

TITLE

WINGS - INSPECT WING NACELLE KEELS FOR MISSING RIVETS

EFFECTIVITY**MODEL**

G58

SERIAL NUMBERSTH-2468, TH-2472 thru TH-2516, TH-2519,
TH-2520, TH-2522**REASON**

To inspect for missing rivets in the outboard wing nacelle keels and install if missing.

DESCRIPTION

This service letter provides parts and instructions to inspect for missing rivets in the outboard wing nacelle keels and install if missing.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at the next 100-hour or 12-month (annual-type) inspection.

A service document published by Textron Aviation may be recorded as *completed* in an aircraft log only when the following requirements are satisfied:

- 1) The mechanic must complete all of the instructions in the service document, including the intent therein.
- 2) The mechanic must correctly use and install all applicable parts supplied with the service document kit. Only with written authorization from Textron Aviation can substitute parts or rebuilt parts be used to replace new parts.
- 3) The mechanic or airplane owner must use the technical data in the service document only as approved and published.
- 4) The mechanic or airplane owner must apply the information in the service document only to aircraft serial numbers identified in the *Effectivity* section of the document.
- 5) The mechanic or airplane owner must use maintenance practices that are identified as acceptable standard practices in the aviation industry and governmental regulations.

No individual or corporate organization other than Textron Aviation is authorized to make or apply any changes to a Textron Aviation-issued service document or flight manual supplement without prior written consent from Textron Aviation.

Textron Aviation is not responsible for the quality of maintenance performed to comply with this document, unless the maintenance is accomplished at a Textron Aviation-owned Service Center.

CONSUMABLE MATERIAL

You must use the consumable materials that follow, or their equivalent, to complete this service document.

January 9, 2020

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Textron Aviation Customer Service, P.O. Box 7706, Wichita, KS 67277, U.S.A. 1-316-517-5800

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NAME	NUMBER	MANUFACTURER	USE
Color Chemical Film Treatment	Alodine 1201	Textron Aviation Parts & Distribution 7121 Southwest Boulevard Wichita, KS 67215	To prepare aluminum surface for intermediate primer.
Epoxy Primer	MIL-PRF-23377	Textron Aviation Parts & Distribution 7121 Southwest Boulevard Wichita, KS 67215	Final finish for aluminum.

TOOLING

No specialized tooling is required to complete this service document.

REFERENCES

Beechcraft Baron Series Maintenance Manual

Beechcraft Baron Series 55/58 Illustrated Parts Catalog

PUBLICATIONS AFFECTED

None

ACCOMPLISHMENT INSTRUCTIONS

1. Prepare the airplane for maintenance.
 - A. Make sure that the airplane is electrically grounded.
 - B. Make sure that all switches are in the OFF/NORM position.
 - C. Disconnect electrical power from the airplane.
 - (1) Disconnect the airplane battery.
 - (2) Disconnect external electrical power.
 - D. 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. Remove the left and right engine cowlings.
3. Remove the engine fairings. (Refer to the 55/58 Illustrated Parts Catalog, Chapter 71, Engine Cowling With Air Conditioning.)
4. (Refer to Figure 1, Detail A, Detail B, View A-A, View B-B and Figure 1, Sheet 5 and Sheet 6.) Inspect the left wing inboard and outboard nacelle keel.
 - A. If all of the rivets shown are installed, go to Step 4.B.
 - (1) Make sure the eight rivets shown are installed.
 - (2) If any of the rivets are not installed, do the steps that follow:
 - (a) Remove the trough. (Refer to the 55/58 Illustrated Parts Catalog, Chapter 54, Nacelle Structure.)

NOTE: It may be necessary to remove the cushioned steel band clamps that attach the wire bundle to the aft side of the firewall to improve access for drilling and riveting.
 - (b) Layout and drill the Number 21 (0.159 inch-diameter) holes through the keel as required.
 - (c) Deburr the holes that were drilled.
 - (d) Apply Alodine 1201 Color Chemical Film Treatment to the holes that were drilled.
 - (e) Apply epoxy primer to the holes that were drilled.

