

Beechcraft SERVICE BULLETIN

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Model: 23

No. 2

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Kit No. 23-1-1

SUBJECT: MODEL 23 IMPROVEMENT CHANGES.

AIRCRAFT AFFECTED: Model 23 Musketeers Serial Numbers M-1 through M-53 except M-25 and M-40, M-54, M-57 through M-61, M-64 through M-71, M-73, M-74, M-76, M-80, M-82, and M-85.

NOTE

The following aircraft are now equipped with bronze nose gear bushings and grease fitting described in Item 7 below: M-3, M-7, M-21, M-36, M-38, M-39, M-44, M-48, and M-52.

REASON FOR CHANGE: To incorporate improvements which have been indicated as desirable, as a result of initial service experience.

ACCOMPLISHMENT: Not later than the next 100-hour inspection of the airplane.

DESCRIPTION: Modification consists of the following rework:

1. **REINFORCEMENT OF COCKPIT SIDE PANEL.** A stiffener is installed on the panel below the pilot's side window for increased structural strength.
2. **REINFORCEMENT OF CABIN DOOR.** A metal strap is attached to the door frame and extended across the latch cutout to impart added rigidity to the door structure.
3. **IMPROVED INSTRUMENT PANEL MOUNTS.** The six laminated mounts are replaced with four solid mounts for greater durability.
4. **COWLING IMPROVEMENTS.** Doublers are installed at each lower cowling latch to provide added strength in these areas. The slot type cowling fasteners are replaced with fasteners incorporating wing nuts to facilitate latching and unlatching.
5. **CABIN FRESH AIR INLET DEFLECTOR.** A shield is installed by the cabin air opening to direct incoming air downward and prevent it from flowing directly on the pilot and front seat passenger.
6. **REINFORCEMENT OF AFT FUSELAGE SKIN PANELS.** A stiffener is installed on each side of the aft fuselage section for increased rigidity.

7. **IMPROVED NOSE GEAR BUSHINGS.** The original Oilite bushings are replaced with closer fitting bronze bushings, and a grease fitting for the new bushings is added.

8. **IMPROVED FUEL TANK CAPS.** New caps incorporating "O" ring seals for more positive sealing are substituted for the original caps containing flat neoprene sheets.

9. **REINFORCEMENT OF NOSE COWL BULKHEAD.** A stiffener is installed on the forward side of the nose cowl bulkhead for added strength.

Kit 23-1-1, Model 23 Improvement Change Installation, contains the necessary parts and installation instructions for accomplishing this modification. A copy of Kit Information Drawing 23-001032, which contains complete rework information, is included in each kit. Further information concerning this kit may be obtained from your local BEECHCRAFT distributor, dealer, or Certified Service Station.

Upon completion of this modification, an appropriate compliance note specifying the kit identification number and the kit serial number should be entered in the aircraft log book. The kit serial number appears on the pink card placed in each kit.

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The following is a preliminary listing of parts contained in Kit 23-1-1 and is provided with this service information for reference and familiarization purposes. Included in each kit at the time of assembly is a packing sheet which lists the parts for check-off

and replacement purposes. It is suggested that this packing sheet be placed in your files for reference when reordering parts, until such time as the listing of parts is incorporated in the airplane parts catalog.

PART NUMBER	NOMENCLATURE	QUANTITY
23-001032	Kit Information Drawing	1
	Copy Parts List	1
Reinforcement of Cockpit Side Panel		
169-400005-343	Stiffener	1
169-400005-345	Clip	1
MS20426AD4-4	Rivet	5
MS20470AD4-4	Rivet	20
Reinforcement of Cabin Door		
169-420010-53	Reinforcement	1
*PK65A-4-6	Screw	2
AN525-832R6	Screw	4
AN960-8	Washer	4
MS20364-832	Nut	4
Improved Instrument Panel Mounts		
169-324000-33	Instrument Panel Mounting	4
AN515-8R4	Screw	1
Cowling Improvements		
169-910013-61	Doubler	1
169-910013-62	Doubler	1
MS20470AD4-4	Rivet	20
169-910013-59	Doubler	4
**W98292-2-200	Stud	4
MS20470AD3-4	Rivet	5
**99785-2	Stud Cross Pin	4
MS20470AD4-5	Rivet	40
MS20426AD4-4	Rivet	30
Cabin Fresh Air Inlet Deflector		
169-400010-51	Louver	1
Reinforcement of Aft Fuselage Skin Panels		
169-400005-355	Stringer	1
169-400005-357	Clip	2
MS20470AD4-4	Rivet	100
169-440005-77	Stringer	2
169-440005-79	Clip	2
MS20470AD3-3	Rivet	8
Improved Nose Gear Bushings		
169-810016-1	Bearing	2
MS15001-4	Fitting	1
C. O. B73751-1, Drawing No. 169-810016	Bearing	2
AN960-416	Washer	1
***130AA	Lubriplate Grease	1/2 Pint

PART NUMBER	NOMENCLATURE	QUANTITY
	Improved Fuel Tank Caps	
****HE 627-1	Fuel Filler Cap	2
	Reinforcement of Nose Cowl Bulkhead	
C. O. B73742-1, Drawing No. 169-910013	Angle	1
MS20470AD4-4	Rivet	10
MS20470AD4-7	Rivet	10

*Part number of Parker-Kalon, a Division of General American
Transportation Corporation, Clifton, New Jersey

**Part number of Monadnock Mills, San Leandro, California

***Part number of Fiske Brothers Refining Company,
Newark, New Jersey and Toledo, Ohio

****Part number of H & E Aircraft Incorporated, Oklahoma City,
Oklahoma