

## REVISION TRANSMITTAL

This sheet transmits Revision 1 to SL680-30-09, which:

- A. Adds Step 2 to remove access panels 165AL and 166AR.
- B. Adds Step 3 to inspect for chafing between the tube assemblies and replace them, if necessary.
- C. Adds Step 5 to remove the top doubler.
- D. Adds Step 4.B.1.(2) to allow the sealant to cure for 24 hours.
- E. Adds Step 5 to install the top doubler.
- F. Adds Step 6 to install the landing light.
- G. Adds Step 7.A to allow the sealant to cure for 24 hours.
- H. Adds Step 8 to install access panels 153BL and 154BR.
- I. Adds Figure 1, Sheet 3 which shows removal and installation of the top doubler.
- J. Adds Figure 1, Sheet 4 and Sheet 5 to show assembly of the inboard and outboard Tube Weld Assemblies.
- K. Adds the table to the MATERIAL INFORMATION section.

**NOTE:** This revision replaces the original issue of SL680-30-09 in its entirety.

### REVISION COMPLIANCE

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

### LOG OF REVISIONS

Original Issue	January 31, 2020
Revision 1	February 18, 2022



**TITLE**

ICE AND RAIN PROTECTION - ADD SEALANT BETWEEN PICCOLO TUBES AND LANDING LIGHT BOX FASTENERS TO PREVENT CHAFING

**EFFECTIVITY**

MODEL	SERIAL NUMBERS
680 (Citation Sovereign)	-0001 thru -0349
680 (Citation Sovereign+)	-0501 thru -0591

**REASON**

To make sure that sealant has been applied between the piccolo tubes and add sealant to the landing light box fasteners to prevent chafing.

**DESCRIPTION**

This service letter provides instructions to add sealant between the piccolo tubes if not present and add sealant to the landing light box fasteners.

**COMPLIANCE**

DISCRETIONARY. 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.

**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
Sealant	U065013S, Type V, Class B	Textron Aviation Parts Distribution 7121 Southwest Boulevard Wichita, KS 67215	To seal between the piccolo tubes and the light box fasteners.

**TOOLING**

No specialized tooling is required to complete this service document.

**REFERENCES**

Cessna Model 680 Maintenance Manual  
 Citation Standard Practices Manual  
 Cessna Model 680 Structural Repair 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 access panels 165AL and 166AR. (Refer to the Model 680 Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
3. Inspect the for chafing between the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly where the tubes come together above the light box assembly.
  - A. Remove the left and right leading edge light box assembly. (Refer to the Model 680 Maintenance Manual, Chapter 30, Wing Leading Edge Anti-Ice System - Maintenance Practices.)
  - B. Remove the left and right landing light. (Refer to the Model 680 Maintenance Manual, Chapter 33, Landing, Taxi and Recognition Lights - Maintenance Practices.)
  - C. (Refer to Figure 1, Detail B.) Remove the left and right top doubler.
    - (1) Remove and discard the rivets from the top doubler. (Refer to the 680 Structural Repair Manual, Chapter 51, Fastener Installation and Removal.)
    - (2) Remove and keep the screws.
    - (3) Remove and keep the top doubler.
  - D. (Refer to Figure 1, View A-A.) Inspect the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly.
    - (1) If there is not excessive chafing damage between the piccolo tubes or tube assemblies, go to Step 4.
    - (2) If there is excessive chafing damage between the piccolo tubes or tube assemblies, do the steps that follow. (Refer to the Model 680 Maintenance Manual, Chapter 30, Wing Anti-Ice Piccolo Tube Assembly - Removal/Installation.)

