

## REVISION TRANSMITTAL

This sheet transmits Revision 1 to SL525-55-04, which:

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

**NOTE:** This revision replaces the original issue of SL525-55-04 in its entirety.

### REVISION COMPLIANCE

NO EFFECT.

### LOG OF REVISIONS

Original Issue	June 2, 2021
Revision 1	July 22, 2021



**TITLE**

STABILIZERS - LOWER HINGE BRACKET IN VERTICAL STABILIZER FASTENER INSPECTION

**EFFECTIVITY****MODEL**

525 (M2)

**SERIAL NUMBERS**

-0912 thru -1070

**REASON**

To inspect the lower hinge bracket in vertical stabilizer for correct fastener installation.

**DESCRIPTION**

This service letter provides instructions to do an inspection of the lower hinge bracket in vertical stabilizer for proper fastener installation and correct if necessary.

**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.

**CONSUMABLE MATERIAL**

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

**TOOLING**

No specialized tooling is required to complete this service document.

**REFERENCES**

Cessna Model 525 (0685 and 0800 and On) Maintenance Manual

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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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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 batteries.
    - (2) Disconnect external electrical power.
  - 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 tailcone stinger. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 53, Tailcone Stinger - Removal/Installation.)
3. (Refer to Figure 1, Detail A). Make sure that the six each AN3-6A Bolts, NAS1149F0363P Washers and MS21044N3 Nuts installs the 6361303-5 Bearing Plate Assembly to the 6361303-6 Hinge Bracket.
  - A. If the number of bolts, washers and nuts are correct, the go to step 4.
  - B. If the number of bolts, washers and nuts are not correct, then install the required number of the bolts, washers and nuts. Remove the rudder if required to install missing hardware. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 55, Rudder - Removal/Installation).
    - (1) Torque the bolts to standard torque value. (Refer to the Citation Standard Practices Manual, Chapter 20, Torque Data - Maintenance Practices).
4. (Refer to Figure 1, Detail A). Make sure that the four each AN3-7A Bolts, NAS1149F0363P Washers and MS21044N3 Nuts installs the 6361303-5 Bearing Plate Assembly to the 6361303-6 Hinge Bracket.
  - A. If the number of bolts, washers and nuts are correct, the go to step 5.
  - B. If the number of bolts, washers and nuts are not correct, then install the required number of the bolts, washers and nuts. Remove the rudder if required to install missing hardware. Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 55, Rudder - Removal/Installation).
    - (1) Torque the bolts to standard torque value. (Refer to the Citation Standard Practices Manual, Chapter 20, Torque Data - Maintenance Practices).
5. (Refer to Figure 1, Detail A). Make sure that the two each AN3-10A Bolts, NAS1149F0363P Washers, NAS1149F0332P Washers and MS21044N3 Nuts installs the 6361303-18 Rigging Bracket to the 6361303-5 Bearing Plate Assembly.
  - A. If the number of bolts, washers and nuts are correct, the go to step 6.
  - B. If the number of bolts, washers and nuts are not correct, then install the required number of the bolts, washers and nuts. Remove the rudder if required to install missing hardware. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 55, Rudder - Removal/Installation).
    - (1) Torque the bolts to standard torque value. (Refer to the Citation Standard Practices Manual, Chapter 20, Torque Data - Maintenance Practices).
6. If removed, install the rudder. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 55, Rudder - Removal/Installation).
7. Connect the rudder control cables and tension the rudder control cables, if required. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 27, Rudder and Tab System - Adjustment/Test).

8. Touch-up the paint as necessary. (Refer to the Citation Standard Practices Manual, Chapter 20, Exterior Finish - Cleaning/Painting.)
9. Check the rigging of rudder and rudder trim tab, if required. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 27, Rudder and Tab System - Adjustment/Test.)
10. Install the tailcone stinger. (Refer to the Model 525 (0685 and 0800 and On) Maintenance Manual, Chapter 53, Tailcone Stinger - Removal/Installation.)
11. Remove the maintenance warning tags and connect the airplane batteries.
12. 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.



**MATERIAL INFORMATION**

It may be necessary to order the parts below to install this modification.

<b>NEW P/N</b>	<b>QUAN- TITY</b>	<b>KEY WORD</b>	<b>OLD P/N</b>	<b>INSTRUCTIONS/ DISPOSITION</b>
AN3-6A	If Required	Bolt	Same	Discard
AN3-7A	If Required	Bolt	Same	Discard
AN3-10A	If Required	Bolt	Same	Discard
MS21044N3	If Required	Nut	Same	Discard
NAS1149F0332P	If Required	Washer	Same	Discard
NAS1149F0363P	If Required	Washer	Same	Discard

\* 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](mailto:parts@txtav.com).





**TITLE**

STABILIZERS - LOWER HINGE BRACKET IN VERTICAL STABILIZER FASTENER INSPECTION

**TO:**

Citation M2 Owner

**REASON**

To inspect the lower hinge bracket in vertical stabilizer for correct fastener installation.

**COMPLIANCE**

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

**LABOR HOURS**

WORK PHASE	MAN-HOURS
Inspection	1.5
Modification	1.5 for replacement of hardware without removing the rudder
Modification	10.0 for replacement of hardware with rudder removal

**MATERIAL AVAILABILITY**

It may be necessary to order the parts below to install this modification.

PART NUMBER	AVAILABILITY	COST
AN3-6A	*	*
AN3-7A	*	*
AN3-10A	*	*
MS21044N3	*	*
NAS1149F0332P	*	*
NAS1149F0363P	*	*

\* 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.

**WARRANTY**

Eligible airplanes exhibiting conditions described in this service document may demonstrate improved operation by incorporation of the work described herein

June 2, 2021

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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.

**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](http://ww2.txtav.com/Parts) or email the completed Textron Aviation Claim Form to [warranty@txtav.com](mailto: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:** June 2, 2023

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](http://www.txtavsupport.com) to register.