

Beechcraft SERVICE BULLETIN

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SUBJECT: MODIFICATION OF HEATER/MUFFLER SHROUD AT THE EXHAUST OUTLET TUBE.

AIRCRAFT AFFECTED: All Model 23 aircraft prior to M-555 except M-1.

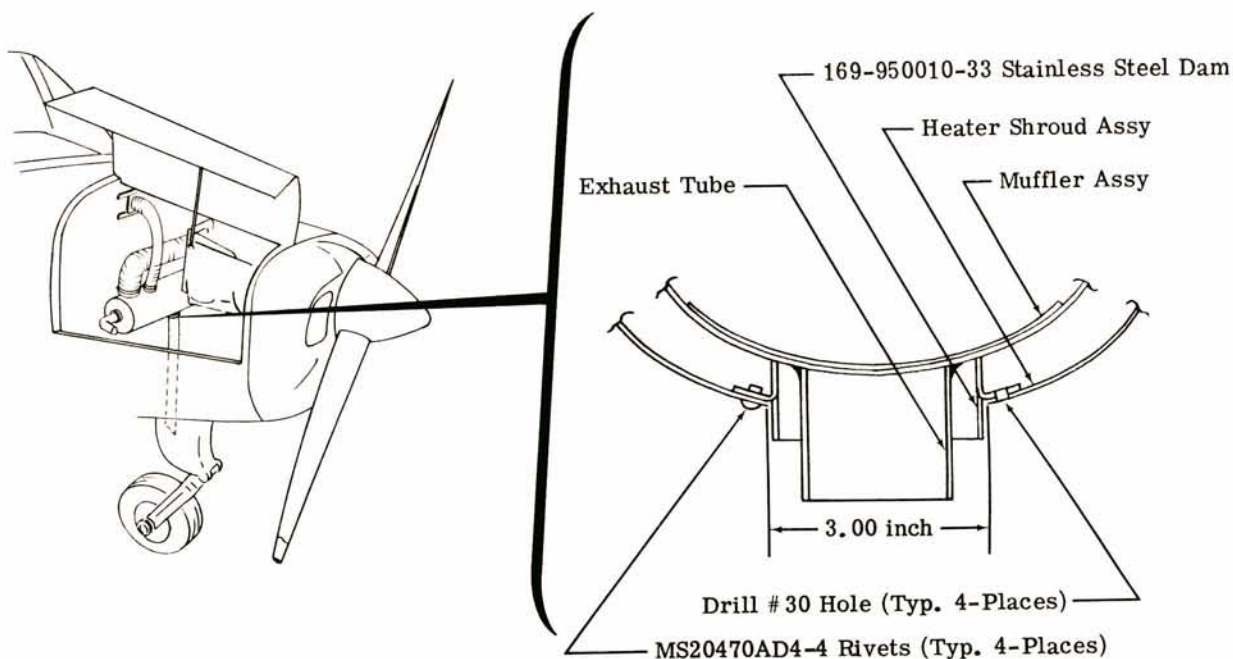
REASON FOR CHANGE: To eliminate the possibility of engine exhaust (carbon monoxide) entering the heater system.

ACCOMPLISHMENT: As soon as possible and before operation of cabin heater. If inspection of exhaust tube weld, in accordance with Service Bulletin 63-5, reveals no cracks, operation may be continued for another 25 hours until the heater/ muffler shroud modification is accomplished.

DESCRIPTION: This bulletin provides heater/muffler shroud modification procedures, to insure that normal heater system operation may be maintained. Service bulletin 63-5, concerning inspection of the weld at the exhaust tube and muffler, should also be observed during compliance with this bulletin.

The following recommended procedure may be used to complete this modification.

1. Remove the complete muffler assembly from the aircraft. This will include disconnecting the engine exhaust assembly at the cylinder exhaust ports (at cylin-



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ders No. 3 and 4) to facilitate disconnection and removal of the muffler assembly from the aircraft.

2. Remove the heater shroud from the muffler assembly and complete the inspection of the exhaust tube and muffler weld described in Service Bulletin 63-5 — accomplish any corrective action required.

3. Modify the heater shroud at the muffler exhaust outlet by enlarging the diameter of the exhaust outlet tube hole to a 3.00 inch dimension. (See illustration.)

4. Position the stainless steel dam P/N 169-950010-33 per illustration - then locate and drill the four rivet holes using a #30 wire drill (drill hole size is .128). Install the four MS 20470 AD4-4 rivets.

5. Reassemble the heater shroud and muffler assembly and reinstall on the aircraft. Accomplish all procedures and operations in accordance with standard shop maintenance practices.