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No. 0807-356
ATA Code 24-30

SUBJECT: ELECTRICAL POWER - MODIFICATION TO THE BATTERY BOX INSTALLATION

EFFECTIVITY: BEEHCRAFT A23-19, 19A, M19A and B19, serials MB-1 through MB-520; B19 Sport 150, serials MB-521 through MB-802.

REASON: To provide a more secure attachment for the battery box.

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

DESCRIPTION: A clip, gusset, and bolt are added to the battery box installation to provide additional security.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

Estimated man-hours: 4 hours.
Suggested number of men: 1 man.

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

PART NUMBER	DESCRIPTION	QUANTITY
169-364015-3	Gusset	1 per airplane
169-364015-5	Clip	1 per airplane
AN525-832R7	Screw	2 per airplane
MS21042L08	Nut	2 per airplane
AN960-8	Washer	2 per airplane
AN3-53 /M/	Bolt	1 per airplane
MS21042L3	Nut	1 per airplane
AN960-10	Washer	1 per airplane
EX1479 PT	Paint	1 per airplane

The value of the material required for the incorporation of these Service Instructions on one airplane is to be advised. Prices, when issued, will be subject to change without notice.

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CLASS II

II

98-34238D

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:

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Service Instructions No 0807-356

WARRANTY:	This is a product improvement type modification, and may be accomplished at the owners discretion, therefore, no warranty is applicable.
SPECIAL TOOLS:	None.
WEIGHT AND BALANCE:	None.
REFERENCES:	None.
PUBLICATIONS AFFECTED:	It is recommended that a note to "See Service Instructions No. 0807-356" be made in all 19, 23 and 24, Parts Catalog copies P/N 169-590012I or subsequent, figure 356.

ACCOMPLISHMENT INSTRUCTIONS:

These Service Instructions may be accomplished as described in the following procedures:

1. Turn off all electrical power.
2. Remove the aft cabin bulkhead upholstery panel to gain access to the battery box.
3. Remove the battery box lid, and disconnect and remove the battery.
4. Install the 169-364015-5 clip with two MS20470AD4-6 rivets (rivets may be obtained locally) through the side of the battery box. Drill two .165/.174-inch diameter holes and install two AN525-832R7 screws, AN960-8 washers and MS21042L08 nuts down through the 169-400005-262 keel as shown in figure 1.
5. Align the 169-364015-3 gusset along the inboard base of the battery box with half of the gusset against the lower case and half against the 169-400005-252 keel. (See figure 2.)
6. Using the gusset as a guide, locate the five rivets in the side of the battery box. Drill out the rivets and drill the holes in the battery box and the gusset to .128/.133-inch diameter, and install the gusset to the battery box with MS20470AD4-6 rivets. (Rivets may be obtained locally.)

