

SERVICE BULLETIN

**Beechcraft
Hawker**

Kit No. 132-9100-0001/-0002

TITLE: NACELLES - ENGINE COWLING FASTENER MODIFICATION

1. Planning Information

A. Effectivity

(1) Airplanes

(a) Civil

Raytheon Aircraft Model 400 Beechjet, Serials RJ-1 through RJ-65;

Raytheon Aircraft Model 400A Beechjet, Serials RK-1 through RK-353;

Raytheon Aircraft Model 400A (Hawker 400XP), Serials RK-354 through RK-499.

(b) Military

Raytheon Aircraft Model 400T (T-1A) Beechjet, Serials TT-1 through TT-180;

Raytheon Aircraft Model 400T (TX) Beechjet, Serials TX-1 through TX-13.

If you are no longer in possession of the airplane, please forward this information to the present owner.

(2) Spares

All customer held spare engine cowlings require modification in accordance with Kit No. 132-9100-0001/-0002.

B. Reason

This Service Bulletin is being issued to require a modification to the engine cowling attachment hardware to provide threaded fasteners at specific locations on the engine cowling panels. Three reports have been received related to cowling panel separations. Aerodynamic forces acting on unsecured cowlings could cause panel separation or damage to the engine and nacelle components. If the separated panel were to

The export of these commodities, technology or software are subject to the US Export Administration Regulations. Diversion contrary to U.S. law is prohibited. For guidance on export control requirements, contact the Commerce Department's Bureau of Export Administration at 202-482-4811 or at www.bxa.doc.gov.

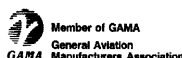
Raytheon Aircraft Company (RAC) issues Service Information for the benefit of owners and fixed base operators in the form of two classes of Service Bulletins. The first class, Mandatory Service Bulletins (red border) includes changes, inspections and modifications that could affect safety or crashworthiness. RAC also issues Service Bulletins with no red border which are designated as either recommended or optional in the compliance section within the bulletin. In the case of recommended Service Bulletins, RAC feels the changes, modifications, improvements or inspections will benefit the owner/operator and although highly recommended, Recommended Service Bulletins are not considered mandatory at the time of issuance. In the case of Optional Service Bulletins, compliance with the changes, modifications, improvements or inspections is at the owner/operator's discretion.

Both classes are mailed to:

- (a) RAC Authorized Service Centers.
- (b) Owners of record on the FAA Aircraft Registration Branch List and the RAC International Owner Notification/Registration Service List.
- (c) Those having a publications subscription.

Information on Owner Notification Service or subscription can be obtained through any RAC Authorized Service Center. As Mandatory Service Bulletins and Service Bulletins are issued, temporary notification in the Service Bulletin Master Index should be made until the index is revised. Warranty will be allowed only when specifically defined in the Service Bulletin and in accordance with the RAC Warranty Policy.

Unless otherwise designated, RAC Mandatory Service Bulletins, Service Bulletins and RAC Kits are approved for installation on RAC airplanes in original or RAC modified configurations only. RAC Mandatory Service Bulletins, Service Bulletins and Kits may not be compatible with airplanes modified by STC installations or modifications other than RAC approved kits.



SERVICE BULLETIN

strike on or near flight control surfaces, airplane control could be impaired. Additionally, an in-flight panel separation could cause injury to person(s) and/or property damage on the ground.

C. Description

This service bulletin introduces Kit No. 132-9100-0001/-0002 which modifies the engine inlet and cowling assemblies and replaces five specific 1/4-turn fastener assemblies on each engine cowling with screws and nutplates.

D. Compliance

An Airworthiness Directive will be requested on the matter covered by this Service Bulletin.

(1) Civil Airplanes

Raytheon Aircraft Company considers this to be a mandatory modification and it should be accomplished at the next scheduled inspection after receipt of this Service Bulletin or the next 200 flight hours, whichever occurs first.

