

REVISION TRANSMITTAL

This sheet transmits Revision 3 MTL-53-05, which:

- A. Corrected image on Page 3.

NOTE: This revision replaces the original issue and all previous revisions of MTL-53-05.

REVISION COMPLIANCE

NO EFFECT. Airplanes previously modified by this service letter are not affected.

LOG OF REVISIONS

Original Issue	August 15, 2023
Revision 1	September 19, 2023
Revision 2	October 31, 2023
Revision 3	November 30, 2023

MANDATORY**MTL-53-05****TITLE**

FUSELAGE - FILLER SHIM OR FASTENER INSTALLATION AT FUSELAGE STATION 221

EFFECTIVITY

MODEL	SERIAL NUMBERS
B300	FL-1237 thru FL-1295, FL-1297, FL-1298
B300C	FM-99 thru FM-106

REASON

During inspection it was found that there may be an insufficient amount of fasteners or shims installed on the left or right side at Fuselage Station (FS) 221.

DESCRIPTION

This service document provides parts and instructions to install additional fasteners or shims as required on the left or right sides at F.S. 221.

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.

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Revision 3 - November 30, 2023

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MANDATORY**MTL-53-05**

NAME	NUMBER	MANUFACTURER	USE
Color Chemical Film Treatment	U074093 (Alodine 1132 Touch n Prep)	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To prepare bare aluminum surface for fastener installation. Bonderite M-CR 1132, (formerly the Alodine 1132 Touch-n-prep) are both approved for small touch up areas, generally less than 6 inches square.)

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

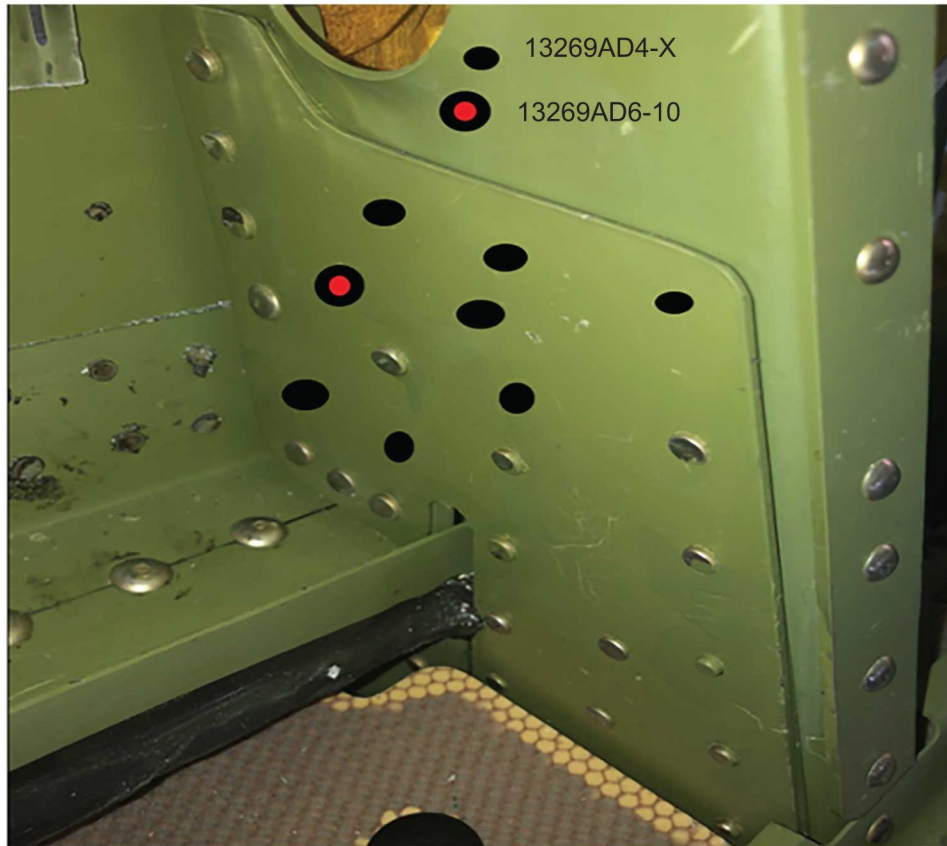
None

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 interior as required to gain access to fuselage station (FS) 221 on the left and right side of the airplane. (Refer to the Beechcraft Super King Air B300/B300C Fusion Maintenance Manual, Chapter 6 Airplane Stations - Description and Operation.)
3. Depending upon the customer's airplane model go to the steps that follows:
 - A. All Beechcraft Model B300 airplanes, go to Step 4.
 - B. All Beechcraft Model B300C airplanes, go to Step 5.
4. (Refer to Figure 1, Sheets 1 and 2.) Inspect and install fasteners into the 101-430026-0031 Reinforcement on the left side at FS 221 as follows:

