

Kit No. 23-9020-1 S

- SUBJECT:** FUEL - REPLACEMENT OF THE FUEL BOOST PUMP
- SYNOPSIS OF CHANGE:** Revised the accomplishment instructions to reflect a new fuel boost pump part number.
- REASON:** This Service Bulletin is being issued to provide a replacement fuel boost pump, plumbing, and attaching hardware because the original equipment fuel boost pump is no longer available. This Service Bulletin need not be accomplished on airplane serials which have previously accomplished the fuel boost pump replacement and plumbing modifications in accordance with Service Instruction No. 0861-281.
- EFFECTIVITY:** BEEHCRAFT A23-19, 19A, M19A and B19, serials MB-321 through MB-812; B23 and C23, serials M-1095 through M-1604, M-1606 through M-1819, M-1821 through M-1836, M-1838 through M-1841, M-1843, M-1844, M-1846 through M-1852, M-1855, M-1857 through M-1859, M-1863, M-1864, M-1867, M-1868 and M-1870.
- COMPLIANCE:** Beech Aircraft Corporation considers compliance to be at the owner's/operator's option or when replacement of the fuel boost pump becomes necessary.
- APPROVAL:** Engineering data contained in this Service Bulletin is FAA Approved.
- MANPOWER:** The following information is for planning purposes only:
Estimated man-hours: 3 hours.
Suggested number of men: 1 man.
The above is an estimate based on experienced, properly equipped personnel complying with this Service Bulletin. Occasionally, after work has started, conditions may be found which could result in additional man-hours.
- MATERIAL:** The parts required for this modification are contained in Kit No. 23-9020-1 S. This kit may be ordered through a BEEHCRAFT Authorized Outlet. Beech Aircraft Corporation expressly reserves the right to supersede, cancel and/or declare obsolete, without prior notice, any kits or publications that may be referenced in this Service Bulletin.

AW-645, AW-1078

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Beech Aircraft Corporation issues Service Information for the benefit of owners and fixed based operators in the form of two classes of Service Bulletins. The first class, Mandatory Service Bulletins (Flag Border) includes changes, inspections and modifications that could affect safety or airworthiness. Beech considers compliance with these Service Bulletins to be mandatory. Beech also issues a Service Bulletin having no border which is designated as either recommended or optional in the Compliance Section within the Bulletin. In the case of recommended Service Bulletins, Beech feels the changes, modifications, improvements or inspections will benefit the owner and although highly recommended, they are not considered mandatory at the time of issuance. In the case of optional Service Bulletins, compliance with the changes, modifications, improvements or inspections is at the owner/operator's discretion. Both classes are mailed to:

(a) BEEHCRAFT Authorized Outlets.

(b) Owners of record on the FAA Aircraft Registration Branch List and the BEEHCRAFT International Owner Notification Service List.

(c) Those having a publications subscription.

Information on Owner Notification Service or subscriptions can be obtained through any BEEHCRAFT Authorized Outlet. As Mandatory Service Bulletins and 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 Mandatory Service Bulletins, Service Bulletins and BEEHCRAFT Kits are approved for installation on BEEHCRAFT airplanes in original or BEEHCRAFT modified configurations only. BEEHCRAFT Mandatory Service Bulletins, Service Bulletins and Kits may not be compatible with airplanes modified by STC installations or modifications other than BEEHCRAFT Approved kits.



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SPARES AFFECTED: None.

WARRANTY CREDIT: None.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: No change.

REFERENCES: None.

**PUBLICATIONS
AFFECTED:**

It is recommended that a note "See Service Bulletin No. 2381, Rev. I" be made in the following:

BEECHCRAFT 19, 23, and 24 Parts Catalog, P/N 169-590012J or subsequent, Figures 281C and 285B.

**ACCOMPLISHMENT
INSTRUCTIONS:**

This Service Bulletin shall be accomplished as follows:

1. Disconnect all electrical power to the airplane.
2. Turn the fuel selector valve to the OFF position.
3. Remove the co-pilot's seat.
4. Remove the co-pilot's rudder pedal cover assembly.
5. Remove the boost pump access plate.
6. Remove the fuel boost pump.
7. Remove the tube assembly from the boost pump to the firewall.
8. Remove the tube assembly from the firewall to the strainer tee.
9. Remove the tube assembly from the strainer tee to the boost pump.
10. Install an AN816-6-2D nipple in the "In" port of the new boost pump.
11. Install an AN822-6-2D elbow in the "Out" port of the new boost pump.
12. Install the P/N 58-920054-3 boost pump and P/N 169-400005-351 channel with a P/N AN4-5A/M/ bolt, P/N AN960-416 washer and MS20365-428 nut through the existing holes in the keel at F.S. 78.40, located 10.4 inches aft of the firewall.

