



Hawker Beechcraft 200 Series Wing
Attach Barrel Nuts.

AWB 57-012 **Issue :** 1
Date : 06 February 2013

1. Applicability

This Airworthiness Bulletin is applicable to Hawker Beechcraft 200 series airplanes, and will be of interest to:

- The owners and operators of 200 series airplanes;
- Maintenance organisations that carry out maintenance on 200 series airplanes

2. Purpose

The purpose of this Bulletin is to bring to the attention of operators and maintainers of Hawker Beechcraft 200 series airplanes that removal of wing attach bolts and disassembly of barrel nuts carried out in accordance with the Hawker Beechcraft instructions contained in the Structural Inspection and Repair Manual (SIRM) can lead to scoring of the wing attach barrel nut hole. The damaged holes can contain local areas of increased stress with the possibility of cracking in the wing structure.

3. Background

This Airworthiness Bulletin arises from multiple defect reports (SDR) where maintainers have assembled the wing attach barrel nuts incorrectly. The SIRM documentation when read systematically through the procedure does not contain adequate warnings of the possibility that barrel nuts can be assembled incorrectly.

The wing attach barrel nuts are required to be disassembled and nuts replaced as a part of Airworthiness Directive AD/BEECH 200/38 Amdt 5 Instructions. This Directive requires inspection and retirement of wing attach parts in accordance with the Hawker Beechcraft SIRM P/N 98-39006C3 Chapter 57-17-00 "GENERAL – MAINTENANCE PRACTICES (MODEL 200 SERIES)". The procedure remains applicable from those aircraft modified in accordance with STC SA1602CE.

The wing attach barrel nut consists of the nut and cradle. It is possible to assemble the nut such that the bevelled area does not match the cradle contour. This protruded section when installed and tightened up in the nut bore scores the sides of the barrel nut hole.

Hawker Beechcraft advise that the issue is discussed when carrying out compulsory Manual training.



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4. Recommendation

That CAUTION be exercised when carrying out the wing attach barrel nut assembly and installation procedure as documented by Hawker Beechcraft in the SIRM.

Note: The wing attach barrel nut bore cannot be readily inspected to ensure that the wing attach barrel nuts have been correctly assembled once they have been installed in the wing.

Report any further occurrences of incorrect installation of barrel nuts assemblies and any resultant wing structure damage to CASA via SDR.

5. Enquiries

Enquiries with regard to the content of this Airworthiness Bulletin should be made via the direct link e-mail address:

AirworthinessBulletin@casa.gov.au

or in writing, to:

Airworthiness & Engineering Branch
Civil Aviation Safety Authority
GPO Box 2005, Canberra, ACT, 2601