

Kit No. 23-4012-1 S
Kit No. 23-4012-3 S

SUBJECT: **DOORS - REPLACEMENT OF CABIN ENTRANCE ASSIST STEPS**

SYNOPSIS OF CHANGE: Changed MATERIAL chart to reflect airplanes without fifth and sixth seat.

OPERATIONAL BENEFITS: Beech Aircraft Corporation recommends that the owner/operator comply with this Service Bulletin because reports have been received of premature cabin assist step breakage. This Service Bulletin offers a stronger step to aid in boarding the aircraft.

EFFECTIVITY: BEECHCRAFT B24R Sierra 200, serials MC-155 and MC-165 through MC-283.

COMPLIANCE: At the owner's/operator's discretion.

If BEECHCRAFT Service Instructions No. 0651-112 or BEECHCRAFT Service Bulletin No. 2090 has been accomplished, this Service Bulletin need not be accomplished.

APPROVAL: Engineering data contained in this Service Bulletin is FAA approved.

MANPOWER: The following information is for planning purposes only:
Estimated man-hours: 8 hours.
Suggested number of men: 1 man.

The above is an estimate based on experienced personnel complying with this Service Bulletin. Occasionally, after work has started, conditions may be found which could result in additional man-hours.

MATERIAL: The following kits required for this modification may be ordered through a BEECHCRAFT Authorized Outlet.

PART NUMBER	DESCRIPTION	QUANTITY PER AIRPLANE
23-4012-1 S (Used on airplanes with fifth and sixth seats)	Kit Information - Cabin Assist Step Installation	1 required
23-4012-3 S (Used on airplanes without fifth and sixth seats)	Kit Information - Cabin Assist Step Installation	1 required

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Issued: March, 1986
Revised: June, 1986

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Beech Aircraft Corporation issues service information for the benefit of owners and fixed base operators in the form of two classes of Service Bulletins. MANDATORY (Red Border) Service Bulletins are changes, inspections and modifications that could affect safety. The factory considers compliance with these Service Bulletins mandatory. OPTIONAL (No Border) Service Bulletins cover changes, modifications, improvements or inspections the factory feels will benefit the owner and although highly recommended, they are not considered mandatory compliance at the time of issuance, unless so stated in the publication. Due to the wide range of information covered by the OPTIONAL Service Bulletin, each owner/operator is responsible for conducting a thorough review of each Optional Service Bulletin and determine if compliance is required based on the applicability of the OPTIONAL Service Bulletin to his particular set of operating conditions. Both classes are mailed to:

- BEECHCRAFT Authorized Outlets.
- Owners of record on the FAA Aircraft Registration Branch List and the BEECHCRAFT International Owner Notification Service List.

(c) Those having a publications subscription.

Information on Owner Notification Service or Subscriptions can be obtained through any BEECHCRAFT Authorized Outlet. As Service Bulletins are issued, temporary notification in the Service Bulletin Master Index should be made until the index is revised. Warranty will be allowed only when specifically defined in the Service Bulletin and in accordance with the Beech Aircraft Corporation Warranty Policy.

Unless otherwise designated, Beech Aircraft Corporation Service Bulletins as well as BEECHCRAFT kits are approved for installation on BEECHCRAFT airplanes in original or BEECHCRAFT modified configurations only. BEECHCRAFT Service Bulletins and Kits may not be compatible with airplanes modified by STC installations or modifications other than BEECHCRAFT Approved kits.

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NOTICE

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WARRANTY: Warranty credit for parts and labor to the extent noted under MATERIAL and MAN-POWER will be allowed on all affected airplanes.

Warranty on this Service Bulletin will apply through June 30, 1987. After this date, the owner/operator assumes the responsibility for the compliance and cost. Beech Aircraft Corporation reserves the right to void continued warranty coverage in the area affected by this Service Bulletin if this Service Bulletin is not complied with.

All warranty reimbursements are handled through franchised BEEHCRAFT Authorized Outlets. Owners and operators should arrange with these outlets to perform the work and have them submit the standard Beech Aircraft Corporation warranty claim form through a BEEHCRAFT Authorized Outlet.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: None.

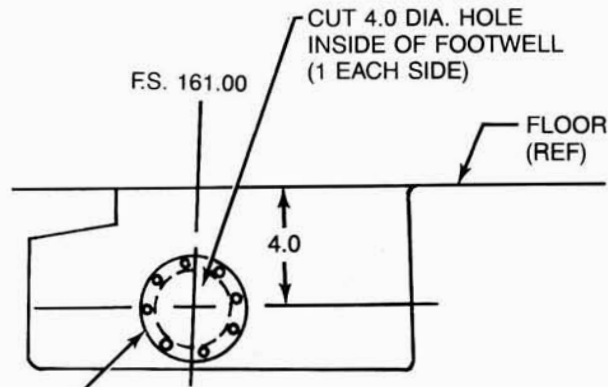
REFERENCES: None.

