

TITLE

AUTO FLIGHT - TRANSMITTAL OF HONEYWELL SERVICE BULLETIN 4006719-22-0019, SM-200 SERVO DRIVE

EFFECTIVITY

MODEL	SERIAL NUMBERS
560XL	-5002 thru -5583

The equivalent of this service letter has been incorporated on production airplanes -5584 and On.

REASON

Certain flight conditions can cause tachometer feedback noise that results in an autopilot disconnect. This can occur during rapid descent after prolonged time at high altitude. The addition of a servo end cap will reduce the tachometer feedback noise and provides smoother autopilot operation.

DESCRIPTION

This service letter transmits Honeywell Service Bulletin 4006719-22-0019, SM-200 Servo Drive.

NOTE: The Honeywell Service Bulletin applies to the aileron, rudder and elevator servos.

COMPLIANCE

DISCRETIONARY. This service letter can be accomplished at the discretion of the owner.

MANPOWER

WORK PHASE	MAN-HOURS
Conversion	3.0
Testing	1.0

WARRANTY

Eligibility: Affected airplanes that were still within the Cessna five (5) year airframe warranty period on the original issue date of this service letter.

Parts: Authorized Citation Service Facilities, individual operators, or other maintenance facilities may submit a Credit Claim Form for the parts kit(s) required for accomplishment of this service letter, provided the work is completed and the claim submitted by the expiration date shown below.

Labor: Authorized Citation Service Facilities may submit a Credit Claim Form for accomplishment of this service letter, on eligible airplanes, provided the work is completed and the claim submitted by the expiration date shown below.

Expiration: Jul 31/2007

MATERIAL - Cost and Availability

The parts listed in Honeywell's Service Bulletin are to be ordered from Cessna Aircraft Company, Citation Parts Distribution, 7121 Southwest Boulevard, Wichita, Kansas 67215, USA. Telephone number 1-800-835-4000 or 316-517-6273.

REFERENCES

Cessna Model 560XL (Excel) Maintenance Manual

Honeywell Service Bulletin 4006719-22-0019, SM-200 Servo Drive

PUBLICATIONS AFFECTED

Cessna Model 560XL (Excel) Illustrated Parts Catalog

ACCOMPLISHMENT INSTRUCTIONS

1. Prepare the airplane for maintenance.
 - A. Make sure that all switches are in the OFF/NORM position.
 - B. Disconnect electrical power from the airplane.
 - (1) Disconnect the airplane battery.
 - (2) Disconnect external electrical power.
 - C. Attach maintenance warning tags to the battery and external power receptacle that have "**DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS**" written on them.
2. Do the steps that follow for the Aileron Servo.
 - A. Remove access panel 314AR to get access to the aileron servo. (Refer to the Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
 - B. Complete the attached Honeywell Service Bulletin 4006719-22-0019, SM-200 Servo Drive.
 - C. Install access panel 314AR. (Refer to the Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
3. Do the steps that follow for the Rudder and Elevator Servos.
 - A. Remove access panel 321ABC to get access to the rudder and elevator servos. (Refer to the Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
 - B. Complete the attached Honeywell Service Bulletin 4006719-22-0019, SM-200 Servo Drive.
 - C. Install access panel 321ABC. (Refer to the Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
4. Remove maintenance warning tags and connect the airplane battery.
5. Record that this service letter has been completed.
 - A. Complete a Maintenance Transaction Report.
 - B. Put a copy of the completed Maintenance Transaction Report in the airplane logbook.
 - C. Send a copy of the completed Maintenance Transaction Report to: CESCO, P.O. Box 7706, Wichita, KS 67277.

Honeywell

Honeywell International Inc.
Commercial Electronic Systems
5353 W. Bell Rd.
Glendale, AZ 85308-3912
U.S.A.
(CAGE 55939)

Service Bulletin

**AUTOFLIGHT — FLIGHT CONTROLS — SM-200 Servo Drive (Servo Drive)
— Conversion of Servo Drive, Part No. 4006719-903, -904, -906, and -910
to Part No. 4006719-918, -919, -921, and -922 Respectively; Adds Servo
End Cap to Provide Smoother Auto Pilot Operation**

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Transmittal Information

Honeywell Pub. No. A21-1146-010

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SERVICE BULLETIN

SM-200 Servo Drive / Base Part No. 4006719

Summary

This is the initial release of Service Bulletin ATA No. 4006719-22-0019 (Pub. No. A21-1146-010).

