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No. 0801-287, Rev. 1
ATA Code 28-10

SUBJECT: FUEL SYSTEM - REPLACEMENT OF THE FUEL CAP AND ADAPTER

SYNOPSIS OF CHANGE: Revised from Class II Service Instructions to Class I Service Instructions.

EFFECTIVITY: BEECHCRAFT 23, serials M-1 through M-554.

REASON: To provide a fuel cap and adapter with improved sealing capability.

COMPLIANCE: Beech Aircraft Corporation considers this to be a mandatory modification and it should be accomplished as soon as possible after receipt of these Service Instructions, but no later than the next 25 service hours.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

Estimated man-hours: 6 man-hours per airplane.
Suggested number of men: 1 man.

MATERIAL: The following parts required for this modification may be ordered through BEECHCRAFT Aero or Aviation Centers and International Distributors and Dealers:

PART NUMBER	DESCRIPTION	QUANTITY
*169-380024-601	Fuel Cap and Adapter Assembly	2 per airplane
**890B1/2 QT	Sealer	1 per airplane

*All parts noted in the ACCOMPLISHMENT INSTRUCTIONS are contained in the P/N 169-380024-601 assembly except the 890B1/2 QT sealer. The value of the material required for the incorporation of these Service Instructions on one airplane is to be advised. Price, when issued, will be subject to change without notice.
**890B1/2 QT is a part number of the Coast Pro-Seal and Manufacturing Company, a division of Essex Chemical, 2235 Beverly Boulevard, Los Angeles, California 90057, and may be obtained locally.

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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.

Service Instructions No. 0801-287, Rev. I

WARRANTY: None.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: None.

REFERENCES: None.

PUBLICATIONS AFFECTED: It is recommended that a note to "See Service Instructions No. 0801-287, Rev. 1" be made in all BEECHCRAFT 19, 23 and 24 Parts Catalog copies, P/N 169-5900121 or subsequent, Figure 287.

ACCOMPLISHMENT INSTRUCTIONS:

These Service Instructions may be accomplished as follows:

1. Drain and purge the fuel system.
2. Remove and discard the existing fuel cap.
3. Place a clean tack rag inside the fuel tank to catch any metal cuttings which might fall into the fuel tank during the fuel cap adapter replacement.
4. Using a router bit, enlarge the existing fuel cap adapter hole to 4.30-inch diameter, centered on the existing fuel cap adapter hole. Use a vacuum cleaner during use of the router bit to catch the metal cuttings.
5. Center the P/N 169-380024-3 fuel cap adapter in the new 4.30-inch diameter hole, positioning a fuel cap notch in an extreme aft position. Using the P/N 169-380024-3 fuel cap adapter as a template, drill two .1875-inch diameter holes, secure with fasteners and drill the remaining ten .1875-inch diameter holes.
6. Remove the P/N 169-380024-3 fuel cap adapter and deburr the twelve .1875-inch diameter holes and the 4.30-inch diameter hole.
7. Remove the rag from inside the fuel tank and vacuum to remove any cuttings the rag did not catch. Place a clean rag inside the fuel tank.
8. Clean the area the P/N 169-380024-3 fuel cap adapter covers on the wing skin with naphtha or an equivalent cleaner.
9. Apply a 1/16-inch thick layer of 890B1/2 QT sealer on the area cleaned in step eight.
10. Place the P/N 169-110000-341 gasket on the wet 890B1/2 QT sealer with the twelve .1875-inch diameter holes aligned.
11. Place the P/N 169-380024-3 fuel cap adapter on the P/N 169-110000-341 gasket with the twelve .1875-inch diameter holes aligned.
12. Install the P/N 169-110000-349 visual fuel gage plate using the aft two .1875-inch diameter holes with the .25-inch flange forward. Use two P/N AN509-10R12 screws with a P/N 800-001-10 seal under the two P/N MS20365-1032 nuts.
13. Install the remaining ten P/N AN509-10R12 screws with a P/N 800-001-10 seal under the P/N MS20365-1032 nuts. Torque the twelve P/N MS20365-1032 nuts to 20 to 25 inch-pounds.
14. Clean the excess 890B1/2 QT sealer from the P/N 169-380024-3 fuel cap adapter with naphtha and allow the sealer to cure per the manufacturer's recommendations.
15. Install the P/N 169-380024-1 fuel cap and adjust as necessary for a firm fit.
16. Remove the rag from inside the fuel tank and vacuum as required to remove any foreign material from the fuel tank.
17. Pressurize the fuel tank to 1 psi. Check for leaks, using a soap and water solution around the P/N 169-380024-3 fuel cap adapter and the P/N 169-380024-1 fuel cap.
18. Clean and sand the P/N 169-380024-1 fuel cap and the P/N 169-380024-3 fuel cap adapter and paint as required.
19. Repeat the procedure on the opposite wing.

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