- (3) (Refer to Figure 1, Detail A, Detail C, Detail D, Detail E and Detail F.) If necessary, assemble the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assemblies.
    - (a) Put the five 6922560-1 Tube Spacers on each 6922551-47 Left, 6922551-48 Right Inboard Tube Weld Assemblies.
      - 1 Drill one Number 30 (0.128 inch-diameter) hole in each 6922560-1 Tube Spacer.
    - (b) Put the two 6922560-4 Inboard Air Dams on each 6922551-47 Left, 6922551-48 Right Inboard Tube Weld Assemblies.
      - 1 Drill one Number 30 (0.128 inch-diameter) hole in each 6922560-4 Inboard Air Dam.
    - (c) Remove the 6922560-1 Tube Spacers and 6922560-4 Inboard Air Dams from the 6922551-47 Left, 6922551-48 Right Inboard Tube Weld Assemblies.
    - (d) Deburr the holes that were drilled.
    - (e) Attach the 6922560-1 Tube Spacers and 6922560-4 Inboard Air Dams to each 6922551-47 Left, 6922551-48 Right Inboard Tube Weld Assemblies with one S2907-4-5 Rivet.
  - (4) Replace the damaged piccolo tubes or tube assemblies, as necessary. (Refer to the Model 680 Maintenance Manual, Chapter 30, Wing Anti-Ice Piccolo Tube Assembly - Removal/Installation.)
  - (5) (Refer to Figure to Figure 1, Detail A, Detail B and View A-A.) Fillet seal between the replaced piccolo tubes or tube assemblies with U065013S (Type V, Class B) Sealant. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure and High Temperature Sealing - Maintenance Practices.)
    - (a) Allow the sealant to cure for 24 hours.
  - (6) Go to Step 5.
4. (Refer to Figure 1, Detail A, View A-A and View B-B.) Inspect for sealant between the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly where the tubes come together above the light box assembly.
- A. If there is a fillet seal between the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly, go to Step 5.
  - B. If there is not a fillet seal between the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly, do the following step.
    - (1) (Refer to Figure 1, Detail A, View A-A and View B-B.) Fillet seal between the 6914060-59 Left, 6914060-60 Right Tube Assembly and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly with U065013S (Type V, Class B) Sealer. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure and High Temperature Sealing - Maintenance Practices.)
      - (2) Allow the sealant to cure for 24 hours.
  - C. Go to Step 5.
5. (Refer to Figure 1, Detail A, Detail B and View A-A.) Install the left and right top doubler.
- A. Put the top doubler on the light box top.
  - B. Attach the top doubler to the light box top with the kept screws and 6 CR3214-4-04 Rivets.
6. Install the left and right landing light. (Refer the Model 680 Maintenance Manual, Chapter 33, Landing Light - Removal/Installation.)
7. (Refer to Figure 1, Detail A, and View A-A .) Fillet seal between the fasteners on top of the Light Box Back and the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly.) with U065013S (Type V,

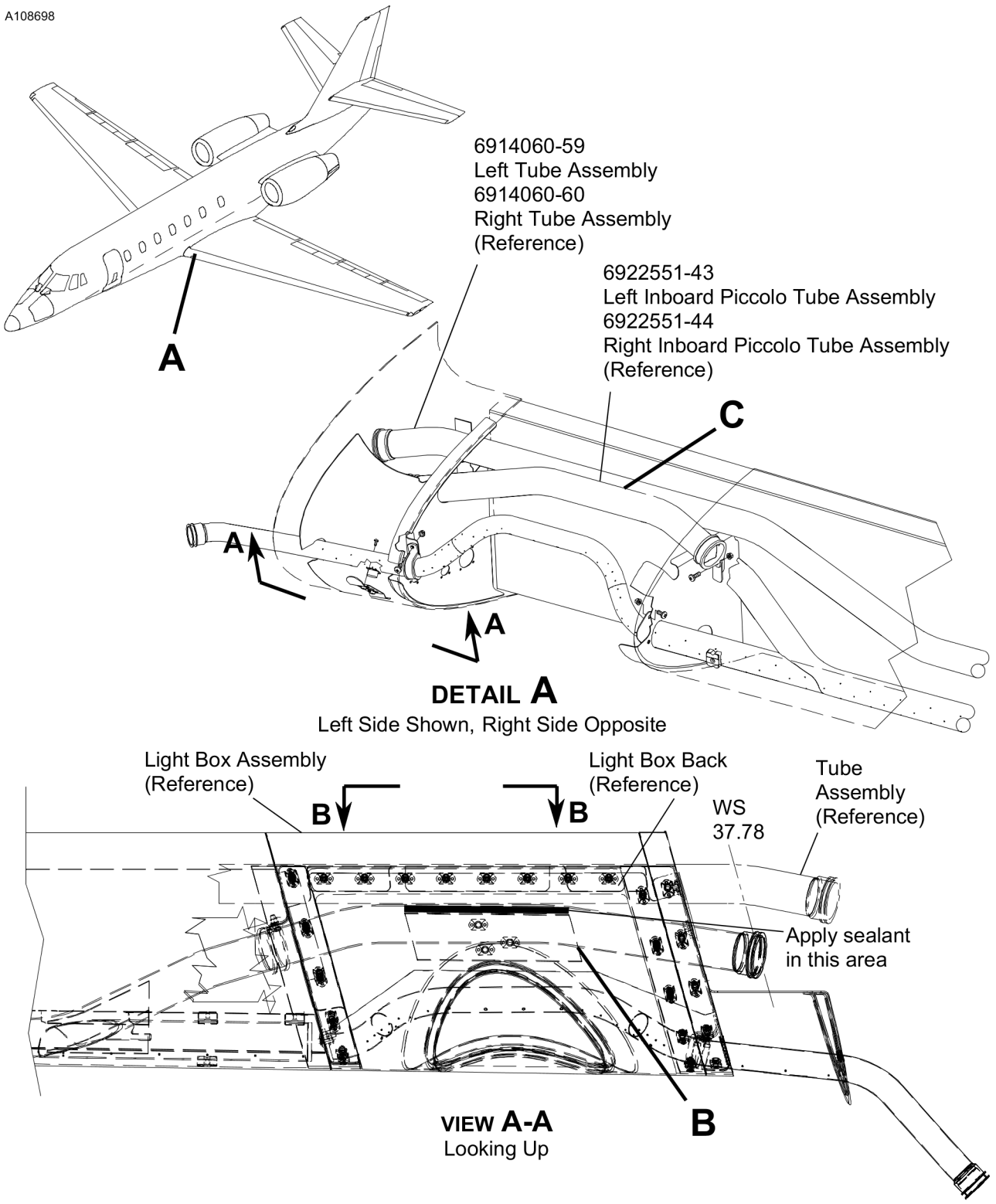
Class B) Sealer. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure and High Temperature Sealing - Maintenance Practices.)

