour(s) for each seat, when done at maintenance shop level.

Note: This does not include:

- Time to schedule the work.
- Time to examine the work.
- Time to find the tools.

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H. Weight and Balance

The weight decreases by approx. 2.59lbs.

I. Electrical Load Data

Not affected.

J. Software Accomplishment Summary

Not affected.

K. References

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

L. Publications Affected

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

M. Interchangeability of Parts

One-way Interchangeable.

N. Warranty Statement

The procedures of this Service Bulletin are not included in Ipeco warranty.



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2 Material Information

A. Material Cost and Availability

Required for each seat:

Part Number	Description	Quantity
3M800-1131f	*LH Pax Seat Modification	1
3M800-1132f	**RH Pax Seat Modification	1
A810R0025H008SC	Hook Fastener 25mm	AR

* LH Pax Seat Only / **RH Pax Seat Only

Please contact Textron for material cost and availability.

B. Industry Support Information

Not Applicable.

C. Material Necessary for Each Component

Table 1 – Mod Kit 3M800-1131f – LH Pax Seat Modification

	Part Number	Description	Quantity	CMM Ref.
1	0A480-0061	Basic Seat Assy	1	N/A
2	3A480-0845f	Cover – Closeout – Seat Back Beam	1	N/A
3	3A480-0846f	Cover – Closeout – Seat Back Beam	1	N/A
4	3A500-1027	Slic Pin 3/16 x 0.38	1	1-95
5	H14-3	Nut Lock 10-32UNF	2	1-75
6	AGS2050-419BS	Rivet Dome HD 1:8 x 0.19	4	N/A

Table 2 – Mod Kit 3M800-1132f – RH Pax Seat Modification

	Part Number	Description	Quantity	CMM Ref.
7	0A480-0062	Basic Seat Assy	1	N/A
8	3A480-0845f	Cover – Closeout – Seat Back Beam	1	N/A
9	3A480-0846f	Cover – Closeout – Seat Back Beam	1	N/A
10	3A500-1027	Slic Pin 3/16 x 0.38	1	1-95
11	H14-3	Nut Lock 10-32UNF	2	1-75
12	AGS2050-419BS	Rivet Dome HD 1:8 x 0.19	4	N/A

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Table 3 – Items to Remove and Discard Per Seat

	Part Number	Description	Quantity	CMM Ref.
13	0A480-0031	*Basic Seat Assy	1	1-170
14	0A480-0032	**Basic Seat Assy	1	1-165
15	3A500-1027	Slic Pin 3/16 x 0.38	1	1-95
16	H14-3	Nut Lock 10-32UNF	2	1-75
17	AGS2050-419BS	Rivet Dome HD 1:8 x 0.19	4	N/A

*LH Pax Seat Only **RH Pax Seat Only

Table 4 – Items not Listed in the CMM

	Part Number	Description	Quantity	CMM Ref.
18	2A517-0069	Nameplate	1	N/A
19	A810R0025H008SC	Hook Fastener 25mm	AR	N/A

Table 5 – List of Consumables

	Part Number	Description	Quantity	CMM Ref.
20	3A504-0067	*Adhesive	AR	N/A
21	3A504-0069	*Adhesive	AR	N/A

* Locally sourced alternate adhesive is permitted.

D. Material Necessary for Each Spare

Not applicable.

E. Re-identified Parts / Existing Parts Accountability

Not applicable.

F. Special Tooling – Price and Availability

Not applicable.

G. Special Tooling Necessary to do this Service Bulletin

Not applicable.

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3 Accomplishment Instructions

Note 1: Item numbers shown thus: - (**-**) refer to items from the Illustrated Parts List of CMM 25-20-53. For example, (1-30) refers to Figure 1, item 30.

Note 2: Item number shown thus: - (*) refer to items listed in the table(s) in section 2.C. Material Necessary for Each Component. For example, (3) refers to item 3.

Note 3: Repairs, rework or modifications in this Service Bulletin require the seat to be removed from the aircraft.

Note 4: In this Service Bulletin keep all removed items if not instructed to discard.

Part A: Disassembly

1. Pull the pan cushion assembly (1-15 – 1-15Y) (1-20 – 1-20X) upward to release it from the fastening strips and then remove.
2. Pull the back cushion (1-25 – 1-25L) (1-30 – 1-30L) forward to release it from the fastening strips and then remove.
3. Remove one screw (8-30) and one washer (8-35) from each headrest tube (8-20).
4. Pull up the headrest assembly (1-100 – 1-100L) from two headrest collars (5-5) and then remove.
5. Remove the headrest bezels (1-105 – 1-105B) from the basic seat assembly (1-165) (1-170).
6. Remove one screw (1-150) and one screw (1-155) from the upper restraint bezel (1-140 – 1-140B) (1-145 – 1-145B).
7. Remove the upper restraint bezel (1-140 – 1-140B) (1-145 – 1-145B) from the basic seat assembly (1-165) (1-170).
8. Remove one screws (1-55) from pan fairing assembly (1-45 – 1-45X) (1-50 – 1-50X).
9. Disengage the pan fairing assembly (1-45 – 1-45X) (1-50 – 1-50X) from the fairing mounting brackets (3-15) (3-35) (3-55) (3-60) (3-80) and (6-20) (6-100A) (6-115A) (6-130) on the basic seat assembly (1-165) (1-170) and pan structure assembly (4-25) (4-30).
10. Disengage the back fairing assembly (1-35 – 1-35Y) (1-40 – 1-40Y) from the mounting brackets (5-40) (5-50) on the back structure assembly (4-65) (4-70).
11. Remove the upholstered armrest assembly (1-65 – 1-65L) (1-70 – 1-70L) from the basic seat assembly (1-165) (1-170) as follows:
 - a. Disconnect the recline cable adjuster, part of the mechanical control (2-160) from the recline unit (4-5).
 - b. Remove one bolt (1-80), one lock nut (16) and two washers (1-90).

