

REVISION TRANSMITTAL

This sheet transmits Revision 1 to SL560XL-53-19, which:

- A. Changes the hole size drilled from Number 30 (0.128 inch-diameter) to Number 21 (0.159 inch-diameter) in Step 2.B.(1).(a).1 and Step 2.C.(2).(a).
- B. Changes Figure 1, Sheet 2 and Sheet 3 to show the correct hole size to be drilled.
- C. Adds a CAUTION to Step 2.B.(1).(a) that the new hole must be located a minimum of 1.0 inch from the F.S. 424 Frame.
- D. Adds a CAUTION to Step 2.C.(2) that the new hole must be located a minimum of 1.0 forward of the F.S. 460 Frame.

NOTE: This revision replaces the original issue of SL560XL-53-19 in its entirety.

REVISION COMPLIANCE

NO EFFECT. Airplanes previously modified by this service letter are not affected by this revision.

LOG OF REVISIONS

Original Issue	May 14, 2020
Revision 1	June 19, 2020

TITLE

FUSELAGE - EMPENNAGE FASTENER VERIFICATION

EFFECTIVITY

MODEL	SERIAL NUMBERS
560XL (Citation Excel)	-5002 thru -5372
560XL (Citation XLS)	-5501 thru -5830
560XL (Citation XLS+)	-6001 thru -6230, -6232

The equivalent of this service document has been incorporated on production airplanes -6231 and -6233 and On.

REASON

A fastener in the aft baggage door structure may have been omitted during manufacturing.

DESCRIPTION

This service document provides instructions to do an inspection for an omitted fastener.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at an Inspection Document 6.

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.

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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	U074093	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To prepare aluminum surface for intermediate primer.
Corrosion Resistant Primer	K000574	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

Cessna Model 560XL Maintenance Manual

Cessna Model 560XL Structural Repair Manual

Citation Standard Practices Manual

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. Do an inspection for rivets in the tailcone.
 - A. Remove access panel 321BL. (Refer to the Model 560XL Maintenance Manual, Chapter 6, Access Plates and Panels - Description and Operation.)
 - B. (Refer to Figure 1, Detail A, View A-A and Detail B.) Inspect the rivets at FS 424 common to the 6612025-1 Stringer, 6612067-3 Longerons, 6612029-33 Clip and 6612029-34 Clip.
 - (1) If there are six rivets common to the 6612025-1 Stringer, 6612067-3 Longerons, 6612029-33 Clip and 6612029-34 Clip, go to Step 3.C.

CAUTION: The fastener must be located a minimum of 1.0 inch from the F.S. 424 Frame to avoid drilling into the edge of the 6612067-12 Bracket.

- (a) If there are not six rivets common to the 6612025-1 Stringer, 6612067-3 Longerons, 6612029-33 Clip and 6612029-34 Clip, do the steps that follow.

1 (Refer to Figure 1, View A-A and Detail B.) Layout and drill one Number 21 (0.159 inch-diameter) hole in the 6612025-1 Stringer, 6612067-3 Longerons, 6612029-33 Clip and 6612029-34 Clip at the location shown.

NOTE: It may be necessary to loosen a fuel line clamp to drill the hole.

2 Deburr the hole.

3 Apply U074093 color chem film treatment to the hole that was drilled. (Refer to the Model 560XL Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

4 Apply K000574 corrosion resistant primer to the hole that was drilled. (Refer to the Model 560XL Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

5 Install one CR3223-5-5 Rivet in the 6612025-1 Stringer, 6612067-3 Longerons, 6612029-33 Clip and 6612029-34 Clip.

- C. (Refer to Figure 1, Detail A, View B-B and Detail C.) Inspect the rivets at FS 460 common to the 6612025-3 Stringer, 6612067-3 Longerons, 6612029-35 Clip and 6612029-36 Clip.

- (1) If there are five rivets common to the 6612025-3 Stringer, 6612067-3 Longerons, 6612029-35 Clip and 6612029-36 Clip, go to Step 3.
- (2) If there are not five rivets common to the 6612025-3 Stringer, 6612067-3 Longerons, 6612029-35 Clip and 6612029-36 Clip, do the steps that follow.

CAUTION: The fastener must be located a minimum of 1.0 inch forward of the F.S. 460 Frame to avoid drilling into the edge of the 6612067-13 Bracket.

- (a) (Refer to Figure 1, View B-B and Detail C.) Layout and drill one Number 21 (0.159 inch-diameter) hole in the 6612025-3 Stringer, 6612067-3 Longerons, 6612029-35 Clip and 6612029-36 Clip at the location shown.

