



CLASS I

# SERVICE INSTRUCTIONS

77

No. 1088  
ATA Code 57-40

**SUBJECT:** WINGS - INSPECTION OF WING ATTACH BOLTS AND ATTACH BOLT NUT PLATE TREADS

**EFFECTIVITY:** BEEHCRAFT Skipper 77, serials WA-1 through WA-39, WA-41, WA-42 and WA-44 through WA-46.

**REASON:** To inspect for possible thread damage to the wing attach bolts and/or internal nut plates.

**COMPLIANCE:** Beech Aircraft Corporation considers this to be a mandatory inspection and it should be accomplished prior to the next flight of the airplane.

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

**MANPOWER:** The following information is for planning purposes only:

Estimated man-hours for inspection of each wing: 1.5 hours.  
Suggested number of men for inspection: 1 man.  
Estimated man-hours for repair of each wing: 8 hours.  
Suggested number of men for repair: 2 men.

**MATERIAL:** The following parts required for this inspection and/or repair may be ordered through BEEHCRAFT Aero or Aviation Centers and International Distributors and Dealers. The value of the parts 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.

PART NUMBER	DESCRIPTION	QUANTITY
AN960-1216	Washer	As required
108-120010-5	Nut Plate	As required
108-100000-11 or NAS1112-11 /M/ or NAS1112-15 /M/	Bolt	As required

**WARRANTY:** Warranty credit for parts and labor to the extent noted under MATERIAL and MANPOWER will be allowed on all affected airplanes.

All warranty reimbursements are handled through franchised BEEHCRAFT outlets. Owners and operators may arrange with these outlets to perform the work and submit the

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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) 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.

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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.

**REFERENCES:** BEEHCRAFT Skipper 77 Maintenance Manual, P/N 108-590000-7 or subsequent, Chapter 57.

**PUBLICATIONS AFFECTED:** It is recommended that a note to "See Service Instructions No. 1088" be made in the following:

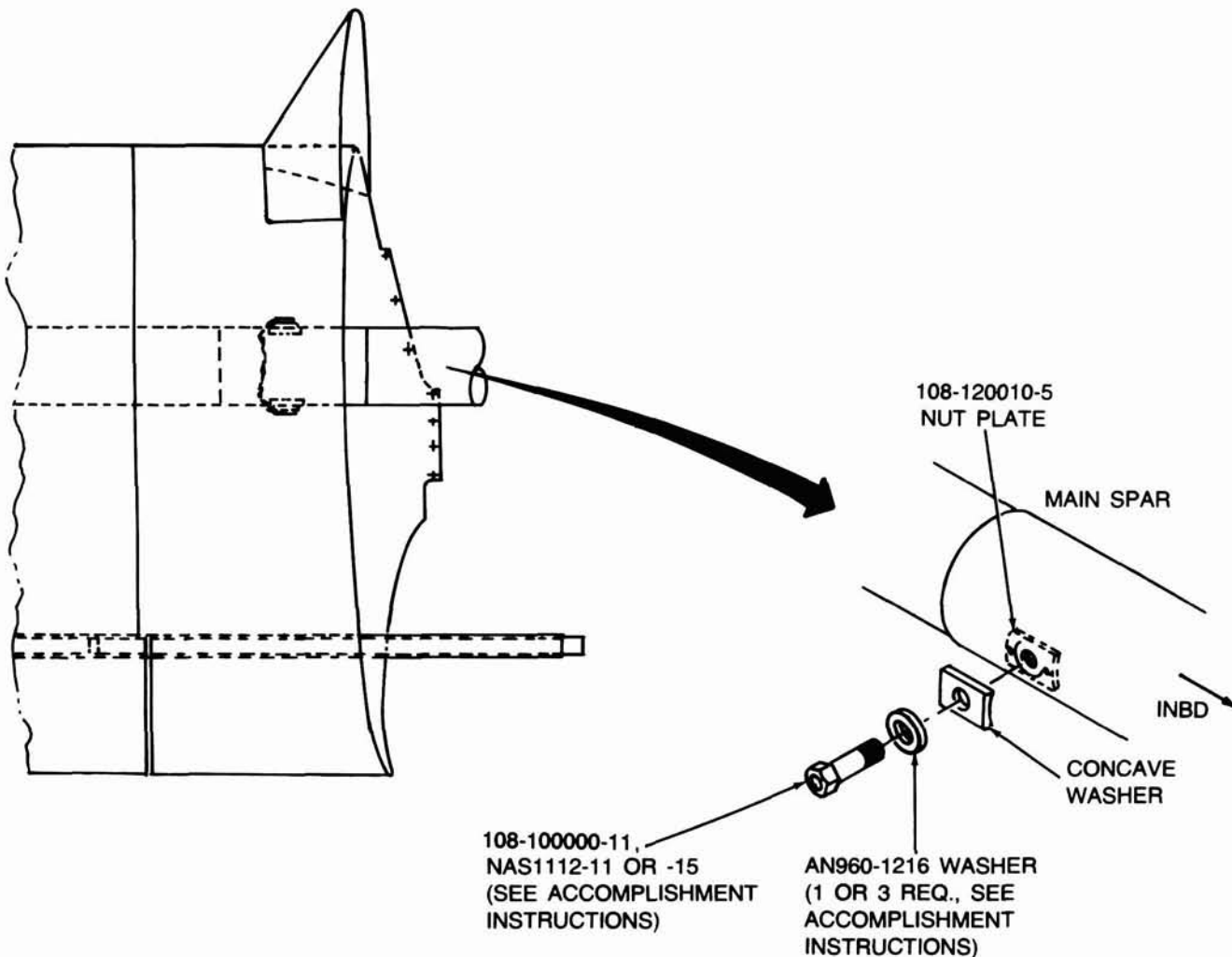
Skipper 77 Maintenance Manual copies, P/N 108-590000-7 or subsequent, Chapter 57;

