



SERVICE INFORMATION LETTER

SERVICE INFORMATION LETTER NO. T-008

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DATE: December 10, 1998

1. SUBJECT: Alternative Spar Fitting Attachment
2. MODEL: TH-28 and 480 Helicopters
3. EFFECTIVITY: All TH-28 and 480 helicopters prior to S/N 5020 and S/N 3007
4. BACKGROUND:

The Civil Aviation Authority in the United Kingdom has placed a 1000 hour life limit on the rivets that attach the stabilizer spar fittings, P/N 4112004-1, to the bulkhead in the tail cone. This Service Information Letter authorizes replacement of the rivets with Hi-Lok® Assemblies, P/N HL18PB70-5-5 and removes the 1000 hour life limit.

Hi-Lok® Assemblies have been used to attach the stabilizer spar fittings in production helicopters effective S/N 5020 and subsequent.

5. COMPLIANCE: U.K. Registered Aircraft Only

At or before the next 100 hour/annual inspection, visually determine if rivets or Hi-Lok® Assemblies are used to attach the stabilizer spar fittings.

If the stabilizer spar fittings are attached using rivets, replace the rivets with Hi-Lok® Assemblies at or before 1000 hours time in service.

5.1. MODIFICATION

- 5.1.1. Remove the stabilizer assemblies and the stabilizer spar from the helicopter in accordance with the TH-28/480 Maintenance Manual.

- 5.1.2. Using a center punch, punch a starter hole in the center of the four rivet heads that attaches the spar fitting to the bulkhead. Using a #40 centering drill bit and turning by hand, carefully start drilling the center of the rivet heads.
- 5.1.3. Using a #30 drill bit, drill the rivet heads to a depth no deeper than the rivet head.
- 5.1.4. Remove the rivet heads and shank using a punch and backing bar.
- 5.1.5. Cleco the fitting in place with two clecos on the diagonal.
- 5.1.6. Drill the other two holes with a #21 drill.
- 5.1.7. With the spar fitting clecoed in place, install a washer on the pin portion of the Hi-Lok® assembly and install the pin from the forward side of the bulkhead. There should be a slight interference fit as the pin is installed into the hole. Ensure the head of the pin and washer is tight against the bulkhead. Install the collar onto the pin.

NOTE:

**The Hi-Lok® fastener should be a snug fit,
the hole may be opened to a #20 if required.**

Repeat the procedure for the remaining two holes. Secure the pins using the correct size hex wrench and tighten the collar until the hex drive separates from the collars.

NOTE:

**If the pin spins before the head separates, an Allen wrench
may be used to hold the pin until the head separates.**

- 5.1.8. Repeat the process for the remaining spar fitting.
- 5.1.9. Reinstall the stabilizer spar and the stabilizer assemblies in accordance with the TH-28/480 Maintenance Manual.

5.2. PARTS:

<u>Nomenclature</u>	<u>Part Number</u>	<u>Quantity</u>
Hi-Lok® Assembly	HL18PB70-5-5	8 Ea.
Washer	AN960-8	8 Ea.

5.3. TOOLS:

#40 Centering Drill Bit
#30 Drill Bit
#21 Drill Bit
#20 Drill Bit

6. SPECIAL TOOLS: None Required
7. MAN-HOURS: 5 Man-hours
8. WARRANTY: None
9. WEIGHT CHANGE: None
10. LOG BOOK ENTRY: Enter compliance with this Service Information Letter.
11. REPETITIVE INSPECTIONS:

As defined in Section 3 of the TH-28/480 Maintenance Manual.

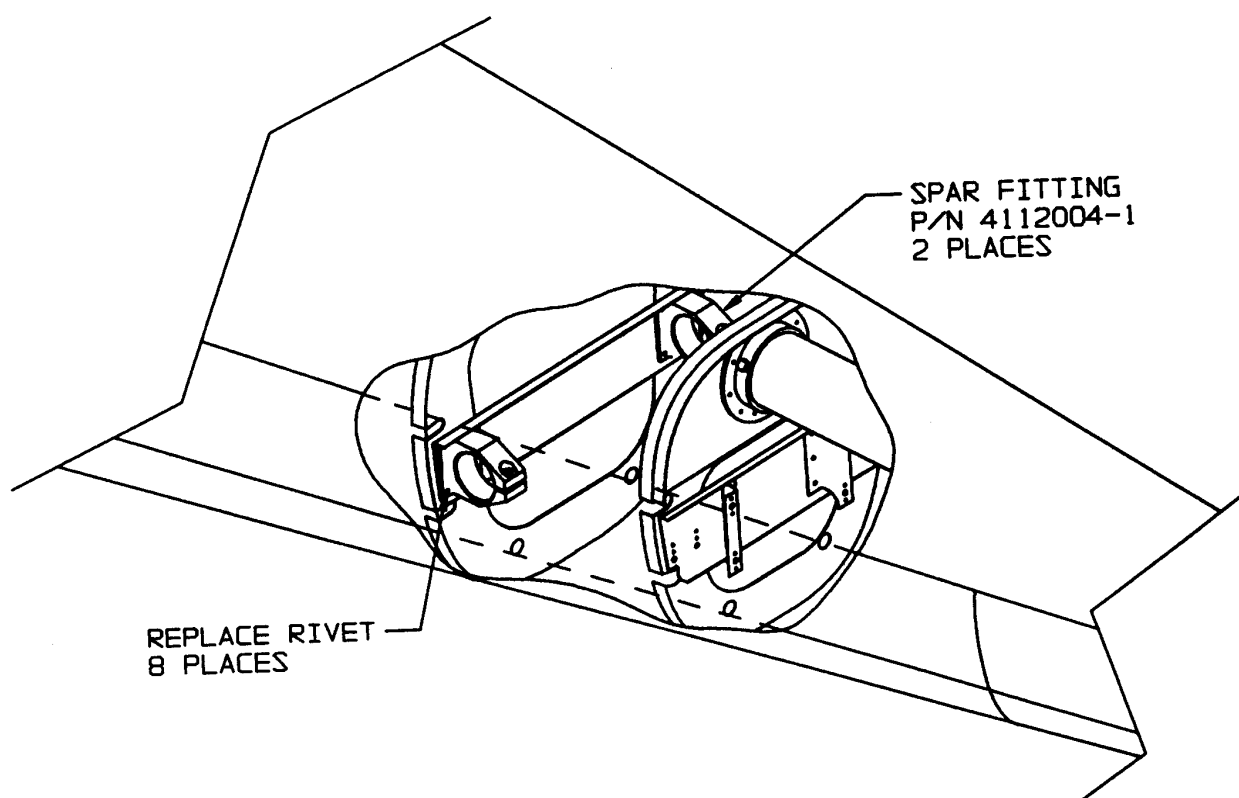


FIGURE 1