

SERVICE BULLETIN

SERVICE BULLETIN NO: 25-031

REF NO: 185

MODIFICATION NO:

ATA CHAPTER: 25

EQUIPMENT/FURNISHINGS - FLIGHT COMPARTMENT CREW SEATS - INSPECTION OF THE BUCKET ASSEMBLY TUBES

1. Planning Information

A. Effectivity

(1) All PC-12 and PC-12/45 aircraft with:

- Pilot's Seat, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001111, 9593001121, 9593001131 and 9593001133
- Co-Pilot's Seat, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001112, 9593001122, 9593001132 and 9593001134

installed and which have done more than 6000 flying hours.

(2) All crew seats as follows:

- Pilot's Seat, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001111, 9593001121, 9593001131 and 9593001133
- Co-Pilot's Seat, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001112, 9593001122, 9593001132 and 9593001134.

held as spare which have accumulated more than 6000 flying hours.

B. Concurrent Requirements

None

C. Reason

(1) Problem

The bucket assembly tubes on one of the crew seats failed. It was found during a maintenance inspection.

(2) Cause

The bucket assembly tubes failed at the location of the energy device pins. The lower tubes remained attached but the upper parts were completely disconnected.

(3) Solution

Do a one time inspection of the bucket assembly tubes of the crew seat. Repeat scheduled inspections, based on the results of this Service Bulletin, (and initial instructions for aircraft with less than 6000 flying hours) will be detailed in the AMM, Chapter 04.


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D. Description

This Service Bulletin gives the data and instructions necessary to do a one time inspection of the bucket assembly tubes at the energy device location.

E. Compliance

Mandatory.

Required within the next 10 flying hours or within the next 2 calendar weeks after the effective date of this Service Bulletin.

F. Approval

The technical content of this Service Bulletin is approved by the Federal Office for Civil Aviation (FOCA) of Switzerland as an Airworthiness Directive.

PILATUS advises Operators/Owners to check with their local Airworthiness Authorities for any changes, local regulations or sanctions that may affect the embodiment of this Service Bulletin.

G. Manpower

	Total
Preparation	0.50
Inspection	1.50
Close up	0.75
TOTAL MAN-HOURS	2.75

NOTE: Man-hours figures do not include the time required to cure sealants and adhesives.

H. Weight and Balance

(1) Weight Change

Not affected.

(2) Moment Change

Not affected.

I. Electrical Load Data

Not changed.

J. Software

Not changed.

K. References

Aircraft Maintenance Manual (AMM), 25-10-01.


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L. Publications Affected

Aircraft Maintenance Manual (AMM), Chapter 04.

M. Interchangeability of Parts

Not applicable.

2. Material Information

A. Material - Price and Availability

Operators should send orders for Service Bulletin Modification Kits, to their Authorized Pilatus Service Center, or to:

PILATUS AIRCRAFT LTD.,
CUSTOMER SUPPORT MANAGER,
CH-6371 STANS,
SWITZERLAND

General Aviation:
Tel: + 41 41 619 6208
Fax: + 41 41 619 7311
eMail: SupportPC12@pilatus-aircraft.com

Government:
Tel: + 41 41 619 6509
Fax: + 41 41 619 6224
eMail: rpaterson@pilatus-aircraft.com

PILATUS BUSINESS AIRCRAFT LTD.,
PRODUCT SUPPORT DEPARTMENT
11755 AIRPORT WAY
BROOMFIELD, CO 80021.
UNITED STATES OF AMERICA

Tel: 303 465 9099
Fax: 303 465 6040
eMail: Productsupport@PilBal.com

PILATUS AUSTRALIA (Pty.) LTD.,
PO BOX 732
MARLESTON SA 5033
AUSTRALIA

Tel: (08) 8234 4433
Fax: (08) 8234 4499
Free Call: 1800 445 007
eMail: info@pilatus.com.au

Operators are requested to advise Pilatus Aircraft Ltd, of the Manufacturer's Serial Number (MSN) and the flying hours of aircraft which are affected by this Service Bulletin.

B. Material Necessary for Each Aircraft

(1) Material to be Procured

None.

