

TITLE

FLIGHT CONTROLS - INSPECTION OF THE ROLL SPOILER SECTOR ASSEMBLY FOR MISSING BUSHING

EFFECTIVITY**MODEL**

680A (Citation Latitude)

SERIAL NUMBERS

-0112, -0121, -0126 thru -0209

REASON

To inspect the roll spoiler sector assembly for a missing bushing and any damage that may have happened from scraping and/or clamping loads.

DESCRIPTION

This service letter provides parts and instructions to inspect for a missing bushing on the roll spoiler sector assembly and any damage that may have occurred from scraping and/or clamping loads.

COMPLIANCE

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

FLIGHT CREW OPERATIONS

No Changes

CONSUMABLE MATERIAL

No specialized consumable materials are required to complete this service document.

TOOLING

No specialized tooling is required to complete this service document.

July 8, 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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REFERENCES

Cessna Model 680A Maintenance Manual
 Cessna Model 680A 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 external electrical power.
 - (2) Disconnect the airplane battery.
 - 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.
 - E. Remove the copilot's seat from the flight deck as follows:
 - (1) Move the copilot's seat back to a vertical position and lower the seat bottom.
 - (2) Remove the forward seat rail stop bolts, spacers, and nuts.
 - (3) If necessary, move the control column to the forward position.
 - (4) Operate the TRACK LOCK handle to disengage the stop pins.
 - (5) Move the copilot's seat forward until the front rollers are free of the seat rails and the aft rollers align with the opening on the seat rails.
 - (6) Release the TRACK LOCK handle.
 - (7) Remove the copilot's seat from the aircraft.
 - F. Remove flight deck floorboard access panel 132BT. (Refer to Cessna Model 680A Maintenance Manual, Chapter 6, Access Plates and Panels Identification.)
2. (Refer to Figure 1, Sheet 1.) Examine the roll spoiler sector assembly for a missing bushing as follows:
 - A. Using a high intensity light and 0.020 inch feeler gauge, make sure there is a minimum of 0.020 inch clearance between the surfaces of the upper support fitting and the roll spoiler sector.
 - (1) If the examination reveals a clearance of 0.020 inch (0.508 mm) or greater between the surface of the upper support fitting and the roll spoiler sector, do the steps that follow:
 - (a) Go to Step 2.B.
 - (2) If the examination reveals a clearance of 0.020 inch (0.508 mm) or less between the surface of the upper support fitting and the roll spoiler sector, do the steps that follow:
 - (a) Install #10 (0.1935) rigging pins through the rigging pin holes of the roll spoiler disconnect sector and the bottom roll spoiler feed-thru sector. (Refer to Cessna Model 680A Maintenance Manual, Chapter 27, Flight Controls Rigging Pin Locations - Maintenance Practices.)
 - (b) Record the cable tension on the cockpit spoiler control cable.

Cockpit Spoiler Control Cable Tension	
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- (c) Remove the locking clips from the turnbuckle. (Refer to Citation Standard Practices Manual, Safetying - Maintenance Practices.)
- (d) Loosen the cockpit spoiler control cable using the turnbuckle.
 - NOTE:** Make sure to count the number of turns the turnbuckle was loosened.
- (e) Record the amount of turns the turnbuckle was loosened.

