

## REVISION TRANSMITTAL

This sheet transmits Revision 1 to SL680A-30-01, which:

- A. Adds Step 2 to remove access panels 153BL and 154BR.
- B. Adds Step 3 to inspect for chafing between the tube assemblies and replace them, if necessary.
- C. Adds Step 4.B.(2) to allow the sealant to cure for 24 hours.
- D. Adds Step 5 to install the top doubler.
- E. Adds Step 6 to install the left and right landing light.
- F. Adds Step 7.A. to allow the sealant to cure for 24 hours.
- G. Adds Step 8 to install access panels 153BL and 154BR.
- H. Adds the table to the MATERIAL INFORMATION section.
- I. Adds Figure 1, Sheet 3 to show 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.

**NOTE:** This revision replaces the original issue of SL680A-30-01 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**

680A (Citation Latitude)

**SERIAL NUMBERS**

-0001 thru -0229

The equivalent of this service document has been incorporated on production airplanes -0230 and On.

**REASON**

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

**DESCRIPTION**

This service letter provides instructions to add sealant between 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 680A Maintenance Manual  
Citation Standard Practices Manual  
Cessna Model 680A Maintenance 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 153BL and 154BR. (Refer to the Model 680A Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
3. Inspect for chafing between the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and 7420411-1 Left, 7420411-2 Right Tube Assembly.
  - A. Remove the left and right leading edge light box assembly. (Refer to the Model 680A Maintenance Manual, Chapter 57, Wing Leading Edge Light Box Assembly - Removal/Installation.)
  - B. Remove the left and right landing light. (Refer to the Model 680A Maintenance Manual, Chapter 33, Landing Lights - Removal/Installation.)
  - 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 680A 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, Detail A and View A-A.) Inspect the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and 7420411-1 Left, 7420411-2 Right 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 680A Maintenance Manual, Chapter 30, Wing Anti-Ice Piccolo Tube Assembly - Removal/Installation.)