- A. Allow the sealant to cure for 24 hours.
8. Install access panels 165AL and 166AR. (Refer to the Model 680 Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
9. Remove the maintenance warning tags and connect the airplane battery.
10. 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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6910T1001  
A6914T1111  
AA6922515-1

Figure 1. Sealing Between Piccolo Tubes And Light Box Fasteners (Sheet 1)

A108767

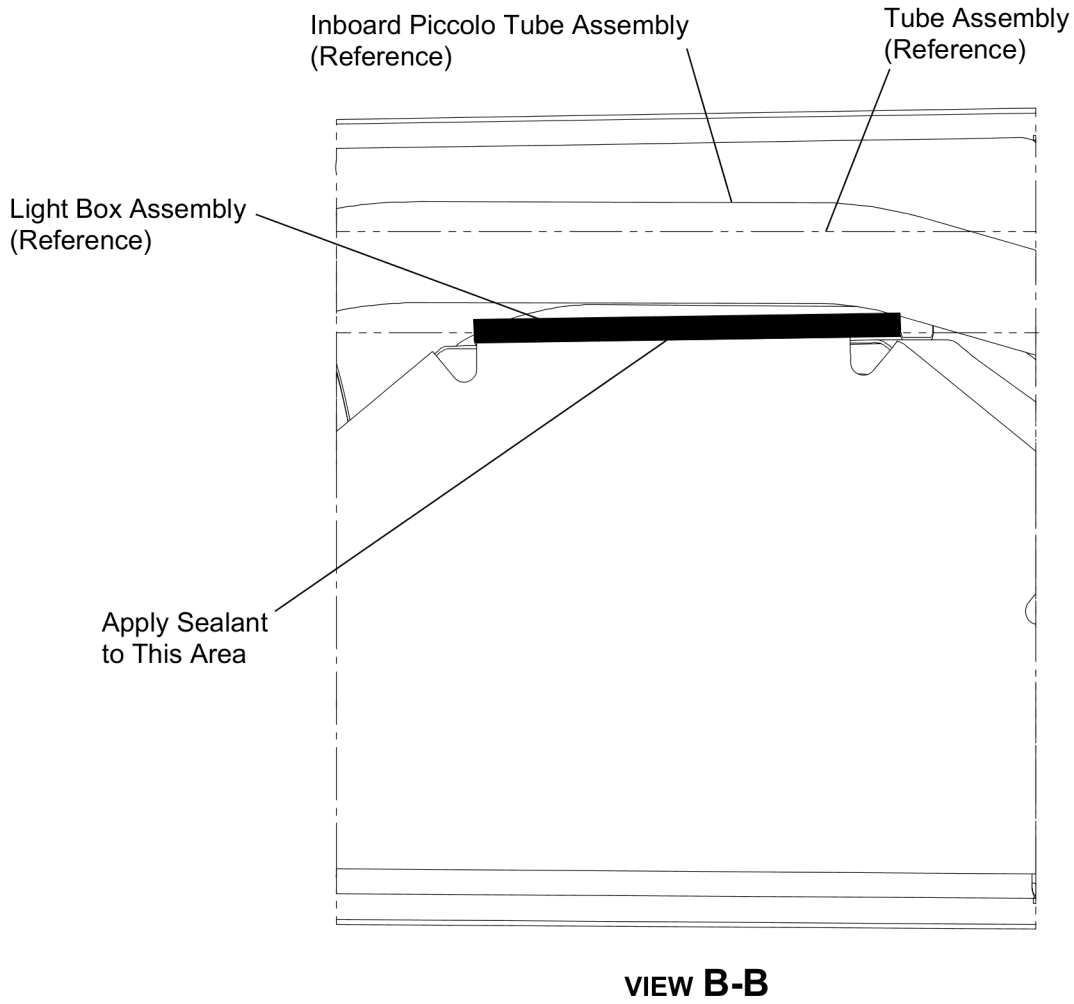
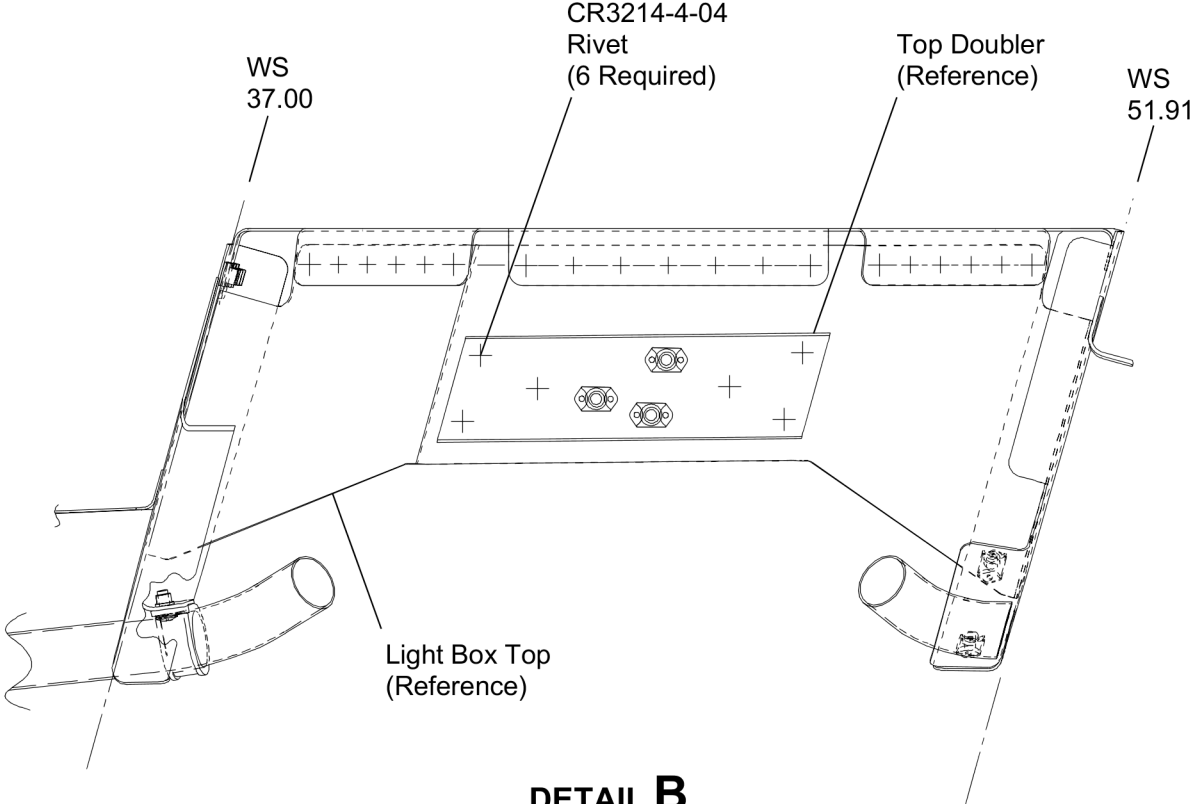


