STUB WING LOWER ATTACH FITTINGS INSPECTION/REPLACEMENT

EFFECTIVITY

<table>
<thead>
<tr>
<th>MODEL</th>
<th>YEAR</th>
<th>SERIAL NUMBERS</th>
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<td>335</td>
<td>1980</td>
<td>335-0001 thru 335-0065</td>
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<td>340</td>
<td>1972</td>
<td>340-0001 thru 340-0115</td>
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<td>340</td>
<td>1973</td>
<td>340-0151 thru 340-0260</td>
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<td>1974</td>
<td>340-0301 thru 340-0370</td>
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<td>340</td>
<td>1975</td>
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<td>1976</td>
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<td>340A0901 thru 340A1045</td>
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<td>340A1201 thru 340A1280</td>
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<td>1982</td>
<td>340A1501 thru 340A1543</td>
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<td>340A1801 thru 340A1817</td>
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DESCRIPTION

To provide fittings inspection and replacement instructions to enable compliance with the applicable Service/Maintenance Manual Supplemental Inspection Document (SID) inspections of the stub wing lower attach fittings.

APPROVAL

FAA approval has been obtained on technical data in this publication that affects airplane type design.

REFERENCE

MEB08-1

CHANGE IN WEIGHT AND BALANCE

Negligible
## SERVICE KIT

### MATERIAL INFORMATION

The parts that follow will be necessary for one Model 335 or 340 airplane:

<table>
<thead>
<tr>
<th>NEW P/N</th>
<th>QUANTITY</th>
<th>DESCRIPTION</th>
<th>OLD P/N</th>
<th>DISPOSITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>SK340-34</td>
<td>1</td>
<td>Kit, consisting of the following parts:</td>
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<tr>
<td></td>
<td></td>
<td>MS20426AD4-12</td>
<td>4</td>
<td>Rivet</td>
</tr>
<tr>
<td></td>
<td></td>
<td>MS21042L3</td>
<td>16</td>
<td>Nut</td>
</tr>
<tr>
<td></td>
<td></td>
<td>MS21042-4</td>
<td>12</td>
<td>Nut</td>
</tr>
<tr>
<td></td>
<td></td>
<td>MS21044N5</td>
<td>32</td>
<td>Nut</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Instructions</td>
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The parts that follow may be necessary for the inspection and replacement of the wing attach fittings:

<table>
<thead>
<tr>
<th>NEW P/N</th>
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<th>DESCRIPTION</th>
<th>OLD P/N</th>
<th>DISPOSITION</th>
</tr>
</thead>
<tbody>
<tr>
<td>AN320-10</td>
<td>If required</td>
<td>Nut</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>AN5-7A</td>
<td>If required</td>
<td>Bolt</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>MS20002C6</td>
<td>If required</td>
<td>Washer</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>MS20002-6</td>
<td>If required</td>
<td>Washer</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>MS21045L6</td>
<td>If required</td>
<td>Nut</td>
<td>Same</td>
<td>Discard</td>
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<tr>
<td>MS24665-355</td>
<td>If required</td>
<td>Nut</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>MS24694S151</td>
<td>If required</td>
<td>Screw</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>NAS1149F0563P</td>
<td>If required</td>
<td>Washer</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>NAS1149F1032P</td>
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<td>Washer</td>
<td>Same</td>
<td>Discard</td>
</tr>
<tr>
<td>NAS146-47</td>
<td>If required</td>
<td>Bolt</td>
<td>Same</td>
<td>Discard</td>
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<tr>
<td>NAS146-49</td>
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<td>NAS464P10L32</td>
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<tr>
<td>NAS6203-10</td>
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<tr>
<td>0811350-10</td>
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<td>Fitting, Lower Forward</td>
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<tr>
<td>5011020-4</td>
<td>If required</td>
<td>Laminated Shim</td>
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<td>Discard</td>
</tr>
<tr>
<td>5011024-2</td>
<td>If required</td>
<td>Fitting, Lower Aft</td>
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Some of the parts that follow will be necessary. Nominal, oversize, and next size fasteners part numbers are listed. Refer to Accomplishment Instructions for replacement fastener criteria.