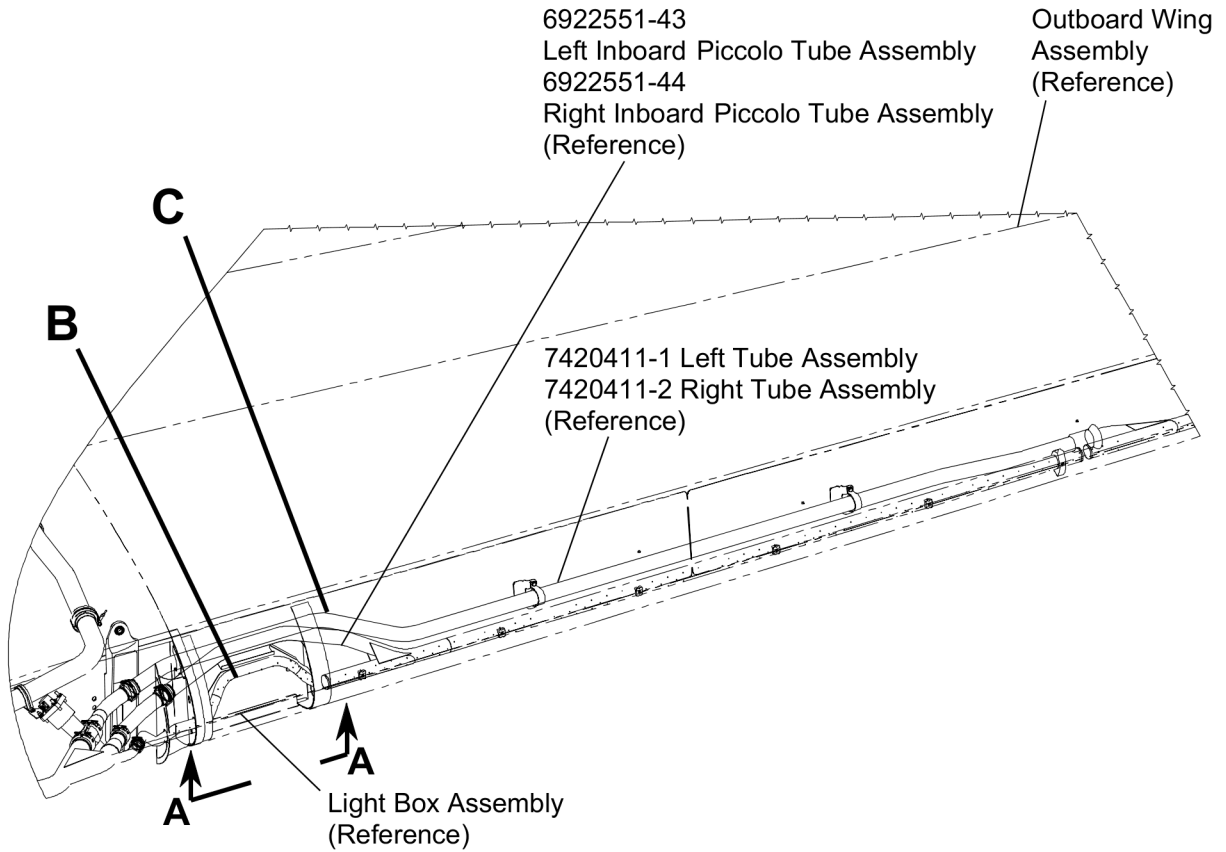
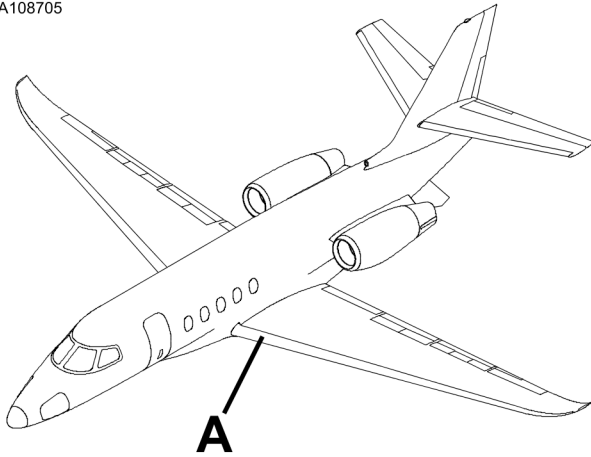
- (3) (Refer to Figure 1, Detail A, Detail C, Detail D, Detail E and Detail F.) If necessary, assemble the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assemblies.
    - (a) Put the five 6922560-1 Tube Spacers on each 6922551-47 Left, 6922551-48 Right Inboard Tube Weld Assemblies.
      - 1 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 the 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 680A Maintenance Manual, Chapter 30, Wing Anti-Ice Piccolo Tube Assembly - Removal/Installation.)
  - (5) (Refer to Figure 1, Detail, Detail B and View A-A.) Fillet seal between the replaced piccolo tubes or tube assemblies with U065012S (Type V, Class B) Sealant. (Refer to the Citation Standard Practices Manual, Chapter 20, Fuel, Weather, Pressure and High Temperature Sealing - Maintenance Practices.)
  - (6) Go to Step 5.
4. (Refer to Figure 1, Detail A, View A-A and View B-B.) Inspect for sealant between the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and the 7420411-1 Left, 7420411-2 Right Tube Assembly where the tubes come together above the light box assembly.
    - A. If there is a fillet seal between the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and the 7420411-1 Left, 7420411-2 Right Tube Assembly, go to Step 6.
    - B. (Refer to Figure 1, View A-A.) If there is not a fillet seal between the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and the 7420411-1 Left, 7420411-2 Right Tube Assembly, do the following step.
      - (1) Fillet seal between the 6922551-43 Left, 6922551-44 Right Inboard Piccolo Tube Assembly and the 7420411-1 Left, 7420411-2 Right Tube Assembly with U065012S (Type V, Class B) Sealant. (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 and Detail B.) 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 six CR3214-4-04 Rivets.
  6. Install the left and right landing light. (Refer the Model 680A Maintenance Manual, Chapter 33, Landing Light - Removal/Installation.)
  7. (Refer to Figure 1, Detail A, View A-A and View B-B.) Fillet seal between the fasteners on top of the 6922530-35 Left, 6922530-36 Right Light Box Back and the 7420411-1 Left and 7420411-2 Right Tube Assembly 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.