Figure 1. Sealing Between Piccolo Tubes And Light Box Fasteners (Sheet 2)

6922510-17



A109274

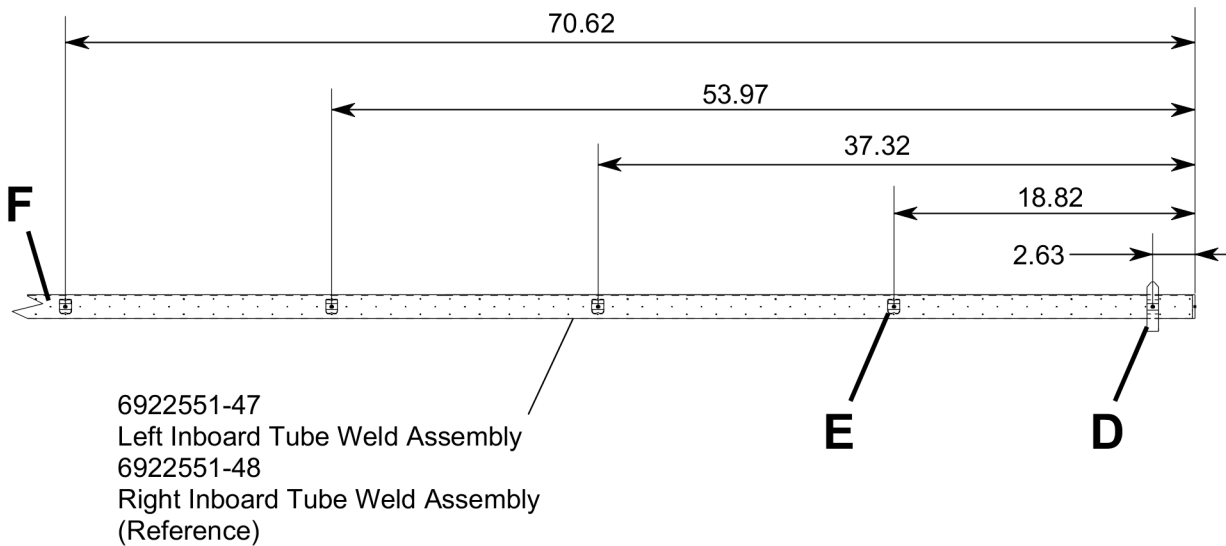


**DETAIL B**  
Left Side Shown,  
Right Side Typical

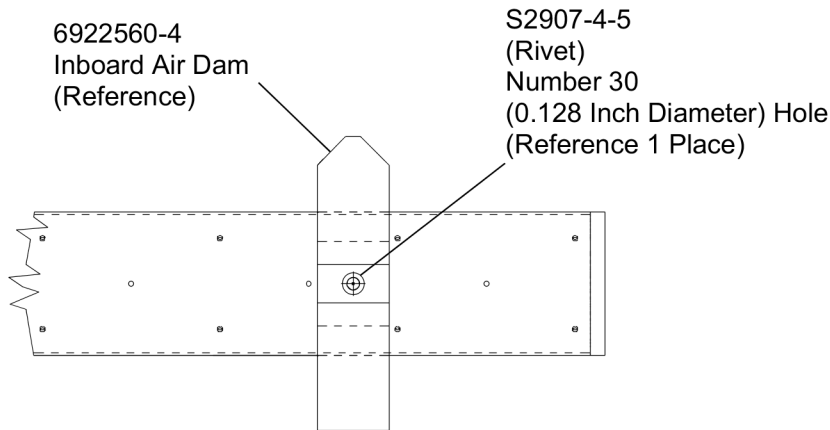
Figure 1. Sealing Between Piccolo Tubes And Light Box Fasteners (Sheet 3)

B6922515-1

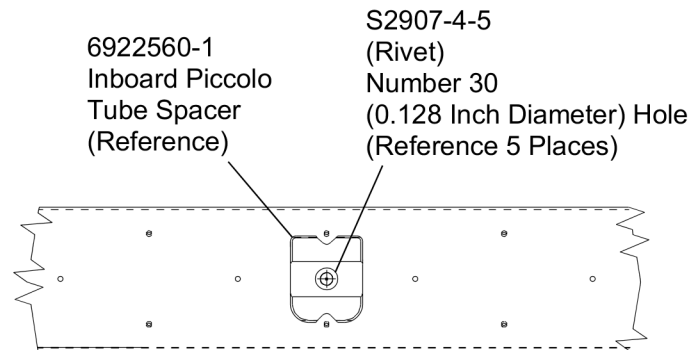
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**DETAIL C**



