

TITLE

FLIGHT CONTROLS - WING AILERON SECTOR PIN AND COLLAR INSPECTION

EFFECTIVITY

MODEL	SERIAL NUMBERS
525C (CJ4)	-0195 right side, -0313 thru -0324, -0326 thru -0338, -0340 thru -0345

The equivalent of this service document has been incorporated on production airplanes -0325, -0339, -0346 and On.

REASON

The swage lock fasteners on the left and right wing aileron sectors may not have been correctly installed. Failure to comply with this service letter could result in reduced control or loss of control of the aircraft.

DESCRIPTION

This service document provides parts and instructions to inspect the aileron sector swage lock pins and collars for correct installation and replace if necessary.

COMPLIANCE

MANDATORY. This service document must be accomplished within 10 flight hours from the date of receipt.

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.

MANDATORY**SL525C-27-08****CONSUMABLE MATERIAL**

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

NAME	NUMBER	MANUFACTURER	USE
Isopropyl Alcohol	Commercially Available		To clean parts.
Color Chemical Film Treatment	U074093 (Alodine 1132 Touch n Prep)	Textron Aviation Parts Distribution	To prepare bare aluminum surface for intermediate primer.
Corrosion-Resistant Primer	513 x 419	PRC - Desoto International 5430 San Fernando Road Glendale, CA 91209	To protect against corrosion.
Sealant	U544067S	Textron Aviation Parts Distribution	For shank sealing pins and weather sealing pins and collars.

TOOLING

NAME	NUMBER	MANUFACTURER	USE
Huck Tool	Model Number 244 or equivalent	Huck Flat No.: #3B27, 2nd Floor, 3rd Block, MS Industrial Complex, 488B, 14th Cross Road, 4th Phase, Bangalore, India 560058	To install huck bolts.
Huck Inspection Tool	HG 90 Inspection Tool or equivalent	Huck Flat No.: #3B27, 2nd Floor, 3rd Block, MS Industrial Complex, 488B, 14th Cross Road, 4th Phase, Bangalore, India 560058	To inspect huck bolts.

REFERENCES

- Cessna Model 525C Maintenance Manual
- Cessna Model 525C 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. Connect external electrical and hydraulic power.

WARNING: Before you move the flaps, speed brakes, and ground spoilers, make sure that the area around the flaps, speed brakes, and ground spoilers is clear. This will prevent injuries to personnel and damage to the equipment.

WARNING: Do not apply hydraulic power to the airplane when you do maintenance near the speed brake or the ground spoiler control surfaces or when the rigging pins are installed in the wing aileron sectors. The speed brake and the ground spoiler actuators will retract when hydraulic power is applied and there is no electrical power. Damage to the airplane or injury to personnel can occur.

- C. Deploy the ground spoilers/speed brakes.
 - D. Lower the flaps.
 - E. Make sure that all switches are in the OFF/NORM position.
 - F. Disconnect external electrical and hydraulic power from the airplane.
 - (1) Disconnect external electrical power.
 - (2) Disconnect the airplane battery.
 - G. Attach maintenance warning tags to the battery and external power receptacle that have "**DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS**" written on them.
 - H. Attach maintenance warning tags to the pilot and co-pilot control wheel that have "**DO NOT MOVE CONTROL WHEEL - AILERON MAINTENANCE IN PROGRESS**" written on them.
 - I. Attach maintenance warning tag to the speed brake handle that has "**DO NOT MOVE SPEED BRAKE HANDLE - MAINTENANCE IN PROGRESS**" written on them.
 - J. Attach maintenance warning tag to the flap handle that has "**DO NOT MOVE FLAP HANDLE - MAINTENANCE IN PROGRESS**" written on them.
2. Remove the wing access panels 542AT, 542GB, 642AT, and 642GB for access to the aileron sector. (Refer to the Model 525C Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
 3. Do an inspection of the four NAS7034-9 Pins and NAS1080K04 Collars on the left and right aileron sectors for proper installation.

NOTE: This procedure is for the left and right aileron sector.

