

SERVICE INFORMATION LETTER

SERVICE INFORMATION LETTER NO. T-034

Revision 1

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Revision 1 incorporated the following changes: aluminum doubler was acrylic, washer AN960-6L was MS51859-15, screw AN526-632R9 was AN526-632R6, and the bonding procedure was removed.

DATE: January 5, 2010

1. SUBJECT: Sliding Window Installation
2. MODEL: TH-28, 480, and 480B
3. EFFECTIVITY: All
4. BACKGROUND:

Enstrom has received reports regarding cracks generated about the sliding window frame at the location of either the upper or lower vent window pivot blocks. The cause for cracks has not been identified but may be attributed to the quality of the workmanship during production assembly, such as overtightening hardware and/or improper deburring of the attachment holes in the acrylic window structure. For an improvement, Enstrom has designed a doubler installation to reinforce the door window in the area of the pivot blocks.

This Service Information Letter (SIL) makes owners/operators aware of the doubler availability.

Technical aspects of this SIL are FAA Approved.

5. COMPLIANCE:

Enstrom recommends incorporation of this modification to preclude damage to the door window. Incorporation of this modification is in accordance with the procedure provided in paragraph 5.1 and in accordance with paragraph 5.2 for applicable parts.

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5.1. INSTALLATION PROCEDURE:

- A. Slide the window aft to avoid damaging the window during the doubler installation.
- B. Remove the two screws that are installed from the inside of the window that screw into the wing window hinge blocks.
- C. Inspect the screw holes for cracks. If cracks are detected, contact Customer Service.
- D. Position the doubler by aligning the two attachment holes of the doubler with the two holes used to attach the pivot block. See Figure 1.
- E. Install the attachment hardware listed in paragraph 5.2 (8 in-lb max. torque).

CAUTION**Do not overtorque hardware.**

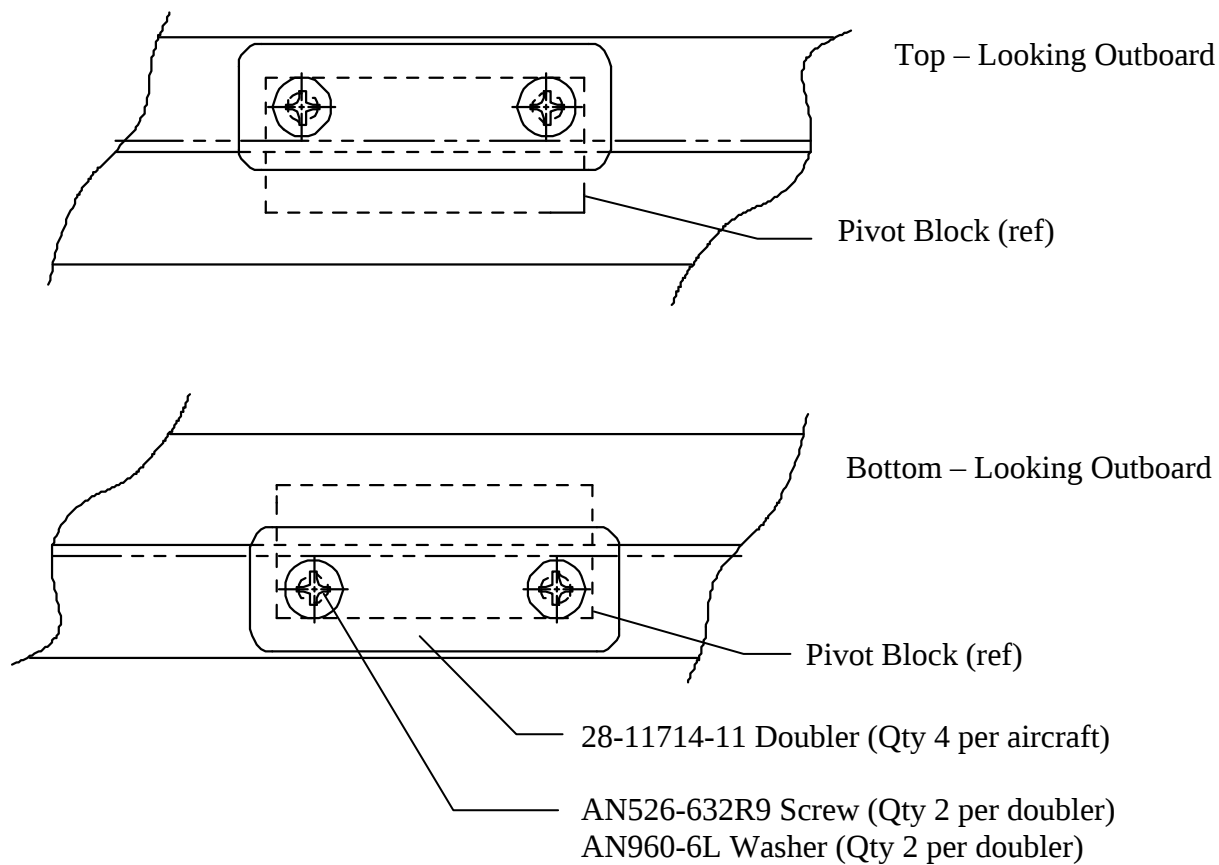
- F. Repeat Steps A through E for the three remaining doublers.

5.2. PARTS:

Description	Part Number	Quantity
Doubler	28-11714-11	4
Screw	AN526-632R9	8
Washer	AN960-6L	8

- 6. SPECIAL TOOLS: None
- 7. MAN-HOURS: 0.5 Man-hour
- 8. WARRANTY: Per Enstrom Helicopter Warranty policy
- 9. WEIGHT CHANGE: None
- 10. LOG BOOK ENTRY: As required for maintenance actions
- 11. REPETITIVE ACTION: None

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**Figure 1**