- (f) Install the CR3523-5-03 Rivets wet with epoxy primer as required in the keel.

NOTE: It is permissible to use MS20470AD5-3 Rivets in locations where they can be used.

- (g) Reinstall any cushioned steel band clamps that may have been removed.
- (h) Install the trough. (Refer to the 55/58 Illustrated Parts Catalog, Chapter 54, Nacelle Structure.)

B. Do Step 4.A. for the right side.

- 5. Install the engine fairings. (Refer to the 55/58 Illustrated Parts Catalog, Chapter 71, Engine Cowling With Air Conditioning.)
- 6. Remove the maintenance warning tags and connect the airplane battery.
- 7. Install the left and right engine cowling.
- 8. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

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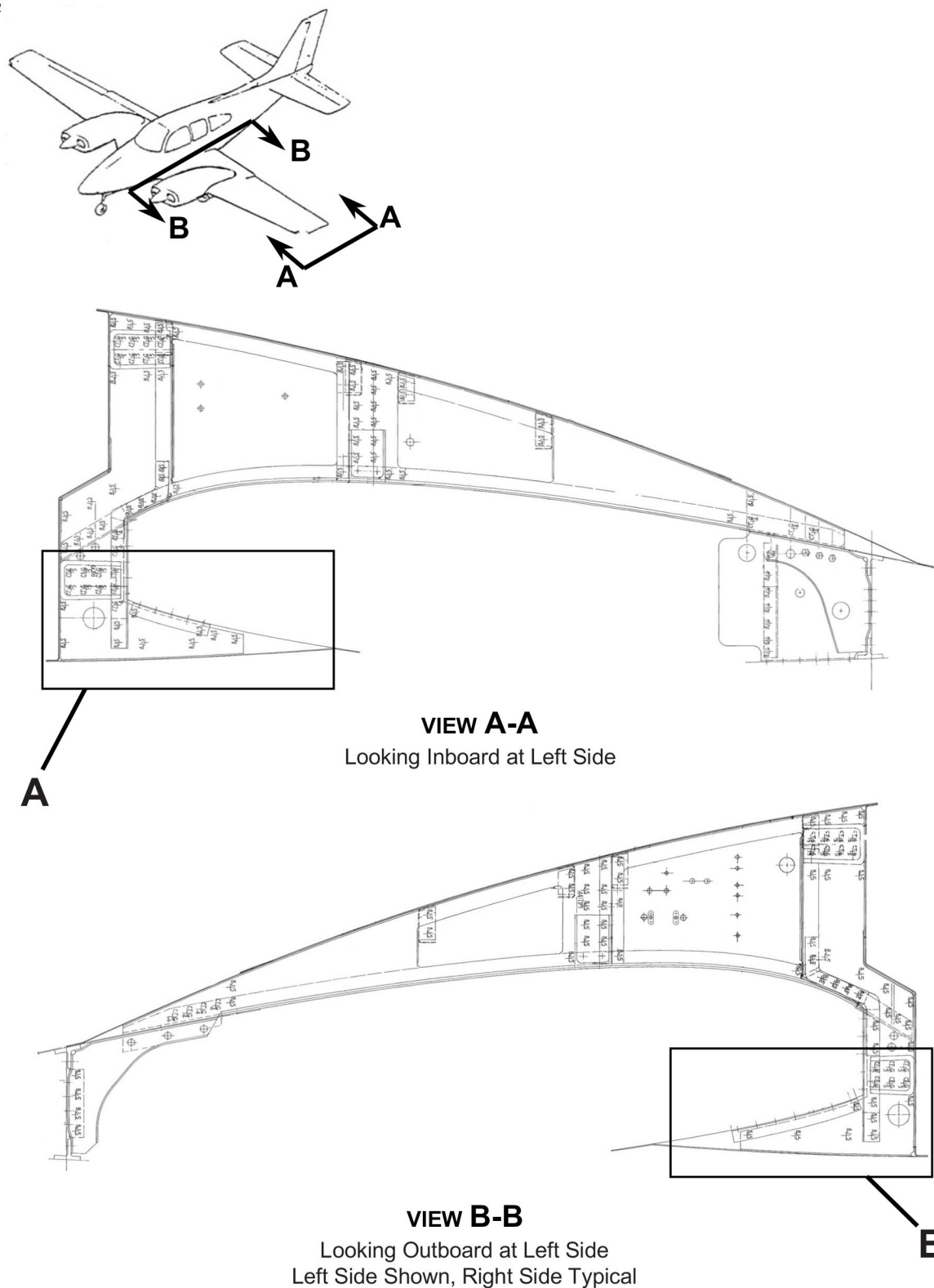
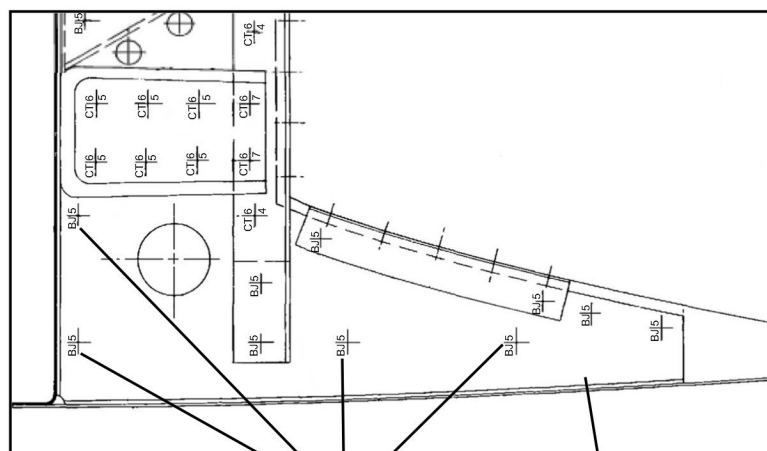


