



CLASS II

SERVICE INSTRUCTIONS

19, 23, 24

No. 0731-114
ATA Code 52-10

SUBJECT: DOORS - REPLACEMENT OF DOOR HANDLES AND CABIN DOOR LATCH BOLTS

EFFECTIVITY: PART I

**BEECHCRAFT B19 Sport 150, serials MB-617 through MB-696;
C23 Sundowner 180, serials M-1485 through M-1563;
B24R Sierra 200, serials MC-181 through MC-268.**

PART II

**BEECHCRAFT B19 Sport 150, serials MB-697 through MB-771;
C23 Sundowner 180, serials M-1564 through M-1651;
B24R Sierra 200, serials MC-269 through MC-351.**

REASON: PART I

To provide cabin and baggage door handles with more positive locking ability and cabin doors with more durable latch bolts.

PART II

To provide cabin and baggage door handles with more positive locking ability.

COMPLIANCE: At the owner's discretion, however, Beech Aircraft Corporation recommends this be accomplished at the next scheduled inspection.

DESCRIPTION: PART I

The outside cabin and baggage door handles and inside cabin door latch bolts are replaced with new handles and latch bolts.

PART II

The outside cabin and baggage door handles are replaced with new handles.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

**Estimated man-hours for PART I: 6 hours.
Estimated man-hours for PART II: 3 hours.
Suggested number of men for PART I or PART II: 1 man.**

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CLASS II

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.

98-34238D



Service Instructions No. 0731-114

MATERIAL: The following parts required for completion of this modification are available through your BEECHCRAFT Parts and Service Outlet.

PART I ONLY

PART NUMBER	DESCRIPTION	QUANTITY PER AIRPLANE	PRICE*
HSP130D**	Pin	2 each	\$.80 each
111501-1**	Latch Bolt	2 each	To be advised
MS171526	Roll Pin	2 each	\$.06 each

PART I AND PART II

H2532-13**	Handle Assembly	3 each (2 each for B19)	\$25.00 each
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*Estimated suggested selling price, (subject to change without notice).

**P/N of Hartwell Corporation, 900 S. Richfield, Placentia, California, 92670.

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 Jan. 1, 1976. All orders for parts should be noted as being on warranty request. Submit all warranty claims to Parts and Service Operations, Beech Aircraft Corporation, Wichita, Kansas, 67201.

SPECIAL TOOLS: None.

WEIGHT & BALANCE: None.

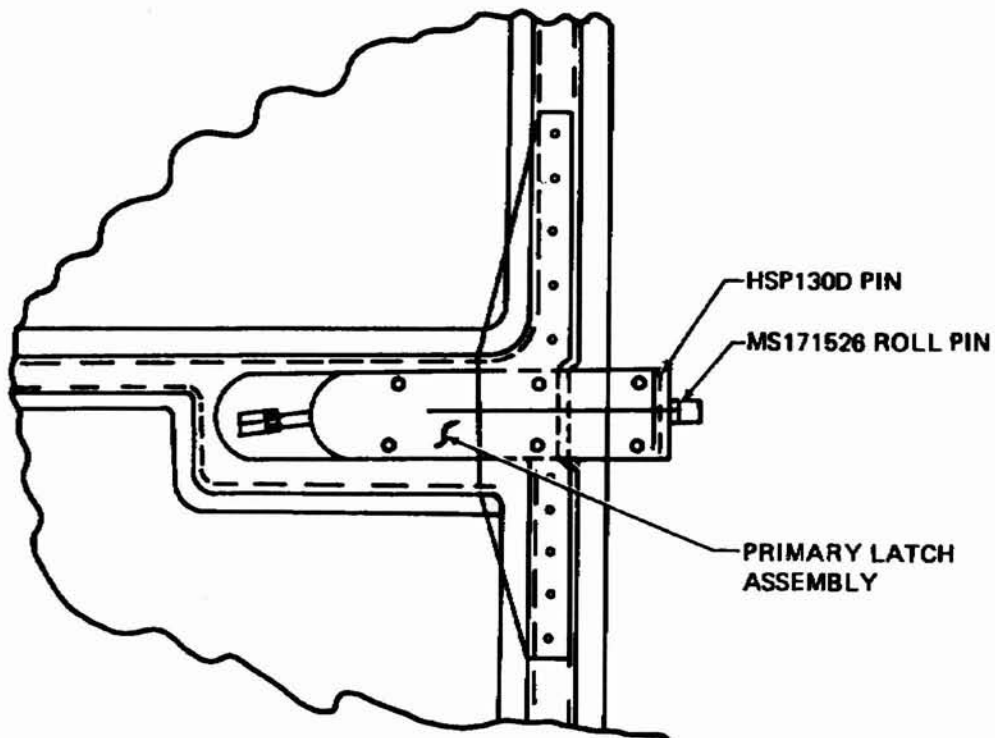
REFERENCES: None.

PUBLICATIONS AFFECTED: It is recommended that a note to "See Service Instructions No. 0731-114" be made on all 19, 23 and 24 series Parts Catalog copies P/N 169-590012H or subsequent, Figures 104A and 106A.

ACCOMPLISHMENT INSTRUCTIONS:

These Service Instructions may be accomplished as follows:

- PARTS I AND II 1. Remove the inside cabin door arm rest, door handle, and upholstery panel. Remove the two screws attaching the outside handle assembly to the primary latch and remove the handle from the door.
- PARTS I AND II 2. Remove the retainer ring from the inboard side of the lockset cylinder and very carefully remove the lockset from the handle assembly. Install the lockset cylinder in the new P/N H2532-13 handle assembly and secure in place with the retainer ring. Discard the old handle.
- PART I ONLY 3. Remove the eight attaching screws and slide the primary latch assembly aft as shown in illustration. Remove the swelled HSP130D pin by driving with small punch through housing of latch.
- PART I ONLY 4. Pull shaft and latch bolt aft to gain access to rivet pin. Split old plastic latch bolt and remove the rivet pin. Install new P/N 111501-1 steel latch bolt over shaft and install P/N MS171526 roll pin through latch bolt and shaft.
- PART I ONLY 5. Slide shaft and latch bolt back in housing and install new P/N HSP130D pin with head of pin on top side. Swage lower end of pin by using a center punch. Slide latch assembly back in door to original position and install the eight attaching screws.
- PARTS I AND II 6. Install the new outside handle assembly back in the primary latch assembly. Replace the upholstery panel, inside door handle and arm rest.
- PARTS I AND II 7. Remove the inside window moulding and with the door open and the upper latch in the closed position check for proper adjustment of the upper latch bolt. The ears on the bolt should engage the fiberglass frame at the edge of the cut-out for the latch. It may be necessary to restrict excessive movement of the latch bolt by installing a spacer between the top of the turnbuckle and the bottom of the plastic guide just above the turnbuckle.



The spacer may be made from a stack of AN960-10 washers or equivalent. Reinstall the window moulding.

For B19 airplanes, no further action is required.

For C23 and B24R airplanes, continue with the following steps:

PARTS I AND II

8. Remove the outside door handle from the baggage door. Remove the lockset from the handle and install the lockset in the new P/N H2532-13 handle assembly.

PARTS I AND II

9. Install the new handle assembly in the baggage door.

RECORD COMPLIANCE:

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