<table>
<thead>
<tr>
<th>NEW P/N</th>
<th>QUANTITY</th>
<th>DESCRIPTION</th>
<th>OLD P/N</th>
<th>INSTRUCTIONS/ DISPOSITION</th>
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<tr>
<td>HL18PB8-7</td>
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<td>HL218-8-7</td>
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<tr>
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<td>Pin, HI-LOK</td>
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<td>Discard</td>
</tr>
<tr>
<td>HL18PB10-9</td>
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<td>Pin, HI-LOK</td>
<td>NAS1054-8-9</td>
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<td>HL18PB10-19</td>
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<td>Discard</td>
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<td>HL70-8</td>
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The materials that follow will be necessary:

<table>
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<tr>
<th>NAME</th>
<th>NUMBER</th>
<th>MANUFACTURER</th>
<th>USE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sealant (Semkit, 6 ounce)</td>
<td>U470519</td>
<td>Cessna Aircraft Company  Cessna Parts Distribution 5800 East Pawnee PO Box 1521 Wichita, KS 67218 USA</td>
<td>Used with installation of Hi-Loks</td>
</tr>
<tr>
<td>Aluminum</td>
<td>0.063-inch thick (Any type is acceptable)</td>
<td>Locally available</td>
<td>To make forward and aft fitting installation tools</td>
</tr>
<tr>
<td>Aluminum</td>
<td>0.50 thick, grind to approximately 0.437-inch thick. Use multiple sheets of aluminum if necessary. (Any type is acceptable)</td>
<td>Locally available</td>
<td>To make pads for forward fitting installation tool</td>
</tr>
</tbody>
</table>
SERVICE KIT

SK340-34

<table>
<thead>
<tr>
<th>Name</th>
<th>Number</th>
<th>Manufacturer</th>
<th>Use</th>
</tr>
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<tbody>
<tr>
<td>Alodine 1132</td>
<td>U074093</td>
<td>Cessna Aircraft Company</td>
<td>To apply to the shims and the lower forward fittings</td>
</tr>
<tr>
<td>Marker</td>
<td></td>
<td>Cessna Parts Distribution</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>5800 East Pawnee</td>
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</tr>
<tr>
<td></td>
<td></td>
<td>PO Box 1521</td>
<td></td>
</tr>
<tr>
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<td></td>
<td>Wichita, KS 67218</td>
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</tr>
<tr>
<td></td>
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<tr>
<td>Corrosion Resistant Primer</td>
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<td>Cessna Aircraft Company</td>
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<tr>
<td></td>
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<td>USA</td>
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</table>

The tool or equivalent that follows may be necessary:

<table>
<thead>
<tr>
<th>Name</th>
<th>Number</th>
<th>Manufacturer</th>
<th>Use</th>
</tr>
</thead>
<tbody>
<tr>
<td>Transfer Punch</td>
<td>3374A11 (3/32-1/2-inch set)</td>
<td>McMaster-Carr Supply Co. P.O. Box 4355 Chicago, Ill 60680-4355 Phone: (630) 833-0300 Email: <a href="mailto:chi.sales@mcmaster.com">chi.sales@mcmaster.com</a></td>
<td>To locate holes in new fittings</td>
</tr>
</tbody>
</table>

ACCOMPLISHMENT INSTRUCTIONS

1. Make sure that you refer to applicable sections of the maintenance/service manual while you do this service kit.

   **WARNING:** When you lower the flaps, make sure that the flap area is clear. If you lower the flaps and they hit personnel or equipment, you can cause personal injury to personnel or damage to the flaps and equipment.

2. Lower the flaps to the full down position.

3. Electrically ground the airplane and turn all switches to the "OFF" position. If external power is connected to the airplane, disconnect external power from receptacle.

4. Disconnect the airplane battery. (Refer to applicable sections of the service manual/maintenance manual.)

5. Attach maintenance warning tags to the battery and external power receptacle that have "DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS" written on them.

   **WARNING:** Obey all fuel, safety and maintenance precautions.

   **WARNING:** Remove all ignition sources from the airplane and all vapor hazard areas. Some typical examples of ignition sources are: static electricity, electrically powered equipment (tools or electronic test equipment) - both airplane and support equipment, smoking, sparks from metal tools, electronic communication devices such as: cellular phones, pagers and radios.

6. Defuel the airplane. (Refer to applicable sections of the service manual/maintenance manual.)
CAUTION: Before you start the separation of the wings from the airplane, put equivalent weight such as sand bags in the nose compartment and use a padded support under the tailcone. If you remove one or two engines and do not put a balance weight in the nose compartment, the airplane can become tail-heavy and damage can result.

