



CLASS II

# SERVICE INSTRUCTIONS

24

No. 0651-112  
ATA Code 51-00

**SUBJECT:** FUSELAGE - ASSIST STEP - REPLACEMENT OF CABIN ASSIST STEPS

**EFFECTIVITY:** BEEHCRAFT B24R Sierra 200, serials MC-151, MC-155 and MC-165 through MC-229 (MC-218 LH side only).

**REASON:** To provide an improved cabin assist step.

**COMPLIANCE:** At the owners discretion.

**DESCRIPTION:** Access holes are to be cut in the fuselage structure and the cabin assist steps replaced.

**APPROVAL:** FAA Approved - DOA CE-2.

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

**MATERIAL:** The following parts are required for this modification and are available through your BEEHCRAFT Parts and Service Outlet.

PART NUMBER	DESCRIPTION	QUANTITY	PRICE*
169-400005-813	Step, Assist LH	1	\$77.00 each
169-400005-814	Step, Assist RH	1	\$77.00 each
169-110000-199**	Door, Access	2	\$ .75 each
AN525-832R7**	Screw	16	\$ 2.00 each
294671**	Clipnut	16	\$ 3.50 †
169-400005-161***	Door, Access	2	\$ .90 each
CR2249-4-2***	Cherry Lock Rivet	30	\$ 5.00 ††

\*Suggested selling price. (Subject to change without notice).  
 \*\*Used on aircraft equipped with the fifth and sixth seats only.  
 \*\*\*Used only on aircraft without the fifth and sixth seats.  
 †Price for a minimum buy quantity of 10 parts.  
 ††Price for a minimum buy quantity of 25 parts.

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574 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) 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.

98-34238D



**Service Instructions No. 0651-112**

**WARRANTY:** Warranty credit will be allowed for parts and for labor not to exceed the man-hours listed under MANPOWER on warranty claims received prior to November 1, 1974. All orders for parts should be noted as being on warranty request.

**SPECIAL TOOLS:** None.

**WEIGHT AND BALANCE:** None.

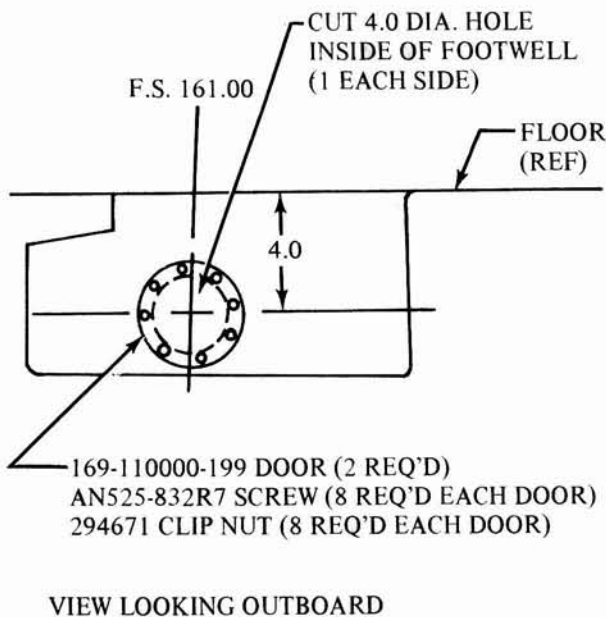
**REFERENCES:** None.

**PUBLICATIONS AFFECTED:** None.

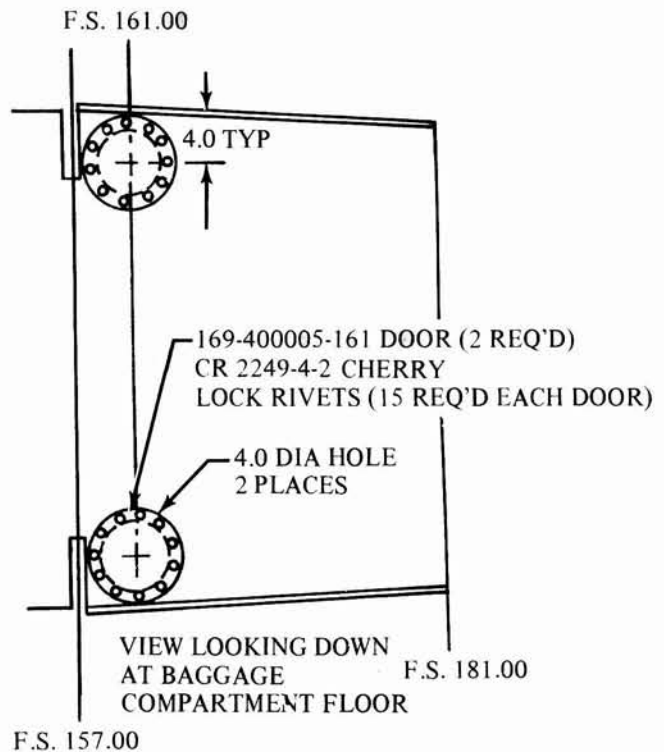
**ACCOMPLISHMENT  
INSTRUCTIONS:**

This modification may be accomplished in the following manner:

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 four 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 in the floor board located forward of the station 157.00 fuselage frame.
4. Install the new steps using the existing attaching parts. Torque the bolts to 20-25 inch pounds.



**Figure 1. Aircraft With Fifth and Sixth Seat**



**Figure 2. Aircraft Without Fifth and Sixth Seat**

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 steps.

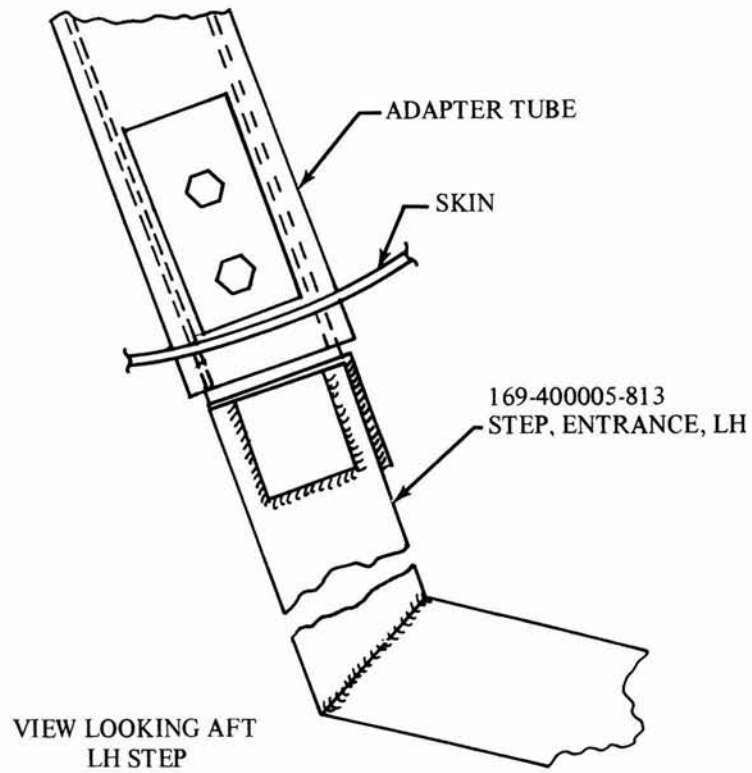


Figure 3. View of LH Assist Step  
Typical For RH Assist Step

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**RECORD COMPLIANCE:**

Upon completion of these Service Instructions, make an appropriate maintenance record entry.