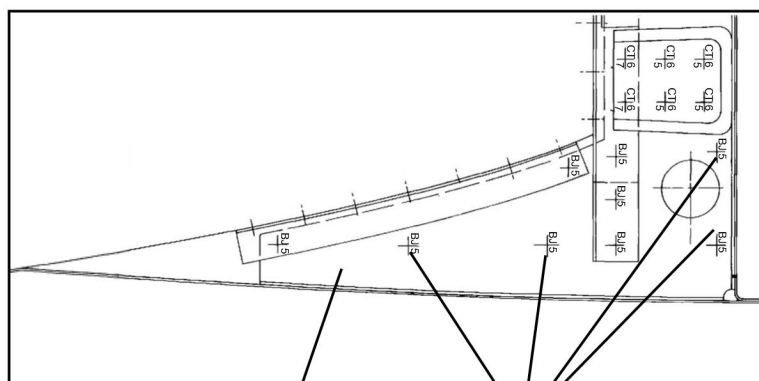
Figure 1. Keel Rivet Inspection (Sheet 1)

B21933



Number 21
(0.159 inch-diameter) Hole
CR3523-5-03
Rivet
(As Required)

Keel
(Reference)

DETAIL A

Keel
(Reference)

Number 21
(0.159 inch-diameter) Hole
CR3523-5-03
Rivet
(As Required)

DETAIL B

Left Side Shown,
Right Side Typical

Figure 1. Keel Rivet Inspection (Sheet 2)

