



ENSTROM HELICOPTER CORPORATION

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SERVICE DIRECTIVE BULLETIN

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DATE: November 3, 2008

1. SUBJECT: Main Rotor Pitch Change Bellcranks Missing Chamfers
2. MODEL: F-28A, F-28C, F-28F, 280, 280C, 280F, and 280FX
3. EFFECTIVITY: All serial numbers
4. BACKGROUND:

Enstrom has become aware of three (3) Pitch Change Bellcranks (Bellcranks), P/N 28-14207-101, that are missing chamfers on the bottom of the inboard ears. The missing chamfers do not create a Safety of Flight issue; however, the chamfers are required in accordance with (IAW) the FAA Approved Engineering Data.

This Service Directive Bulletin (SDB) requires a one time inspection of specific serial number Pitch Change Bellcranks for the chamfers and if required, re-working the Bellcranks to add the chamfers.

Technical aspects of this SDB have been coordinated with the FAA.

5. COMPLIANCE:

At or before the next 100 hour/annual inspection, review the aircraft maintenance records, component record cards, and/or the Pitch Change Bellcranks, P/N 28-14207-101, for the applicable serial numbers listed in Table 1. If applicable serial number Bellcranks are installed on the aircraft, inspect the bottom of the inboard ears for the chamfers IAW paragraph 5.1.

NOTE

All of the Bellcranks affected by this SDB would have been installed after June 2, 1999.

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Table 1.	
Pitch Change Bellcranks, P/N 28-14207-101	
Applicable Serial Numbers	
99211-1 through 99211-24	04110-001 through 04110-040
99334-1 through 99334-24	04251-001 through 04251-063
01-292-01 through 01-292-24	05087-001 through 05087-055
03070-01 through 03070-24	06122-01 through 06122-77
03239-01 through 03239-53	

5.1 INSPECTION:

NOTE

Perform all maintenance IAW the applicable F-28/280 Model Series Maintenance Manual.

- A. Using a suitable light source and inspection mirror or by disconnecting the pitch change bellcranks from the main rotor control rods and attachment bracket, inspect the bottom of the inboard ears for a .02" - .04" X 45° / 0.5 mm – 1.0 mm X 45° chamfer (refer to Figure 1). If chamfers are not on the Bellcrank(s), rework the Bellcrank(s) to add the chamfers IAW paragraph 5.2. If the chamfers are on the Bellcranks, reinstall the Bellcranks and return the aircraft to service.

5.2. REWORK:

- A. Remove the Pitch Change Bellcranks from the helicopter following the procedures in the applicable maintenance manual.
- B. Using a small file or other suitable device, add a .02" - .04" X 45° / 0.5 mm – 1.0 mm X 45° chamfer to both sides of the bottom inboard ear (refer to Figure 2). Apply a protective coating of epoxy primer (Desoto #593 X 300 or equivalent) to the reworked area.
- C. Reinstall the Pitch Change Bellcranks following the procedures in the applicable maintenance manual and return the aircraft to service.

6. SPECIAL TOOLS: None

7. MAN-HOURS: Inspection - 20 minutes; Rework - 1 hour
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

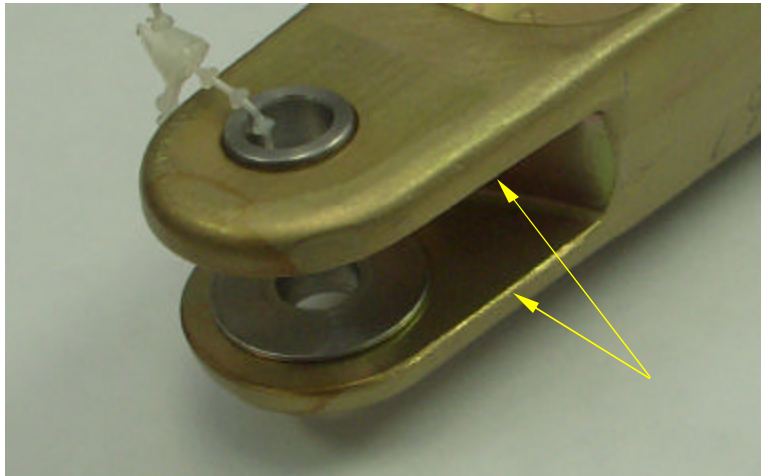
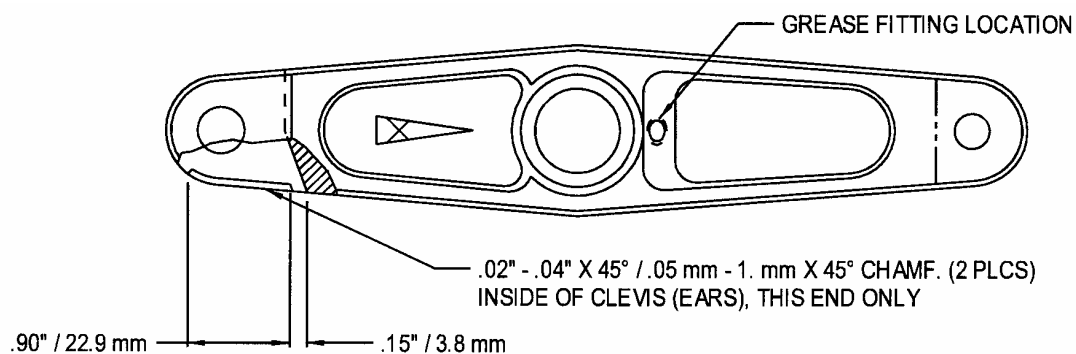


Figure 1. Chamfer on the inboard ear – two places



NOTE: BLEND ENDS OF CHAMFER INTO ADJACENT MATERIAL

Figure 2. Dimensional data for chamfer application