TITLE
WINGS - ACCESS PANEL INSTALLATION FOR FORWARD SPAR

EFFECTIVITY

<table>
<thead>
<tr>
<th>MODEL</th>
<th>SERIAL NUMBERS</th>
</tr>
</thead>
<tbody>
<tr>
<td>425</td>
<td>425-0001 thru 425-0236</td>
</tr>
</tbody>
</table>

REASON
Customers have requested an access panel to gain easy access to the forward spar for inspections.

DESCRIPTION
This service document provides parts and instructions to trim the lower skin and install an access panel on the wings.

COMPLIANCE

OPTIONAL. This service document can be accomplished at the discretion of the owner.

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.

APPROVAL

Textron Aviation received FAA approval for the technical data in this publication that changes the airplane type design.

FLIGHT CREW OPERATIONS

No Changes

December 20, 2017
CONSUMABLE MATERIAL
You must use the consumable materials that follow, or their equivalent, to complete this service document.

<table>
<thead>
<tr>
<th>NAME</th>
<th>NUMBER</th>
<th>MANUFACTURER</th>
<th>USE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color Chemical Film</td>
<td>U074093</td>
<td>Textron Aviation Parts Distribution</td>
<td>To protect bare material for final finish.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>7121 Southwest Boulevard Wichita, KS 67215</td>
<td></td>
</tr>
<tr>
<td>Corrosion Resistant Primer</td>
<td>K000574</td>
<td>Textron Aviation Parts Distribution</td>
<td>Final finish for aluminum.</td>
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</tbody>
</table>

TOOLING
No specialized tooling is required to complete this service document.

WEIGHT AND BALANCE INFORMATION
Negligible

REFERENCES
Cessna Model 425 Maintenance Manual

NOTE: To make sure all publications used are complete and current. Refer to www.txtavsupport.com.

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 access panels.
   A. Remove and keep the MS27039-0808 Screws from access panels 511CB and 611CB. (Refer to the Model 425 Maintenance Manual.)
      NOTE: The MS27039-0808 Screws will be used to install the new access panel.
   B. Remove and discard access panels 511CB and 611CB. (Refer to the Model 425 Maintenance Manual.)
   C. Remove and keep the aft row of MS24694-S50 Screws from the 511BB and 611BB access panels. (Refer to the Model 425 Maintenance Manual.)
      NOTE: The MS24694-S50 Screws will be used to install the new access panel.

3. (If 5991001-7 Panels are not purchased) (Refer to Figure 1, Detail B.) Fabricate the access panels.
   A. Cut out two 7.50 inch by 5.67 inch rectangles from the S3806-11 Sheet Material or ALCLAD 2024-T3.
   B. Cut, trim, and shape the panel as necessary.
   C. Identify one panel as LEFT and one as RIGHT.
D. Identify one surface on each of the panels as UP.
E. Roll or crimp the outer 0.25 inch of the panel upward 6° around the perimeter.
F. Protect the fabricated panels with U074093 Color Chemical Film and K000574 Corrosion Resistant Primer.

4. (Refer to Figure 1, Detail A.) Make the cutout in lower right wing skin.
   
   **NOTE:** The cutout dimension is identified in Figure 1 Detail A.
   
   A. Identify the area to cut the lower wing skin between the engine and fuselage inboard of the rib.
   B. Put the 5991001-7 (or fabricated) Access Panel into position and trace the outline on the lower wing skin.
   C. Remove the rivets that are inside the traced panel outline.
   D. Insert a piece of scrap stainless steel between the lower wing skin and the lower forward spar cap.
   
   **WARNING:** Do not damage the forward spar when making the cutout in the lower wing skin. Any damage to the forward spar will likely required spar, spar cap, or spar fitting replacement. Premature cracking may occur if damage to the spar, spar cap, or spar fitting is not noticed. Mechanics should use great care and caution when making this cutout. Every effort must be made to protect the spar, spar cap, and spar fitting from damage.
   
   E. Make the cutout in the lower wing skin at the identified area.
   F. Deburr the cutout.
   G. Remove the scrap stainless steel.
   H. Protect the edges of the cutout with U074093 Color Chemical Film and K000574 Corrosion Resistant Primer.

5. (Refer to Figure 1, Detail A.) Install the nutplate on the right wing.
   
   A. Measure and identify the location for the MS21069L3 Nutplate.
   B. Drill one 0.171 inch-diameter hole in the lower wing skin at the identified location.
   C. Match drill two Number 40 (0.098 inch-diameter) holes in the lower wing skin that align with the holes in the MS21069L3 Nutplates.
   D. Deburr the drilled holes.
   E. Countersink the Number 40 (0.098 inch-diameter) holes 100° x 0.179 inch-diameter.
   F. Install one MS21069L3 Nutplate with two MS20426AD3-4A Rivets.

6. (Refer to Figure 1, Detail A.) Install 14 CM3827AD4-6 Rivets on the right wing.
   