8. Install access panels 153BL and 154BR. (Refer to the Model 680A Maintenance Manual, Chapter 6, Access Plates and Panels Identification - Description and Operation.)
9. Remove the maintenance warning tags and connect the airplane batteries.
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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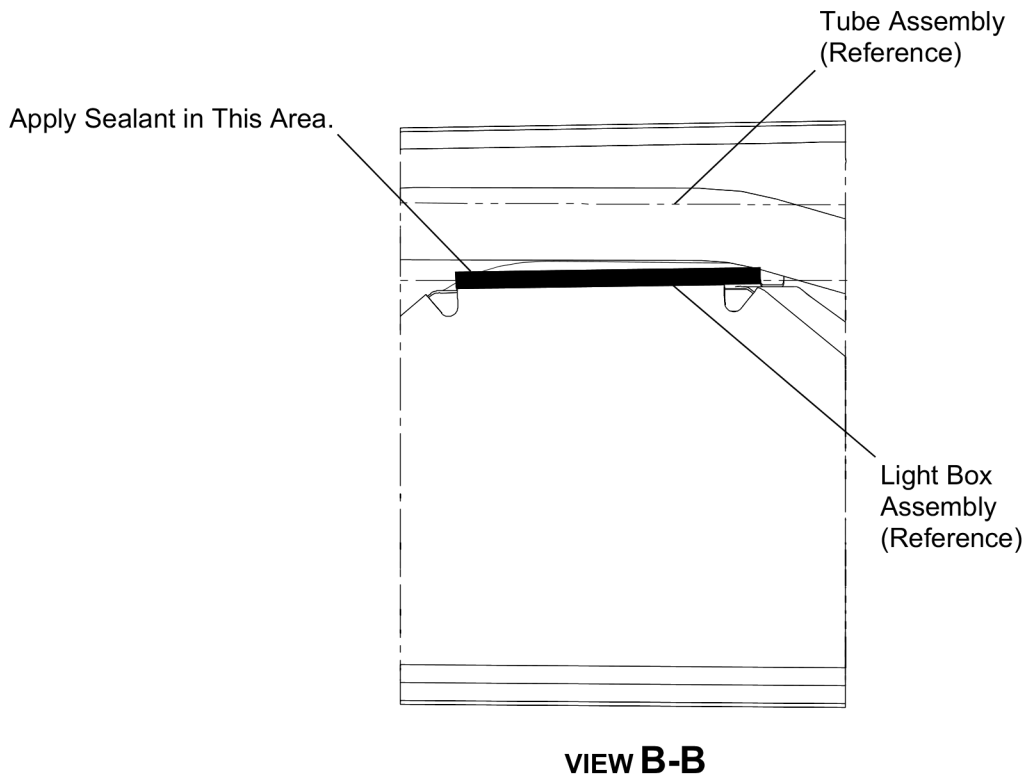
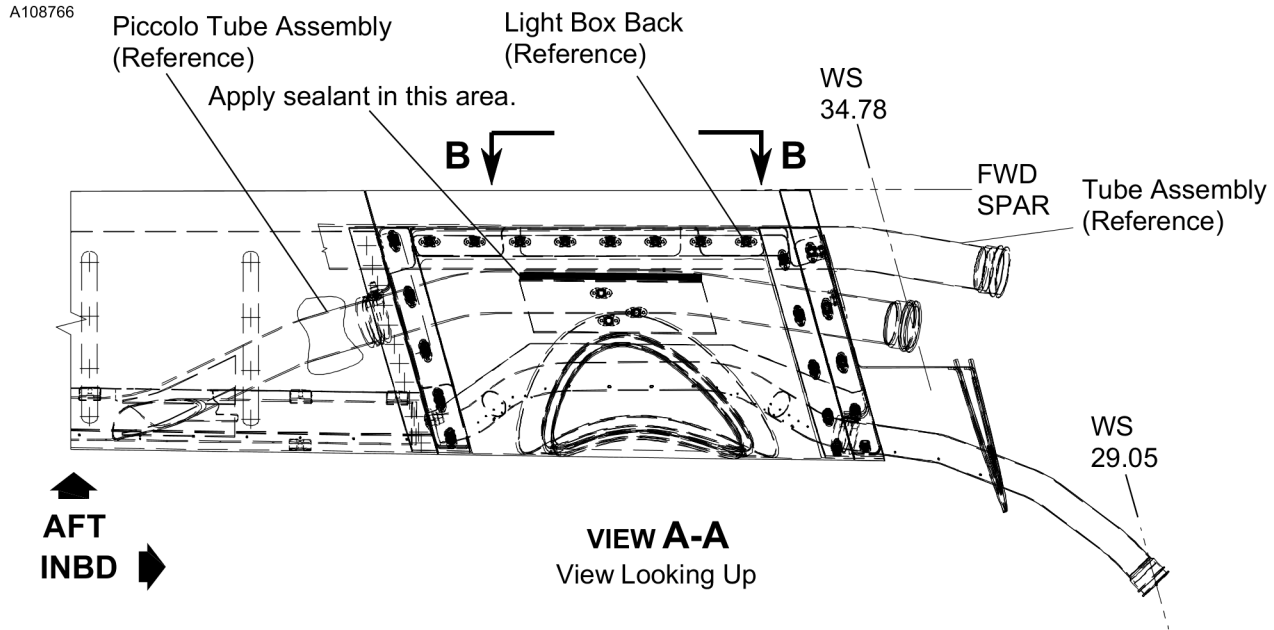