Skipper 77 Parts Catalog copies, P/N 108-590000-9 or subsequent, Chapter 57.

### ACCOMPLISHMENT INSTRUCTIONS:

These Service Instructions may be accomplished as follows:

1. Remove the access panels from the lower wing surface to gain access to the wing attach bolts.
2. Remove the wing attach bolts (one at a time) and examine the bolt threads and the internal nut plate threads for possible damage caused by overtorque of the bolts. Discard all existing washers EXCEPT THE RECTANGULAR CONCAVE WASHER which nests against the spar. (See illustration.)



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3. If the threads are satisfactory, proceed with steps 4, 5 and 6. If thread damage to the bolts is noted, replace the bolts with new P/N 108-100000-11 bolts and new washers as described in steps 4, 5 and 6. If thread damage to the internal nut plates is noted, proceed to steps 7 through 10.

4. Chamfer the inside diameter of one side of a new AN960-1216 washer .065 inch for each of the four wing attach bolts and apply zinc chromate primer to the chamfered washers.

5. If new NAS1112-11 or NAS1112-15 bolts are to be installed, drill a .093/.103 inch diameter hole through the bolt heads as they were in the removed bolts and apply zinc chromate primer to the drilled surface.

6. If the existing attach bolts are NAS1112-11 or if new P/N 108-100000-11 are to be used, install the bolts with one chamfered washer and the existing concave washer for each bolt. If the existing attach bolts are NAS1112-15, install the bolts with one chamfered washer, two unchamfered AN960-1216 washers and the existing concave washer for each bolt. The chamfered side of the washer should fit in the head-to-shank radius under the bolt head. Torque the bolts to 1300/1500 inch pounds and install MS20995NC32 safety wire (obtain locally) between the heads of the two wing attach bolts on each wing.

7. If the internal nut plates have thread damage, remove the affected wing as directed in the Maintenance Manual to gain access to the interior of the wing spar carry-thru

8. Carefully drill out the two rivets which attach the damaged internal nut plate to the wing spar and remove the nut plate.

9. Install a new P/N 108-120010-5 nut plate in the wing spar using MS20426AD6 rivets of the appropriate length (obtain locally).

### *CAUTION*

Make certain the nut plates align with the hole in the spar when riveting.

10. Reinstall the wing as directed in the Maintenance Manual using the appropriate bolts and washers as directed in steps 4, 5 and 6 of these Service Instructions.

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#### **RECORD COMPLIANCE:**

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