

TITLE

AIR CONDITIONING - AIR CYCLE MACHINE (ACM) EXHAUST DUCT DRAINAGE IMPROVEMENT

EFFECTIVITY**MODEL**

680A (Citation Latitude)

SERIAL NUMBERS

-0001 thru -0272

The equivalent of this service document has been incorporated on production airplanes -0273 and On.

REASON

To add a drain to the Air Cycle Machine (ACM) exhaust duct for rain water drainage to prevent water from pooling.

DESCRIPTION

This service document provides parts and instructions to add a drain to the Air Cycle Machine (ACM) exhaust duct.

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

February 26, 2021

SB680A-21-04

Page 1 of 6

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

COPYRIGHT © 2021

CONSUMABLE MATERIAL

In addition to the kit below, you must use the consumable materials that follow, or their equivalent, to complete this service bulletin.

NAME	NUMBER	MANUFACTURER	USE
Sealant	U065013	Textron Aviation Parts Division	To bond and seal parts.

TOOLING

No specialized tooling is required to complete this service document.

WEIGHT AND BALANCE INFORMATION

Negligible

REFERENCES

Cessna Model 680A Maintenance Manual.

PUBLICATIONS AFFECTED

Cessna Model 680A Illustrated Parts Catalog

ACCOMPLISHMENT INSTRUCTIONS

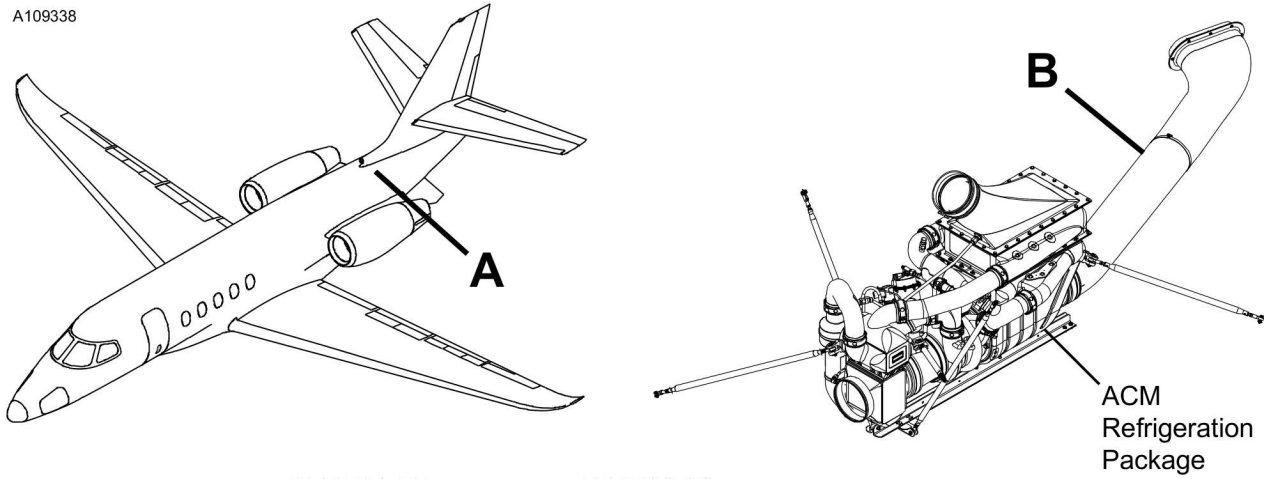
1. Prepare the airplane for maintenance.
 - A. Make sure that the airplane is electrically grounded.
 - B. Make sure that all switches are in the OFF/NORM position.
 - C. Disconnect electrical power from the airplane.
 - (1) Disconnect external electrical power.
 - (2) Disconnect the airplane batteries.
 - D. Attach maintenance warning tags to the batteries and external power receptacle that have **"DO NOT CONNECT ELECTRICAL POWER - MAINTENANCE IN PROGRESS"** written on them.
2. Remove the Air Cycle Machine (ACM) exhaust duct. (Refer to the Model 680A Maintenance Manual, Chapter 21, Air Cycle Machine Exhaust Assembly - Removal/Installation.)
3. (Refer to Figure 1, Sheet 1.) Install the 7414521-55 Exhaust Drain Assembly.
 - A. Locate and drill a 0.375 inch diameter hole 2.25 inches from the forward end of the bottom of the exhaust duct.
 - B. Deburr the drilled hole and clean debris from the exhaust duct.
 - C. Locate and bond the 7414521-55 Exhaust Drain Assembly to the 7414521-33 Exhaust Duct per Type V, Class B. (Refer to Cessna Standard Practices Manual, Chapter 20, Adhesive And Solvent Bonding - Maintenance Practices.)
4. Install the Air Cycle Machine (ACM) exhaust duct. (Refer to the Model 680A Maintenance Manual, Chapter 21, Air Cycle Machine Exhaust Assembly - Removal/Installation.)
5. (Refer to Figure 1, Sheet 2.) Install the exhaust duct drain line.
 - A. Measure and cut the lower aft drain line approximately two to three inches down from the top of the drain line off the Air Cycle Machine (ACM).
 - B. Install the S3017-6-6-6 Tee with two NAS1922-0050-3 Clamps.
 - C. Install the new R221236 Tube on to the 7414521-55 Drain Assembly with one NAS1922-0050-3 Clamp.