NOTE: It may be necessary to loosen a fuel line clamp to drill the hole.

(b) Deburr the hole.

(c) Apply U074093 color chem film treatment to the hole that was drilled. (Refer to the Model 560XL Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

(d) Apply K000574 corrosion resistant primer to the hole that was drilled. (Refer to the Model 560XL Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)

(e) Install one CR3223-5-5 Rivet in the 6612025-3 Stringer, 6612067-3 Longerons, 6612029-35 Clip and 6612029-36 Clip.

3. Install access panel 321BL. (Refer to the Model 560XL Maintenance Manual, Chapter 6, Access Plates and Panels - Description and Operation.)
4. Remove the maintenance warning tags and connect the airplane battery.

5. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

NOTE: Textron Aviation recommends that compliance with all service documents is reported to Camp Systems International.

- Complete a record of compliance. (Maintenance Transaction Report, Log Book Entry, or other record of compliance.)
- Put a copy of the completed record of compliance in the airplane logbook.
- Send a copy of the completed record of compliance to: Camp Systems International Incorporated, 8201 East 34th Street North, Building 1100 Suite 1101 Wichita, KS 67226.

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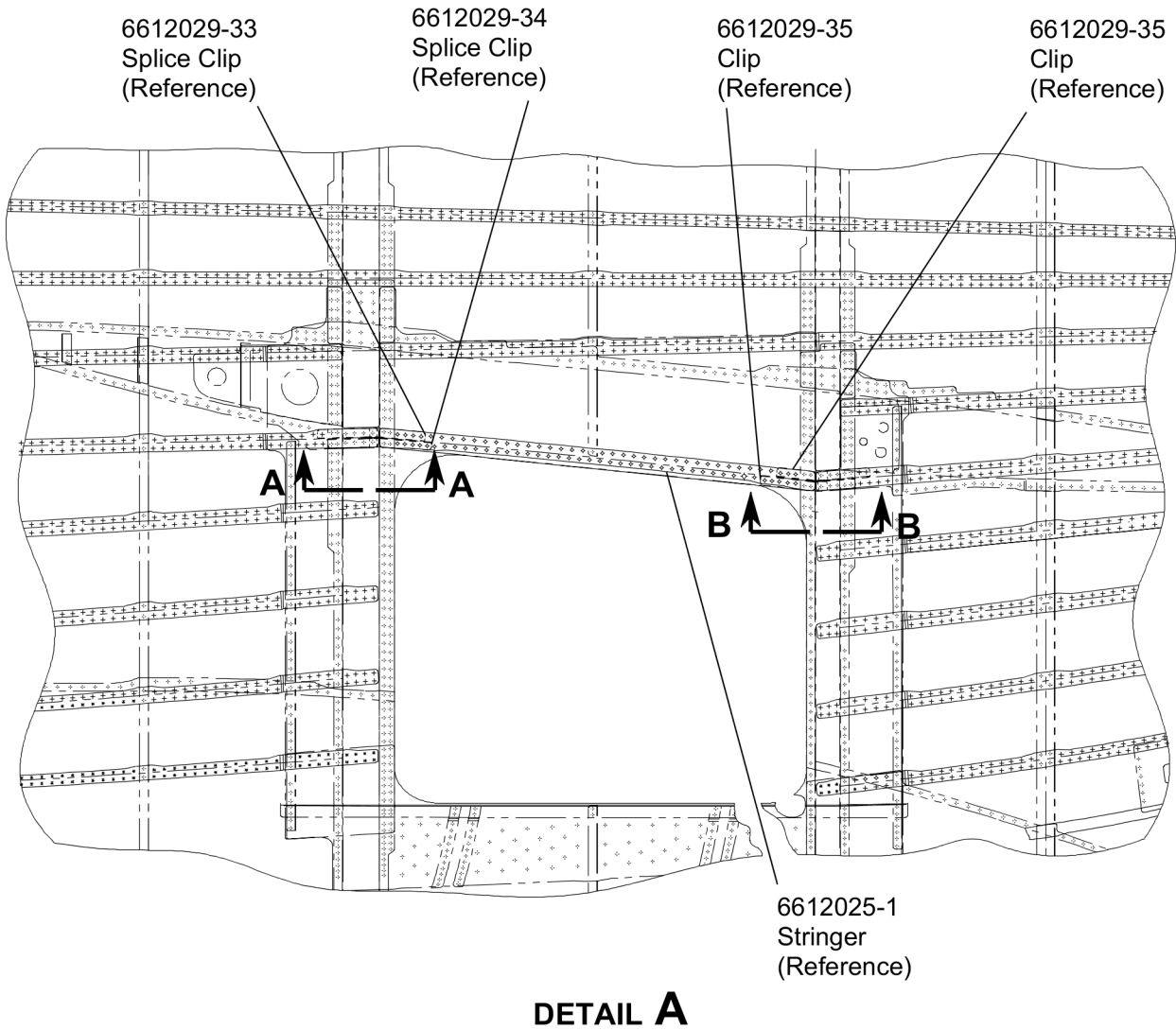
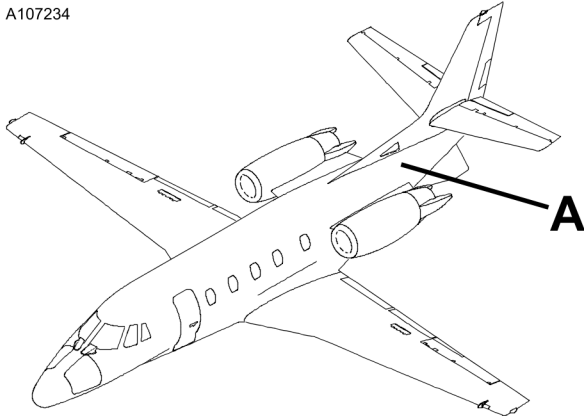
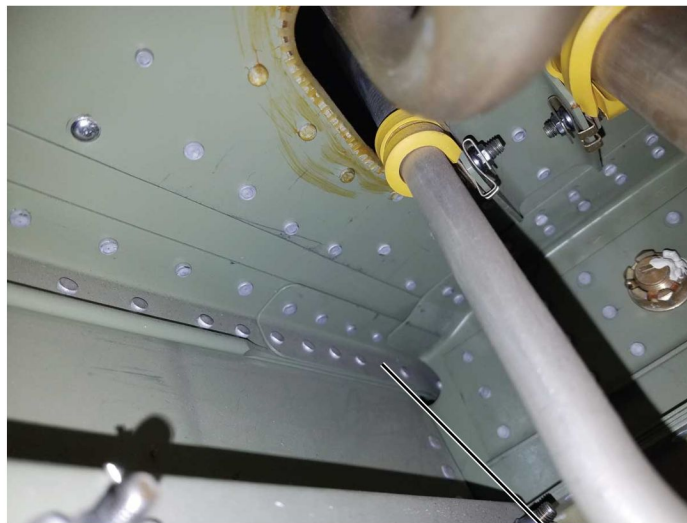
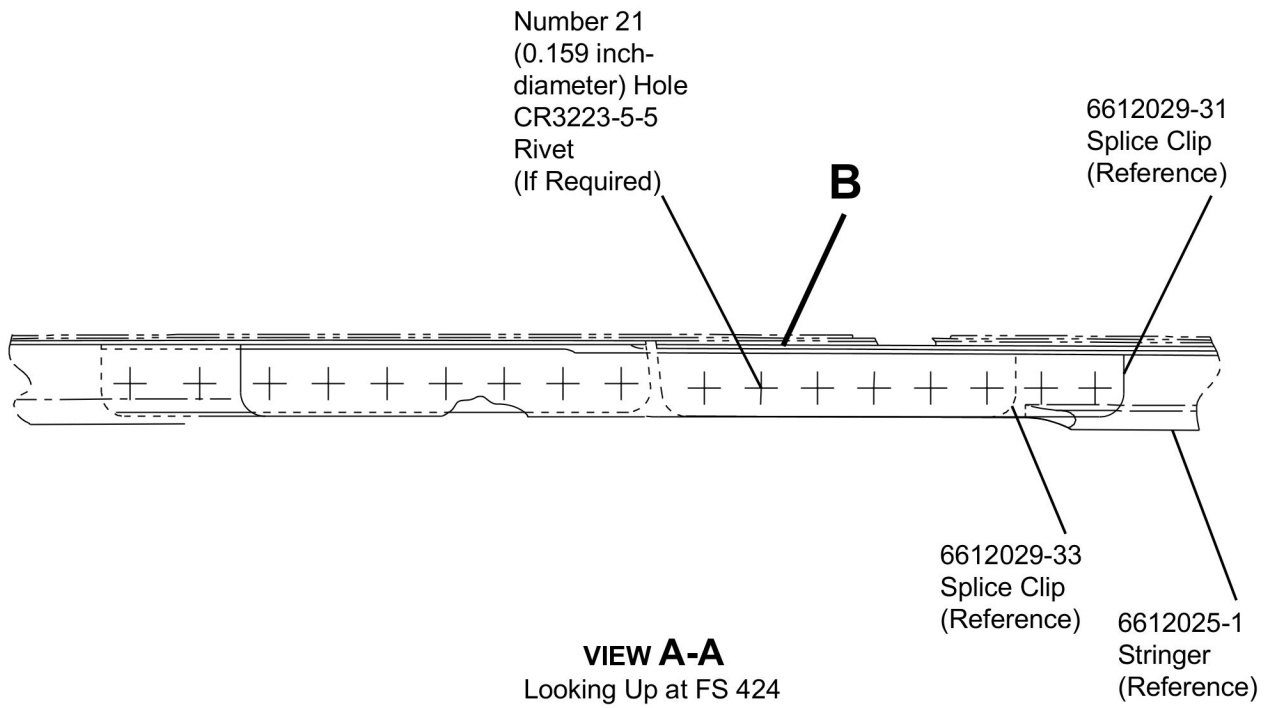