MANDATORY**MTL-53-05**

E77654



View Looking Aft at FS 221 on the Right Side.

NOTE: The illustration above is an example of a possible configuration of missing fasteners.

- A. Measure and mark all locations that are missing a fastener from the 101-430026-0031 Reinforcement.
- B. Drill the marked areas of the 101-430026-0031 Reinforcement.

CAUTION: If the tooling hole needs to have a rivet installed, the 101-430026-005 Doubler will need to be removed from the forward side from the frame. Over sizing the holes during the removal of the 101-430026-005 Doubler can cause additional work or damage the frame.

- C. If the tooling hole needs a rivet installed, remove and keep the 101-430026-005 Doubler from the forward side of the frame.

NOTE: The Number 11 (0.191 inch diameter) hole is a tooling hole that is already located on the frame. This hole might be covered up by the 101-430026-005 Doubler or the 101-430026-0031 Reinforcement.

- Number 30 (0.128 inch diameter) hole
- Number 21 (0.159 inch diameter) hole
- Number 11 (0.191 inch diameter) hole

- D. Debur all drilled holes.

MANDATORY

- E. Apply Color Chemical Film Treatment to all bare metal.
- F. Install the rivets into the drilled holes that do not go through the 101-430026-0005 Doubler. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)

NOTE: The -5 length rivets are not installed through the 101-430026-0005 Doubler.

- 132369AD4-5 Rivet into all Number 30 holes.
- 132369AD5-5 Rivet into all Number 21 holes.

- G. Install the rivets into the drilled holes that go through the 101-430026-0005 Doubler. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)

NOTE: The -10 length rivets are installed through the 101-430026-0005 Doubler.

- 132369AD4-10 Rivet into all Number 30 holes.
- 132369AD5-10 Rivet into all Number 21 holes.
- 132369AD6-10 Rivet into the Number 11 hole.

- H. Go to Step 6.

5. (Refer to Figure 1, Sheets 1 and 2.) Install the 101-430026-0035 Shim and the 101-430026-0031 Reinforcement on the forward side of the frame at F.S. 221 on the left side as follows:

NOTE: The installation of the 101-430026-0035 Shim and the 101-430026-0031 Reinforcement is only for the King Air B300C Models.

E77655



Tooling Hole
(Reference)

Left Side
(View Looking Aft)

Right Side
(View Looking Aft)

NOTE: The 101-430026-0035 Shim is placed between the 101-430026-0031 Reinforcement and the frame at F.S. 221 on the left and right sides.

- A. Remove the rivets that were previously installed into the frame at F.S. 221. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)
- B. Match drill and locate all the holes from the frame to the 101-430026-0035 Shim and the 101-430026-0031 Reinforcement.

NOTE: The Number 11 (0.191 inch diameter) hole is a tooling hole that is already located on the frame.

- Number 30 (0.128 inch diameter) hole
 - Number 21 (0.159 inch diameter) hole
 - Number 11 (0.191 inch diameter) hole
- C. Debur all the drilled holes.
 - D. Apply Color Chemical Film Treatment to all bare metal.

- E. Install the rivets into the drilled holes that do not go through the 101-430026-0005 Doubler. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)
- 132369AD4-4 Rivet into all Number 30 holes.
 - 132369AD6-4 Rivet into all Number 11 holes.
- F. Install the rivets into the drilled holes that go through the 101-430026-0005 Doubler. (Refer to the Beechcraft Structural Inspection and Repair Manual, Chapter 20, Fastener Installation and Removal.)