7. Remove the engines or use hoists as support for the weight of the engines. (Refer to applicable sections of the service manual/maintenance manual.)

8. Lift the airplane with jacks. (Refer to applicable sections of the service manual/maintenance manual.)

9. Put support cradles in position under the center of the front and the rear spars of the left and the right wings as necessary.

10. Disconnect the main landing gear control tubes and linkage as necessary. (Refer to applicable sections of the service manual/maintenance manual.)

11. Remove the wing-to-fuselage close out panels and fairings. Keep the panels, fairings, and all serviceable hardware.

12. Disconnect all fuel, hydraulic, and pneumatic lines, electrical connections, and control linkages as necessary to give from 12 to 18 inches clearance between the wing and the fuselage.

13. As necessary to remove the aft wing spar attach bolts, you can remove the row of rivets aft of the aft upper wing attach fitting that attaches the upper wing skin.

14. Remove the left wing. Keep the attaching hardware. (Refer to applicable sections of the service manual/maintenance manual.)

15. (Refer to Figure 1, Detail A, View A-A, and View C-C.) Make the forward fitting installation tool that will be necessary if new fittings are installed as follows:

   NOTE: Actual tool dimensions can vary for each airplane.

   A. Make two forward fitting installation tools to the dimensions shown with any type of locally available 0.063-inch aluminum.

   B. Make the pads as shown from 0.50-inch aluminum. Grind the pads to approximately 0.437 inch or as necessary for correct fit between the attach fitting lugs.

   NOTE: You can use more than one sheet of different thicknesses to make approximately 0.437-inch thickness.

   C. Install two MS20426AD4-12 Rivets, double-flush, in each pad.

   (1) Make the rivets shorter as necessary for a double-flush fit.

   D. Cut the notch in the bottom part of the tool to fit the bottom fitting.

   E. Do not drill the wing attachment bolt holes through the pads until you are told to do it in these instructions.

16. (Refer to Figure 2, Detail A, View A-A, and View C-C.) Make the aft fitting installation tools that will be necessary if new fittings are installed.

   A. Make two aft fitting installation tools (one for the left wing and one for the right wing) to the dimensions shown with any type of locally available 0.063-inch aluminum.

   B. Do not drill the six attach fitting bolt holes until you are told to do it in these instructions.

17. (Refer to Figure 1, Detail A and View A-A.) Install the forward fitting installation tool between the attach fitting lugs with the edge of the tool tight against the top and the bottom stub wing structure.

   A. Mark holes with a transfer punch.

   B. Match drill two holes with a diameter of 0.6245 inch, +0.0015 or -0.0000 inch, in the forward fitting installation tool through the fitting attachment holes.

   C. Deburr the holes.
D. Write RIGHT SIDE (or LEFT SIDE) TOP, BOTTOM, INBD and OUTBD on the forward fitting installation tool as shown.

E. Remove the forward fitting installation tool.

18. (Refer to Figure 2, Detail A and View A-A.) Put the aft fitting installation tool in the position shown, tight against the top and bottom stub wing structure.
   A. Make a mark for the holes with a transfer punch.
   B. Match drill six holes with a diameter of 0.375 inch, +0.004 or -0.001 inch, in the aft fitting installation tools through the fitting attach holes.
   C. Deburr the holes.
   D. Write RIGHT SIDE (or LEFT SIDE) TOP, BOTTOM, INBD and OUTBD on the aft fitting installation tool.
   E. Remove the aft fitting installation tool.

19. (Refer to Figure 1, View A-A and View B-B.) Remove the 0811350 Lower Forward Fitting as follows:
   A. Remove the bolts from the side holes and record the location and bolt length.
      (1) Keep the bolts if they are not corroded or do not have thread damage.
      (2) Discard the nuts.
   B. Carefully drill off the heads of the rivets in the bottom holes of the 0811350 Lower Forward Fitting.
   C. Carefully drive out the rivets with a pin punch.
   D. Remove the fitting from the stub wing.
      (1) If shims are installed on the sides of the fitting, keep the shims to install them later.
      (2) Record the position of the shims, if any shims were installed.
   E. Do an inspection in accordance with the applicable service manual/maintenance manual supplemental inspection document 57-10-08.
      (1) If there are no cracks or corrosion on the fitting, go to Step 20.
      (2) If there are cracks or corrosion on the fitting, go to Step 21.