Figure 1. Rivet Inspection/Replacement (Sheet 1)

6610T1001
A6612T015-1

A107235

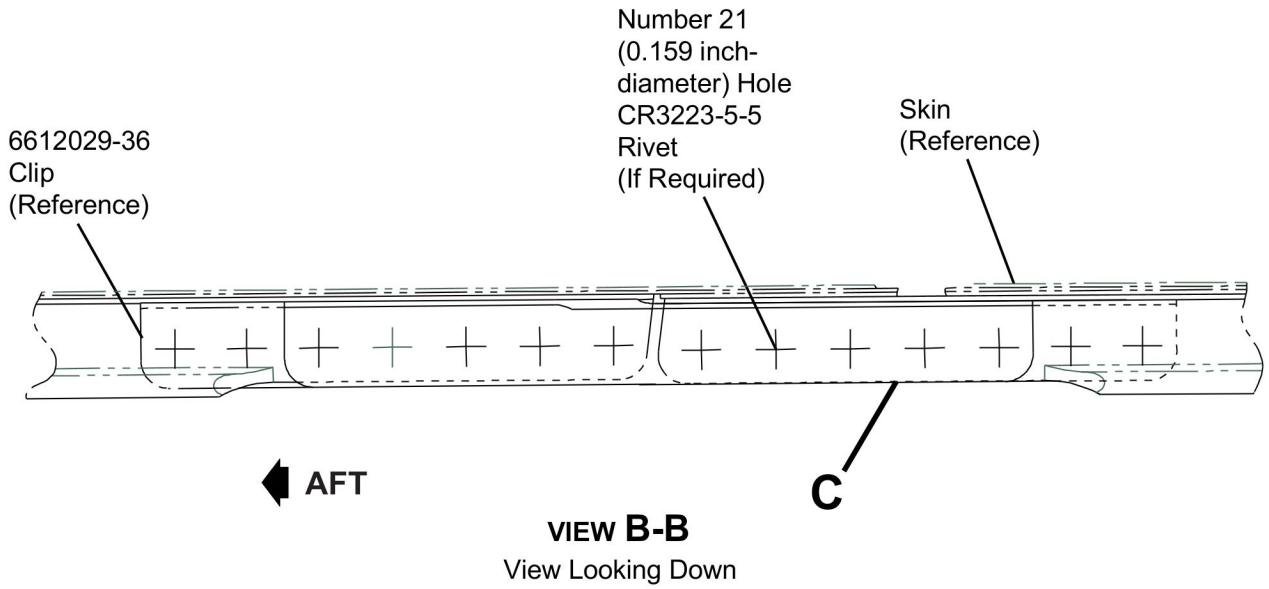


DETAIL B

Location of possible missing rivet

Figure 1. Rivet Inspection/Replacement (Sheet 2)

A108351



Location of possible missing rivet

DETAIL C
Looking Down

Figure 1. Rivet Inspection/Replacement (Sheet 3)

MATERIAL INFORMATION

Order the part below to install this modification.

NEW P/N	QUANTITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
CR3223-5-5	2	Rivet	None	

* 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

FUSELAGE - EMPENNAGE FASTENER VERIFICATION

TO:

Aircraft Owner

REASON

A fastener in the aft baggage door structure may have been omitted during manufacturing.

COMPLIANCE

RECOMMENDED. This service document should be accomplished at a scheduled maintenance period or inspection.

LABOR HOURS

For planning purposes only:

WORK PHASE	LABOR-HOURS
Modification (If Necessary)	0.7 to install the forward rivet
Modification (If Necessary)	0.3 to install the aft rivet

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
CR3223-5-5	*	*

* 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.

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.

May 14, 2020

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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: May 14, 2022 (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.