PUBLICATIONS AFFECTED: It is recommended that a note to "See Service Bulletin No. 2090, Rev. I" be made in the following:

BEEHCRAFT 19, 23, 24 Parts Catalog copies, P/N 169-590012J or subsequent, Figure 98.

ACCOMPLISHMENT INSTRUCTIONS: This Service Bulletin may be accomplished as follows:

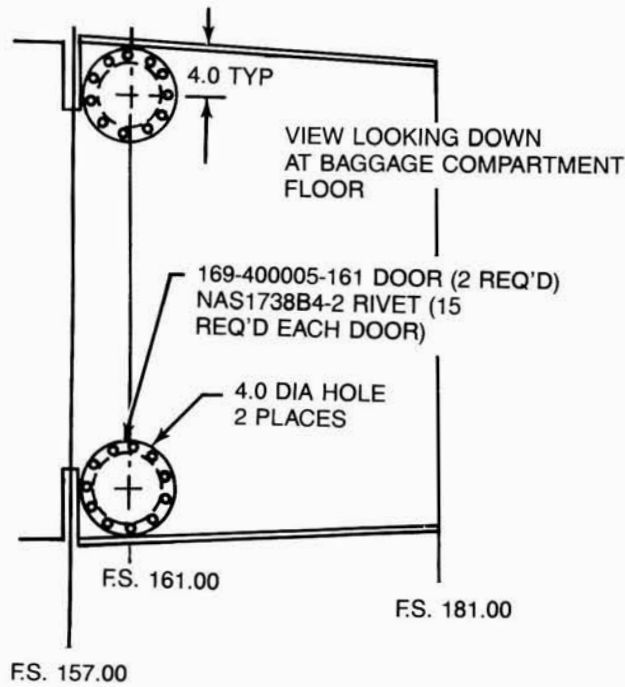
1. Remove the seats and floor carpet as required to obtain access to the area shown in Figure 1 or Figure 2.
2. Cut two 4-inch diameter access holes as indicated in Figure 1 or Figure 2.
3. Remove the two bolts holding the assist step in the adapter tube and remove the step. (See Figure 3.) Access to the nuts on the bolts may be obtained through an existing lightening hole
4. Install the new steps using the existing attaching parts. Torque the bolts to 20-25 inch pounds.
5. Install the two doors over the access holes as shown in Figure 1 or Figure 2. Reinstall the floor carpet and seats and paint the new assist step.



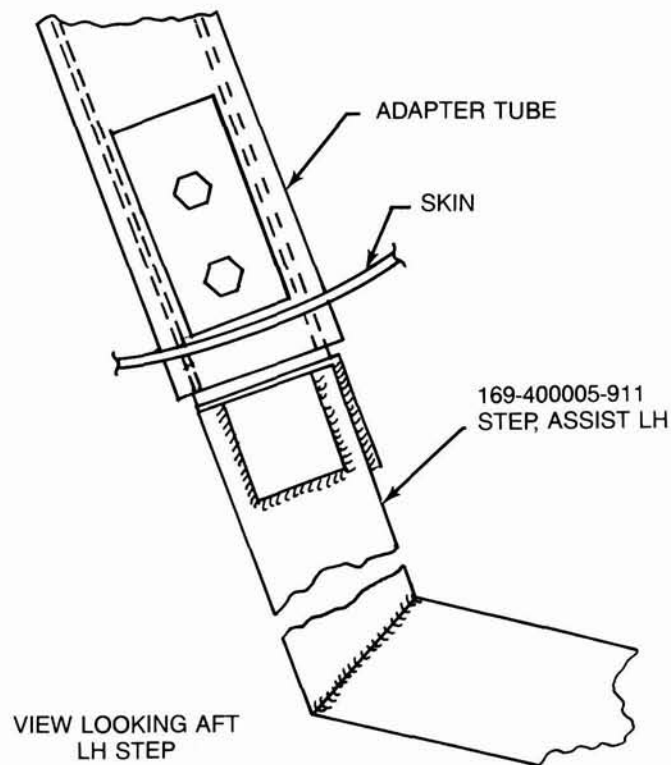
- 169-110000-199 DOOR (2 REQ'D)
- AN525-832-R7 SCREW (8 REQ'D EACH DOOR)
- 130290-1 CLIP NUT ASSY (8 REQ'D EACH DOOR)

VIEW LOOKING OUTBOARD

**Airplanes With Fifth And Sixth Seat
Figure 1**



**Airplanes Without Fifth And Sixth Seat
Figure 2**



**LH Assist Step
Figure 3**

RECORD COMPLIANCE: Upon completion of this Service Bulletin, make an appropriate maintenance record entry specifying the kit identification number and the kit serial number. It is recommended that the parts list contained in the kit be filed for future reference.

NOTE

If you are no longer in possession of this airplane, please forward this information to the present owner.