

Service Bulletin No: 52-006

Ref No: 136

Modification No: INSPECTION

ATA Chapter: 52

**CANOPY - GENERAL
INSPECTION OF THE CANOPY HINGE SCREWS FOR SECURITY OF INSTALLATION****1. Planning Information****A. Effectivity**

Aircraft MSNs 675 thru 764.

B. Concurrent Requirements

Aircraft MSNs 675 thru 715 equipped with a Canopy Assy listed below must be Post SB 52-005.

Serial Number	Serial Number	Serial Number
6455	6563 thru 6566	6596 thru 6598
6458	6568	6600
6459	6571	6603 thru 6610
6476	6573 thru 6583	6460
6477	6586	6572
6480 thru 6484	6594	6620

C. Reason**(1) Problem**

An operator found that some of the screws that attach the canopy to the canopy hinge had become loose.

(2) Solution

Remove the screws and re-install using adhesive (Loctite).

D. Description

This Service Bulletin gives the data and instructions necessary to remove, clean, and re-install the screws with adhesive.

E. Compliance

Mandatory.

Required within 90 days after the effective date of this Service Bulletin.

F. Approval

The technical content of this Service Bulletin is approved under the authority of Letter of DOA Acceptance ref. FOCA.21J.002.

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

G. Copyright Information

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H. Manpower

	Total
Inspection Procedure	2.0
Close up	0.5
TOTAL MAN-HOURS	2.5

I. Weight and Balance

(1) Weight Change

None.

(2) Moment Change

None.

J. Electrical Load Data

Not changed.

K. Software

Not changed.

L. References

Aircraft Maintenance Manual (AMM): 20-31-00, 25-10-00.

M. Publications Affected

AMM: 52-10-01.

N. Interchangeability of Parts

Not Affected.

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

No Modification Kit is necessary to do this Service Bulletin.

Operators who require further information should contact their Customer Liaison Manager at Pilatus Aircraft Ltd., 6371 Stans, Switzerland.

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

B. Material Necessary for Each Aircraft**(1) Consumable Materials (Ref. AMM 20-31-00)**

Material No.	Description	Remarks
P01-008	Solvent	
P02-041	Lint-free Cleaning Cloth	
P08-017	Adhesive	

(2) Tools and Equipment

Part No.	Description	Remarks
-	Lifting sling	Min. capacity 100 kg (220 lb)

C. Re-identified Parts

Not Applicable.

D. Tooling - Cost and Availability

Not Applicable.

3. Accomplishment Instructions**A. Inspection Procedure (Ref. Fig. 1)**

WARNING: BEFORE YOU GO INTO THE COCKPIT, MAKE SURE THAT BOTH EJECTION SEATS HAVE THE SAFETY PINS INSTALLED IN THE SAFE FOR SERVICING LOCATIONS (REF. AMM 25-10-00, PAGE BLOCK 201).

WARNING: BE CAREFUL WHEN YOU MOVE THE CANOPY. IT WEIGHS APPROXIMATELY 46 KG (101.4 LB).

CAUTION: TAKE CARE WHEN YOU WORK NEAR THE CANOPY, THAT YOU DO NOT SCRATCH OR SCORE THE TRANSPARENCIES.

- (1) Fully open the canopy (3).
- (2) Attach the lifting sling (1) to the left side of the canopy cross member (2).
- (3) Attach the lifting sling (1) to the hoist and support the weight of the canopy (3).
- (4) Remove the nut (5), the washer (6) and bolt (7) which attach the damper strut (8) to the canopy operating lever (4).
- (5) Move the canopy damper (8) clear of the work area.

CAUTION: DO THE PROCEDURE FOR ALL THE SCREWS (9) INSTALLED THROUGH THE CANOPY HINGE (10) BUT LOOSEN/REMOVE ONLY ONE SCREW AT A TIME.

- (6) Loosen one screw (9) at a time, two turns, then continue to loosen for a third turn.
- (7) Make sure that, on the third turn, you can still feel the resistance of the self-locking threads of the rivnut.
- (8) Continue to loosen the screw (9). After the third turn you should feel a small but obvious reduction in the force required to turn the screw.

NOTE: The reduction in the force required to turn the screw indicates that the self-locking of the rivnut is sufficient and adhesive is not required.

- (9) If you feel the reduction in force as described in Step (8), fully tighten the screw (9).
- (10) If you cannot feel the reduction in force as described in Step (8), do the steps that follow:
 - (a) Remove the screw (9).
 - (b) Use solvent (Material No. P01-008) and a lint-free cleaning cloth (Material No. P02-041) to clean the:
 - Threads of the removed screw (9)
 - Threads of the rivnut in the canopy beam (11)
 - (c) Let the solvent dry.
 - (d) Apply adhesive (Material No. P08-017) to the threads of the screw (9) and install it. Make sure you fully tighten the screw (9).

(11) Install the canopy damper (8) to the canopy operating lever (4) with the bolt (7), the washer (6) and the nut (5).

(12) Remove the hoist and the lifting sling (1).

