

24, 24R

No. 0384-24I, Rev. I
ATA Code 75-40

Kit No. 23-9012-I S

SUBJECT: POWER PLANT – MANIFOLD PRESSURE LINE MODIFICATION

SYNOPSIS OF CHANGES: Service Instructions reprinted in ATA format and reissued to supersede and cancel the original issue of these Service Instructions. The manifold hose assembly is replaced with a new hose assembly instead of the tube assembly specified on the original issue. Additional aircraft serials added to the EFFECTIVITY.

EFFECTIVITY: BEEHCRAFT A23-24 and A24, serials MA-1 through MA-368 which are equipped with a constant speed propeller installation;
A24R, serials MC-2 through MC-95;

Sierra A24R, serials MC-96 through MC-150.

REASON: To provide an improved manifold pressure line.

COMPLIANCE: At the next scheduled inspection.

DESCRIPTION: The existing manifold pressure line is to be removed and discarded and replaced with a new hose assembly. Aircraft on which the P/N 169-910017-29 tube has been installed per the original issue of these Service Instructions must be modified by removing and discarding the tube and replacing it with the new hose assembly specified in these Service Instructions.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

Estimated man-hours: 2 hours.
Suggested number of men: 1 man.

MATERIAL: The parts required to accomplish this modification are contained in Kit No. 23-9012-I S. The kit is available through your BEEHCRAFT Parts and Service Outlet at a suggested selling price of \$22.25 each. (Price subject to change without notice.)

Warranty credit will be allowed for parts and labor not to exceed 2 man-hours for all affected aircraft that have previously installed the P/N 169-910017-29 tube per the original issue of these Service Instructions. All kit orders for replacement of P/N 169-910017-29 tube should be noted as being on warranty request.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: None.

REFERENCES: None.

AW-855

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- (a) BEEHCRAFT Aero or Aviation Centers and International Distributors and Dealers.
- (b) Owners of record on the FAA Registration list and the

BEEHCRAFT International Owner Notification Service List.
(c) Those having a publications subscription.

CLASS III (No Border) covers changes which are optional, maintenance aids, product improvement kits and miscellaneous service information. Compliance is at the owner or operator's prerogative. Copies of Class III are distributed per a and c above. Information on Owner Notification Service or Subscriptions can be obtained through any BEEHCRAFT Aero or Aviation Center, International Distributor and Dealer, or the Factory. As Service Instructions are issued, temporary notation in the index should be made until the index is revised. Warranty will be allowed only when specifically defined in the Service Instructions and in accordance with Beech Warranty Policy.