- D. Hold the R221236 Tube in place up to the S3017-6-6-6 Tee so that the R221236 Tube has a downward flow toward the S3017-6-6-6 Tee.
 - E. Mark the R221236 Tube and cut it to length.
 - F. Install the R221236 Tube with one NAS1922-0050-3 Clamp on to the S3017-6-6-6 Tee.
 - G. Discard any excess R221236 Tube.
6. Remove the maintenance warning tags and connect the airplane batteries.
 7. 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.

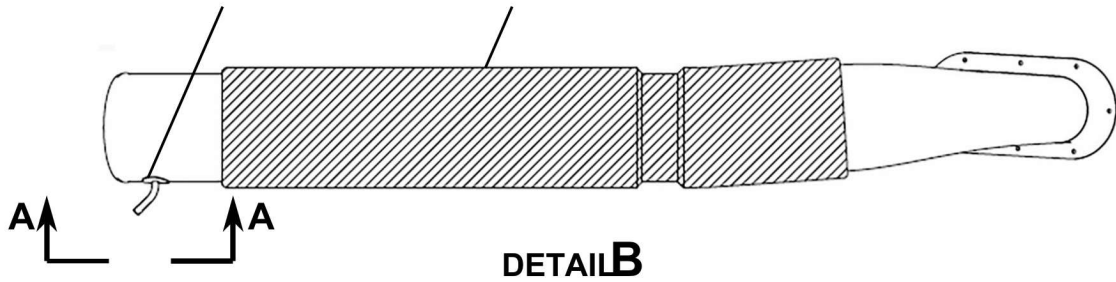
A109338



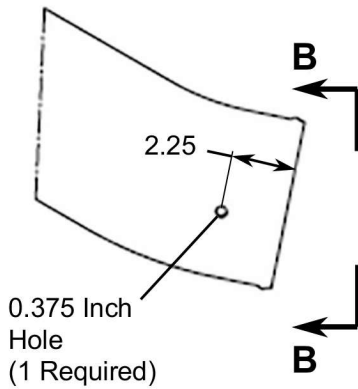
7414521-55
Drain Assembly
(1 Required)

7414521-33
Exhaust Duct Assembly
(Reference)

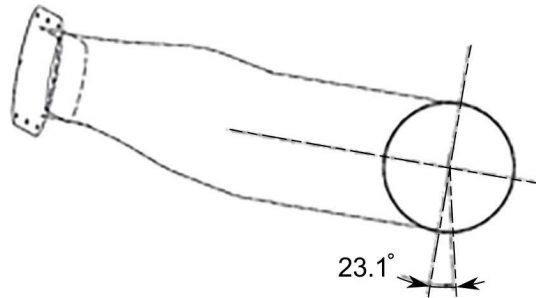
DETAIL A



DETAIL B



VIEW A-A



VIEW B-B
NOTE

NOTE: Hole location will be 6:00 position when duct is installed.

Figure 1. 7414521-56 ACM Exhaust Drain Assembly (Sheet 1)