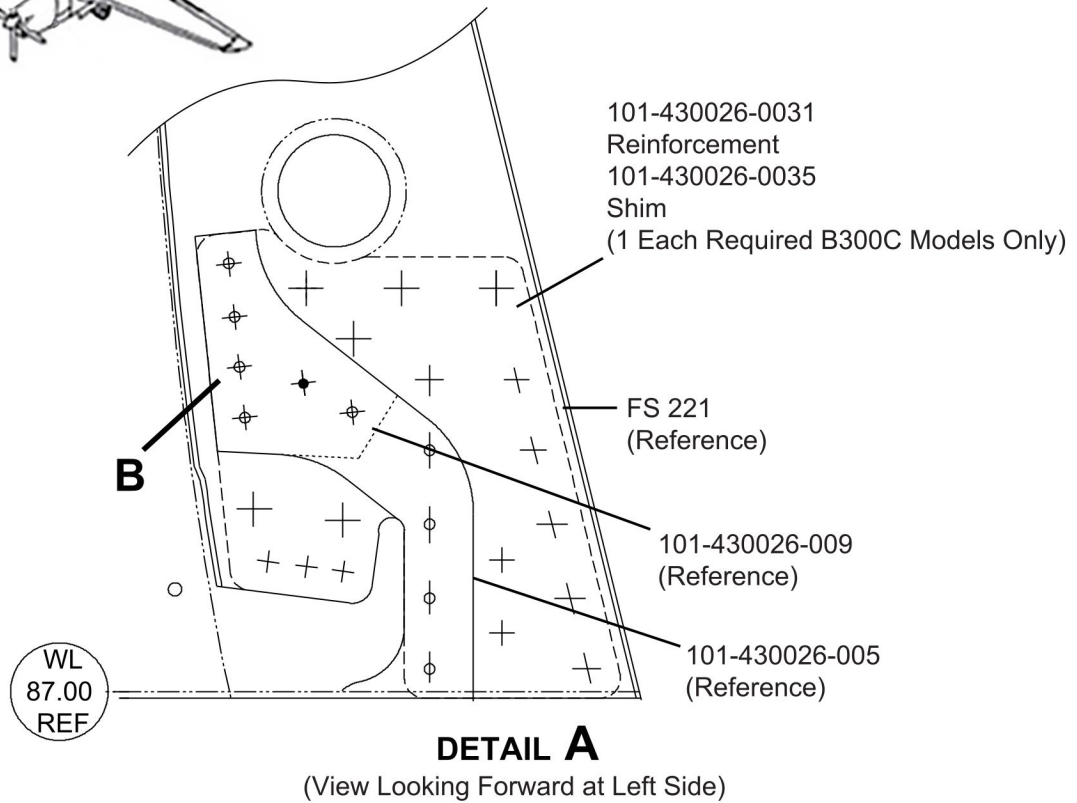
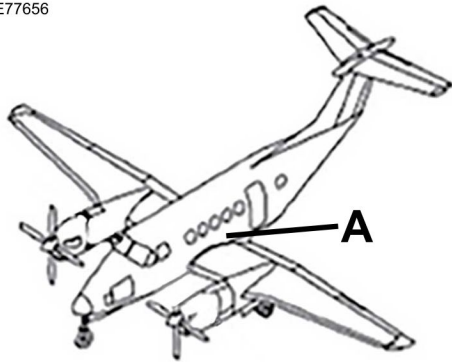
NOTE: The -10 length rivets are installed through the 101-430026-0005 Doubler.

- 132369AD4-10 Rivet into all Number 30 holes.
 - 132369AD5-10 Rivet into all Number 21 holes.
 - 132369AD6-10 Rivet into all Number 11 holes.
6. Remove all metal shavings from the left side at F.S. 221.
7. Go to Step 3 to repeat the steps for the right side rivet or shim installations.
8. Install all interior that was removed to gain access to fuselage station (FS) 221. (Refer to the Beechcraft Super King Air B300/B300C Fusion Maintenance Manual, Chapter 6 Airplane Stations - Description and Operation.)
9. Remove the maintenance warning tags and connect the airplane battery.
10. 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.