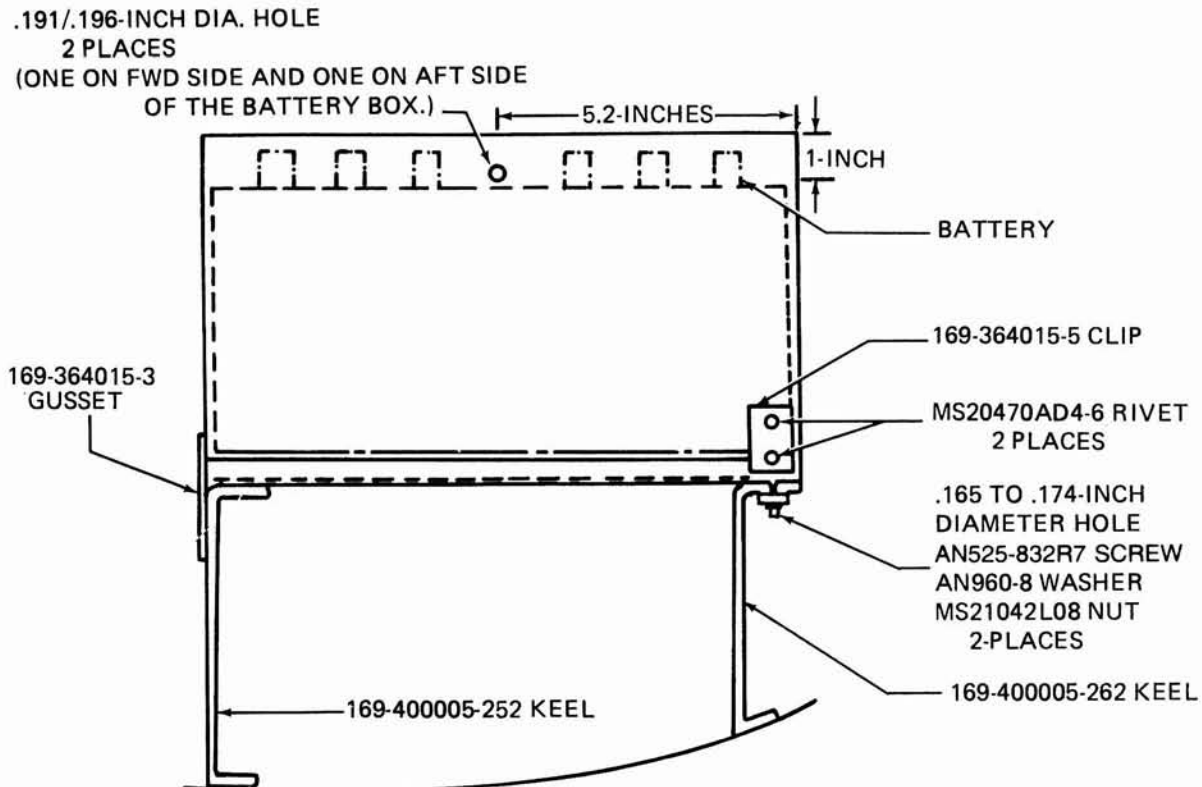


Figure 1

7. Install the lower half of the gusset to the keel by drilling five .128/.133-inch diameter holes through the gusset and keel, and install with MS20470AD4-5 rivets. (Rivets may be obtained locally) (See figure 2.)

NOTE

If the side of the battery box is not aligned with the keel it is permissible to shim between the 169-364015-3 gusset and the 169-400005-252 keel with 2024T3 aluminum alclad flat sheet. Attach the 169-364015-3 gusset and shim to the 169-400005-252 keel with AN525-832 screws of the appropriate length, AN960-8 washers, and MS21042L08 nuts in lieu of the MS20470AD4-5 rivets.

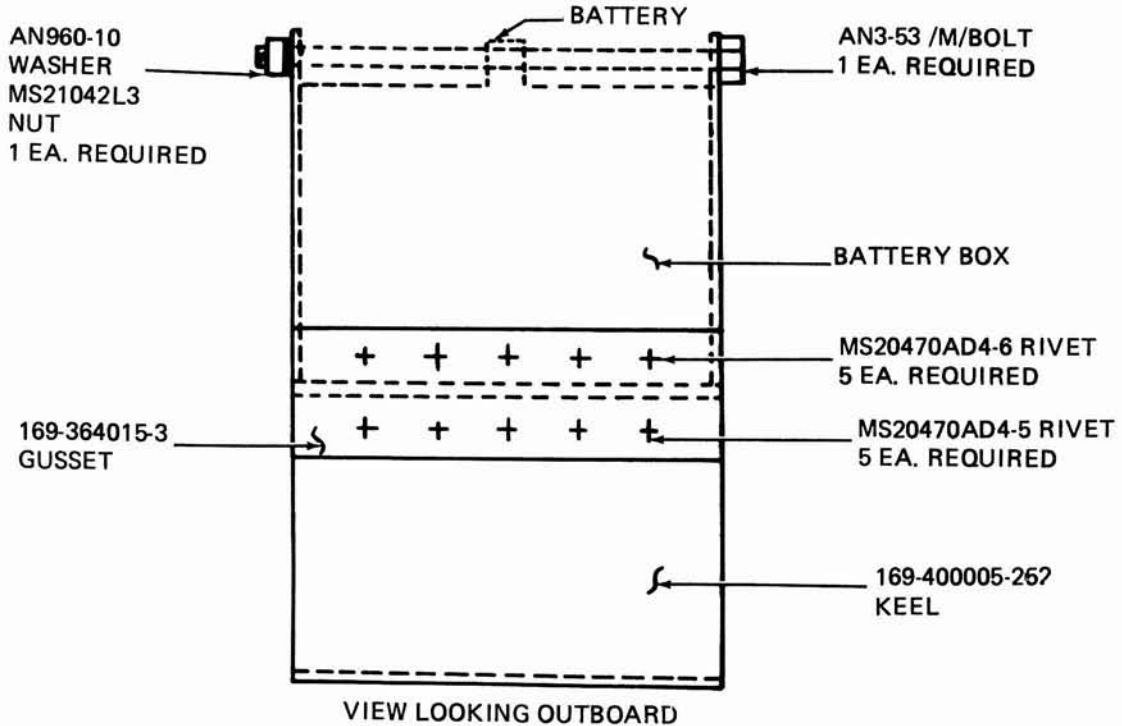


Figure 2

8. Starting at the outboard end of the battery box, measure in 5.2-inches and down 1-inch, and drill a .191/.196-inch diameter hole through the forward and aft sides of the battery box. (See figure 1.)

9. Apply a coat of EX1479 PT acid resistant paint to the battery box on and around all new installed rivets, and any other areas not properly protected.

10. Reinstall and reconnect the battery. Install the AN3-53 /M/ bolt through the holes in the battery box (drilled in step 8) across the top of the battery and secure the bolt with an AN960-10 washer and MS21042L3 nut.

11. Reinstall the battery box lid, and aft cabin bulkhead upholstery panel removed for this modification.

RECORD COMPLIANCE:

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