

REFRIGERANT HOSE INSULATION

1. PLANNING INFORMATION

- A. EFFECTIVITY All PAL 750XL Aircraft up to and including S/N 208 excluding S/N 206, that are fitted with factory air-conditioning (Modification PAC/XL/0409) or the provision for air-conditioning (Modification PAC/XL/0618).

- B. REASON The insulation lagging provided by the air-conditioning supplier has been found to be non-compliant and may cause large amounts of smoke in the cabin in the event of a fire.

- C. DESCRIPTION Remove the foam insulation from the refrigerant hoses IAW Accomplishment Instructions.

Install Velcro fire sleeve and Aluminium tape around hoses IAW Accomplishment Instructions.

- D. COMPLIANCE Within the next 150 hours TIS from the last maintenance check.

- E. TOOLING No special tools are required.

- F. WEIGHT AND BALANCE Negligible change.

- G. REFERENCE 750XL Maintenance Manual & Maintenance Manual Supplement PAC/XL/0409.

- H. HOURS REQUIRED 32 hours.

- I. WARRANTY COVER Normal warranty conditions apply.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Removal of existing refrigeration hose lagging:

(Refer to Figure 1 & 2)

- 1) To access the refrigerant hoses, the following must be removed IAW standard aircraft maintenance practices, retaining all hardware:
 - Pilots Seat IAW MM 25-10-00 Page 401.
 - Left hand cabin linings from the instrument bulkhead to STN 166.53
 - Spar Cover
 - Floor panels from left hand cabin lining to fuselage center line between STN's 143.0 and 166.53.
 - Floor panels in the central bay of the fuselage from STN 166.53 to STN 240.08.
 - Rear cabin lining/cargo bin (if present) to access evaporator and compressor.
- 2) Remove and retain all P-Clips from both suction and discharge hoses, including those that run over the spar.
- 3) Remove all black foam insulation from the flexible refrigerant lines taking care to ensure the refrigerant hoses are not damaged when removing the insulation.
- 4) Remove the black cork insulation from the discharge (smaller diameter) pipe running over the spar. The insulation is to be left in place on the suction (larger diameter) pipe.
- 5) Visually inspect all refrigerant hosing, if the hose is cut the assembly will require replacement.

B. Installation of fire sleeve lagging (All hoses excluding over the spar):

(Refer to Figure 1)

- 1) Cut lengths of Velcro fire sleeve to match hose assembly lengths. Use larger diameter fire sleeve for suction hoses and smaller diameter fire sleeve for discharge hoses. The lengths of fire sleeve should be continuous from union to union.
 - Note: If non-continuous lengths of fire sleeve are required, the fire sleeve should be overlapped and secured using cable ties to ensure continuous lagging.
- 2) Wrap fire sleeve around refrigerant hoses, sealing using Velcro.
- 3) At unions and as required secure the fire sleeve using cable ties.
- 4) Replace P-Clips to secure hoses in position.

