

Service Bulletin No: 55-004

Ref No: 390

Modification No: -

ATA Chapter: 55

STABILIZERS - HORIZONTAL STABILIZER - CHECK OF THE REAR ATTACHMENT BOLTS**1. Planning Information****A. Effectivity**

All PC-12 horizontal stabilizer rear attachment bolts P/N 555.10.12.139 with production order number (FAUF) FAUF 10169753, FAUF 10171067 or FAUF 10171267 installed on PC-12, PC-12/45, PC-12/47 and PC-12/47E Series aircraft and/or held as spares.

The horizontal stabilizer rear attachment bolts with the above listed P/N and FAUF were installed on new production PC-12/47E with aircraft MSN 1821 thru 1848 or were delivered as spares.

This Service Bulletin has been incorporated during production on MSN 1849 and Up.

All PC-12, PC-12/45, PC-12/47 and PC-12/47E Series aircraft which have replaced the horizontal stabilizer rear attachment bolts P/N 555.10.12.139 between July 24, 2018 and the issue date of this Service Bulletin may also be affected by the use of spares.

B. Concurrent Requirements

None.

C. Reason**(1) Issue**

Horizontal stabilizer rear attachment bolts P/N 555.10.12.139 with FAUF 10169753, FAUF 10171067 or FAUF 10171267 without the correct heat treatment have reduced material properties, which can possibly result in fatigue failure.

(2) Cause

The component manufacturer identified the incorrect heat treatment after delivery of the above listed P/N and FAUF to Pilatus Aircraft Ltd. A small number of affected bolts were used for new production aircraft and were supplied to operators as spares during a limited time period.

(3) Solution

At the 12 Months Inspection interval, do a check of the part number and production order number of the rear attachment bolts for the horizontal stabilizer. Replace the bolts if necessary.

D. Description

This Service Bulletin gives the data and instructions to do a check of the rear attachment bolts for the horizontal stabilizer and to replace defective bolts if necessary.

E. Compliance

Mandatory.

To be incorporated not later than 1350 flying hours or 13 months, whichever comes first after the issue date of this Service Bulletin.

Rear attachment bolts held as spares shall be checked before the installation on an aircraft or within 13 months, whichever comes first after the issue date of this Service Bulletin.

F. Approval

The technical content of this document is approved under the authority of DOA No. EASA. 21J. 357.

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

G. Copyright and Legal Statement

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H. Manpower

Task	During 12 Months Inspection Interval	
	Check	Replacement
Preparation	0	0.2
Check	0	-
Replacement	-	1.1
Close Up	0	0.2
TOTAL MAN-HOURS	0	1.5

I. Weight and Balance

No change.

J. Electrical Load Data

No change.

K. Software

No change.

L. References

Aircraft Maintenance Manual (AMM):

NOTE: AMM references are given without the model prefix. For PC-12, PC-12/45, PC-12/47 Series aircraft use the prefix 12-A, for PC-12/47E Series aircraft use the prefix 12-B.

06-20-00-00A-040A-A

24-00-00-00A-901A-A

27-40-00-00A-903A-A

30-10-00-00A-903A-A

30-10-00-00A-903B-A

55-10-01-00A-920A-A

M. Publications Affected

Not applicable.

N. Interchangeability of Parts

Not applicable.

2. Material Information**A. Material - Price and Availability**

Operators that require additional information and/or Service Bulletin Material should contact their authorized Pilatus Service Center, or Pilatus Customer Support on www.pilatus-aircraft.com → contact us

NOTE: Part Numbers given in this Service Bulletin are correct at the time of approval. Pilatus Aircraft Ltd. reserves the right to change part numbers as necessary. Part numbers of items delivered are correct when dispatched. This could lead to differences between those part numbers quoted in this Service Bulletin and if parts are superseded. Operators are requested to check the IPD for delivered parts which differ from those listed in the Service Bulletin Materials List.

Operators are requested to advise Pilatus Aircraft Ltd of the Manufacturer's Serial Number of aircraft which are affected by this Service Bulletin.