E77656



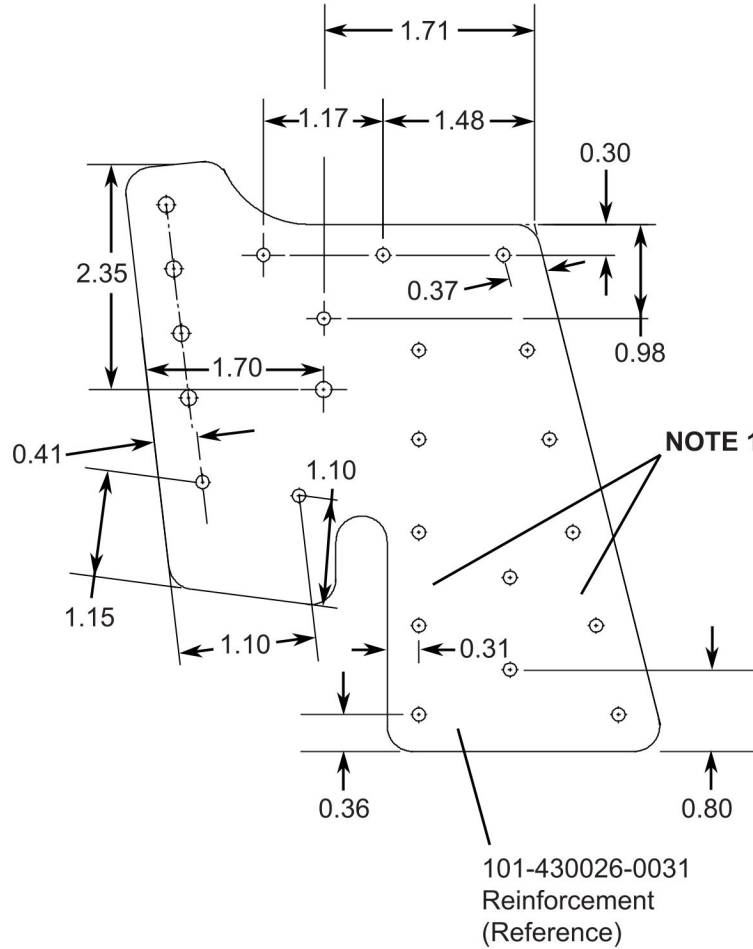
Legend	
Rivet Symbol	Rivet Label
+	132369AD4-5 Number 30 (0.128 inch diameter) hole.
φ	132369AD4-10 Number 30 (0.128 inch diameter) hole
⊖	132369AD6-10 Number 11 (0.191 inch diameter) hole.
⊕	132369AD5-10 Number 21 (0.159 inch diameter) hole.

NOTE: The location of the missing fasteners might be different for each B300.

101-430026

Figure 1. Shim and Fastener Location (Sheet 1)

E77657



DETAIL B

NOTE: All Dimensions are in inches.

NOTE 1: The rivets should be evenly spaced and maintain the minimum edge distance as shown.

101-430026

Figure 1. Shim and Fastener Location (Sheet 2)

MANDATORY**MTL-53-05****MATERIAL INFORMATION**

Order the part below to install this modification.

NEW P/N	QUAN-TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
101-430026-0031	2	Reinforcement (Model B300C Only)	N/A	Install
101-430026-0035	2	Shim (Model B300C Only)	N/A	Install
132369AD4-5	As Required	Rivet	N/A	Install
132369AD5-5	As Required	Rivet	N/A	Install
132369AD6-5	As Required	Rivet	N/A	Install
132369AD4-10	As Required	Rivet	N/A	Install
132369AD5-10	As Required	Rivet	N/A	Install
132369AD6-10	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 - FILLER SHIM OR FASTENER INSTALLATION AT FUSELAGE STATION 221

TO:

Beechcraft Model B300 and B300C Aircraft Owner

REASON

During inspection it was found that there may be an insufficient amount of fasteners or shims installed on the left or right side at Fuselage Station (FS) 221.

COMPLIANCE

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

LABOR HOURS

WORK PHASE	LABOR-HOURS
Modification	50 (B300)
Modification	35 (B300C)

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
101-430026-0031	*	*
101-430026-0035	*	*
132369AD4-5	*	*
132369AD5-5	*	*
132369AD6-5	*	*
132369AD4-10	*	*
132369AD5-10	*	*
132369AD6-10	*	*

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

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Revision B - November 30, 2023

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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.

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
Bldg. P43 Dock R5
7123 SW BLVD
Wichita, KS 67215

Expiration: August 15, 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.