**DETAIL A**

Left Side Shown, Right Side Opposite

Figure 1. Piccolo Tube Sealing (Sheet 1)

7410T1002  
A7420T410-1

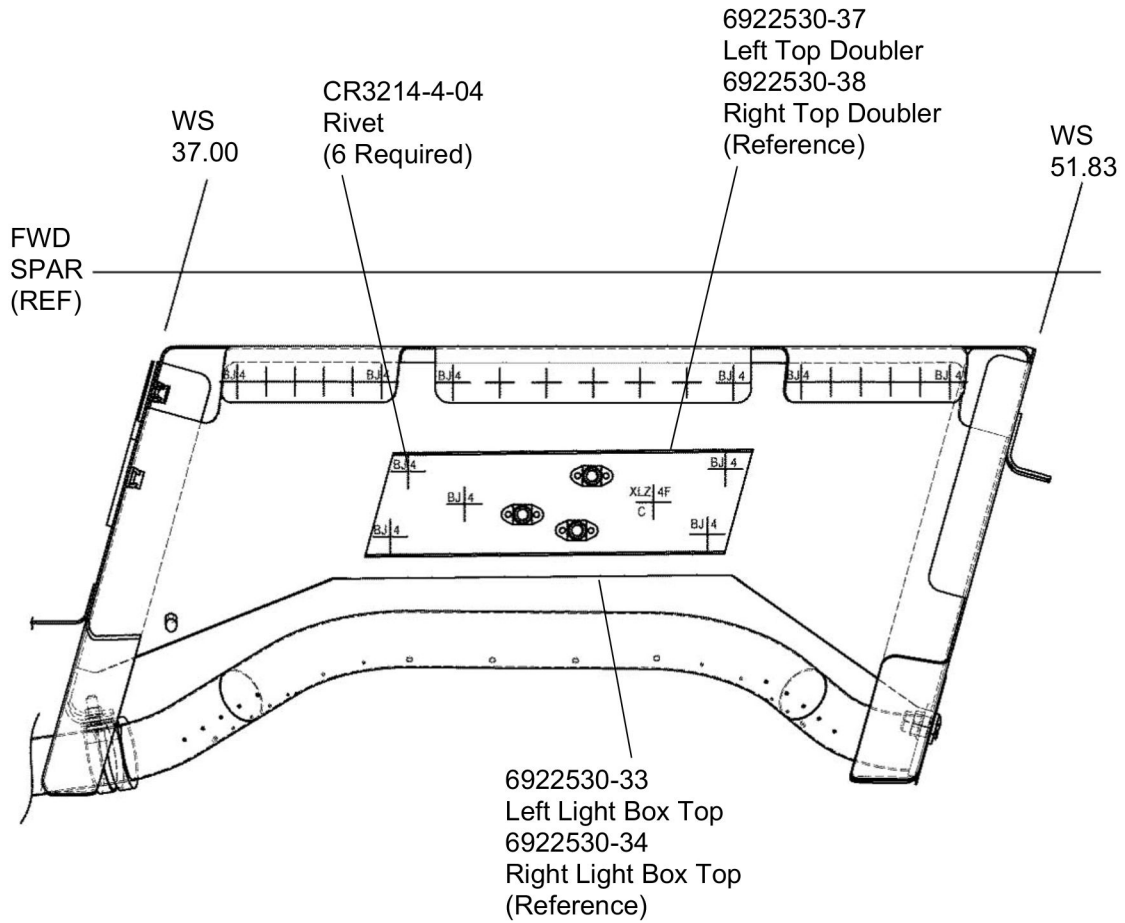


AA7422T052-3  
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Figure 