- A. Remove all sealant on and around the NAS7034-9 Pins and NAS1080K04 Collars.
- B. Use a HG 90 Inspection Tool to make sure the NAS7034-9 Pins and NAS1080K04 Collars on the aileron sectors are installed correctly.

NOTE: The aileron sector may need to be removed if the collar inspection cannot be completed with the aileron sector installed in the airplane.

NOTE: If a HG 90 inspection tool or the equivalent is not available, please contact Team 525 at (316) 517-7785 for further instructions.

- C. If all the NAS7034-9 Pins and NAS1080K04 Collars are installed correctly, go to Step 6.
- D. If any of the NAS7034-9 Pins and NAS1080K04 Collars are not installed correctly, go to Step 4.

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4. (Refer to Figure 1, Sheet 1.) Replace any NAS7034-9 Pin and NAS1080K04 Collar that is not installed correctly.
 - A. Remove the affected aileron sector. (Refer to the Model 525C Maintenance Manual, Chapter 27, Wing Aileron Sector - Removal/Installation.)
 - B. Remove the affected NAS7034-9 Pin and NAS1080K04 Collar.
 - C. Measure the hole diameter in multiple locations to make sure the hole is 0.124 to 0.1277 inch-diameter.
 - (1) If the hole is 0.124 to 0.1277 inch-diameter, go to step 4.C.(1)(a).
 - (a) Make sure all exposed bare material is protected with a color chemical film treatment and corrosion resistant primer. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
 - (b) No further action is required, go to Step 4.C.(3)
 - (2) If the hole is not 0.124 to 0.1277 inch-diameter, use a ream to increase the hole size to 0.155 to 0.1585 inch-diameter.
 - (a) Protect all exposed bare material with color chemical film treatment and corrosion resistant primer. (Refer to the Model 525C Structural Repair Manual, Chapter 51, Protective Treatment of Metal.)
5. Install aileron sector(s) and complete all travel checks/adjustments. (Refer to the Model 525C Maintenance Manual, Chapter 27, Wing Aileron Sector - Removal/Installation.)
6. Install the removed wing access panels 542AT, 542GB, 642AT, and 642GB. (Refer to the Model 525C Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
7. Make an entry in the airplane logbook that states compliance and method of compliance with this service document.

NOTE: When the hole is reamed to the next size, a NAS7035-9 Pin and NAS1080K05 Collar will be used.

NOTE: This step is only required for sector(s) that were removed for pin replacement.

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.