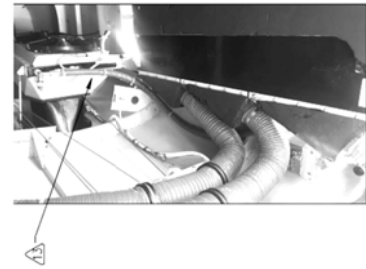
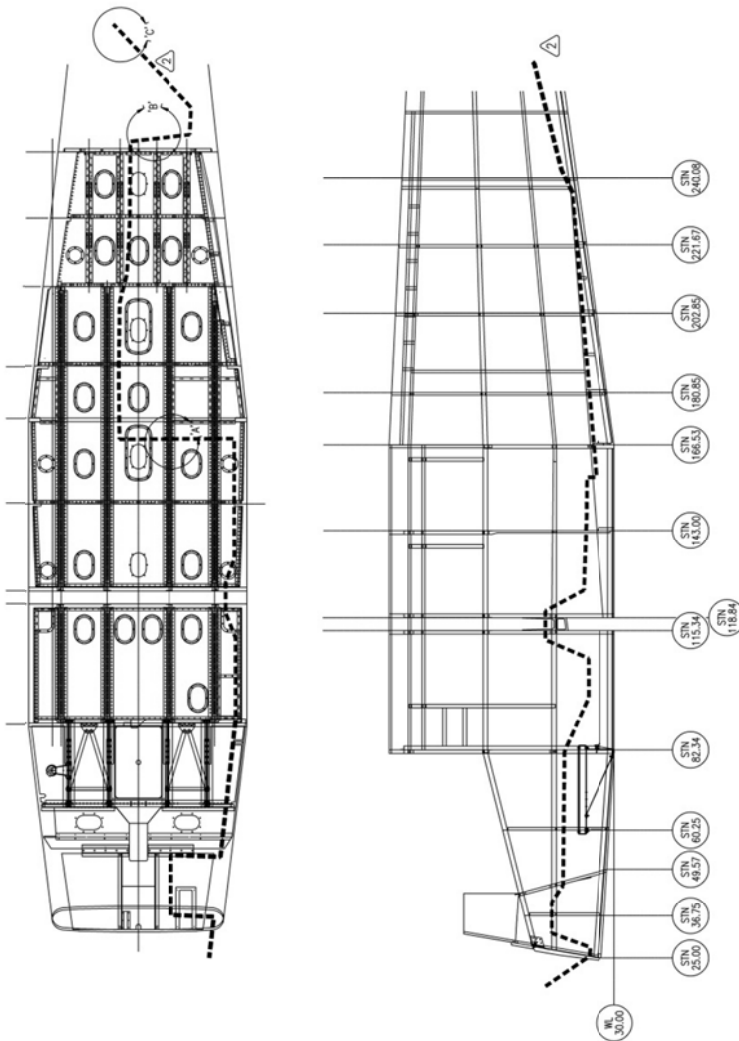
C. Aluminium Tape installation at wing spar:

(Refer to Figure 2)

- 1) Cover the black cork based insulation on the suction hose with Aluminum foil tape.
- 2) Secure hoses in position using P-Clips.
- 3) Install P-Clip at existing floor hole and cable ties to ensure refrigerant lines remain clear of control cables. (Refer Detail 'A' – Figure 2)
- 4) Return aircraft to a serviceable condition.

- NOTES:**
- REPAIRS/INSTALLATIONS ON THIS DRAWING TO BE COMPLETED IN ACCORDANCE WITH COMPANY APPROVED MANUFACTURING STANDARDS AND PROCEDURES.
 - LOCATION OF REFRIGERANT HOSES.
 - REMOVE THE FOLLOWING LAW STANDARD AIRCRAFT MAINTENANCE PRACTICES IN ORDER TO ACCESS REFRIGERANT LINES:
 - PILOT'S SEAT
 - FLOOR CABIN LININGS FROM INSTRUMENT BULKHEAD TO STN 166.53
 - FLOOR PANELS FROM CABIN LINING TO FUSELAGE CENTER LINE BETWEEN STN's 143.0 AND 166.53
 - FLOOR PANELS IN THE CENTRAL BAY OF THE FUSELAGE FROM 166.53 TO STN 240.08
 - CARGO BIN TO ACCESS THE EVAPORATOR AND COMPRESSOR
 - REMOVE AND RETAIN ALL P-CLIPS FROM BOTH SUCTION AND DISCHARGE HOSES.
 - REMOVE ALL BLACK FOAM INSULATION FROM REFRIGERANT HOSES. ENSURE REFRIGERANT HOSES ARE NOT PROTECTED WHEN REMOVING INSULATION. VISUALLY INSPECT, IF THE HOSE IS CUT THE ASSEMBLY WILL REQUIRE REPLACEMENT.
 - CUT LENGTHS OF ITEM 5 & 6 TO SUIT HOSE ASSEMBLY LENGTHS. USE ITEM 5 FOR DISCHARGE HOSES AND ITEM 6 FOR SUCTION HOSES.
 - WRAP FIRE SLEEVE AROUND REFRIGERANT HOSES, SEAL USING VELCRO.
 - AT UNIONS AND AS REQUIRED, SECURE THE FIRE SLEEVE USING ITEM 8.
 - REPLACE P-CLIPS TO SECURE HOSES IN POSITION.
 - RETURN AIRCRAFT TO SERVICEABLE CONDITION.
- ⚠ IF FUEL CROSS FLOW VALVES ARE INSTALLED, ENSURE REFRIGERANT LINES ARE SECURED TO BRACKET BEHIND VALVE TO ENSURE NO INTERFERENCE WITH VALVE OPERATION.
- ⚠ IF THE LENGTH OF HOSE UNDER THE EVAPORATOR IS INACCESSIBLE, IT IS ACCEPTABLE TO ENSURE THAT THE LENGTH OF HOSE IS FULLY COVERED BY FIBREGLASS TAPE AS SHOWN.
- ⚠ FIRE SLEEVE TO BE INSTALLED IN PLACE OF INSULATION UP TO CONDENSER UNIT.