(2) Military Airplanes

For compliance information on military airplanes affected by this Service Bulletin, contact the appropriate headquarters.

E. Approval

The engineering data contained in this Service Bulletin is FAA approved.

F. Manpower

The following information is for planning purposes only:

Estimated man-hours per engine: 5 hours.

Suggested number of men: 1 man.

The above is an estimate based on experienced, properly equipped personnel complying with this Service Bulletin. Occasionally, after work has started, conditions may be found which could result in additional man-hours.

G. Weight and Balance

Negligible.

It is the responsibility of the owner/operator to maintain compliance with the applicable Airworthiness Regulations.

H. Electrical Load Data

Not changed.

I. Software Accomplishment Summary

Not applicable.

SERVICE BULLETIN

J. References

Appropriate chapters of applicable Raytheon Aircraft Hawker Beechjet 400/400A Structural Repair Manual, P/N 128-590001-17C6 or subsequent revision, Chapter 51;

Appropriate chapters of applicable U.S. Air Force Technical Orders;

Appropriate chapters of applicable JDA Manuals;

Raytheon Aircraft T-1A Model Series Communique T-1A MSC 03-009R3;

U. S. Air Force Time Compliance Technical Order (TCTO) TO 1T-1A-693D and subsequent supplements.

K. Publications Affected

It is recommended that a note "See Service Bulletin No. 54-3788" be made in the following:

Appropriate chapters of applicable JDA Manuals;

Raytheon Aircraft Hawker Beechjet 400/400A Illustrated Parts Catalog, P/N 128-590001-11G or subsequent revision, Chapter 71;

L. Interchangeability of Parts

Not applicable.

M. Warranty Credit

(1) Civil Airplanes

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

Warranty coverage offered in this Service Bulletin will expire 18 months from the last day of the month this Service Bulletin is issued. After that date, the owner/operator assumes the responsibility for compliance cost. Raytheon Aircraft Company reserves the right to void warranty coverage in the area affected by this Service Bulletin until the date the Service Bulletin is accomplished by a Raytheon Aircraft Company Authorized Service Center.

All warranty work must be accomplished by a Raytheon Aircraft Authorized Service Center rated to perform maintenance on the specific model of Beechcraft Airplane.

All warranty reimbursements are handled through Raytheon Aircraft Company Authorized Service Centers. The owner/operator should arrange for an Authorized Service Center to perform the work and the Authorized Service Center must submit the standard Raytheon Aircraft Company warranty claim.

(2) Military Airplanes

For warranty information on military airplanes affected by this Service Bulletin, contact the appropriate headquarters.

SERVICE BULLETIN

2. Material Information

A. Materials - Price and Availability

Contact a Raytheon Aircraft Authorized Service Center for information.

B. Industry Support

Not applicable.

C. Airplanes

- (1) The following information only kit may be ordered through a Raytheon Aircraft Authorized Service Center or RAPID:

Part Number	Description	Quantity Per Airplane
132-9100-0001/-0002	Copy of Drawing, Kit - Fastener Modification, Inlet Duct Assembly	1

Raytheon Aircraft Company expressly reserves the right to supersede, cancel and/or declare obsolete, without prior notice, any kits, parts or publications that may be referenced in this Service Bulletin.

CAUTION

All Raytheon Aircraft approved kits, unless otherwise designated, are approved for installation on Raytheon Aircraft airplanes in original or Raytheon Aircraft approved modified configurations only. Raytheon Aircraft approved kits may not be compatible with airplanes modified by STC installations or modifications other than Raytheon Aircraft approved kits.

