



CLASS I SERVICE INSTRUCTIONS

19, 23, 24

No. 0638-240, Rev. I
ATA Code 28-00

SUBJECT: POWER PLANT - INSPECTION OF PLUMBING FITTINGS AT THE FIREWALL

SYNOPSIS OF CHANGE: EFFECTIVITY is expanded, MATERIAL section is corrected, warranty date is extended for some airplanes, and COMPLIANCE and PUBLICATIONS AFFECTED are rewritten in new format.

EFFECTIVITY: PART I

BEECHCRAFT A23-19, 19A and B19, serials MB-1 through MB-520;
B19 Sport 150, serials MB-521 through MB-651 and MB-653 through MB-663;
23, B23 and C23, serials M-1, M-2, M-4 through M-554 and M-1095 through M-1361;
C23 Sundowner 180, serials M-1362 through M-1532;
A23-24 and A24, serials MA-1 through MA-368;
A24R, serials MC-2 through MC-95;
A24R and B24R Sierra 200, serials MC-96 through MC-341.

PART II

BEECHCRAFT A23-19, 19A and B19, serials MB-1 through MB-520;
B19 Sport 150, serials MB-521 through MB-651 and MB-653 through MB-677;
23, A23, A23A, B23 and C23, serials M-1 through M-1361;
C23 Sundowner 180, serials M-1362 through M-1545;
A23-24 and A24, serials MA-1 through MA-368;
A24R, serials MC-2 through MC-95;
A24R and B24R Sierra 200, serials MC-96 through MC-250.

REASON: To improve the effectiveness of the firewall.

COMPLIANCE: Beech Aircraft Corporation considers this to be a mandatory change and it should be accomplished no later than the next scheduled inspection.

DESCRIPTION: Aluminum fittings and component assemblies equipped with aluminum fittings at the engine firewall are to be inspected and replaced with steel fittings and/or components with steel fittings as necessary.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

Estimated man-hours for inspection: 1 hour.
Estimated man-hours for modification: 3 hours.
Suggested number of men: 1 man.

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Beech Aircraft Corporation issues service information for the benefit of owners and fixed base operators in the form of three classes of Service Instructions. CLASS I (Red Border) are changes, inspections, and modifications that could affect safety. The factory considers compliance mandatory. CLASS II (Green Border) covers changes, modifications, improvements or inspections the factory feels will benefit the owner and although highly recommended, they are not considered mandatory compliance, unless specified at the time of issuance. Class I and II are mailed to:

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

BEECHCRAFT 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 BEECHCRAFT 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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CLASS I

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MATERIAL:

The following parts, if required, are available through your BEECHCRAFT Parts and Service Outlet. The value of the materials required for the incorporation of these Service Instructions on one airplane is to be advised. Prices, when released, will be subject to change without notice.

PART I

AIRPLANES AFFECTED	PART NUMBER	DESCRIPTION	QUANTITY
A23-19, 19A, B19, 23 B23, C23	169-920000-171	Tube Assembly	1 per airplane
A23-24, A24, A24R, B24R	AN832-6	Union	1 per airplane
A23-24, A24, A24R, B24R	AN924-6	Nut	1 per airplane
A23-24, A24, A24R, B24R	AN833-6	Elbow	1 per airplane
A24R, B24R (MC-2 through MC-244)	AN822-4	Elbow	2 per airplane
A24R, B24R	AN837-4	Elbow	1 per airplane
A24R, B24R	AN832-4	Union	1 per airplane

PART II

A23-19, 19A, B19, 23, B23, C23	AN837-6	Elbow	1 per airplane
A23, A23A	AN833-6	Elbow	1 per airplane
A23-19, 19A, B19, 23, B23, C23	AN832-6	Union	1 per airplane
A23-19, 19A, B19, 23, B23, C23	AN960-916	Washer	1 per airplane
A23, A23A	AN924-6	Nut	1 per airplane
23, B23, C23, A23-24, A24, A24R, B24R (except MA-1 through MA-325)	169-920000-173	Hose Assembly	1 per airplane
A23, A23A	169-920001-49	Hose Assembly	1 per airplane
A23-24 (MA-1 through MA-325)	130524-6-0170	Hose Assembly	1 per airplane
A23-19, 19A, B19, 23, B23, C23	169-920000-175	Hose Assembly	1 per airplane on 23, B23 and C23; 2 per airplane on A23-19, 19A, and B19

WARRANTY:

Warranty credit will be allowed for parts and labor not to exceed the man-hours listed under MANPOWER on warranty claims received prior to December 31, 1975. Warranty credit for MC-245 through MC-341 will be allowed for claims received prior to July 1, 1976. All orders for parts should be noted as being on warranty request. Submit all warranty claims to Commercial Service Operations, Beech Aircraft Corporation, Wichita, Kansas, 67201.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: None.

REFERENCES: None.