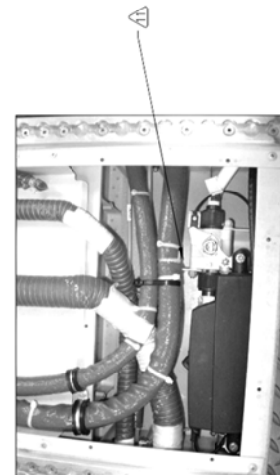
A/R	ITEM	PART NUMBER	DESCRIPTION	SIZE	SPECIFICATION	NEXT ASSY
8	8	TY5272MX	CABLE TIE			
6	6	5-F5-VCL-4600-M019-12	FIRE SLEEVE HOOK & LOOP			
5	5	5-F5-VCL-4600-M013-08	FIRE SLEEVE HOOK & LOOP			
1	1	11-03489-1	REPAIR - ARCON REFRIGERANT HOSE LAGGING			
-1	-1					



DETAIL '2' - RT. OF CABIN



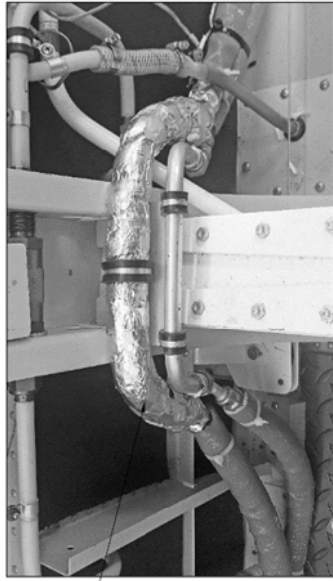
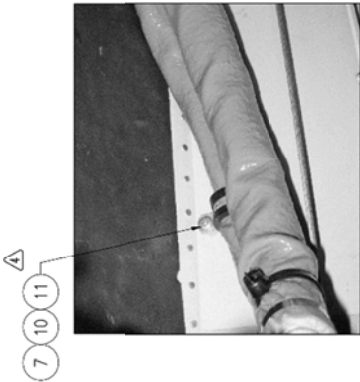
DETAIL '2' - REFRIGERANT LINE LOCATED UNDER EVAPORATOR



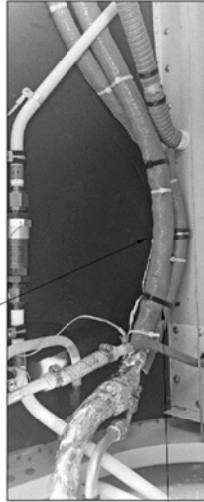
DETAIL '1' - FUEL CROSSFLOW VALVES

FIGURE 1 FIRE SLEEVE INSTALLATION (ALL REFRIGERANT HOSES EXCLUDING OVER SPAR)

- NOTES:**
- ASSEMBLES ON THIS DRAWING TO BE IN ACCORDANCE WITH COMPANY APPROVED MANUFACTURING STANDARDS AND PROCEDURES.
 - REMOVE THE SPAR COVER AND CABIN LINKS IN THE BAY IMMEDIATELY FORWARD OF THE SPAR.
 - COVER BLACK CORK BASED INSULATION ON THE SUCTION HOSE (LARGER DIAMETER) WITH ITEM 5 - ALUMINIUM TAPE.
 - USE ITEM 4 (MOUNTING PLATE) TO SECURE REFRIGERANT HOSES.
 - INSTALL P CLIP AND CABLE TIES TO ENSURE REFRIGERANT LINES REMAIN CLEAR OF CONTROL CABLE.
 - RETURN AIRCRAFT TO A SERVICEABLE CONDITION.