- (2) The following materials are not contained in Kit No. 132-9100-0001/-0002 and may be fabricated or obtained locally:

Part Number	Description	Quantity Per Airplane
132-9100-9	Bracket	1, As Required
132-9100-5	Bracket	2, As Required
MS21075L3N	Nutplate	3, As Required
MS24693C274*	Screw	10, As Required
MS20427M3-4	Rivet	20, As Required
MS20427M3-3	Rivet	6, As Required

SERVICE BULLETIN

Part Number	Description	Quantity Per Airplane
FCM10F12CPG09WH*	Screw	10, As Required
A3235SS020-27*	Washer	10, As Required
A-A-58054 or equivalent	Abrasive Pad (Scotch Brite or equivalent)	As Required
ASTM D329	Acetone	As Required
TT-N-95, Type II	Aliphatic Naphtha	As Required
CCC-C-440 or A-A-1491	Cheesecloth, Cotton	As Required
MIL-DTL-81706, Class A in accordance with MIL-C-5541 (Alodine 1201 preferred)	Chemical Conversion Coating for Aluminum and Aluminum Alloys	As Required
MIL-PRF-23377 or MIL-P-8585	Epoxy Polyamide Primer	As Required
A-A-53513 or equivalent or P/N 187 7711 (Obtain from Eastman Kodak Company, 343 State Street, Rochester, NY 14650)	Gloves, Polyethylene, Industrial, Solvent Handling	As Required
TT-I-735A	Isopropyl Alcohol	As Required
Obtain from Barton Solvents, Inc., 201 South Cedar, P. O. Box 366, Valley Center, KS 67147 or Eastman Chemical Company, Inc., P. O. Box 431, 100 North Eastman Road, Kingsport, TN 37662	Methyl Propyl Ketone (MPK)	As Required
* It is permissible to use MS24693C274 screw and A3235SS020-27 washer in lieu of FCM10F12CPG09WH screw.		

D. Spares

Refer to MATERIAL INFORMATION, paragraph 2.C. (1) and (2).

E. Reidentified Parts

None.

SERVICE BULLETIN

F. Tooling - Price and Availability

Not applicable.

3. Accomplishment Instructions

This Service Bulletin shall be accomplished as follows:

NOTE

Should any difficulty be encountered in accomplishing this Service Bulletin, contact Raytheon Aircraft Company at 1-800-429-5372 or 316-676-3140 for commercial aircraft, and appropriate headquarters for military aircraft.

A. Airplane

WARNING

Observe all Warnings and Cautions contained in the aircraft manuals referenced in this Service Bulletin.

Whenever any part of this system is dismantled, adjusted, repaired or renewed, detailed investigation must be made on completion to make sure that distortion, tools, rags or any other loose articles or foreign matter that could impede the free movement and safe operation of the system are not present, and that the systems and installations in the work area are clean.

PART I - COMMERCIAL AIRPLANES

- (1) Remove all power from the airplane and disconnect the battery. Display warning notices prohibiting reconnection of airplane electrical power.

NOTE

Following removal of existing fastener assemblies, prepare fastener installation surfaces in accordance with Chapter 51 of the Model 400/400A Structural Repair Manual, using the material identified in paragraph 2.C.(2) of MATERIAL INFORMATION.

- (2) Accomplish rework in accordance with procedures listed in Kit No. 132-9100-0001/-0002.
- (3) Reconnect the airplane battery, remove warning notices and restore power.
- (4) Ensure all work areas are clean and clear of tools and miscellaneous items of equipment.
- (5) Return airplane to service.

SERVICE BULLETIN

PART II - MILITARY AIRPLANES

- (1) For Model 400T (T-1A) airplanes, accomplish modification procedures in accordance with TCTO 1T-1A-693D and T-1A Model Series Communique 03-009R3 to modify the inlet duct assembly fasteners.
- (2) For Model 400T (TX) airplanes, accomplish modification procedures in accordance with applicable JDA publications and Kit No. 132-9100-0001/-0002 to modify the inlet duct assembly fasteners.

B. Spares

Accomplish this modification of customer held spares in accordance with procedures in Kit No. 132-9100-0001/-0002 and information provided in PART I and PART II of ACCOMPLISHMENT INSTRUCTIONS in this Service Bulletin, as applicable.

C. Record of Compliance

Upon completion of this Service Bulletin, make an appropriate maintenance record entry.