PUBLICATIONS AFFECTED: It is recommended that a note to "See Service Instructions No. 0638-240, Rev. I" be made on all 19, 23 and 24 series Parts Catalog copies, P/N 169-590012G or subsequent, Figures 211, 281, 281A, 281B and 281C.

ACCOMPLISHMENT INSTRUCTIONS: Inspection and/or modification may be accomplished in the following manner:

NOTE

Inspection of plumbing fittings at the engine firewall covered in detail in PART I and PART II, must be performed to determine if replacement is necessary. If a fitting is blue in color, it is aluminum and must be replaced.

AIRPLANES AFFECTED: PART I

All
A23-19, 19A, B19, 23,
B23, C23
A23-24, A24, A24R, B24R

1. Remove the engine cowling.
2. Remove the tube assembly between the firewall and the primer block and replace it with a P/N 169-920000-171 tube assembly.
3. Inspect the firewall fittings where the hose from the engine driven fuel pump attaches to the firewall. If aluminum fittings are found, they are to be replaced with an AN832-6 union or an AN833-6 elbow and an AN924-6 nut. Retain the existing AN960-916 washer.

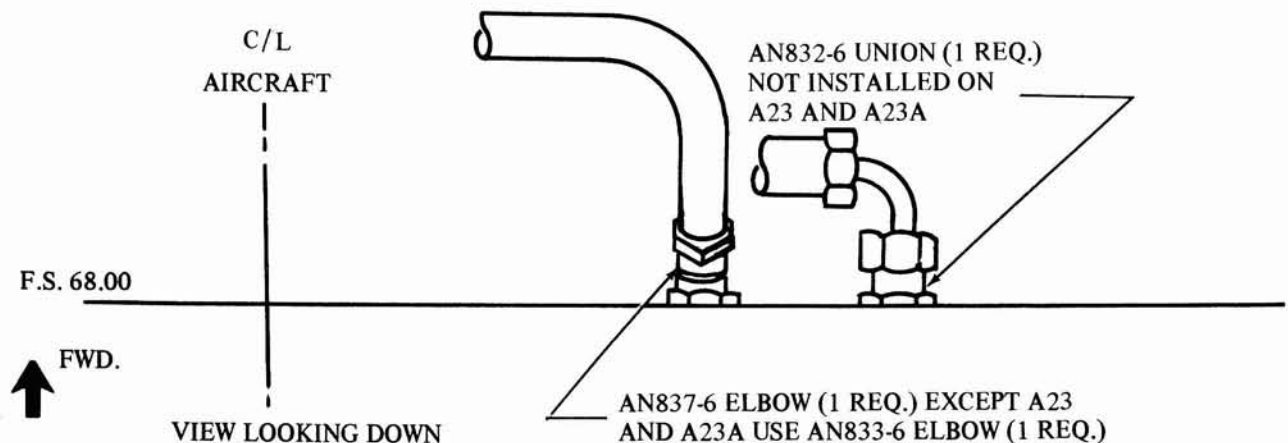
A24R and B24R

4. Disconnect the two hydraulic lines between the nose gear down lock cylinder and firewall. Serials MC-2 through MC-341: Replace the two firewall fittings with one AN832-4 union and one AN837-4 elbow. Serials MC-2 through MC-244 only: Also replace the two MS20822-4D cylinder elbows with two AN822-4 elbows. Reconnect the hydraulic lines. Serials MC-251 through MC-341: Reinstall the engine cowling.

PART II

A23-19, 19A, B19, 23,
B23, C23

1. Remove the engine cowling if not already removed and inspect the firewall fuel line union and elbow shown in the illustration and if necessary, replace them with an AN832-6 union and AN837-6 elbow. An AN960-916 washer must be installed between the union and the firewall.



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| A23-19, 19A, B19 | 2. Remove and discard, if necessary, the two hose assemblies routed between the firewall and carburetor and the firewall and engine driven fuel pump. Replace the two hoses with two P/N 169-920000-175 hose assemblies. |
| 23, B23, C23 | 3. Inspect the hose assemblies which are routed between the firewall and the carburetor and between the firewall and the engine driven fuel pump for aluminum fittings at the firewall end. If aluminum fittings are found, replace the hose to the carburetor with a P/N 169-920000-173 hose assembly and the hose to the engine driven fuel pump with a P/N 169-920000-175 hose assembly. |
| A23, A23A | 4. Inspect the firewall fuel line elbow and nut and if necessary replace them with an AN833-6 elbow and AN924-6 nut. |
| A23, A23A, A23-24, A24, A24R, B24R | 5. Remove and replace, if necessary, the hose assembly routed between the firewall and engine driven fuel pump. A23-24 serials MA-1 through MA-325 only will require a P/N 130524-6-0170 hose assembly and A23 and A23A airplanes will require a P/N 169-920001-49 hose assembly. All other airplane serials affected will require a P/N 169-920000-173 hose assembly. |
| All | 6. Reinstall the engine cowling. |
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RECORD COMPLIANCE: Upon completion of these Service Instructions, make an appropriate maintenance record entry.