1. Piccolo Tube Sealing (Sheet 2)



A109269

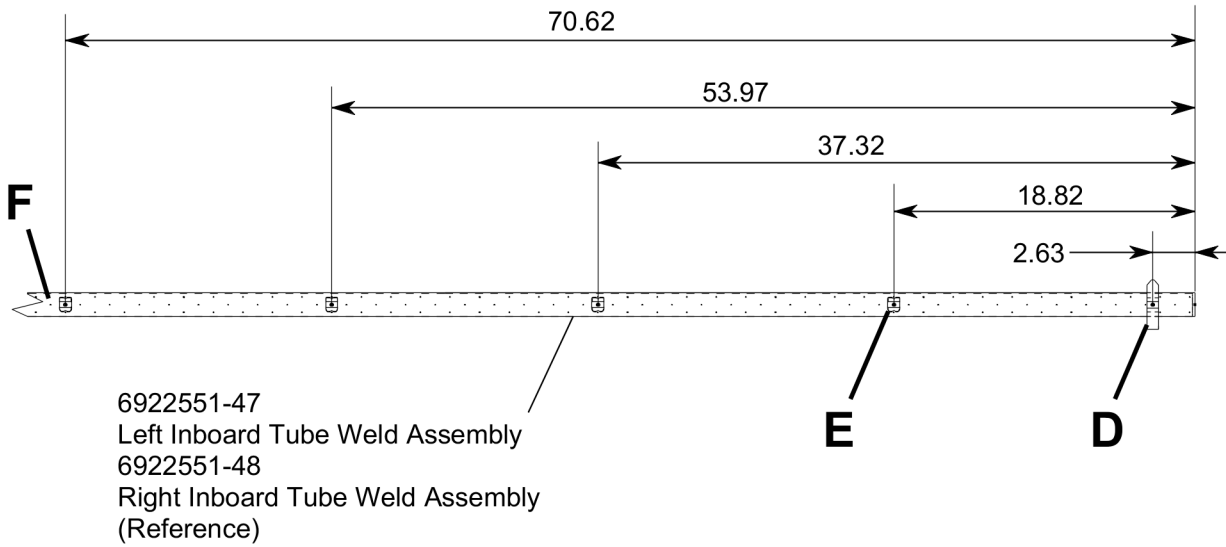


**DETAIL B**  
Left Side Shown, Right Side Typical

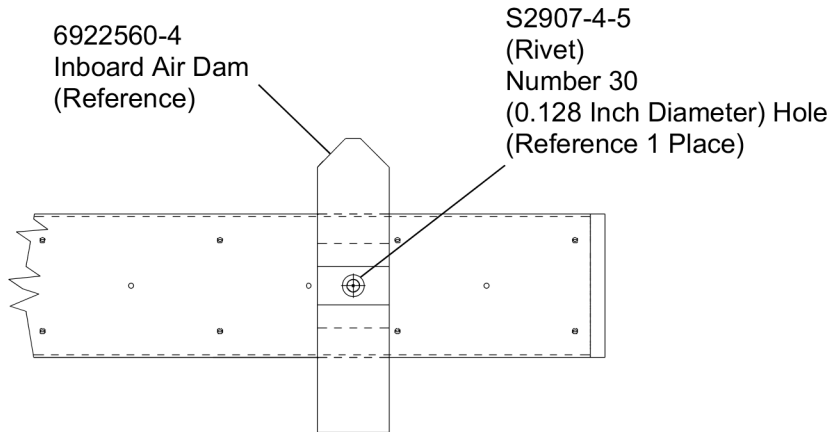
Figure 1. Piccolo Tube Sealing (Sheet 3)