NOTE: The acronyms and abbreviations used in this Service Bulletin are identified in Appendix A.

Revision History

This Service Bulletin, ATA No. 4006719-22-0019 (Pub. No. A21-1146-010), has had no revisions as summarized in Table 1.

Table 1. Service Bulletin Revisions

Revision	Date of Release
Initial Release	7 April 2005

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SERVICE BULLETIN

SM-200 Servo Drive / Base Part No. 4006719

1. Planning Information

A. Effectivity

This Service Bulletin, ATA No. 4006719-22-0019 (Pub. No. A21-1146-010), is applicable to SM-200 Servo Drive (Servo Drive), Part No. 4006719-903, -904, -906, -910, to be converted to Part No. 4006719-918, -919, -921, -922 respectively.

B. Concurrent Requirements

No other modification must be completed before the conversion given in this Service Bulletin.

C. Reason

Certain flight conditions can cause tachometer feedback noise that results in unsatisfactory flight characteristics or an autopilot disconnect. This can occur during rapid descent after prolonged time at high altitude. The addition of a servo end cap will reduce the tachometer feedback noise and provide smoother autopilot operation.

D. Description

A servo end cap is attached over the tachometer. The part number identification is changed and a test is performed.

E. Compliance

This conversion is optional; it is the individual operator's decision if this conversion is necessary.

F. Approval

The conversion information herein meets the requirements of TSO. Installation on a specific airframe may require a change to the airframe type design data. Contact the Type Certificate (TC) or Supplemental Type Certificate (STC) holder to determine effect on type design data.

G. Manpower

This conversion can be completed in approximately 3.0 hour when done at the same time as other repair and testing operations. Approximately 1.0 more hour are necessary for testing.

H. Weight and Balance

The net total change in weight of the Servo Drive is +0.1 pound (0.045 kg).

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not applicable.

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K. References

NOTE: An electronic distribution system that allows you to search, view, and download Honeywell technical publications is available at the following web site:
<https://pubs.cas.honeywell.com/>

The documents that follow are necessary to complete this conversion. Unless specified differently, subsequent revisions can be used.

- ATA No. 22-11-50 (Pub. No. A09-1146-004), Component Maintenance Manual (CMM), SM-200 Servo Drive, Revision 10 with Temporary Revision 1.
- Doc. No. IT4006719, Integrated Test Specification (IT), Integrated Test Specification for SPZ-200 Servo, Part No. 4006719, Revision AT.

This document is for reference only and is not necessary to do this conversion. Unless specified differently, subsequent revisions can be used.

- Pub. No. A09-1100-004, Instruction Manual (IM), Standard Repair Procedures for Honeywell Avionics Equipment Instruction Manual, Revision 6.

L. Other Publications Affected

ATA No. 22-11-50 (Pub. No. A09-1146-004), CMM, SM-200 Servo Drive, will be revised as a consequence of this Service Bulletin.

Airworthiness analysis is not affected.

Testing is not affected.

M. Interchangeability or Intermixability of Parts

Not applicable.

N. Service Bulletin License Agreement

Figure 1 of this Service Bulletin shows the Service Bulletin License Agreement.

NOTE: If the conversion described in this Service Bulletin is done at a location other than a Honeywell Service Center, complete and return a copy of the Customer Support Service Report (Appendix A of the Honeywell Service Bulletin License Agreement).

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Honeywell Service Bulletin License Agreement

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9. CONTROLLING LAW This agreement constitutes the entire agreement between the parties with respect to the use of this software. This agreement shall be governed and construed in accordance with the laws of the State of New York.