(2) Additional Material to be Procured

None

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(3) Operator Supplied Materials

Part No.	Description	Qty	Remarks
919.01.11.104	Lockwire	A/R	P02-001

C. Material Necessary for Each Spare

None.

D. Re-identified Parts

Not applicable.

E. Tooling - Cost and Availability

Not applicable.

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3. Accomplishment Instructions - Aircraft

A. Preparation

- (1) Remove the crew seats (Ref. AMM, 25-10-01, Page Block 401).

B. Inspection of the Bucket Assembly Tubes (Ref. Figure 1)

- (1) Remove the seat pan cushion (1) and the back rest cushion (2).

NOTE: Para. (2) is only applicable to the Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001111 and 9593001121 and to the Co-Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001112 and 9593001122.

- (2) Disconnect the ultralock.

(a) Remove the nut (4), the washer (5) and the bolt (7).

(b) Move the ultralock (6) clear of its bracket (3) on the seat back.

(c) Move the seat back to the front of the seat to permit easy access to the inspection area.

- (3) Remove the lockwire from each pair of the energy device pins (8).

- (4) Loosen the four energy device pins (8), but do not remove them from their holes in the supports (10).

NOTE: There is a ball bearing (9) in each of the holes. Loosen the pins (8) sufficiently to permit the vertical movement of the bucket assembly tubes (11) in the supports (10).

- (5) Push down on the bucket assembly tubes (11) until the circular groove is visible below the supports (10).

- (6) Use heavy duty cord, or a suitable alternative, to keep the seat in this position.

- (7) Do a fluorescent dye-penetrant inspection of the grooved area of the bucket assembly tubes (11). Crack(s) are not permitted.

- (8) If you find crack(s):

- Contact PILATUS for a repair procedure to replace the bucket assembly. Give the aircraft Serial Number (S/N) and the seat S/N and flying hours
- Continue with this procedure.

- (9) If there are no crack(s), continue with this procedure.

- (10) Report the results of the fluorescent dye-penetrant inspection to PILATUS. Give the aircraft S/N, the seat S/N and flying hours and the number of cracks found with the location and length.

- (11) Tighten the four energy device pins (8) with your fingers until you can feel them contact the bucket assembly tubes (11).

- (12) Hold the bucket assembly, remove the heavy duty cord, or the suitable alternative, and carefully release the bucket assembly.

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- (13) Permit the bucket assembly to move up the bucket assembly tubes (11) until you can feel the ball bearings (9) go into the groove of the bucket assembly tubes (11).
- (14) Keep the bucket assembly in this position and torque the four energy device pins (8) to between 5,42 and 5,65 Nm (48 and 50 lb in).
- (15) Secure each pair of the energy device pins (8) with the lockwire (Mat. No. P02-001).

NOTE: Para. (16) is only applicable to the Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001111 and 9593001121 and to the Co-Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001112 and 9593001122.

- (16) Connect the ultralock.
 - (a) Put the ultralock (6) in the correct position on the bracket (3).
 - (b) Install the bolt (7), the washer (5) and the nut (4).
- (17) Attach the seat pan cushion (1) and the back rest cushion (2).

C. Close up

- (1) Install the crew seats (Ref. AMM, 25-10-01, Page Block 401).
- (2) Make sure the seat moves freely vertically and that the locks engage and disengage in the correct positions.
- (3) For the Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001111 and 9593001121 and the Co-Pilot's Seats, made by Israel Aircraft Industries Ltd, Pilatus P/Ns 9593001112 and 9593001122 only:
 - (a) Make sure there is free angular movement of the backrest and that the backrest locks in all selected positions.
- (4) Make sure the work area is clean and clear of tools and other items.

D. Documentation

- (1) Make an entry in the Aircraft Logbook that this Service Bulletin has been incorporated.
- (2) Use the Service Bulletin Evaluation Sheet to report your results and the serial number of the aircraft and the seats to PILATUS.