VIEW LOOKING OUTBOARD
ON L.H. CABIN WALL



VIEW LOOKING OUTBOARD
FORWARD OF SPAR

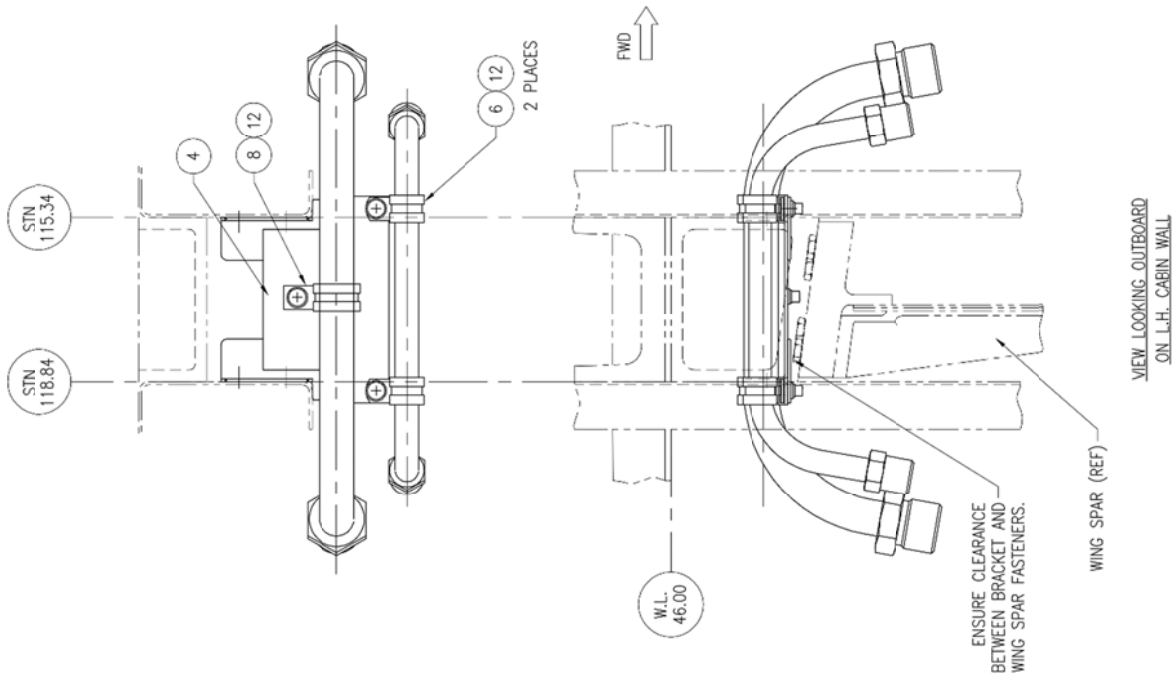


FIGURE 2 ALUMINIUM TAPE INSTALLATION – WING SPAR

3	12	ANS25-10R12	SCREW
1	11	ANS25-10R16	SCREW
1	10	DIS2-10-0500	SPACER
2	9	TYE272MX	CABLE TIE
1	8	MS21919WDC20	P CLIP
1	7	MS21919WDC12	P CLIP
2	6	MS21919WDC08	P CLIP
A/R	5	3M793627	ALUMINIUM FOIL TAPE
1	4	11-03495-1	REFRIGERANT LINE MOUNTING PLATE
	3		
	2		
✓	1	11-03509-1	REPAIR – REFRIGERANT HOSE LAGGING (X1209)
-1	ITEM	PART NUMBER	DESCRIPTION – SIZE – SPECIFICATION

3. CERTIFICATION

Record compliance with this Service Bulletin in the aircraft Log Book.

4. MATERIAL REQUIRED:

<u>Description</u>	<u>Part Number</u>	<u>Qty Required</u>
VELCRO FIRE SLEEVE	S-FS-VCL-AERO-M013-08	9 METERS
VELCRO FIRE SLEEVE	S-FS-VCL-AERO-M019-12	7 METERS
MOUNTING PLATE, REFRIGERANT LINE	11-03495-1	1
P CLIP	MS21919WDG20	1
P CLIP	MS21919WDG12	1
P CLIP	MS21919WDG08	2
HOSE CLAMP	10781-4-32CR	2
SPACER	DIS2-10-0500	1
SCREW	AN525-10R16	1
SCREW	AN525-10R12	3
ALUMINIUM FOIL TAPE	3M FOIL TAPE 425 (B40067910)	A/R
CABLE TIES	TY5272MX	A/R

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