

Beechcraft SERVICE LETTER

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REPAIR OF CRACKS IN ROYALITE COMPONENTS

MODELS AFFECTED: All Model 23 airplanes.

Most cracks in Royalite components such as tail cones, wing tips, and nose cowls can be easily repaired, resulting in a reworked area that is equal or superior to the original material. Following is a general procedure for repair of cracks in Royalite parts such as those used on the Model 23 Musketeer.

1. Thoroughly clean both sides of the material in the affected area by sanding. If oil or grease is present, first clean the area with lacquer thinner, naphtha, or other acceptable degreasing solvent.
2. Prepare a Royalite adhesive by dissolving Royalite chips in methyl ethyl ketone. The solution should be thick, but capable of being poured. If desired, a commercial Royalite adhesive such as MP-1000 (Travis Plating Company, Inc., 12222 West Olympic Boulevard, Los Angeles 64, California), 3M-EC 776 or 3M-EC 847 (Minnesota Mining and Manufacturing Company, 411 Piquette Street, Detroit 2, Michigan), Pliobond 20 (Campbell Industries, 645 West 73rd Street, Chicago, Illinois), or equivalent may be used.
3. Bond a strip of Royalite over the crack on the inside of the part for added support. This strip can be somewhat thinner than the original material. The edges of the strip should be chamfered to fair in smoothly with the adjacent area.
4. Using clamps or other suitable means, hold the Royalite strip in place until the adhesive is dry (approximately one hour).
5. Remove all foreign matter from the crack on the outside of the part. Form the crack into a V-shaped groove and fill with adhesive. If a commercial Royalite adhesive is used, some sanding surfacer will be required to aid in filling the groove.
6. Clean, sand smooth, and repaint the repaired area when it is thoroughly dry.

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