



# CLASS I SERVICE INSTRUCTIONS

76

No. 1188  
ATA Code 57-50

**SUBJECT:** WINGS - INSPECTION AND POSSIBLE REWORK OF THE FLAP HINGE BRACKETS

**EFFECTIVITY:** BEECHCRAFT Duchess 76, serials ME-1, ME-2, ME-4 through ME-286, ME-288 through ME-295, ME-297 through ME-313, ME-315 through ME-324, ME-326 through ME-339, ME-341 through ME-347, ME-349, ME-351 through ME-359, ME-362 through ME-367, ME-372 through ME-377, ME-382 and ME-383.

**REASON:** To inspect the flap hinge brackets for possible elongation of the pivot point holes and install bushings in the holes if required.

**COMPLIANCE:** Beech Aircraft Corporation considers this to be a mandatory inspection/modification and it should be accomplished at the next scheduled inspection.

**APPROVAL:** FAA Approved.

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

Estimated man-hours for inspection: 0.5 hours per airplane.  
Suggested number of men: 1 man.

Estimated man-hours to install bushings: 2 hours per airplane.  
Suggested number of men: 2 men.

**MATERIAL:** The following parts, if required, may be ordered through BEECHCRAFT Aero or Aviation Centers and International Distributors and Dealers.

PART NUMBER	DESCRIPTION	QUANTITY PER AIRPLANE
105-160001-1	Bushing Assembly	12
LOCTITE RC/601	Bearing Mount Compound	As Required
or		
LOCTITE 2214	Bearing Mount Compound	As Required

**WARRANTY:** Warranty credit for parts and labor to the extent noted under MATERIAL and MANPOWER will be allowed for claims received prior to June 30, 1982 on all affected airplanes.

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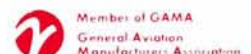
Beech Aircraft Corporation issues service information for the benefit of owners and fixed base operators in the form of three classes of Service Instructions. CLASS I (Red Border) are changes, inspections, and modifications that could affect safety. The factory considers compliance mandatory. CLASS II (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.

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All warranty reimbursements are handled through franchised BEEHCRAFT Aero or Aviation Centers and International Distributors and Dealers. Owners and operators should arrange with these outlets to perform the work and have them submit the standard Beech Aircraft Corporation warranty claim form through BEEHCRAFT Parts and Equipment Marketing Wholesalers or International Distributors.

**SPECIAL TOOLS:**

None.

**WEIGHT & BALANCE:**

None.

**REFERENCES:**

BEEHCRAFT Duchess 76 Maintenance Manual, P/N 105-590000-7 or subsequent, Chapter 27-50.

**PUBLICATIONS AFFECTED:**

It is recommended that a note to "See Service Instructions No. 1188" be made in the following:

BEEHCRAFT Duchess 76 Maintenance Manual copies, P/N 105-590000-7 or subsequent, Chapter 27-50;

BEEHCRAFT Duchess 76 Parts Catalog copies, P/N 105-590000-9B or subsequent, Chapter 57-50.

**ACCOMPLISHMENT**

**INSTRUCTIONS:**

These Service Instructions may be accomplished as follows:

1. Remove the pivot bolts one at a time from the flap hinge brackets and inspect the hinge brackets for enlarged and/or elongated pivot bolt holes. The pivot bolt holes should have a maximum diameter of .200 inch. The maximum allowable difference between the two holes on each flap hinge bracket is .003 inch diameter.

2. If the pivot bolt holes are not enlarged or elongated beyond the maximum allowable diameter specified in step 1, no further action is necessary. Reinstall the pivot bolts.

3. If the pivot bolt holes are enlarged or elongated beyond the maximum allowable diameter as specified in step 1, refer to the Maintenance Manual, Chapter 27-50 and remove the flap(s).

4. On each flap hinge bracket which has enlarged or elongated pivot bolt holes, ream the two holes to .257 inch diameter.

5. Apply Loctite RC/601 or Loctite 2214 bearing mount compound to the outer surface of the P/N 105-

160001-1 bushings and press the bushings into each of the two holes in the flap hinge bracket(s) with the flange of the bushing on the inside of the flap hinge bracket.

**NOTE**

Clean the mating surfaces of the bushings and the holes in the flap hinge bracket(s) and apply the Loctite as specified in the manufacturers instructions on the container.

6. Allow the Loctite to harden as specified in the instructions on the container before reinstalling the flap(s).

7. Refer to the Maintenance Manual, Chapter 27-50 and reinstall the flap(s).

8. Check the flaps for proper operation prior to flight.

**RECORD**

**COMPLIANCE:**

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