NOTE

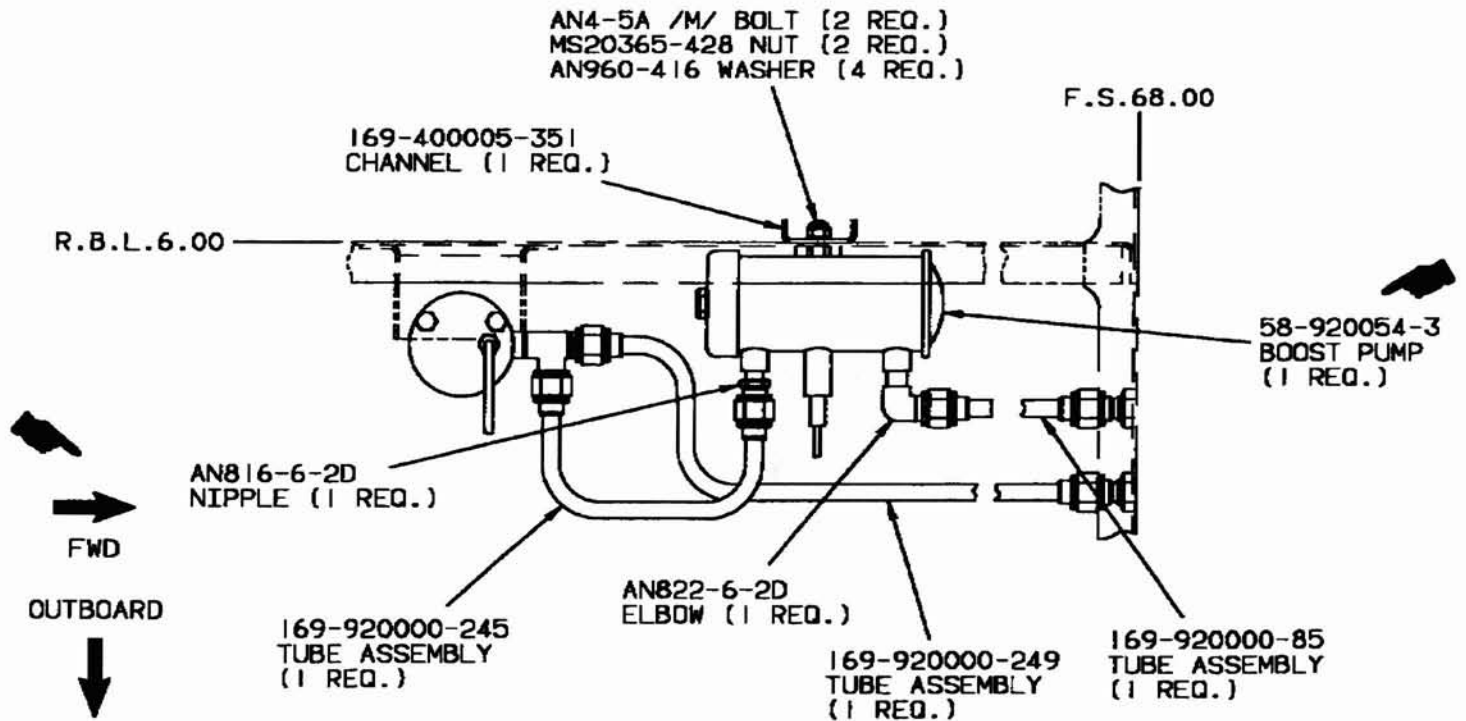
Trim the diagonal channel between the inboard and outboard keel as necessary to provide clearance between the channel and the new boost pump.

13. Referring to Figure 1, complete the installation of the fuel line tube assemblies.

NOTE

It may be necessary to make minor adjustments to the tube assemblies and/or shim the firewall fittings in order to ensure proper alignment of the installation. Use care when hand-bending the tube assemblies to prevent crimping or damaging them.

14. Leak test the system.
15. Reinstall the boost pump access plate, co-pilot's rudder pedal cover assembly, and the co-pilot's seat.
16. Restore electrical power to the airplane.



**Fuel Boost Pump Installation
Figure 1**

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 until the listing of parts has been incorporated into the Parts Catalog.

NOTE

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