B. Warranty

Credit will be issued for parts and labor for all affected aircraft on approval of a warranty claim, provided:

- The work is accomplished during the next 12 Months Inspection by an authorized Service Center within 13 months from the issue date of this Service Bulletin.
- The affected bolts and the feedback sheet have been returned to Pilatus Aircraft Ltd.

C. Material Necessary

No modification kit is required.

(1) Material to be Procured

New Part No.	Description	Old Part No.	Qty	Disp. Code	Fig
555.10.12.139	BOLT	555.10.12.139 (with production order numbers: FAUF 10169753 FAUF 10171067 FAUF 10171267)	AR	R	1

Disposition Codes: D - Discard / N - New / R - Return to Pilatus

D. Operator Supplied Materials

None.

E. Tooling - Cost and Availability

None.

3. Accomplishment Instructions - Aircraft**A. Preparation**

- (1) De-energize the aircraft electrical system, refer to AMM 24-00-00-00A-901A-A.
- (2) Put a warning notice DO NOT MOVE THE ELEVATOR CONTROLS in the flight compartment.
- (3) Remove the access panel 33ET, refer to AMM 06-20-00-00A-040A-A.

B. Check / Replace

Refer to Figure 1 and Figure 2.

- (1) Check the rear attachment bolts to determine the P/N and FAUF.
- (2) Replace the rear attachment bolts, refer to AMM 55-10-01-00A-920A-A, and return the bolts to Pilatus, if one of these conditions apply:
 - (a) The P/N and FAUF are listed in 1.C.(1)
or
 - (b) The bolts were installed between July 24, 2018 and the issue date of this Service Bulletin, but the P/N and FAUF are not readable.
- (3) If the rear attachment bolt(s) was replaced, do the adjustment/test of the horizontal stabilizer trim, refer to AMM 27-40-00-00A-903A-A.
- (4) If the rear attachment bolt(s) was replaced, do the adjustment/test of the airfoil de-ice system. For PC-12, PC-12/45, PC-12/47 Series aircraft refer to AMM 30-10-00-00A-903A-A. For PC-12/47E Series aircraft, refer to 30-10-00-00A-903A-A or 30-10-00-00A-903B-A.

C. Close Up

- (1) Make sure that the work area is clean and clear of tools and other items.
- (2) Install the access panel 33ET, refer to AMM 06-20-00-00A-040A-A.
- (3) Remove the warning sign (DO NOT OPERATE THE FLIGHT CONTROLS) from the flight compartment.

D. Documentation

- (1) Make an entry in the Aircraft Logbook that this Service Bulletin has been incorporated.
- (2) If the rear attachment bolt(s) was replaced, return the completed feedback sheet and the bolt(s) to Pilatus Aircraft Ltd.