MANDATORY

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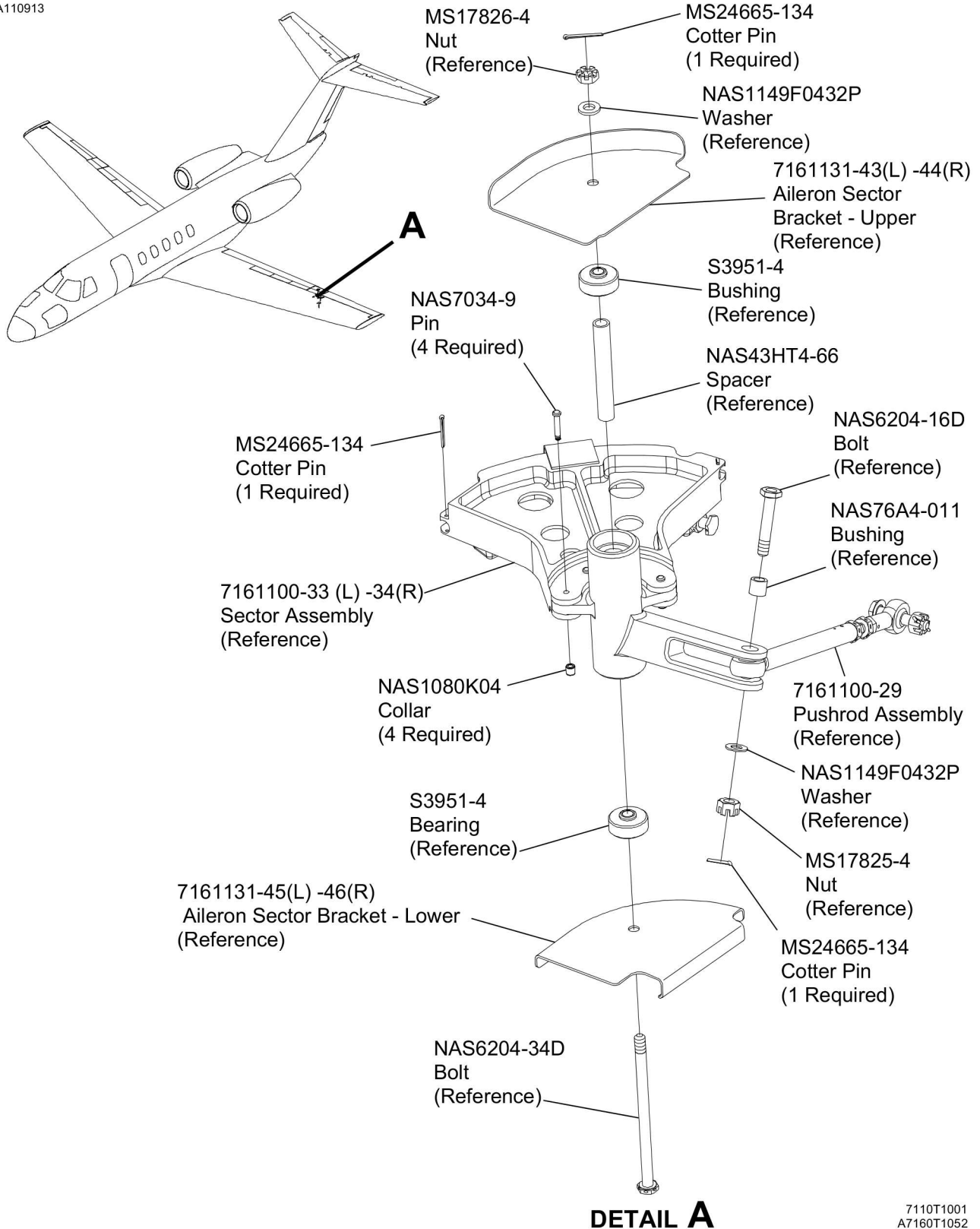


Figure 1. Aileron Sector (Sheet 1)

MANDATORY**SL525C-27-08****MATERIAL INFORMATION**

The parts below may be necessary to complete this service document.

NEW P/N	QUANTITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
MS24665-134	As Necessary	Cotter Pin	Same	As necessary
NAS1080K04	As Necessary	Collar for NAS7034-9	NAS1080K04	As necessary
NAS1080K05	As Necessary	Collar for NAS7035-9	NAS1080K04	As necessary
NAS7034-9	As Necessary	Pin	NAS7034-9	As necessary
NAS7035-9	As Necessary	Pin	NAS7034-9	As necessary

* 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 - WING AILERON SECTOR PIN AND COLLAR INSPECTION

TO:

Cessna Model 525C Aircraft Owner

REASON

The swage lock fasteners on the left and right wing aileron sectors may not have been correctly installed. Failure to comply with this service letter could result in reduced control or loss of control of the aircraft.

COMPLIANCE

MANDATORY. This service document must be accomplished within 10 flight hours.

LABOR HOURS

WORK PHASE	LABOR-HOURS
Inspection	1.0
Modification	15.0

MATERIAL AVAILABILITY

PART NUMBER	AVAILABILITY	COST
MS24665-134	*	*
NAS1080K04	*	*
NAS1080K05	*	*
NAS7034-9	*	*
NAS7035-9	*	*

* 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

Eligible airplanes exhibiting conditions described in this service document may demonstrate improved operation by incorporation of the work described herein. This service document is to be accomplished at the *discretion* of the owner. Eligible airplanes may qualify for parts and labor coverage to the extent noted in the *Labor Hours* and *Material Availability* sections of this document.

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

January 15, 2021

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

This document contains technical data and is subject to U.S. export regulations. This information has been exported from the United States in accordance with export administration regulations. Diversion contrary to U.S. law is prohibited. ECCN: 9E991

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 15, 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.