

Beechcraft

CLASS I SERVICE INSTRUCTIONS

76

No. 1041
ATA Code 55-20

SUBJECT: STABILIZERS - INSPECTION OF ELEVATOR TRAILING EDGE BOND THICKNESS

EFFECTIVITY: BEECHCRAFT Duchess 76, serials ME-1 through ME-6 and ME-8 through ME-62.

REASON: To inspect the trailing edge of the elevator for proper bond thickness and install rivets along the trailing edge if necessary.

These Service Instructions are issued to submit the information contained in Liberal Service Letter No. 78-10 dated October 30, 1978 in the format of regular BEECHCRAFT Service Instructions. Liberal Service Letter No. 78-10 was issued to inspect the bond thickness of the elevator trailing edge.

If compliance was made with the Liberal Service Letter, no further action is required except to enter a compliance statement for both documents in the airplane maintenance records.

COMPLIANCE: Beech Aircraft Corporation considers this to be a mandatory inspection and/or modification and it should be accomplished as soon as possible after receipt of these Service Instructions, but no later than the next 50 service hours.

APPROVAL: FAA Approved - DOA CE-2.

MANPOWER: The following information is for planning purposes only:

Estimated man-hours: 3 hours.
Suggested number of men: 1 man.

MATERIAL: The MS20470AD3 rivets, if required, may be obtained from local sources.

WARRANTY: Warranty credit for parts and labor to the extent noted under MATERIAL and MANPOWER will be allowed for all claims submitted prior to June 30, 1979.

All warranty reimbursements are handled through franchised BEECHCRAFT outlets. Owners and operators may arrange with these outlets to perform the work and submit the standard Beech Aircraft Corporation warranty claim form to the Commercial Service Department, Beech Aircraft Corporation, Wichita, Kansas 67201.

SPECIAL TOOLS: None.

WEIGHT AND BALANCE: None.

No BECP

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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:

- BEECHCRAFT Aero or Aviation Centers and International Distributors and Dealers.
- 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.

98-34239D



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CLASS I

Service Instructions No. 1041

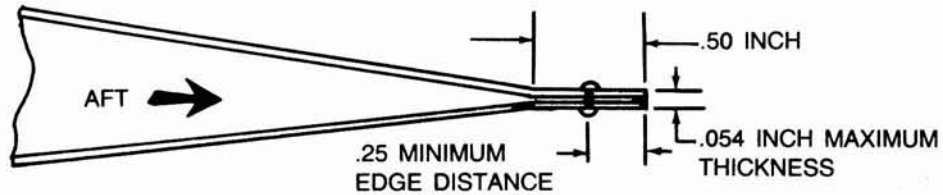
REFERENCES: BEECHCRAFT Duchess 76 Maintenance Manual, P/N 105-590000-7 or subsequent, Chapter 55-20.

PUBLICATIONS AFFECTED: None.

ACCOMPLISHMENT INSTRUCTIONS:

These Service Instructions may be accomplished as follows:

1. Inspect the elevator trailing edge .50 inch forward of the aft edge for proper thickness. Maximum thickness should be .054 inch.



2. If the elevator trailing edge is not over .054 inch thick anywhere along the specified area no further action is necessary. If the elevator trailing edge is over .054 inch thick proceed with step 3.
3. Mark the inboard and outboard boundaries of any area that exceeds .054 inch thick.
4. Beginning .5 inch from the edge of the thick area, drill #40 (.098 inch diameter) holes and install P/N MS20470AD3 rivets of appropriate length (obtain locally) as required. Space the rivets 1.25 inch apart and continue until just past the opposite end of the thick area. Maintain a minimum edge distance of .25 inch on all rivets.
5. Touch up paint as required.
6. Refer to the Duchess 76 Maintenance Manual, Chapter 55-20 and check the elevator for balance.

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