20. (Refer to Figure 1, View A-A and View B-B.) Install the 0811350 Lower Forward Fitting that was kept as follows:
   A. Measure and record the hole diameters through the spar cap and the inner fitting to find out if oversize fasteners will be necessary.
      (1) Replacement fastener criteria is as follows: (Refer to Table 1 for applicable hole diameter and washers.)
      
      **NOTE:** Hi-Loks are interference fit as specified in Table 1 and installed with U470519 sealant.
      
      (a) Discard all Hi-Loks and Hi-Shears that you remove from the airplane. You can use bolts again if they are in serviceable condition, but you must use new Hi-Loks and Hi-Shears when you install the fittings.
      (b) 1/64 (HL62PB8) and 1/32 (HL18PB8)-inch oversize fasteners can be used in any of the 10 holes through the 0811350 Lower Forward Fitting.
      (c) If one or both holes in the first set of holes must have the next larger size of fastener (HL18PB10), then all fasteners in the first set, second set, and third set of holes must use the next size fastener (HL18PB10) also.
      (d) If one or both holes in the second set of holes must have the next larger size of fastener (HL18PB10), then all fasteners in the second and third set of holes must use the next size fastener (HL18PB10) also.
(e) Use oversize fasteners as necessary.

(f) Fastener lengths must be adjusted longer or shorter if necessary to make sure that three or more threads are in view at the end of the collar. A maximum of two washers can be used under the collar.

B. (Refer to Figure 1, View A-A and View B-B.) Install the fasteners in the side and bottom holes of the 0811350 Lower Forward Fitting.

(1) Apply color chemical film treatment (Alodine) and corrosion resistant primer to the shims and the 0811350 Lower Forward Fitting as necessary.

(2) Attach the 0811350 Lower Forward Fitting with the parts that follow:
   - The shim that was kept, if necessary, for no more than a 0.005-inch gap between the 0811350 Lower Forward Fitting and the inner fitting
   - New or kept NAS6203-10, NAS6203-11, NAS6204-38, NAS6204-42, and NAS6204-44 Bolts
   - New MS21042L3 and MS21042-4 nuts. Torque the MS21042L3 nuts from 20 to 25 inch-pounds and the MS21042-4 nuts from 50 to 70 inch-pounds.

(3) Install replacement fasteners as follows:
   (a) Install six each HL18PB8-7 pins and HL70-8 collars.
   (b) Install two each HL18PB8-9 pins and HL70-8 collars.
       1 If there is damage in the area around the second most outboard pair of holes (fourth set), spot face as necessary to 0.060-inch maximum depth with a 0.060-inch radius to remove any damage.
   (c) Install two each HL18PB8-19 pins and HL70-8 collars.
       1 If there is damage in the area around the bottom outboard holes (fifth set), spot face as necessary to 0.100-inch maximum depth with a 0.060-inch radius to remove any damage.

C. Go to Step 22.

21. (Refer to Figure 1, View A-A and View B-B.) Install a new 0811350-10 Lower Forward Fitting as follows:

   A. Put the fitting into the stub wing.
   B. If installed before, install the 5011020-4 Laminated Shims on the sides of the 0811350-10 Lower Forward Fitting as necessary to make sure that there is no more than a 0.005-inch gap.
   C. Put the forward fitting installation tool in position on the spar. Put a bolt through the upper attach fitting hole and clamp the tool in position.
   D. Clamp the 0811350-10 Lower Forward Fitting in place on the spar cap with a C-clamp.
   E. Use a transfer punch to make marks for the location of the bottom holes on the 0811350-10 Lower Forward Fitting to align with the holes in the spar cap.
   F. Drill the bottom pilot holes in the 0811350-10 Lower Forward Fitting to Number 40 (0.098-inch diameter) to align with the holes in the bottom spar cap.
   G. Attach the 0811350-10 Lower Forward Fitting with draw-type, temporary sheet metal fasteners.
   H. Use a transfer punch that matches the diameter of the holes on the spar cap to make marks for the side holes of the 0811350-10 Lower Forward Fitting on forward and aft sides.
   I. Remove the 0811350-10 Lower Forward Fitting and installation tool.
   J. Drill the side pilot holes with a Number 40 (0.098-inch diameter) drill bit.
   K. Attach the 0811350-10 Lower Forward Fitting with temporary sheet metal fasteners.
L. Move the wing and the stub wing back together and make sure the forward fitting attach holes align with the wing fitting attach holes.
   (1) If the holes do not line up, examine the tool position. If it is not correct and the holes cannot be aligned correctly, then you must do Step 21 again with a new 0811350-10 Lower Forward Fitting.