Number of Turns Turnbuckle Loosened	
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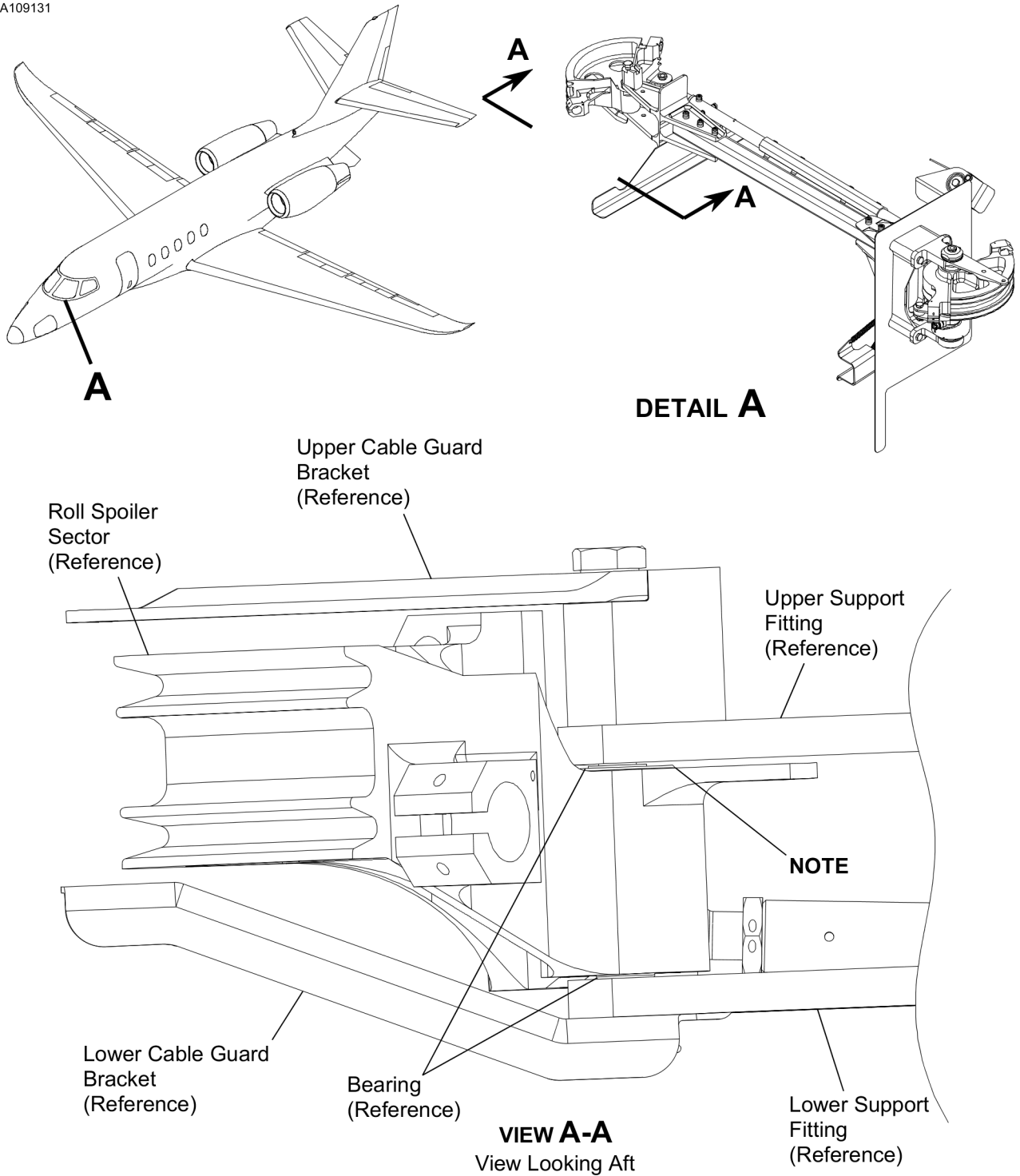
- (f) Remove the roll spoiler sector as follows:
 - 1 Remove the cotter pin from the roll spoiler sector bolt. (Refer to Citation Standard Practice Manual, Chapter 20, Safetying - Maintenance Practices.)
 - 2 Remove the nut and washer and lower cable guard from the roll spoiler sector bolt.
 - 3 Remove the bolt, cable guard spacer, upper cable guard and roll spoiler sector.
 - NOTE:** Do not disconnect the cables from the roll spoiler sector.
 - 4 Make sure the upper MS27641-4 Bearing rotates freely. If the upper bearing does not rotate freely, replace as necessary, (Refer to Citation Standard Practices Manual, Chapter 20, Bearing - Maintenance Practices.)
 - NOTE:** The upper bearing is installed loose and can be removed easily using a pick and/or punch.
- (g) Examine the roll spoiler sector assembly, if any damage is noted, repair the damage as necessary. (Refer to Cessna Model 680A Structural Repair Manual, Chapter 51, Crack, Scratch, Gouge, and Corrosion.)
- (h) Examine the surface of the upper support fitting, if any damage is noted, repair the damage as necessary. (Refer to Cessna Model 680A Structural Repair Manual, Chapter 51, Crack, Scratch, Gouge, and Corrosion.)
 - NOTE:** The NAS75-4-027 Bushing should be installed between the two bearings on the roll spoiler sector assembly.
- (i) Install the roll spoiler sector assembly as follows:
 - 1 If necessary, install one NAS75-4-027 Bushing through the roll sector upper and lower bearings.
 - 2 Install the roll spoiler sector, cable guard spacer, upper cable guard bracket and bolt.
 - 3 Install the lower cable guard bracket, washer and nut on the roll spoiler sector bolt.
 - 4 Torque the roll spoiler bolt. (Refer to Citation Standard Practices Manual, Chapter 20, Torque Data - Maintenance Practices.)
 - 5 Install one MS24665-132 Cotter Pin. (Refer to Citation Standard Practices Manual, Chapter 20, Safetying -Maintenance Practices.)
- (j) Tighten the cockpit spoiler control cable using the turnbuckle. Make sure to only tighten the turnbuckle the amount of turns recorded in Step 2.A.(2)(e).
- (k) Measure the cockpit spoiler control cable tensions. Make sure the cockpit spoiler control cable tension matches the tension recorded in Step 2.A.(2)(b).
 - 1 If the tension falls within the recorded value of Step 2.A.(2)(b), go to Step 2.A.(2)(l).
 - 2 If the tension does not fall within the recorded value of Step 2.A.(2)(b), do the Cockpit Spoiler Control Cable Rigging. (Refer to Cessna Model 680A Maintenance Manual, Chapter 27, Spoiler Control System - Adjustment/Test.)