ID-134864

Figure 1 (Sheet 1 of 2). Honeywell Service Bulletin License Agreement

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Appendix A to the Honeywell Service Bulletin License Agreement Customer Support Service Report

*LRU/SRU Model/Nomenclature: _____

*LRU/SRU Part No. (Prior to Conversion/Modification): _____

*LRU/SRU Part No. (After Conversion/Modification): _____

*LRU/SRU Serial No.: _____

Hardware/Software MOD Letter (Prior to Conversion/Modification): _____

Hardware/Software MOD Letter (After Conversion/Modification): _____

*Aircraft Type: _____

Aircraft Serial No.: _____

Company Name and Address (End User): _____

*Company Name, Address, Phone No. (Service Provider): _____

* Signature: _____ *Date: _____

Honeywell Internal Use Only

SAR No.: _____

QDS Customer No.: _____

Mail or Fax Completed Form to:

Honeywell
Acrospacc Electronic Systems
Attn: Order Management
P.O. Box 21111
Phoenix, AZ 85036-1111

Fax: 1-602-822-7272

*Required Information Fields

ID-134883

Figure 1 (Sheet 2 of 2). Honeywell Service Bulletin License Agreement

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2. Material Information

A. Material — Price and Availability

Use the data that follows to contact Honeywell for necessary documentation or current material prices, availability and lead-times.

Honeywell
Aerospace Electronic Systems
Attn: Customer Response Center
P.O. Box 21111
Phoenix, AZ 85036-1111
U.S.A.

Phone: 1-877-484-2979
Fax: 1-602-822-7272
International Direct Dial Phone: 1-602-436-0272

NOTE: Registered Global Material Services (GMS) users can order material at <https://gms.cas.honeywell.com>. Click on "Customer Applications".

This conversion will be done for no charge to existing Customers for 24 months after the initial release date of this Service Bulletin. After that time, the price will be as quoted at the time of order.

The parts necessary to do this conversion will be supplied by Honeywell for no charge to existing Customers for 24 months after the initial release date of this Service Bulletin. After that time, parts will be available for the price given at the time of order. When requesting parts, send a no-charge purchase order that refers to this Service Bulletin, ATA No. 4006719-22-0019 (Pub. No. A21-1146-010) — FOC. The purchase order must include only the applicable parts listed in Table 2 of this Service Bulletin.

B. Industry Support Information

After this conversion is completed, a maximum of 3.0 hour for labor will be reimbursed by Honeywell for a maximum of 24 months after the initial release date of this Service Bulletin. To get reimbursement, a labor claim must be sent to Honeywell after each Servo Drive is modified. Parts are supplied for no charge to existing Customers if ordered less than 24 months after the initial release date of this Service Bulletin. The price for parts ordered after that time will be the price given at the time of order.

If this conversion was done less than 24 months after the initial release date of this Service Bulletin and was the only work done on the Servo Drive, a maximum of 1.0 more hour for labor to test the Servo Drive will be reimbursed by Honeywell not to exceed Honeywell's current reimbursement labor rate or as per agreement or contract.

To get reimbursement after the conversion of each Servo Drive is completed, send a labor claim to Honeywell. The invoice must be sent less than 60 days after the authorized work was completed.

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Use the data that follows to submit warranty labor claims after this Service Bulletin is completed:

Honeywell
Aerospace Electronic Systems
Attn: Warranty Administration
P.O. Box 21111
Phoenix, AZ 85036-1111
U.S.A.

Fax: 1-602-436-1500

C. Material Necessary for Each Component

If the conversion described in this Service Bulletin is done at a location other than a Honeywell Service Center, complete and return a copy of the Customer Support Service Report (Appendix A of the Honeywell Service Bulletin License Agreement) found in Paragraph 1.N. of this Service Bulletin. The form must be completed and returned before parts are shipped from Honeywell.

The items listed in Table 2 are necessary to do this Service Bulletin.

Table 2. Operator-Purchased Material

New Part Number	Keyword	Old Part Number	Qty	List Price	Instructions/Disposition
7035737	Servo Cap	N/A	1	N/C	4
7000652-103	Name Plate	7000652-103	1	N/C	1, 2, 4
4005679-1	Motor	4005679-1	A/R	N/C	1, 3, 4
7015354-3	Solder splice	7015354-3	A/R	N/C	1, 3, 4

A/R = As Required
N/A = Not Applicable
N/C = No Charge

INSTRUCTIONS/DISPOSITION:

- (1) The disposition of old parts is at the Customer's discretion or local regulatory authority.
- (2) Honeywell does not supply blank plates. The dash number, serial number, and weight of the Servo Drive must be given when you order this part. Do not specify any MOD letters.
- (3) Only ordered if replacement is required based on Paragraph 3.B.
- (4) Various lead-times are necessary to procure parts. Contact the Customer Response Center (refer to Paragraph 2.A. of this Service Bulletin) or your local Honeywell Service Center for schedules, current prices, and parts availability.