M. Prepare side holes in the 0811350-10 Lower Forward Fitting as follows:
   (1) Step drill the NAS6203 Bolt locations through the fitting and web with a Number 12 (0.1890-inch diameter) drill bit.
       (a) Ream the holes to 0.1894 +0.0010 or -0.000.
   (2) Step drill the NAS6204 Bolt locations through the fitting and web with a Letter D (0.2460-inch diameter) drill bit.
       (a) Ream the holes to a diameter of 0.2494 inch, +0.0010 or -0.000 inch.
   (3) Deburr the holes.
   CAUTION: Make sure that the spot face is the same as the removed fitting spot face.
   (4) Spot face the side holes inside the fitting where the NAS6203-11 and NAS6203-10 bolts are to be installed to 0.4375-inch diameter. Remove only enough material to make the bolt fit flush with the inner wall surface of the fitting.

N. Apply color chemical film treatment (Alodine) and corrosion resistant primer to the shims and the 0811350-10 Lower Forward Fitting as necessary.

O. Attach the 0811350-10 Lower Forward Fitting with the parts that follow:
   (1) Install the shim that was kept, if necessary, for no more than a 0.005-inch gap between the 0811350-10 Lower Forward Fitting and the inner fitting.
   (2) Install the new or kept NAS6203-10, NAS6203-11, NAS6204-38, NAS6204-42, and NAS6204-44 Bolts.
   (3) Install the new MS21042L3 and MS21042-4 Nuts. Torque the MS21042L3 Nuts from 20 to 25 inch-pounds and the MS21042-4 Nuts from 50 to 70 inch-pounds.

P. Install the fasteners in the 0811350-10 Lower Forward Fitting as follows:
   NOTE: Hi-Loks are interference fit as specified in Table 1 and installed with U470519 sealant.
   (1) Discard all Hi-Loks and Hi-Shears that you remove from the airplane. You can use bolts again if they are in serviceable condition, but you must use new Hi-Loks and Hi-Shears when you install the fittings.
   (2) Replacement fastener criteria is as follows: (Refer to Table 1 for the applicable hole diameter and washers.)
       (a) 1/64 (HL62PB8) and 1/32 (HL18PB8)-inch oversize fasteners can be used in any of the 10 holes through the 0811350-10 Lower Forward Fitting.
       (b) If one or both holes in the first set of holes must have the next larger size of fastener (HL18PB10), then all fasteners in the first set, second set, and third set of holes must use the next size fastener (HL18PB10) also.
       (c) If one or both holes in the second set of holes must have the next larger size of fastener (HL18PB10), then all fasteners in the second and third set of holes must use the next size fastener (HL18PB10) also.
       (d) Use oversize or next size fasteners as necessary.
       (e) Use longer or shorter length HL18PB8 pins as necessary to make sure that three or more threads are in view at the end of the collar. A maximum of two washers can be used to make adjustment.
(3) Drill bottom holes through the 0811350-10 Lower Forward Fitting to the size necessary for the fasteners that you will install. (Refer to Table 1 for applicable hole diameters.)

(4) Install replacement fasteners as follows:
   (a) Install six each HL18PB8-7 pins and HL70-8 collars.
   (b) Install two each HL18PB8-9 pins and HL70-8 collars.
   (c) Install two each HL18PB8-19 pins and HL70-8 collars. Use oversize or the next size fasteners as necessary.

Q. Remove the fitting installation tool.

22. (Refer to Figure 2, View A-A and View B-B.) Remove the 5011024 Lower Aft Fitting as follows:
   A. Remove the screws from the bottom holes of the 5011024 Lower Aft Fitting.
      (1) Keep the screws if they are not corroded or do not have thread damage.
      (2) Discard the nuts.
   B. Remove the bolts from the side holes of the 5011024 Lower Aft Fitting.
      (1) Keep the bolts if they are not corroded or do not have thread damage.
      (2) Discard the nuts.
   C. Remove the 5011024 Lower Aft Fitting, record the position of the shims if installed on the sides of the fitting, and keep the shims that you need for installation.
   D. Do an inspection in accordance with the applicable service manual/maintenance manual supplemental inspection document 57-10-05 for the affected airplane.
      (1) If there are no cracks or corrosion on the 5011024 Lower Aft Fitting, go to Step 23.
      (2) If there are cracks or corrosion on the 5011024 Lower Aft Fitting, go to Step 24.