7422053

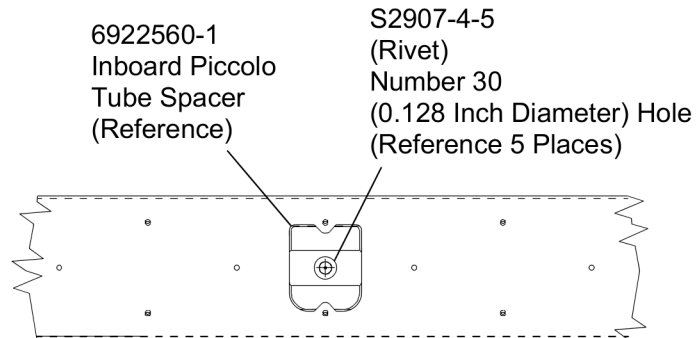
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**DETAIL C**



**DETAIL D**



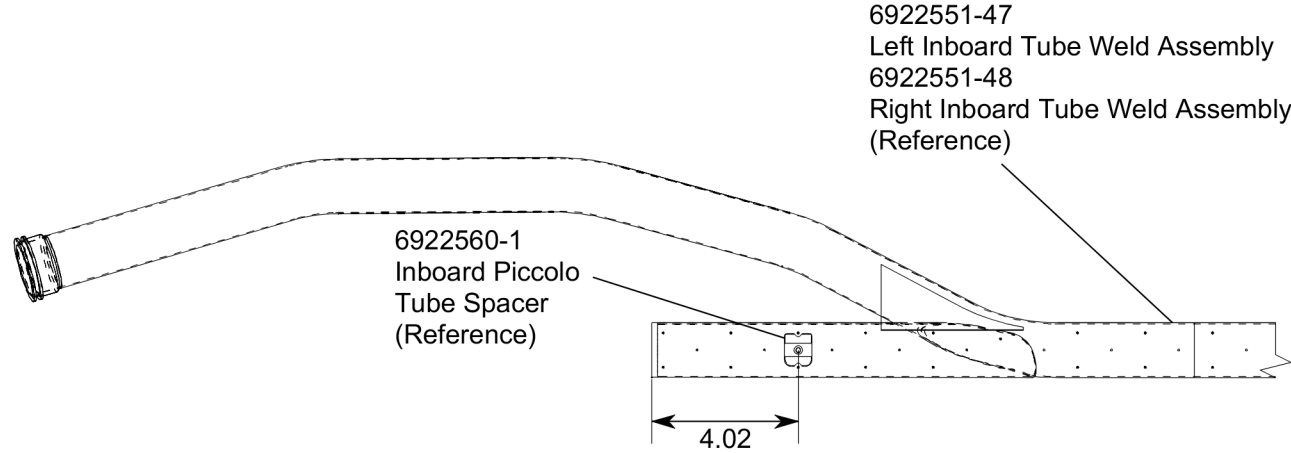
**DETAIL E**

**NOTE:** All Dimensions are in Inches

C6922T515-1  
 D6922T515-1  
 E6922T515-1

Figure 1. Piccolo Tube Sealing (Sheet 4)

A109830



**DETAIL F**

**NOTE:** All Dimensions are in Inches.

F6922T515-1

Figure 1. Piccolo Tube Sealing (Sheet 5)

**MATERIAL INFORMATION**

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

NEW P/N	QUAN- TITY	KEY WORD	OLD P/N	INSTRUCTIONS/ DISPOSITION
S2907-4-5	12	Rivet		
CR3214-4-04	12	Rivet		
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	
7420411-1	1	Left Tube Assembly	Same	
7420411-2	1	Right Tube Assembly	Same	

\* 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).

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

**TITLE**

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

**TO:**

Cessna Citation Latitude 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**

For planning purposes only:

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	*	*
6922551-47	*	*
6922551-48	*	*
6922560-1	*	*
6922560-4	*	*
7420411-1	*	*
7420411-2	*	*

**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

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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.