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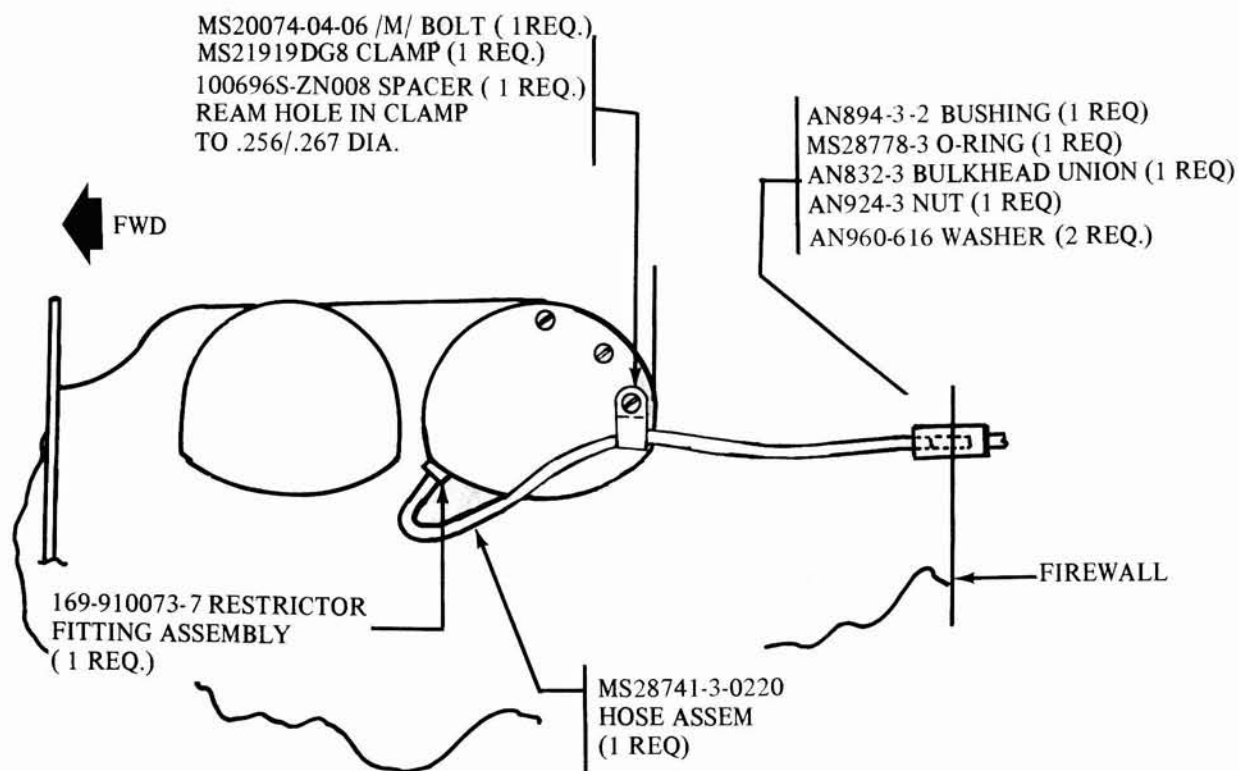
Service Instructions No. 0384-241, Rev. I

PUBLICATIONS AFFECTED: It is recommended that a note be made on Figures 241C and 241E of all Parts Catalog copies to "See Service Instructions No. 0384-241, Rev. I".

ACCOMPLISHMENT INSTRUCTIONS:

Installation of the new manifold pressure line is accomplished as follows:

1. Open the upper cowling to gain access to the left side of the engine compartment.
2. Disconnect the manifold pressure line from the aft left engine cylinder connection and from the firewall fitting and remove the line from the aircraft.
3. Remove the AN816-2 nipple from the aft left engine cylinder and replace it with a 169-910073-7 restrictor fitting assembly.
4. Disconnect the manifold pressure line aft of the firewall fitting and remove the firewall fitting (one each AN832-2 bulkhead union, AN924-2 nut and two each AN960-516 washers) from the aircraft.
5. Drill one .44-inch diameter hole, centered .50-inch inboard and 5.38-inch above the center line of the hole where the firewall fittings were removed in step 4.
6. Install new, one each, AN832-3 bulkhead union, AN924-3 nut and two AN960-616 washers in the .44-inch diameter hole which was drilled in step 5. (See illustration.)
7. Install an SS51043 plug button in the open hole in the firewall where the fitting was removed.
8. Install one each, AN894-3-2 bushing and MS28778-3 O-ring on the aft side of the bulkhead union and connect the manifold pressure line aft of the firewall to the bushing. Torque the line nut to 90 to 100 inch-pounds.
9. Install the new MS28741-3-0220 hose assembly between the fitting on the aft left engine cylinder and the firewall fitting per the illustration. Torque these fittings to 70 to 100 inch-pounds.
10. Ream the attaching hole in an MS21919DG8 clamp to .256/.267 inch diameter.
11. Remove the existing aft left cylinder rocker arm cover screw as shown in the illustration and install the clamp on the rocker arm cover with a 100696S-ZN008 spacer and an MS20074-04-06 /M/ bolt. Torque this bolt to 50 to 70 inch-pounds.
12. Close the engine cowling and place the aircraft back in service.



Manifold Pressure Line Modification.

RECORD COMPLIANCE:

Upon completion of these Service Instructions, make an appropriate maintenance record entry, specifying the kit identification number and the kit serial number. The parts list contained in the kit should be filed for future reference until the listing of parts has been incorporated into the Parts Catalog.