- (l) Install two MS21256-1 Locking Clips on the cockpit spoiler control cable turnbuckle. (Refer to Citation Standard Practices Manual, Chapter 20, Safetying -Maintenance Practices.)
 - (m) Remove #10 (0.1935) the rigging pins from the roll spoiler disconnect sector and the bottom roll spoiler feed-thru sector. (Refer to Cessna Model 680A Maintenance Manual, Chapter 27, Flight Controls Rigging Pin Locations - Maintenance Practices.)
 - B. Install flight deck floorboard access panel 132BT. (Refer to Cessna Model 680A Maintenance Manual, Chapter 6, Access Plates and Panels Identification.)
 - C. Install the copilot's seat on the flight deck as follows:
 - (1) Before you install the seats, do a visual inspection of the crew seat rails and rail holes.
 - (a) Make sure there are no loose fasteners, Foreign Object Debris (FOD) or other damage.
 - (2) If necessary, move the control column to the forward position.
 - (3) Install the copilot's seat in the aircraft.
 - (4) Operate the TRACK LOCK handle to disengage the stop pins.
 - (5) Lower the copilot's seat until the front roller housings are forward of the seat rails and the aft roller housings align with the opening on the seat rails.
 - (6) Move the copilot's seat fully aft and release the TRACK LOCK handle.
 - (7) Install the forward seat stop bolts, spacers, and nuts on the seat rails.
 - (8) Make sure the copilot's seat operates correctly.
3. Remove the maintenance warning tags and connect the airplane battery.
4. 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 a maintenance tracking system provider.

- 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 the maintenance tracking system provider used.

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NOTE: Make sure there is a minimum of 0.020 inch (0.5 mm) between the upper support fitting surface and the bearing.

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A7460115-1
AA7460115-1

Figure 1. Inspection of the Roll Spoiler Sector Assembly for Missing Bushing (Sheet 1)

MATERIAL INFORMATION

If the examination revealed the roll spoiler sector bushing was not installed and/or the bearing has been damaged, order the parts below to do this service document.

NEW P/N	QUANTITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
MS21256-1	2	Clip	MS21256-1	Discard
MS24665-132	1	Cotter Pin	MS24665-132	Discard
MS27641-4	1	Bearing	MS27641-4	Discard
NAS75-4-027	1	Bushing	N/A	Install

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

FLIGHT CONTROLS - INSPECTION OF THE ROLL SPOILER SECTOR ASSEMBLY FOR MISSING BUSHING

TO:

Cessna Model 680A Aircraft Owner

REASON

To inspect the roll spoiler sector assembly for a missing bushing and any damage that may have happened from scraping and/or clamping loads.

COMPLIANCE

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

LABOR HOURS

WORK PHASE	LABOR-HOURS
Inspection Only	1.00
Modification	13.00

MATERIAL AVAILABILITY

If the examination revealed the roll spoiler sector bushing was not installed, order the part below to do this service document.

PART NUMBER	AVAILABILITY	COST
MS21256-1	*	*
MS24665-132	*	*
MS27641-4	*	*
NAS75-4-027	*	*

* 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.

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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: July 31, 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.