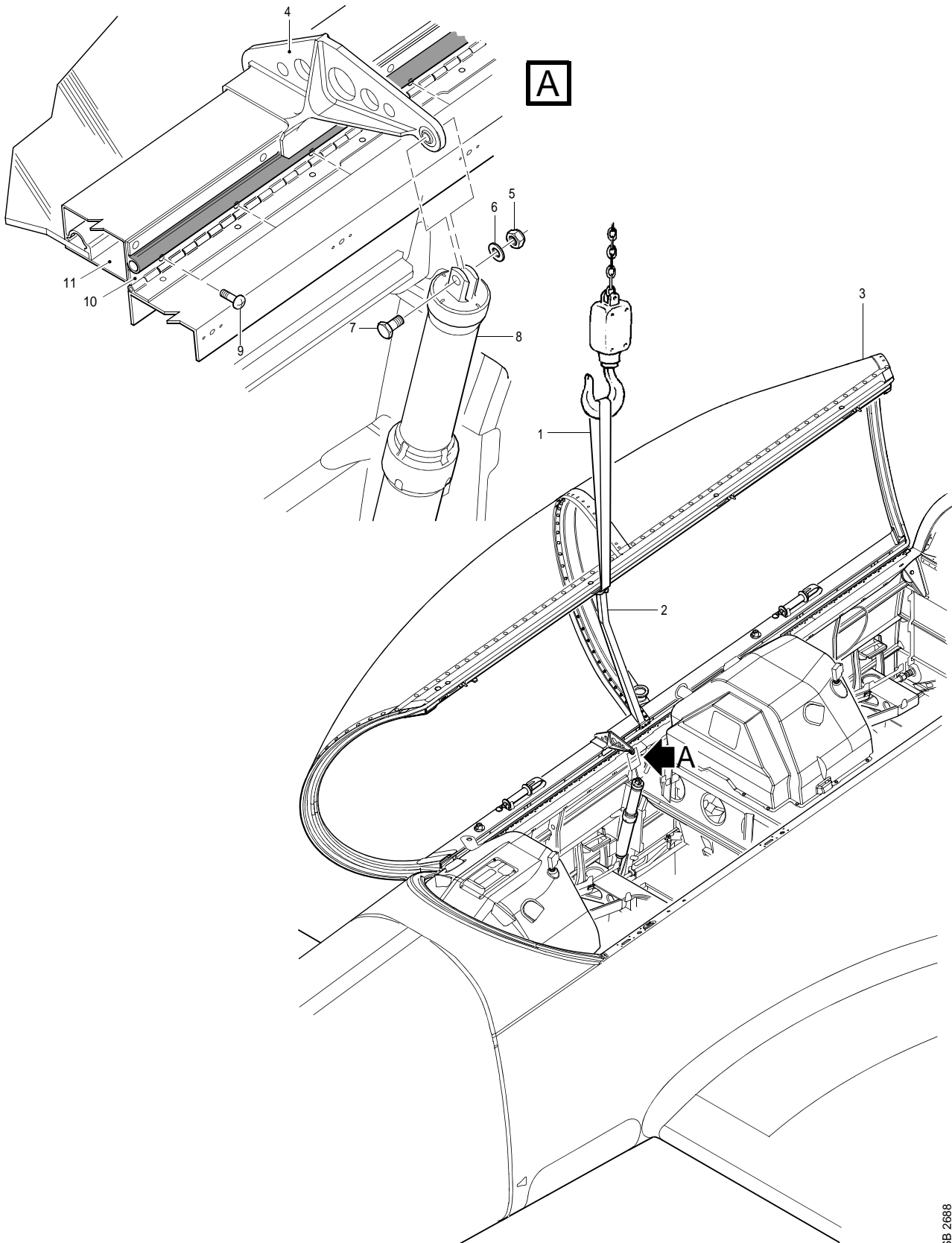
B. Close-Up

(1) Remove all equipment, materials and tools from the work area. Make sure that the work area is clean.

C. Documentation

(1) Make an entry in the Aircraft Logbook that this Service Bulletin has been incorporated.

(2) Use the Service Bulletin Evaluation Sheet and report your results and the serial number of the aircraft to Pilatus.



Inspection
Figure 1

SB 2688

SERVICE BULLETIN EVALUATION SHEET FOR SB No. 52-006			
Title	Canopy - General - Inspection of the Canopy Hinge Screws for Security of Installation		
Customer			
Service Center			
EMBODIMENT REPORTING			
This SB has been embodied:		<input type="checkbox"/>	On the entire fleet
		<input type="checkbox"/>	Only partially
Provide embodiment details per aircraft (use additional copies of this table, if necessary)			
MSN	Flying Hours	MSN	Flying Hours
Additional embodiment comments/findings			
EDITORIAL COMMENTS (procedure, kit quality, suggested improvements, etc.)			
Name	Signature	Date	
Please complete and forward this form to: Pilatus Aircraft LTD, Customer Technical Support (MCC), P.O. BOX 992, 6371 Stans, Switzerland Fax: +41 (0)41 619 6773 Email: Techsupport@pilatus-aircraft.com			

SERVICE BULLETIN EVALUATION SHEET

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