23. (Refer to Figure 2, View A-A and View B-B.) Install the 5011024 Lower Aft Fitting that was kept as follows:
   A. Apply color chemical film treatment and corrosion resistant primer to the shims and the 5011024 Lower Aft Fitting as necessary.
   B. Install the 5011024 Lower Aft Fitting with 10 new or kept AN5-7A bolts, 20 NAS1149F0563P Washers, and 10 new MS21044N5 nuts through the side holes. Torque the nuts from 100 to 140 inch-pounds.
   C. Install MS24694S151 Screws and MS21044N5 Nuts to the 5011024 Lower Aft Fitting. Torque the nuts from 100 to 140 inch-pounds.

NOTE: As necessary, you can use MS24694S149 or MS24694S150 Screws as alternatives to MS24694S151 Screws to make sure that there are one to three exposed threads on the screws when installed.

D. Go to Step 25.

24. (Refer to Figure 2, View A-A and View B-B.) Install a new 5011024-2 Lower Aft Fitting as follows:
   A. Put the fitting into the stub wing.
   B. Install the aft fitting installation tool.
   C. Clamp the 5011024-2 Lower Aft Fitting in position.
   D. Use a transfer punch to make marks at the location of the bottom pilot holes on the 5011024-2 Lower Aft Fitting to align with the holes in the spar cap.
   E. Remove the fitting if necessary and drill the bottom pilot holes through the 5011024-2 Lower Aft Fitting to Number 40 (0.098-inch diameter).
F. Install the 5011020-4 Shims on the sides of the 5011024-2 Lower Aft Fitting as necessary for no more than a 0.005-inch gap between the 5011024-2 Lower Aft Fitting and the inner fitting.

G. Attach the 5011024-2 Lower Aft Fitting to the spar cap with temporary sheet metal fasteners.

H. Make marks for the side holes on the forward and aft sides of the 5011024-2 Lower Aft Fitting with a transfer punch to align with the existing holes.

I. Remove the 5011024-2 Lower Aft Fitting if necessary and drill the side pilot holes with a Number 40 (0.098-inch diameter) drill bit.

J. Put the fitting in position and attach the 5011024-2 Lower Aft Fitting with temporary sheet metal fasteners if the fitting was removed.

K. Move the wing and the stub wing back together and make sure the aft fitting attach holes align with the wing fitting attach holes.

(1) If the holes do not line up, examine the tool position. If it is not correct and the holes cannot be aligned correctly, then you must do Step 24 again with a new 5011024-2 Lower Aft Fitting.

L. Step drill and ream the side holes of the 5011024-2 Lower Aft Fitting to a diameter of 0.313 inch (+0.006 or -0.001 inch).

M. Step drill and ream the bottom holes in the 5011024-2 Lower Aft Fitting to a diameter of 0.313 inch (+0.006 or -0.001 inch).

N. Attach the 5011024-2 Lower Aft Fitting with 10 new or kept AN5-7A Bolts, 20 NAS1149F0563P Washers, and 10 new MS21044N5 Nuts through the side holes. Torque from 100 to 140 inch-pounds.

O. Deburr the holes.

P. Apply color chemical film treatment and corrosion resistant primer to the shims and the 5011024-2 Lower Aft Fitting as necessary.

Q. Install MS24694S151 Screws and MS21044N5 Nuts to the 5011024-2 Lower Aft Fitting. Torque the nuts from 100-140 inch-pounds.

25. Install the left wing with the kept attaching hardware. (Refer to applicable sections of the service manual/maintenance manual.)

A. Connect all fuel, hydraulic, and pneumatic lines, electrical connections, and control linkages as necessary.

B. Install replacement rivets in the upper wing skin if you removed them to help in the removal of the aft wing spar attach bolts.

C. Install the wing-to-fuselage close out panels and fairings with new or kept serviceable hardware.

D. Connect the main landing gear control tubes and linkage as necessary. (Refer to the applicable sections of the service manual/maintenance manual.)

26. Do Steps 11 through 25 above as applicable for the right wing.

27. Remove maintenance warning tags from battery and external power receptacle.

28. Connect the airplane battery. (Refer to the applicable sections of the service manual/maintenance manual.)

29. Do the rigging of the landing gear and do the necessary operational checks. (Refer to applicable sections of the service manual/maintenance manual.)