   A. Countersink 14 Number 30 (0.128 inch-diameter) holes 100° x 0.190 inch-diameter.
   B. Install 14 CM3827AD4-6 Rivets to attach the skin to the wing structure.

7. (Refer to Figure 1, Detail A.) Install the access panel on the right wing.
   
   A. Put the 5991001-7 or fabricated Access Panel into position and identify the hole locations.
      
      **NOTE:** Make sure that the crimped surface of the panel contacts the lower wing skin.
   B. Match drill 13 0.171 inch-diameter holes in the aft portion of the 5991001-7 or fabricated Access Panel that align with the nutplates.
   C. Match drill seven Number 10 (0.193 inch-diameter) holes in the forward portion of the 5991001-7 or fabricated Access Panel that align with the nutplates.
D. Deburr the drilled holes.
E. Dimple seven Number 10 (0.193 inch-diameter) holes at 100°.
F. Enlarge the existing countersinks in the wing skin if necessary to allow the 5991001-7 (or fabricated) Access Panel to sit flush.
G. Protect the 5991001-7 (or fabricated) Access Panel with U074093 Color Chemical Film and K000574 Corrosion Resistant Primer.
H. Paint the 5991001-7 (or fabricated) Access Panel the same color as the lower surface of the wing.
I. Install the 5991001-7 (or fabricated) Access Panel with one MS27039-0808 Screw and the 19 kept screws from Step 2.

8. Do this modification for the left wing.
9. Remove the maintenance warning tags and connect the airplane battery.
10. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.
Figure 1. Access Panel Installation For Forward Spar (Sheet 1)
Figure 1. Access Panel Installation For Forward Spar (Sheet 2)
MATERIAL INFORMATION

Order the kit/parts below to install this modification.

<table>
<thead>
<tr>
<th>NEW P/N</th>
<th>QUANTITY</th>
<th>KEY WORD</th>
<th>OLD P/N</th>
<th>INSTRUCTIONS/DISPOSITION</th>
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</thead>
<tbody>
<tr>
<td>CQB-57-01</td>
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<td>Kit, consisting of the following parts:</td>
<td></td>
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<tr>
<td>CM3827AD4-6</td>
<td>28</td>
<td>Rivet</td>
<td>MS20470AD4-6A</td>
<td>Discard</td>
</tr>
<tr>
<td>MS21069L3</td>
<td>2</td>
<td>Nutplate</td>
<td>None</td>
<td></td>
</tr>
<tr>
<td>MS27039-0808</td>
<td>2</td>
<td>Screw</td>
<td>None</td>
<td></td>
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<tr>
<td>MS20426AD3-4A</td>
<td>4</td>
<td>Rivet</td>
<td>None</td>
<td></td>
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<tr>
<td>CQB-57-01</td>
<td>1</td>
<td>Instructions</td>
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The part that follows is required to complete this modification.

<table>
<thead>
<tr>
<th>NEW P/N</th>
<th>QUANTITY</th>
<th>KEY WORD</th>
<th>OLD P/N</th>
<th>INSTRUCTIONS/DISPOSITION</th>
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<tbody>
<tr>
<td>5991001-7</td>
<td>2</td>
<td>Access Panel</td>
<td>5911017-5 and 5911017-6</td>
<td>Discard</td>
</tr>
</tbody>
</table>

If 5991001-7 Access Panels are not available, the part that follows can be used to fabricate two 5292032-4 Access Panels.

<table>
<thead>
<tr>
<th>NEW P/N</th>
<th>QUANTITY</th>
<th>KEY WORD</th>
<th>OLD P/N</th>
<th>INSTRUCTIONS/DISPOSITION</th>
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<tbody>
<tr>
<td>S3806-11</td>
<td>1</td>
<td>Sheet Material</td>
<td>None</td>
<td>Optional to fabricate access panel</td>
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</tbody>
</table>

* Please contact a Textron Aviation Authorized Service Facility for current cost and availability of parts listed in this service document.
Conquest

OWNER ADVISORY

CQB-57-01

TITLE
WINGS - ACCESS PANEL INSTALLATION FOR FORWARD SPAR

TO:
Cessna Model 425 Aircraft Owner

REASON
Customers have requested an access panel to gain easy access to the forward spar for inspections.

COMPLIANCE
OPTIONAL. This service document can be accomplished at the discretion of the owner.

MATERIAL AVAILABILITY
No part are required to complete this service document.

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>AVAILABILITY</th>
<th>COST</th>
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<tbody>
<tr>
<td>CQB-57-01</td>
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<td>*</td>
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<tr>
<td>S3806-11</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>5991001-7</td>
<td>*</td>
<td>*</td>
</tr>
</tbody>
</table>

* Please contact a Textron Aviation Authorized Service Facility for current cost and availability of parts listed in this service document.

WARRANTY
None

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.