

SOUTH SEAS VENTURES, INC.
317 CATRELL DRIVE
HOWELL, MI 48843

STAINLESS STEEL
PASSENGER STEP

PART #: 002-430076-23

MAT'L DESC: SEE BELOW

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DESIGNED BY:

DRAWN BY: RJ

APPROVED BY: PHB

DWG.: 15628A

SCALE: N/A

DATE: 6/24/99

REV.: 9

DATE: 1/23/01

INT.: PHB

SHEET 1 OF 1

INSTALLATION INSTRUCTIONS:

THE REPLACEMENT STEP ASSEMBLY IS DESIGNED TO BE AN EXACT REPLACEMENT FOR STEP FOUND ON BEECH AIRCRAFT MODELS HAVING FIXED PASSENGER STEPS. INSTALLATION MUST BE PRECEDED BY REMOVAL OF THE EXISTING STEPS AS FOLLOWS:

- 1) REMOVE SEATS 5 AND 6, IF INSTALLED.
- 2) REMOVE CARPET.
- 3) REMOVE SEAT HARDWARE ON FLOORBOARDS (2 AFT FITTINGS AND 2 FORWARD SLIDE-IN ATTACH POINTS), SAVE ALL FASTENERS.
- 4) REMOVE FLOORBOARDS (FRONT AND REAR HALVES), SAVE ALL FASTENERS.
- 5) STEP ATTACH POINT WILL NOW BE FULLY ACCESSIBLE, REMOVE STEP (PHILLIPS NO. 2 EXTERIOR, 3/8" NUT AND WASHER INTERIOR, 9 EACH).

NOTE - MANY STEPS IN SERVICE ARE CRACKED DUE TO EXCESSIVE LOADS AND/OR INADEQUATE STRUCTURE DESIGN. IT IS ADVISED THAT ATTEMPTS TO REPAIR BY WELDING WILL MOST LIKELY BE UNSUCCESSFUL DUE TO BRITTLE, THIN MATERIAL AND LACK OF ADEQUATE WELD CONTROL IN FIELD SITUATIONS.

INSTALLATION OF NEW STEP ASSEMBLY MAY NOW BE ACCOMPLISHED AS FOLLOWS:

- 1) DUE TO VARIATION IN ATTACHMENT HOLE LOCATIONS AMONG AIRCRAFT, THE STEP ASSEMBLY MUST BE DRILLED TO ASSURE AN EXACT MATCH WITH THE HOLE LOCATIONS ON THE AIRCRAFT ON WHICH IT IS TO BE INSTALLED. FIRST, INSPECT THE AIRCRAFT FOR ANY DAMAGE TO THE INTERIOR OR STRUCTURE FROM EXCESSIVE FORCE APPLIED TO PREVIOUS STEP - REPAIR PER BEECH SERVICE MANUAL OR AC 43.13-1 (b) AS REQUIRED.
- 2) CAREFULLY POSITION REPLACEMENT STEP ASSEMBLY IN POSITION ON THE AIRCRAFT MAKING SURE IT HAS CLEARANCE FROM ALL RIVET HEADS ON THE EXTERIOR.
- 3) HOLDING THE STEP ASSEMBLY IN POSITION, MARK HOLE LOCATIONS (9 EACH) FROM INSIDE THE AIRCRAFT. HOLES SHOULD MAINTAIN AN EDGE DISTANCE OF .38" OR GREATER.
- 4) DRILL 9 HOLES IN REPLACEMENT STEP ASSEMBLY WITH AN 11/64 DRILL (CLEARANCE FOR 10-32 MACHINE SCREW) USING A DRILL BIT SHARPENED FOR STAINLESS STEEL (118° ANGLE, 12° RELIEF). A COOLANT SUCH AS "TAP FREE" FOR STAINLESS STEEL IS RECOMMENDED.
- 5) CHECK HOLES FOR CONFORMITY WITH AIRCRAFT.
- 6) A PRIME COAT OF ZINC OXIDE PRIMER IS RECOMMENDED TO BE APPLIED TO AIRCRAFT SURFACE FOR PREVENTION OF GALVANIC CORROSION (MASK AREA OUTSIDE OF STEP FOOT PRINT FOR APPEARANCE SAKE).
- 7) INSTALL REPLACEMENT STEP USING NEW SCREWS, NUTS AND WASHERS OR EQUIVALENT BEECH P/N MS27039-1-09, AN960-10 AND 130909N29 (10-32 BALLUSTER HD. NYLON INSKIT LOCKING NUTS AND A AN WASHER)
- 8) REPLACE PREVIOUSLY REMOVED FLOORBOARDS, HARDWARE, CARPET (AND SEATS, IF APPLICABLE).

FAA APPROVED

MAY 22 2001

CHICAGO AIRCRAFT
CERTIFICATION OFFICE
CENTRAL REGION.

NM
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