The sundry items listed in Table 3 are necessary to do this Service Bulletin. The items are commercially available and should not be ordered as part of this Service Bulletin.

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WARNING: BEFORE YOU USE A MATERIAL, REFER TO THE MANUFACTURER'S MATERIAL SAFETY DATA SHEETS FOR SAFETY INFORMATION. SOME MATERIALS CAN BE DANGEROUS.

CAUTION: DO NOT USE MATERIALS THAT ARE NOT EQUIVALENT TO MATERIALS SPECIFIED BY HONEYWELL. MATERIALS THAT ARE NOT EQUIVALENT CAN CAUSE DAMAGE TO THE EQUIPMENT AND CAN VOID THE WARRANTY.

NOTE: Equivalent alternatives are permitted for materials in Table 3.

NOTE: A Honeywell Material Number (HMN) comes before the identification of materials. The Supplier CAGE code is given in parentheses () after the Supplier location.

Table 3. Operator-Supplied Material

Part/Specification Number	Qty	Keyword
HMN 9722878	A/R	Sealant, two part-compound — (PR-1440, Type II, Class B-1/2, per MIL-S-8802); Courtaulds Aerospace, Glendale, CA (CAGE 83574)
HMN 1130778	A/R	Solvent — Isopropyl alcohol (99%), semigrade - Grade A; Optional source
HMN 60C9503	A/R	Ink, permanent marker, black - No. 37001 Sharpie ultra fine point per ASTM D-4236; Sanford Corp, Bellwood, IL (CAGE 86874)
HMN 5704624-C See Note	A/R	Wire, high temperature, insulated, electrical, AWG 24, WHT-BLK-ORN (MIL-W-16878/4); Belden Wire and Cable Co, Fort Mill, SC (CAGE 28581)
HMN 9730478 See Note	A/R	Retaining/staking compound (MIL-S-22473, grade CV) — Grade CV; Loctite Corp, Rocky Hill, CT (CAGE 05972)
HMN 9731178 See Note	A/R	Primer for retaining compound, ready-to-use, quick (MIL-S-22473, grade T, form R) — Locquic Grade T; Loctite Corp, Rocky Hill, CT (CAGE 05972)
HMN 6105378 See Note	A/R	Grease, wide temperature range, general purpose, aircraft (MIL-G-81322) — MOBILEGREASE 28; Mobil Chemical Co, Chemical Coatings Div, Azusa, CA (CAGE 60798)

A/R = As Required

NOTE: Only ordered if motor replacement is required. See Paragraph 3.B.

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D. Material Necessary for Each Spare

Same as Paragraph 2.C., Material Necessary for Each Component.

E. Reidentified Parts

Not applicable.

F. Tooling — Price and Availability

Other than what is specified in the documents listed in Paragraph 1.K. of this Service Bulletin, no special equipment is necessary to do this conversion.

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3. Accomplishment Instructions

A. General Information

WARNING: USE SOLVENTS WITH ADEQUATE VENTILATION. AVOID INHALATION OF VAPORS OR EXPOSURE OF FUMES TO FLAME.

CAUTION: THE SERVO DRIVE CONTAINS ESDS ITEMS. USE PROTECTIVE PROCEDURES.

NOTE: The paragraph, item, table, and/or figure numbers given in this Service Bulletin are found in SM-200 Servo Drive CMM, ATA No. 22-11-50 (Pub. No. A09-1146-004), unless specified differently.

NOTE: Keep all hardware for use in assembly. Refer to the DISASSEMBLY, REPAIR, and ASSEMBLY sections of the SM-200 Servo Drive CMM, ATA No. 22-11-50 (Pub. No. A09-1146-004), for procedures and precautions, and the ILLUSTRATED PARTS LIST (IPL) for component identification and location. Observe all CAUTIONS and WARNINGS.