B21936

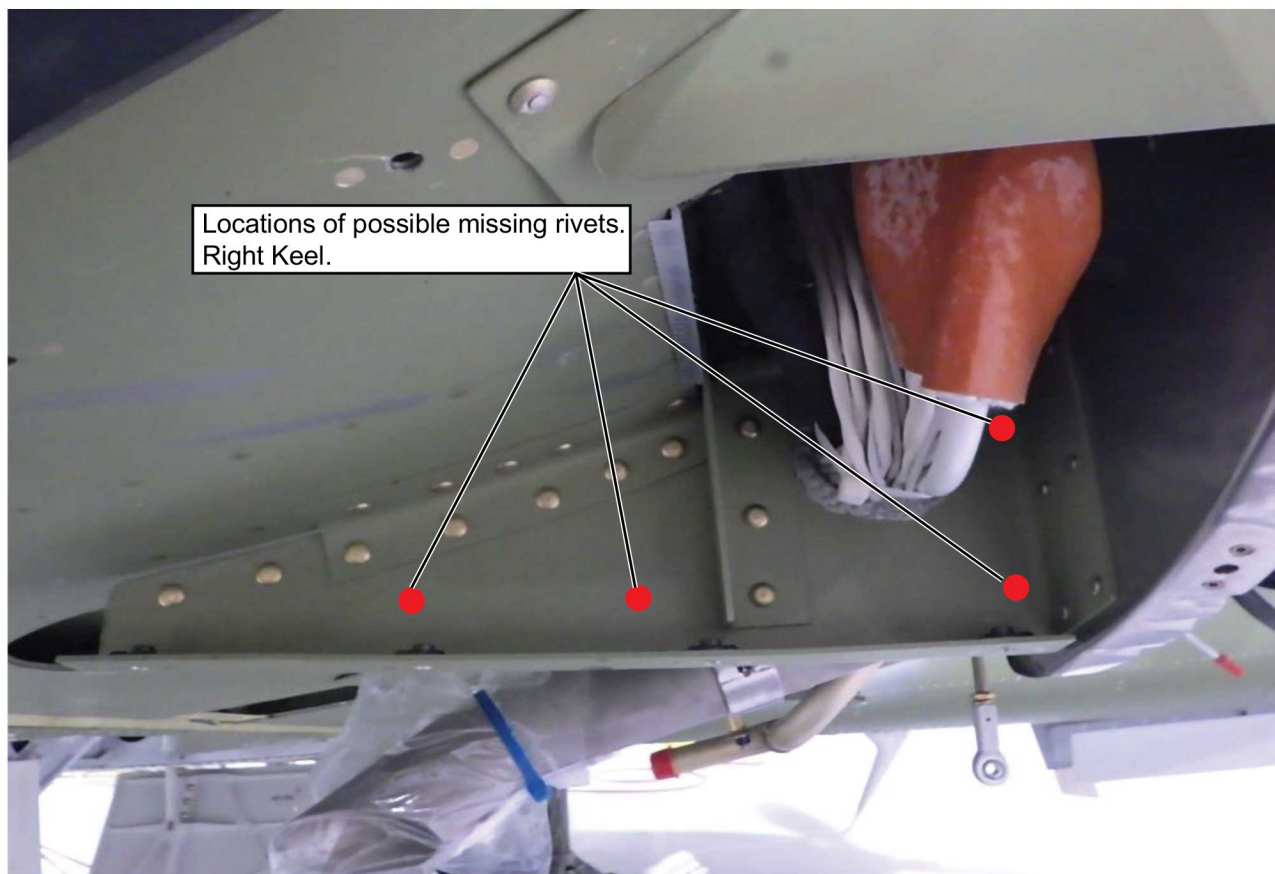


Figure 1. Keel Rivet Inspection (Sheet 3)

