

Beechcraft SERVICE LETTER

Published by the Customer Service Division

Model: 23

No. 2

Issued: March, 1963

Kit 23-3-1
23-3-3
23-3-5
23-3-7
23-3-9
23-3-11

Model 23 IMPROVEMENT KIT

Service experience has shown that the following improvements are desirable additions to all Musketeers. These improvements have been added to Musketeers, serials M-62, M-79, M-84, M-108, M-112, M-131, M-132, M-179, M-183, M-204, M-205, M-208, M-229, M-231 through M-233, and M-251 and after (Kit 23-3-1 factory installed M-220 and after) at the factory and may be added to airplanes in the field with the following kits:

Kit 23-3-1 COWL STIFFENERS AND LATCHES. Two flat stiffeners are installed on each upper engine cowl door adding not only stiffness to the upper cowl doors, but curvature as well. The new latch straps incorporate the latest production design changes and are made of improved material.

Kit 23-3-3 NEW ENGINE BAFFLE SEALS. The replacement seals, made of thinner, more flexible material, eliminates the transfer of engine vibration to the cowl.

Kit 23-3-5 NEW CABIN DOOR STOP. A stronger, more rigid door stop and a clip riveted to the lower front door corner provides improved cabin door operation.

Kit 23-3-7 NEW STARTER CABLE. The cable included in the kit increases the cable size from No. 2 gage to No. 0 gage to reduce current loss and improve engine starting.

Kit 23-3-9 SHOCK MOUNTED VOLTAGE REGULATOR.

The new shock mounts isolate the voltage regulator from engine vibration and improve battery charging.

Kit 23-3-11 NEW SEALS FOR FUEL CAP ASSEMBLIES. The new seals replace the present "O" rings in the fuel caps to stop fuel cap leakage.

Kits 23-3-1, 23-3-3, 23-3-5, 23-3-7, 23-3-9, and 23-3-11, contain the necessary parts and installation instructions for accomplishing the modifications. A copy of Kit Information Drawing 23-001032, which contains complete rework information, is included with the kits. Further information concerning the kits may be obtained from your local BEECHCRAFT distributor, dealer, or Certified Service Station.

Upon completion of these modifications, an appropriate compliance note specifying each kit identification number and serial number should be entered in the aircraft log book. The kit serial number appears on the pink card placed in each kit.

The following is a preliminary list of parts contained in Kits 23-3-1, 23-3-3, 23-3-5, 23-3-7, 23-3-9, and 23-3-11 and is provided with this service information for reference and familiarization purposes. Included in each kit at the time of assembly is a packing sheet which lists the parts for check-off and replacement purposes. It is suggested that this packing sheet be placed in your files for reference when reordering parts, until such time as the list of parts is incorporated in the airplane parts catalog.

THE OPERATION, CARE AND MAINTENANCE OF AN AIRPLANE IS THE OWNERS RESPONSIBILITY. AS CONDITIONS WARRANT, BEECH AIRCRAFT CORPORATION ISSUES SERVICE BULLETINS AND SERVICE LETTERS RECOMMENDING MODIFICATIONS AND OPERATIONAL PROCEDURES TO ENABLE THE OWNER TO GET THE MAXIMUM UTILITY AND SAFETY FROM HIS AIRPLANE.

THESE BULLETINS AND LETTERS ARE AVAILABLE TO BEECHCRAFT OWNERS THROUGH THEIR BEECHCRAFT DISTRIBUTOR OR DEALER. WHEN SERVICE BULLETINS AND LETTERS ARE ISSUED, A TEMPORARY RECORDING OF THE PUBLICATION SHOULD BE MADE ON THE APPROPRIATE INDEX.

Model: 23

Service Letter No. 2; Kit 23-3-1, 23-3-3, 23-3-5, 23-3-7, 23-3-9, 23-3-11

PART NUMBER	NOMENCLATURE	QUANTITY
23-001035	Kit Information Drawing	1 copy
	Copy Parts List	1 copy

Kit 23-3-1 COWL STIFFENERS AND LATCHES

CO 75049-3 (169-910013)	Strap Assy	4 each
MS20470AD3-5	Rivet	12 each
MS20470AD3-4	Rivet	60 each
MS9048-005	Roll Pin	2 each
MS20470AD4-4	Rivet	10 each
AN960-416	Washer	2 each
AN380-2-2	Pin	2 each
185678	Clip	2 each
169-910013-91	Angle	2 each
169-910013-93	Rod	2 each
CO B75086-1 (169-910013)	Strip	1 each
CO B75086-2 (169-910013)	Strip	1 each
CO B75086-3 (169-910013)	Strip	1 each
CO B75086-4 (169-910013)	Strip	1 each

Kit 23-3-3 NEW ENGINE BAFFLE SEALS

MS20995F32-8	Safety Wire	3 each
MS20470AD3-4	Rivet	100 each
MS20470AD4-4	Rivet	5 each
185678	Clip	2 each
169-910010-113	Retainer	1 each
169-910010-111	Seal	1 each
169-910010-91	Retainer	1 each
169-910010-89	Seal	1 each
169-910010-69	Retainer	1 each
169-910010-67	Seal	1 each
169-910010-63	Retainer	1 each
169-910010-61	Seal	1 each
169-910010-49	Retainer	1 each
169-910010-47	Seal	1 each
169-910010-37	Retainer	1 each
169-910010-35	Seal	1 each
169-910010-21	Retainer	1 each
169-910010-19	Seal	1 each
169-910010-17	Retainer	1 each
169-910010-15	Seal	1 each

Kit 23-3-5 NEW CABIN DOOR STOP

MS20470AD4-5	Rivet	7 each
MS20470AD4-4	Rivet	10 each
23-001035-1	Angle	1 each
MS20470AD3-4	Rivets	25 each
169-420010-61	Clip	1 each
CO B75439-1 (169-420010)	Door Stop Assy	1 each
169-420010-65	Bushing	2 each

Kit 23-3-7 NEW STARTER CABLE

MS21919DG8	Clamp	1 each
MS20365-832	Nut	3 each
AN960-8	Washer	3 each
NAS220-4	Screw	3 each
K4AO	Wire with Terminals	1 each
NAS51-75	Ring	1 each
112149-12	Grommet	2 each
169-400010-47	Doubler	1 each

Model: 23

Service Letter No. 2; Kit 23-3-1, 23-3-3, 23-3-5, 23-3-7, 23-3-9, 23-3-11

PART NUMBER	NOMENCLATURE	QUANTITY
Kit 23-3-9 SHOCK MOUNTED VOLTAGE REGULATOR		
NAS220-6	Screw	3 each
MS20365-832	Nut	3 each
MS20365-428	Nut	4 each
AN960-8	Washer	6 each
AN960-416	Washer	4 each
AN4-12A	Bolt	4 each
1910966	Shock Mounts	1 each
Kit 23-3-11 NEW SEALS FOR FUEL CAP ASSEMBLIES		
169-110000-290	Cap Seal	2 each