A109572

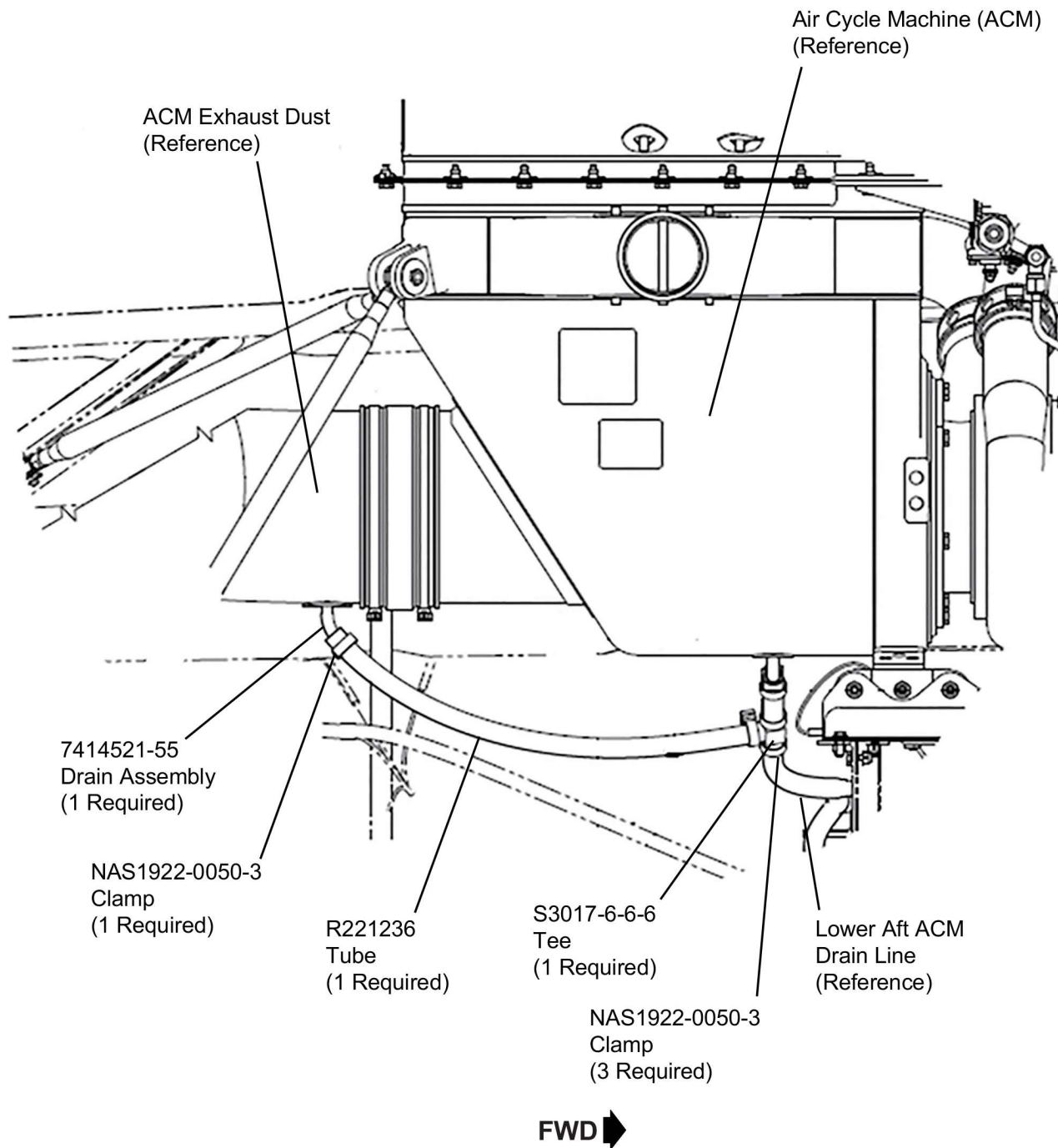


Figure 1. 7414521-56 ACM Exhaust Drain Assembly (Sheet 2)

MATERIAL INFORMATION

Order the kit/parts below to install this modification.

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
SB680A-21-04	1	Kit , consisting of the following parts:		
7414521-55	1	Drain Assembly		
7414521-20	1	Gasket		
S3017-6-6-6	1	Tee		
NAS1922-0050-3	4	Clamp		
R221236	18 inches	Tube		
SB680A-21-04	1	Instructions		

* Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document.

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

TITLE

AIR CONDITIONING - AIR CYCLE MACHINE (ACM) EXHAUST DUCT DRAINAGE IMPROVEMENT

TO:

Cessna Model 680A (Citation Latitude) Aircraft Owner

REASON

To add a drain to the Air Cycle Machine (ACM) exhaust duct for rain water drainage to prevent water from pooling.

COMPLIANCE

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

LABOR HOURS

WORK PHASE	LABOR-HOURS
Modification	As Necessary

MATERIAL AVAILABILITY

Order the parts below to complete this service document.

PART NUMBER	AVAILABILITY	COST
SB680A-21-04	*	*

*Please contact your Regional Textron Aviation Parts Distribution Customer Support Team for current cost and availability of parts listed in this service document.

For more information, please visit the TAPD Support & Aftermarket Account Management website at <https://ww2.txtav.com/Parts/Promos/TAPD>.

Based on availability and lead times, parts may require advanced scheduling.

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.

