



ENSTROM HELICOPTER CORPORATION

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SERVICE DIRECTIVE BULLETIN

SERVICE DIRECTIVE BULLETIN NO. T-031

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DATE: October 18, 2007

1. SUBJECT: Inspection of Horizontal Stabilizer Aft Spar Bolt Engagement
2. MODEL: 480 and 480B
3. EFFECTIVITY: Serial Numbers 5001 through 5112
4. BACKGROUND:

Enstrom has determined that thread engagement of the bolts through the aft spar attachment for the horizontal stabilizers may be insufficient. When the horizontal stabilizers were installed to the tail section, shims may have been used in the assembly of the horizontal stabilizers to the aft spar attachment. The added thickness change may affect the thread engagement of the bolt through the nutplate.

This Service Directive Bulletin (SDB) requires a one time inspection of the aft spar attachment of the horizontal stabilizer installation, and if required, correcting the bolt length.

Technical aspects of this SDB are FAA Approved.

5. COMPLIANCE:

Within 100 hours time in service or at the next annual inspection, which ever occurs first, inspect the horizontal stabilizer attachment spar in accordance with paragraph 5.1 of this Service Bulletin Directive and if required, replace the bolts in accordance with paragraph 5.2 of this Service Directive Bulletin.

5.1. INSPECTION:

NOTE**Perform all maintenance IAW the TH-28/480 Series Maintenance Manual.**

- A. Remove screws and the left and right side tail cone closure panels to access spar attachment (reference Figure 1).
- B. Using a suitable light source and an inspection mirror, inspect the thread engagement of all four bolts through the nutplates. The bolts must be threaded completely through the nutplates plus show a minimum of one (1) thread.
- C. If the bolts are too short, remove the bolts and replace with the proper length bolts IAW paragraph 5.2.

5.2. REPAIR:

- A. Replace short bolts with either AN3-5A or AN3-6A bolts, as applicable.

NOTE**Additional washers may be required for the longer bolt installation.**

5.3. PARTS:

Description	Part Number	Quantity
Bolt	AN3-5A	As Required
Bolt	AN3-6A	As Required
Washer	AN960-10	As Required
Washer	AN960-10L	As Required

6. SPECIAL TOOLS: None

7. MAN-HOURS:

One (1) Man-hour for the visual inspection only.

8. WARRANTY: Per Enstrom New Helicopter Warranty policy.

9. WEIGHT CHANGE: None

10. LOG BOOK ENTRY:

Enter compliance with this SDB in the aircraft maintenance records.

11. REPETITIVE INSPECTIONS: None

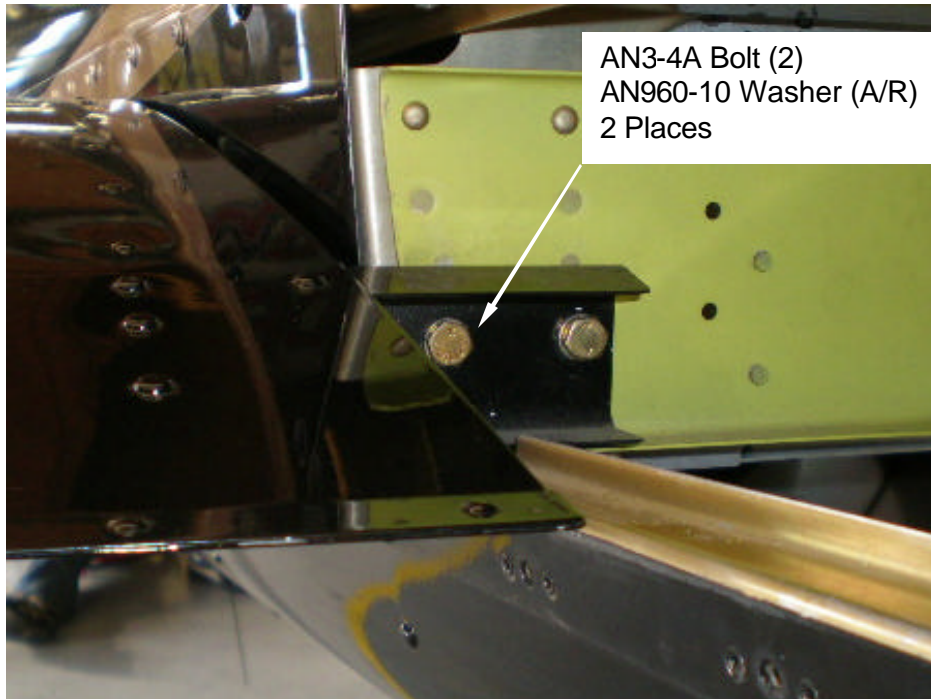


Figure 1. Horizontal Stabilizer Installation (Left-Hand Side Shown)