NOTE: Obey standard, established local shop practices during Servo Drive conversion unless specified differently.

NOTE: Remove servo motor from aircraft use the Cessna OEM Maintenance Manual.

B. Inspection

(1) Verify that the Servo Drive motor (175, IPL Figure 1) is marked with the word "Tamagawa". If it is, then go to Paragraph 3.C.

NOTE: Servo Drive must be returned to a Honeywell Service Center or Honeywell-authorized repair location for motor replacement.

(2) If the motor (175) is not marked with the word "Tamagawa" then replace it with Part No. 4005679-1. Refer to the ASSEMBLY section of the CMM, ATA No. 22-11-50 (Pub. No. A09-1146-004).

(a) When installing the motor (175) in the housing (325), do not apply silicone thermal compound to mounting surfaces of the motor even if the compound is referenced in the CMM ASSEMBLY section step.

C. Preparation

(1) Use isopropyl alcohol (HMN 1130778) to clean the end of the motor (175) completely of all contaminants that would prevent the sealant from adhering.

(2) Use isopropyl alcohol (HMN 1130778) to clean inside surfaces of the servo cap, Part No. 7035737.

D. Modification

(1) Apply a continuous bead of sealant (HMN 9722878) around the outside circumference at the end of the motor (175). See Figure 2

(a) Do not apply sealant to the flat circular end surface of motor (175).

(b) Do not apply sealant at the end of the motor where it mounts to the housing (325).

(2) Apply a continuous bead of sealant (HMN 9722878) around the inside circumference of the servo cap mounting surface, Part No. 7035737. See Figure 2.

(a) Do not apply sealant to the inside flat circular area of the servo cap.

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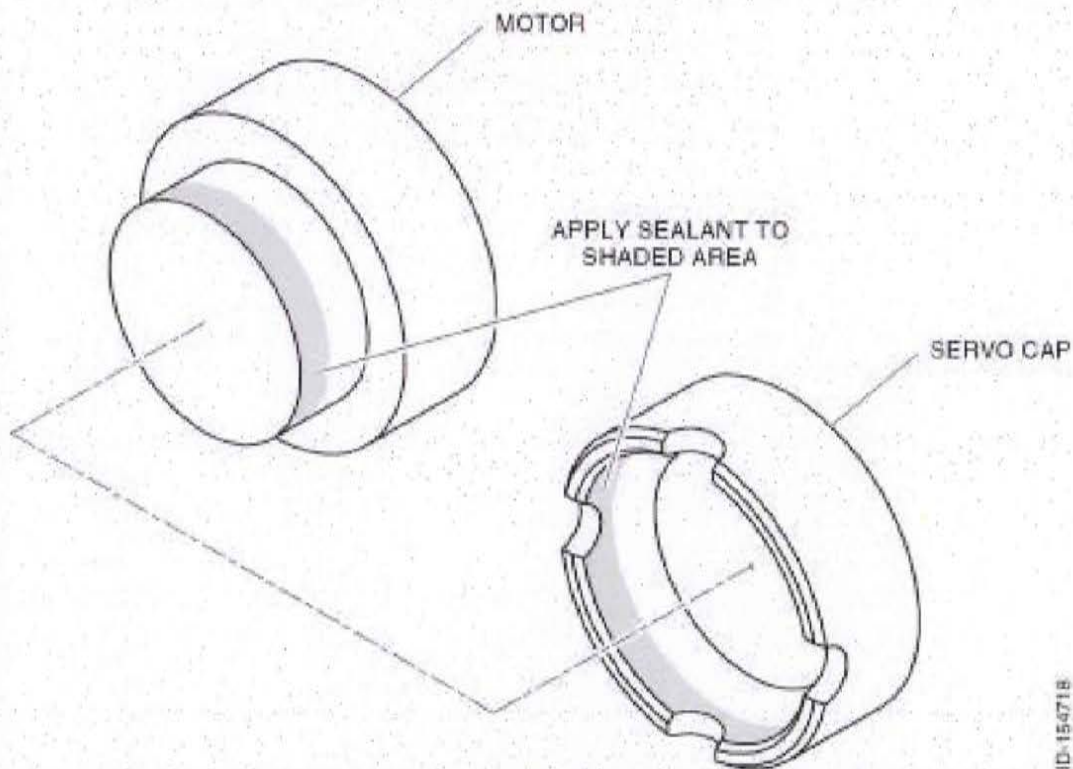