4. Accomplishment Instructions - Spares

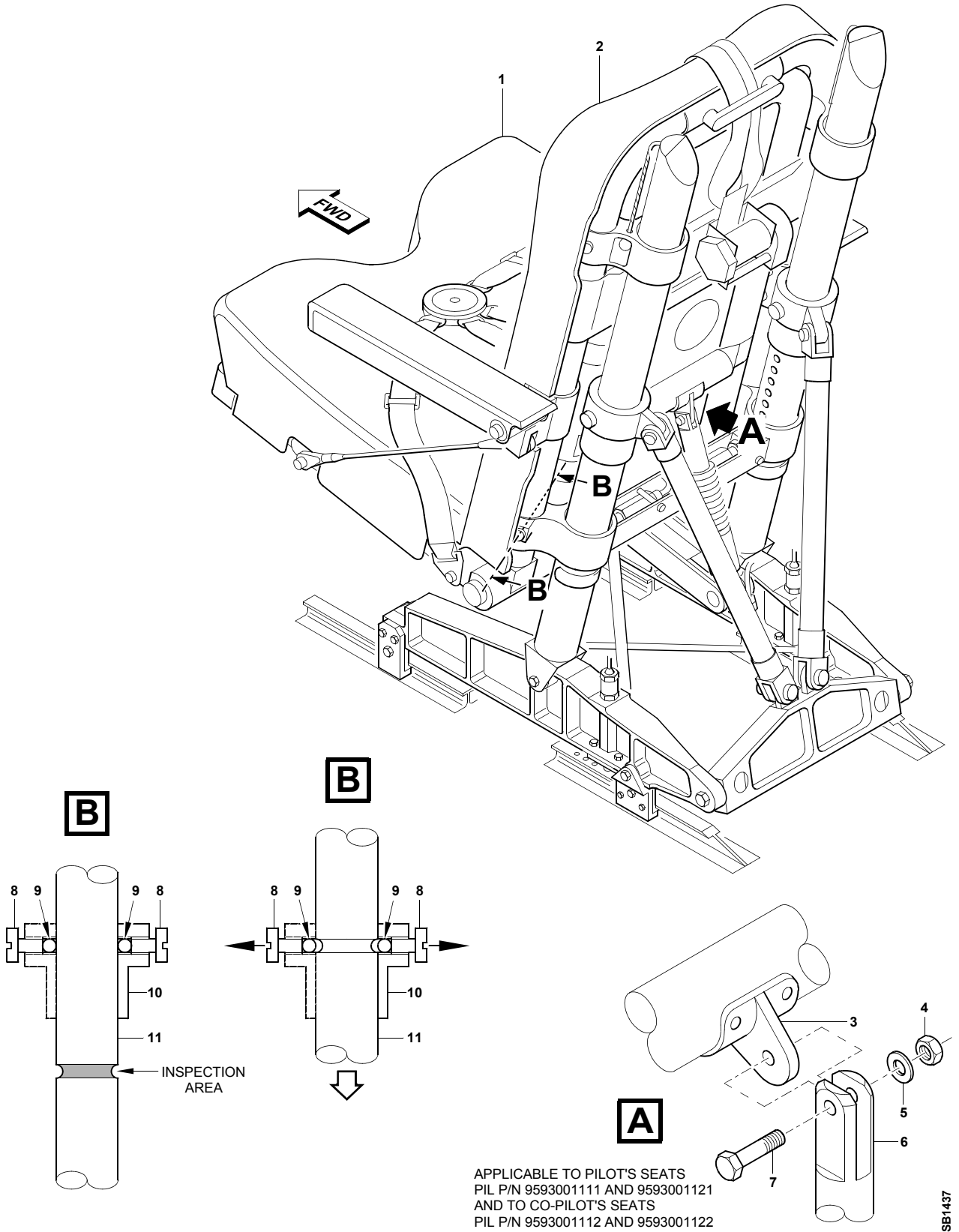
A. Inspection of the Bucket Assembly Tubes (Ref. Figure 1)

- (1) Do the inspection of the bucket assembly tubes (Ref. Para. 3.B.).

B. Documentation

- (1) Make an entry in the spare parts inventory list that this modification has been incorporated.
- (2) Use the Service Bulletin Evaluation Sheet to report your results and the serial number of the seats to PILATUS.

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APPLICABLE TO PILOT'S SEATS
 PIL P/N 9593001111 AND 9593001121
 AND TO CO-PILOT'S SEATS
 PIL P/N 9593001112 AND 9593001122

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Inspection of the Bucket Assembly Tubes Adjacent to the Energy Devices
 Figure 1