



THE ENSTROM HELICOPTER CORPORATION
TWIN COUNTY AIRPORT, P.O. BOX 490, MENOMINEE, MICHIGAN 49858

SERVICE INFORMATION LETTER

SERVICE LETTER NO. 0019
FAA APPROVED

Date: November 13, 1970

Subject: Inspection of Tail Rotor Gearbox Housing Drawing No. 28-13502F

Model: F-28A

Effectivity: S/N 20, 21, 24, and 27 thru 59

Reason: To detect housing wall thicknesses below the limit specified on the drawing

Compliance: Immediate

It has been found, through reinspection of tail rotor gearbox housings at the factory, that some castings in service on aircraft may have wall thicknesses below the specified minimum. The approved minimum is .120 inches.

The primary portion to be inspected is located in the "input" gear area on the lower portion of the housing. Casting thicknesses may be measured by use of outside calipers and micrometers of verniers. Sheet metal micrometers with a deep throat are acceptable. The tolerance of the instrument should be within .005 inches.

In addition to the above specified inspection, the wall thickness in the "output" portion of the housing should be inspected in the same manner as above.

The input shaft and bearing housing assembly and the output shaft assembly should be removed to expose the portions in question. It will be necessary to apply heat to the gearbox housing before the components are removed.

When replacing the components after inspection approval, caution should be taken to maintain the same shims as previously assembled.