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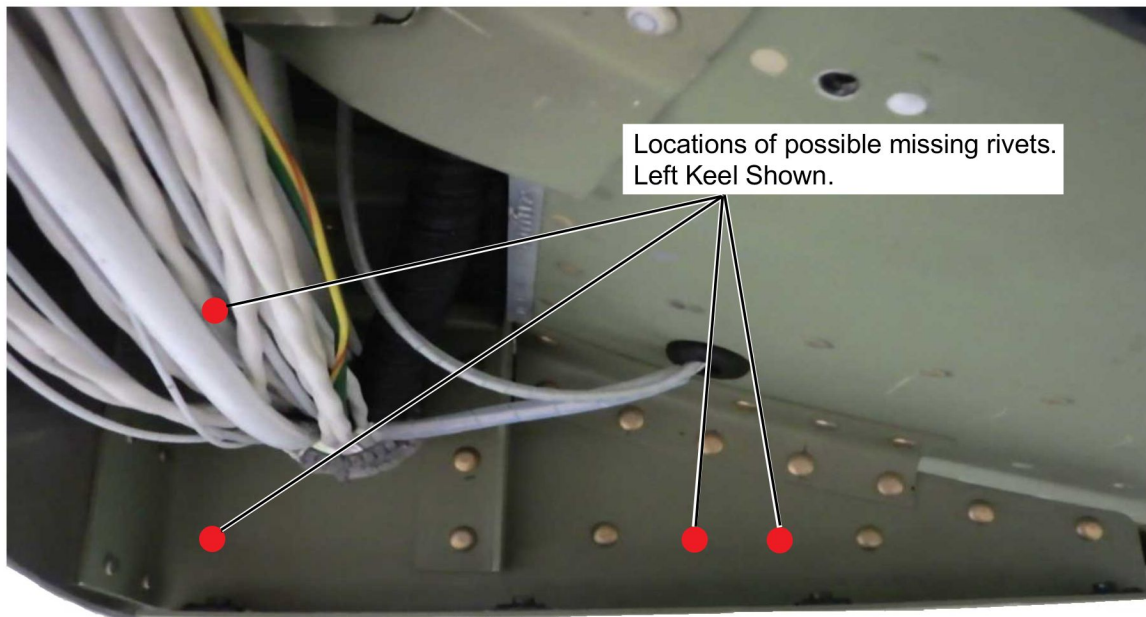


Figure 1. Keel Rivet Inspection (Sheet 4)

MATERIAL INFORMATION

Order the kit/parts below to install this modification.

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
CR3523-5-03	As Required	Rivet	Same	Discard

* Please contact Textron Aviation Parts Distribution for current cost and availability of parts listed in this service document. Phone at 1-800-835-4000 (Domestic) or 1-316-517-5603 (International). Send email to: parts@txtav.com.

Based on availability and lead times, parts may require advanced scheduling.

TITLE

WINGS - INSPECT WING NACELLE KEELS FOR MISSING RIVETS

TO:

Beechcraft Baron Model G58 Owner

REASON

To inspect for missing rivets in the outboard wing nacelle keels and install if missing.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at the next 100-hour or 12-month (annual-type) inspection.

LABOR HOURS

WORK PHASE	LABOR-HOURS
Test and Inspection	1.0
Modification	3.5

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
CR3523-5-03	*	*

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WARRANTY

This service document is *recommended*. Eligible airplanes may qualify for parts and labor coverage to the extent noted in the *Labor Hours* and *Material Availability* sections of this document.

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Eligibility: Airplanes identified within the serial number effectivity of this service document must have active Airframe warranty coverage on the original issue date of this document and the coverage must be active on the day the work is accomplished.

Parts Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities, operators, or other maintenance facilities may submit a claim for the parts required to accomplish this service document as defined in the *Material Availability* section of this document.

Labor Coverage: Textron Aviation-owned and Textron Aviation-authorized Service Facilities rated to perform maintenance on the specific model of Cessna Aircraft may submit a claim for the labor necessary to accomplish this service document as defined in the *Labor Hours* section of this document.

Credit Application: After this service document has been accomplished, a claim must be submitted to Textron Aviation within 30 days of the service document completion. Claims for compliance of this service document are to be filed as a W4 type claim.

Please submit your claim form online at ww2.txtav.com/Parts or email the completed Textron Aviation Claim Form to warranty@txtav.com. If submitted on-line a Return Authorization will be provided. If a paper claim is submitted your claim will be entered into the system and a Return Authorization will be sent to you.

The Return Authorization must accompany any required return parts (see *Material Availability*), to the point of purchase.

Parts to be returned to Textron Aviation Parts Distribution should be forwarded to:

Textron Aviation Parts Distribution
Warranty Administration
285 South Greenwich Road
Bldg B89, Docks 1-4
Wichita, KS 67206
USA

Expiration: January 9, 2021 (after this date the owner/operator assumes the responsibility for compliance costs)

Textron Aviation reserves the right to void continued airplane warranty coverage for the parts affected by this service document until the service document is accomplished.

NOTE: As a convenience, service documents are now available online to all our customers through a simple, free-of-charge registration process. If you would like to sign up, please visit the Customer Access link at www.txtavsupport.com to register.