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- c. Remove one bolt (1-85), one lock nut (16) and two washers (1-90).
 - d. Remove one slic pin (15) from the cable splitter assembly (7-120) (7-125).
 - e. Remove the upholstered armrest assembly (1-65 – 1-65L) (1-70 – 1-70L).
12. Remove one screw (1-55) from the life-vest strap (1-160E – 1-160K) (1-160S) and remove the life-vest strap (1-160E – 1-160K) (1-160S).
13. Remove the restraint system (1-110 – 1-110L) (1-115 – 1-115L) from the basic seat assembly (1-165) (1-170) as follows:
- a. Remove the straps of the restraint system (1-110 – 1-110L) (1-115 – 1-115L) from each lap strap anchor (3-100A).
 - b. Remove two bolts (1-120) and two washers (1-130).
 - c. Remove two bolts (1-125) and two washers (1-135).
 - d. Remove the restraint system (1-110 – 1-110L) (1-115 – 1-115L) from the basic seat assembly (1-165) (1-170).
14. Carefully drill out four rivets (17) that secures the nameplate (18) from the pan structure assembly (4-25) (4-30).

Part B: Assembly

1. Exposed areas of both back side members, part of basic seat assembly (1) (7) are to be covered by seat back beam – closeout – cover (2) (8) and (3) (9) and secured with adhesive (20).
2. Secure the restraint system (1-110 – 1-110L) (1-115 – 1-115L) to the basic seat assembly (1) (7) as follows:
 - a. Position the restraint system (1-110 – 1-110L) (1-115 – 1-115L) on the basic seat assembly (1) (7) and secure with two bolts (1-120), two washers (1-130), two bolts (1-125) and two washers (1-135).
 - b. Attach the straps of the restraint system (1-110 – 1-110L) (1-115 – 1-115L) to each lap strap anchor (3-100A).
3. Attach life-vest strap (1-160E – 1-160K) (1-160S) and secure with one screw (1-55).
4. Attach the upholstered armrest assembly (1-65 – 1-65L) (1-70 – 1-70L) to the basic seat assembly (1) (7) as follows:
 - a. Attach one slic pin (4) (10) to the cable splitter assembly (7-120) (7-125).
 - b. Attach one bolt (1-85), one lock nut (5) (11) and two washers (1-90).
 - c. Attach one bolt (1-80), one lock nut (5) (11) and two washers (1-90).

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- d. Connect the recline cable adjuster, part of the mechanical control (2-160) to the recline unit (4-5).
 5. Attach the back fairing assembly (1-35 – 1-35Y) (1-40 – 1-40Y) to the mounting brackets (5-40) (5-50) on the back structure assembly, part of the basic seat assembly (1) (7).
 6. Attach the pan fairing assembly (1-45 – 1-45X) (1-50 – 1-50X) to the fairing mounting brackets (3-15) (3-35) (3-55) (3-60) (3-80) and (6-20) (6-100A) (6-115A) (6-130) onto the basic seat assembly (1) (7).
 7. Secure pan fairing assembly (1-45 – 1-45X) (1-50 – 1-50X) with one screw (1-55).
 8. Attach the headrest bezels (1-105 – 1-105B) to the basic seat assembly (1) (7).
 9. Push the headrest assembly (1-100 – 1-100L) with the two headrest collars (5-5) into the basic seat assembly (1) (7).
 10. Remove and discard the retaining tubes, part of the basic seat assembly (1) (7).
 11. Secure each headrest tube (8-20) with one screw (8-30) and one washer (8-35).
 12. Attach the nameplate (18) to the pan structure assembly, part of the basic seat assembly (1) (7) and secure with four rivets (6) (12).
- Note:** Complete Part C of this Service Bulletin before fitting the pan cushion (1-15 – 1-15Y) (1-20 – 1-20X).
13. Position the hook fastener (19) onto the back structure assembly, part of the basic seat assembly (1) (7) to suit the loop fastener on the back cushion (1-25 – 1-25L) (1-30 – 1-30L) and secure with adhesive (21).
 14. Position the hook fastener (19) onto the pan structure assembly, part of the basic seat assembly (1) (7) to suit the loop fastener on the pan cushion (1-15 – 1-15Y) (1-20 – 1-20X) and secure with adhesive (21).
 15. Attach the back cushion (1-25 – 1-25L) (1-30 – 1-30L) to the back structure assembly, part of the basic seat assembly (1) (7).
 16. Attach the pan cushion (1-15 – 1-15Y) (1-20 – 1-20X) to the pan structure assembly, part of the basic seat assembly (1) (7).

Part C: Test & Equipment Marking

1. Onto the nameplate (18), mark by vibro etch or similar method:
 - a. The Service Bulletin Number
 - b. The Service Bulletin Issue Number
 - c. The implementation date of the Service Bulletin

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