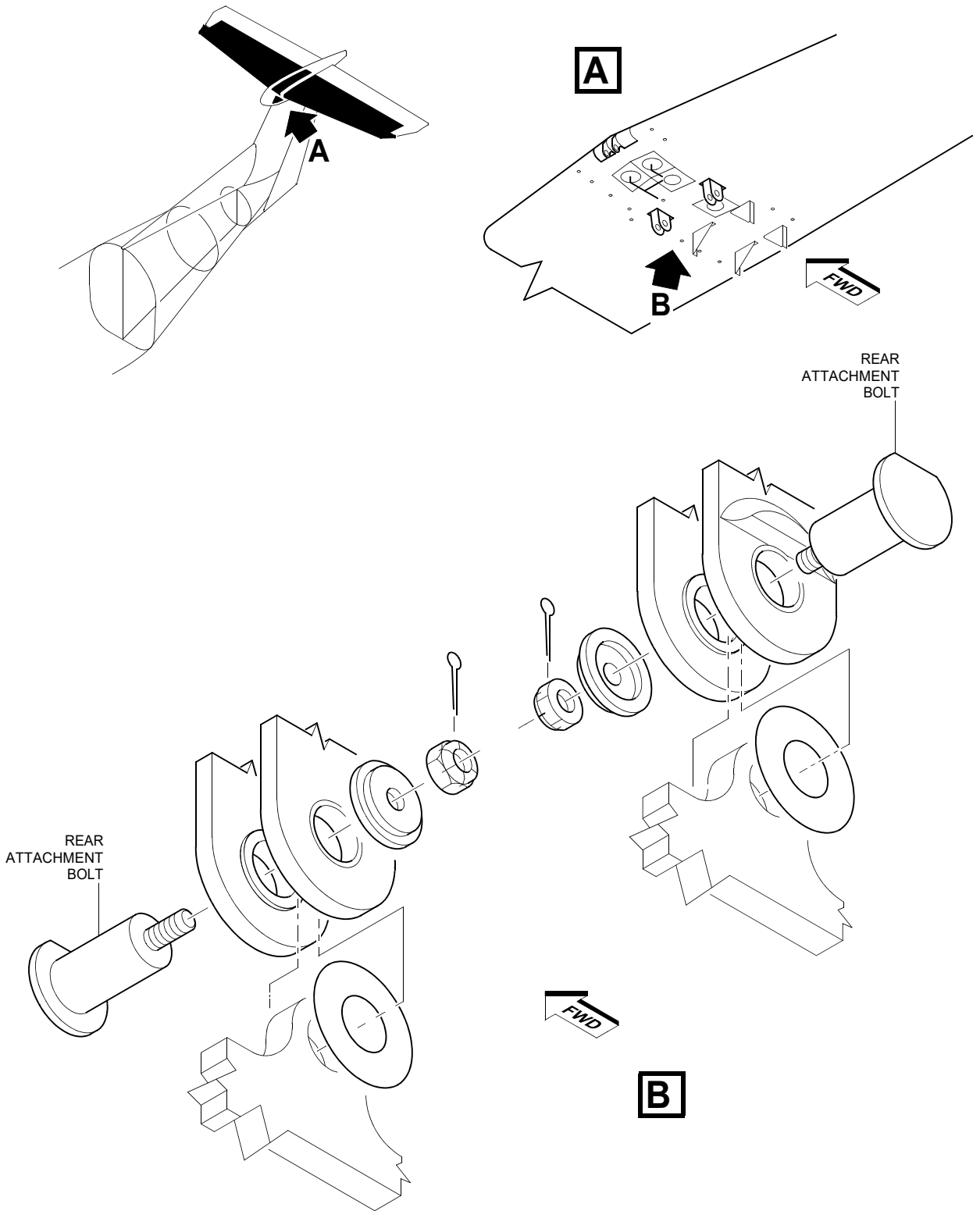
4. Accomplishment Instructions - Spares**A. Check**

Refer to Figure 2.

- (1) Check the rear attachment bolts to determine the P/N and FAUF.
- (2) Return the rear attachment bolts to Pilatus, if one of these conditions apply:
 - (a) The P/N and FAUF are listed in 1.C.(1)
or
 - (b) The bolts were put on stock between July 24, 2018 and the issue date of this Service Bulletin, but the P/N and FAUF are not readable.

B. Documentation

- (1) If the rear attachment bolt(s) are affected, return the completed feedback sheet and the bolt(s) to Pilatus Aircraft Ltd.



Rear Attachment Bolt - Component Location
Figure 1



Rear Attachment Bolt - Identification
Figure 2

The purpose of this Feedback Sheet is to allow you, the customer, to comment on this Service Bulletin. Your comments will be used to further improve our Service Bulletin program. It also provides Pilatus Aircraft Ltd with current information on each individual aircraft.

FEEDBACK SHEET FOR ACCOMPLISHMENT OF

SB No: _____ **Ref No:** _____

Aircraft MSN		Aircraft Registration		Total Airframe Hours	
Owner				Total Landings	
Operator					
Service Center					
<input type="checkbox"/> We have embodied/accomplished this SB			<input type="checkbox"/> Fully		
<input type="checkbox"/> We will not embody/accomplish this SB			<input type="checkbox"/> Partially		
The undersigned confirms the accomplishment of this Service Bulletin					
Date of accomplishment	Name		Signature		
Comments (procedure, kit quality, suggested improvements etc.)					

Important Note: If a parts replacement are involved, please provide the applicable work card including the component details (part number(s) and serial number(s)) together with the feedback sheet.

Please send this form to:
 PILATUS AIRCRAFT LTD.
 CUSTOMER SUPPORT PC-12
 CH 6371 Stans, Switzerland
 www.pilatus-aircraft.com ----> contact us

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