Figure 2 (Sheet 1 of 1). Servo Cap and Motor Sealant Application

- (3) Slide the servo cap over the end of the motor (175). Align the four cut outs with four screws on the motor and press down until the servo cap contacts the end of the motor. Make sure that there are no air pockets in the sealant between the servo cap and the motor.
- (4) Apply a small amount of sealant (HMN 9722878) to the counter bore in the center of the servo cap.
- (5) Allow sealant to cure. A complete cure is accomplished in three hours at room temperature followed by 24 hours at 80° F, or 12 hours at 100° F, or six hours at 120° F. Refer to the Standard Repair Procedures Instruction Manual, Pub. No. A09-1100-004.

E. Shop Modification Status Marking

NOTE: The following marking instructions only apply to a Honeywell Service Center or Honeywell-authorized repair location. If the Servo Drive is converted on the aircraft, go to Paragraph 3.F. for identification plate instructions.

- (1) Copy the serial number from the existing identification plate to the new identification plate, Part No. 7000652-103.
- (2) Put the new converted dash number on the identification plate. See Table 4 for the converted dash numbers.

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Table 4. Converted Dash Numbers

From	To
-903	-918
-904	-919
-906	-921
-910	-922

- (3) Write the weight on the new identification plate. See Table 5 for the correct new weight.

Table 5. Servo Weight

MOD A thru MOD C	MOD D and Higher
5.1 lbs max	4.5 lbs max

- (4) Remove the existing identification plate. Do not discard.
- (5) Use established shop practices to clean the area.
- (6) Install the new identification plate in the same location as the old plate.
- (7) Use black ink (HMN 60C9503) to copy the modification status from the old plate to the new plate. Discard the old plate.

F. Customer Site Modification Status Marking

NOTE: The following marking instructions only apply to units that are converted on the aircraft.

NOTE: Honeywell does not supply blank plates. The dash number, serial number, and weight of the Servo Drive must be given when you order Part No. 7000652-103. Do not specify any MOD letters.

- (1) Remove the existing identification plate. Do not discard.
- (2) Clean the area use established shop practices.
- (3) Install the new identification plate in the same location as the old plate.
- (4) Use black ink (HMN 60C9503) to copy the modification status from the old plate to the new plate. Discard the old plate.

G. Shop Testing

NOTE: It is necessary to test the Servo Drive only if it was converted at a Honeywell Service Center or Honeywell-authorized repair location. It is not necessary to test the Servo Drive if it is converted on the aircraft.

- (1) Test the Servo Drive (Part No. 4006719-918, -919, -921, -922). Refer to the IT in Paragraph 1.K.

H. Customer Site Modification Servo Installation and Testing

- (1) Re-install servo in aircraft use Cessna OEM Maintenance Manual Procedures.
- (2) Apply avionic power and ensure that no Autopilot related failure message or annunciation appear.

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I. Verification

- (1) If the conversion described in this Service Bulletin was done at a location other than a Honeywell Service Center, make sure that the data sent to Honeywell was accurate on the Customer Support Service Report (Appendix A of the Honeywell Service Bulletin License Agreement) found in Paragraph 1.N. of this Service Bulletin. Make sure that all serial numbers were accurate.

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Appendix A Acronyms and Abbreviations

The acronyms and abbreviations used by Honeywell are identified in the List of Acronyms and Abbreviations that follows:

Table A-1. List of Acronyms and Abbreviations

Term	Term Definition
ATA	Air Transport Association
A/R	as required
CAGE	Commercial and Government Entity
CMM	component maintenance manual
ESDS	electrostatic discharge sensitive
GMS	Global Material Services
HMN	Honeywell material number
IPL	illustrated parts list
in.	inch
inHg	conventional inch of mercury
IT	integrated test specification
MOD	modification
No.	number
PPI	prepare, package, and inspect
Pub.	publication
Qty	quantity
U.S.	United States

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