30. Remove the support cradles from the wings.

31. Lower the airplane and remove the jacks. (Refer to the applicable sections of the service manual/maintenance manual.)

32. Do an operational check of the engines. (Refer to applicable sections of the service manual/maintenance manual and Pilot's Operating Handbook.)
33. Make an entry in the airplane logbook stating that this Service Kit has been installed.

**NOTE:** This information shall be considered an amendment to the Cessna Manufacturer's Service/Maintenance Manual or Instructions for continued airworthiness and must be accomplished for ongoing airworthiness compliance in accordance with 14 CFR Part (FAR) 43.13.

Table 1. Hi-LOK fasteners part numbers and hole sizes.

<table>
<thead>
<tr>
<th>HI-LOK PART NUMBER</th>
<th>COLLAR</th>
<th>SIZE</th>
<th>HOLE SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>HL18PB8</td>
<td>HL87-8</td>
<td>NOMINAL</td>
<td>0.2485-0.2495</td>
</tr>
<tr>
<td>HL62PB8</td>
<td>HL79-8</td>
<td>1/64 OVERRSIZE</td>
<td>0.2641-0.2651</td>
</tr>
<tr>
<td>HL218-8</td>
<td>HL84-8</td>
<td>1/32 OVERRSIZE</td>
<td>0.2797-0.2807</td>
</tr>
<tr>
<td>HL18PB10</td>
<td>HL87-10</td>
<td>NOMINAL (NEXT SIZE)</td>
<td>0.3110-0.3120</td>
</tr>
</tbody>
</table>
NOTE 1: All dimensions shown are in inches.
NOTE 2: See accomplishment instructions for spot facing instructions.

Install Tool Tight Against Structure

0.1894 (+0.0015, -0.0000) Inch Diameter Hole
or
0.2494 (+0.0010, -0.0000) Inch Diameter Hole
(1 Required, 14 Places)
(For New Fittings Only)
(NOTE 2)

0811350-10 Lower Forward Fitting (If Required)

NAS6203-11 Bolt
(6 Places)
(Replace if Required)
MS21042L3 Nut
(1 Required, 6 Places)
(NOTE 2)

NAS6204-42 Bolt
(2 Places)
(Replace if Required)
MS21042-4 Nut
(1 Required, 2 Places)

NAS6204-44 Bolt
(2 Places)
(Replace if Required)
MS21042-4 Nut
(1 Required, 2 Places)

5011020-4 Laminated Shim
(If Required, 2 Places)

Attach Fitting Lug (Reference)

Forward Fitting Installation Tool (Reference)

OUTBD

VIEW A-A
Looking Forward At Right Side Forward Spar Stub Wing (Left Side Opposite)

Figure 1. Lower Forward Fitting Installation (Sheet 1)
NOTE 3: Dimensions for Forward Fitting Installation Tool can vary for each airplane.

Figure 1. Lower Forward Fitting Installation (Sheet 2)
NOTE 4: Nominal fastener size is shown. See accomplishment instructions for oversize and next size fastener allowances. Install all Hi-Lok pins with 0.0005 to 0.0015-inch interference fit.
AN5–7A Bolt (10 Places) (Replace if Required)
NAS1149F0563P Washer (20 Places) (Replace if Required)

MS21044N5 Nut (1 Required, 10 Places)

5011020–4 Laminated Shim (If Required, 2 Places)

5011024–2 Lower Aft Fitting (If Required)

0.313–Inch, +0.006 or −0.001–Inch Diameter Hole (1 Required, 10 Places) (For New Fittings Only)

5011021–9 Doubler (Reference)

Aft Fitting Installation Tool (2 Places, Forward and Aft Sides) (Reference)

VIEW A–A
Looking Aft At Left Side Rear Spar Stub Wing (Right Side Opposite)

Figure 2. Lower Aft Fitting Installation (Sheet 1)
NOTE 1: All dimensions shown are in inches.

Aft Fitting Installation Tool (Make From 0.063 Aluminum)

0.25 Radius

0.063

VIEW C–C

0.375-Inch, +0.004 or −0.001-Inch, Diameter Hole to Match the Attach Fittings (6 Required)

DETAIL A

Lower Aft Fitting Installation Tool

Figure 2. Lower Aft Fitting Installation (Sheet 2)
NOTE 2: Use MS24694S149 or MS24694S150 Screws as alternatives to MS24694S151 Screws to make sure that there are one to three exposed threads on the screws when installed.