**DETAIL D**



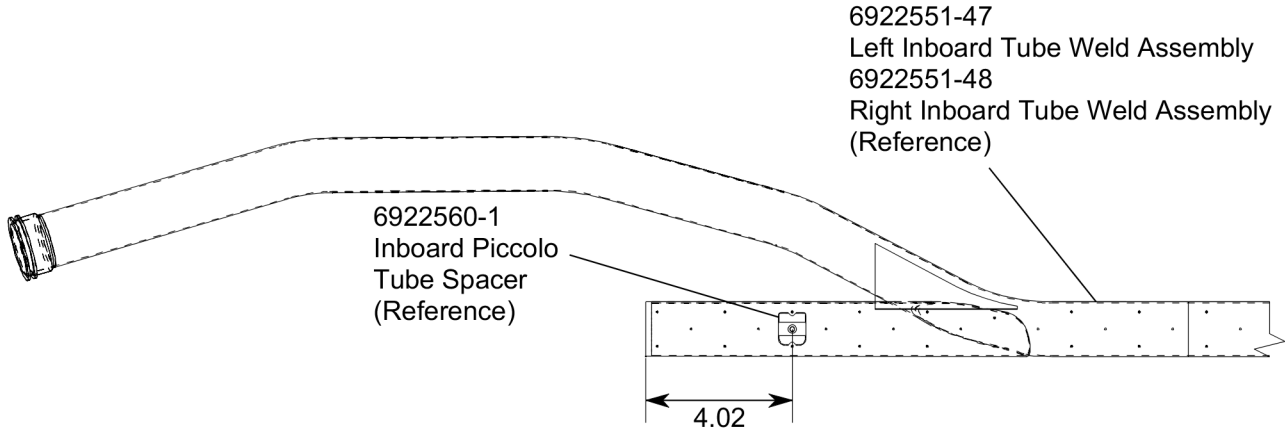
**DETAIL E**

**NOTE:** All Dimensions are in Inches

C6922T515-1  
 D6922T515-1  
 E6922T515-1

Figure 1. Sealing Between Piccolo Tubes And Light Box Fasteners (Sheet 4)

A109832



**DETAIL F**

**NOTE:** All Dimensions are in Inches

F6922T515-1

Figure 1. Sealing Between Piccolo Tubes And Light Box Fasteners (Sheet 5)

**MATERIAL INFORMATION**

It may be necessary to order the following parts to complete this service letter.

<b>NEW P/N</b>	<b>QUAN- TITY</b>	<b>KEY WORD</b>	<b>OLD P/N</b>	<b>INSTRUCTIONS/ DISPOSITION</b>
S2907-4-5	12	Rivet		
CR3214-4-04	12	Rivet		
6914060-59	1	Left Tube Assembly	Same	
6914060-60	1	Right Tube Assembly	Same	
6922551-47	1	Left Inboard Tube Weld Assembly	Same	
6922551-48	1	Right Inboard Tube Weld Assembly	Same	
6922560-1	10	Inboard Piccolo Tube Spacer	Same	
6922560-4	2	Inboard Air Dam	Same	

**TITLE**

ICE AND RAIN PROTECTION - ADD SEALANT BETWEEN PICCOLO TUBES AND LANDING LIGHT BOX FASTENERS TO PREVENT CHAFING

**TO:**

Cessna Citation Sovereign Owner

**REASON**

To make sure that sealant has been applied between piccolo tubes and add sealant to the landing light box fasteners to prevent chafing.

**COMPLIANCE**

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

**LABOR HOURS**

WORK PHASE	LABOR-HOURS
Test and Inspection	8.0
Modification	80.0

**MATERIAL AVAILABILITY**

It may be necessary to order the following parts to complete this service letter.

PART NUMBER	AVAILABILITY	COST
S2907-4-5	*	*
CR3214-4-04	*	*
6914060-59	*	*
6914060-60	*	*
6922551-47	*	*
6922551-48	*	*
6922560-1	*	*
6922560-4	*	*

\* 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.

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**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.

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