



PILATUS AIRCRAFT LTD. CH-6371 STANS, SWITZERLAND

SERVICE LETTER

SUBJECT: IPECO SERVICE BULLETIN 318-25-03

To all Customers and Operators:

Date: Jul 24/06

This Service Letter is issued to draw attention to the following vendor information:

Ipeco Service Bulletin 318-25-03 Issue 2 - Change to Armrest Assembly

Ipeco Service Bulletin 318-25-03 Issue 2 is issued to address the problems of looseness in the armrests and the catching of screws in the back boards of crew seats in PC-12, PC-12/45 and PC-12/47 aircraft. The Service Bulletin is applicable to seats with PILATUS part numbers: 959.30.01.135, 959.30.01.136, 959.30.01.143 and 959.30.01.144, with serial numbers up to and including 45767.

To rectify and prevent looseness in the armrests and the catching of screws, PILATUS recommends Operators comply fully with the instruction given in Ipeco Service Bulletin 318-25-03 Issue 2 at the next available opportunity.

Operators requiring further information on this subject, please contact one of the addresses given below:

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

PILATUS BUSINESS AIRCRAFT LTD.,
PRODUCT SUPPORT DEPARTMENT,
11755 AIRPORT WAY,
BROOMFIELD, CO 80021.
USA

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

PILATUS AUSTRALIA (Pty.) LTD.,
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Adelaide Airport SA 5950,
AUSTRALIA

Tel : +61 (08) 8234 4433
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Free Call: 1800 445 007
eMail: info@pilatus.com.au

Attachment: Ipeco Service Bulletin 318-25-03 Issue 2.



SERVICE BULLETIN EQUIPMENT / FURNISHINGS

FLIGHT COMPARTMENT

**CHANGE TO ARMREST
ASSEMBLY**

PILATUS PC-12

SERVICE BULLETIN NUMBER

318-25-03

ISSUE 2

ISSUED BY:

**IPECO
SEATING PRODUCTS DIVISION
AVIATION WAY
SOUTHEND ON SEA
ESSEX SS2 6UN
ENGLAND**

TELEPHONE: 01702 549371 FAX 01702 540782

A DIVISION OF IPECO HOLDINGS LTD. REGISTERED IN ENGLAND NO. 672443



SERVICE BULLETIN

TRANSMITTAL SHEET

THIS PAGE TRANSMITS A REVISION TO SERVICE BULLETIN
NUMBER 318-25-03

THIS REVISION DATED 24 April 2006
PLACE THIS PAGE UNDER FRONT SHEET OF SERVICE BULLETIN

REASON FOR REVISION Addition of Seat Serial Numbers, revision of text and illustrations.

PREVIOUS ISSUES 1 DATE: 31 January 2006

PROCEDURE Discard Front page Issue 1, replace with Front page Issue 2.
Discard page 2 Issue 1, replace with page 2 Issue 2.

DETAIL OF CHANGE

PAGE No.	ISSUE No.	DESCRIPTION OF CHANGE
Front	2	Raise document Issue from 1 to 2.
2	2	Serial Number Added.

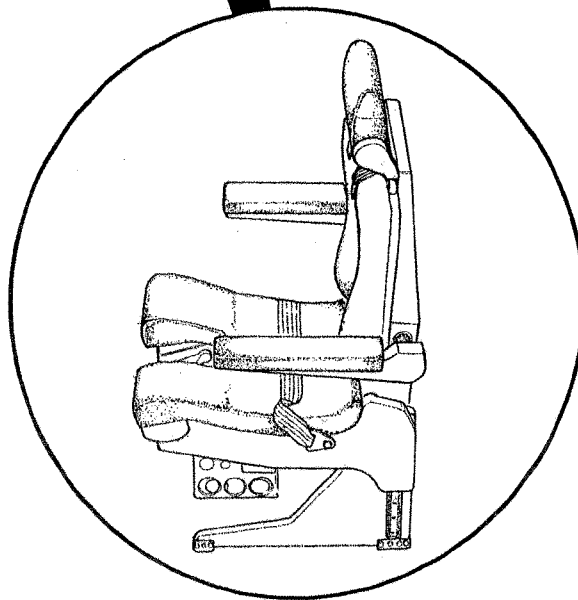
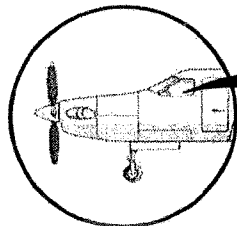
COMPILED: _____

APPROVED BY: _____



SERVICE BULLETIN

SERVICE BULLETIN No.
318-25-03



LOCATION OF SERVICE BULLETIN CONTENT

COMPILED BY:


I. GARDNER
DESIGN DRAUGHTSMAN

APPROVED BY:


D. A. SCOTT
TECHNICAL DIRECTOR

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PLANNING INFORMATION

Effectivity

Pilatus PC-12 aircraft fitted with Ipeco Pilot and Co-pilot seats of the following part numbers, up to and including seat serial number 45767:-

	Ipeco Part No.	Pilatus Part No.
Pilot Seat:	3A318-0007-(**)-1	959.30.01.135
Co-pilot Seat	3A318-0008-(**)-1	959.30.01.136
Pilot Seat:	3A318-0007-(**)-2	959.30.01.143
Co-pilot Seat	3A318-0008-(**)-2	959.30.01.144

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Classification

Aircraft manufacturer's recommendation.

Reason

To reduce the play in the armrest and eliminate interference of screws with the Backboard.

Description

Removal, modification and replacement of the armrest assembly to reduce the play. Removal of existing countersunk head screws with cup washers and replacement with pan head screws.

Approval

This Service Bulletin contains no modification information that revises the approved configuration and therefore does not require CAA or other regulatory agency approval.

Manpower

The incorporation of this Service Bulletin is estimated to require 1 man-hour per aircraft, when accomplished at maintenance level.

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Material Cost and Availability

IPECO drawing number:-
Mod Kit - ARMREST - 3M800-0567

Purchase Order to be issued to:-

Ipeco
Seating Products Division
Sales Department
Aviation Way
Southend-on-Sea
Essex SS2 6UN
England

Telephone: 01702 549371

containing the following information:-

Title and Part Number
Quantity required
Name of Airline/Operator
Part Number of Seat

Parts will be shipped within 4 – 6 weeks of receipt of Purchase Order.

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Weight

Not affected, less than 0.05 lbs.

Tooling

Not required.

Software Accomplishment Summary

Not applicable

References

Component Maintenance Manual SM667 (25-11-52), Mark I Seat.

Component Maintenance Manual SM681 (25-11-66), Mark II Seat.

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Accomplishment Instructions

Figure 1	Page 8
Figure 2	Page 9
Figure 3	Page 10
Figure 4	Page 11
Figure 5	Page 12
Figure 6	Page 13
Figure 7	Page 14

Note 1: Figures show Pilot seat, Co-Pilot seat is symmetrically opposite.

Note 2: Item numbers shown thus:- (*) refer to items from the mod kit.

Note 3: Item numbers shown thus:- (***) refer to items from the illustrated parts list, (1-81) refers to figure 1 item 81.

1. Remove seat from aircraft (refer to aircraft maintenance manual).
2. Operate the vertical handle and position seat in the fully up position. See figure 1.
3. Operate the recline control lever and adjust seat back to minimum recline position. See figure 1.
4. Rotate both armrests fully forward to deploy. See figure 1.
5. Remove and retain the csk hd screw (1-14) and associated cup washers (1-15) (Inboard Armrest only). See figure 2.
6. Remove and retain the armrest upholstery (1-6, 1-10) and armrest cover (1-7, 1-11). (Inboard Armrest only). See figure 2.
7. Remove and retain the special bolt (1-18). (Inboard Armrest only). See figure 3.
8. Remove and discard the four csk hd screws (1-39) and associated cup washers (1-42). See figure 2.
9. Remove and retain the armrest structure cover (1-36, 1-33). (Inboard Armrest only) See figure 3.

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10. Remove and retain the csk hd screw (1-27) and associated cup washers (1-30) (Outboard Armrest only). See figure 4.
11. Remove and retain the armrest rear cover (1-24). (Outboard Armrest only). See figure 4.
12. Drive out and discard the two spirol pins (1-51) during reassembly replace with new spirol pins (Item 2, table 1). See figure 5.
13. Remove the armrest assy (1-54, 1-57) taking care not to damage the paint work.
14. Add a washer (item 1, table 1) on both armrests, between the armrest assy (1-54, 1-57) and the bearing armrest tube (1-45) on the inside of the armrest only. See figure 6.
15. Reassemble in reverse order noting to replace the two spirol pins (1-51) with new spirol pins (Item 2, table 1). See figure 5. Add four pan hd screws (Item 3, table 1) instead of the four csk hd screws (1-39) and associated cup washers (1-42). See figure 7.
16. After modification Pilatus should mark by vibro etch or similar method the Service Bulletin number (318-25-03), Issue number (1) in the modification box of the seat identification label, which is located on the base rear skin panel.

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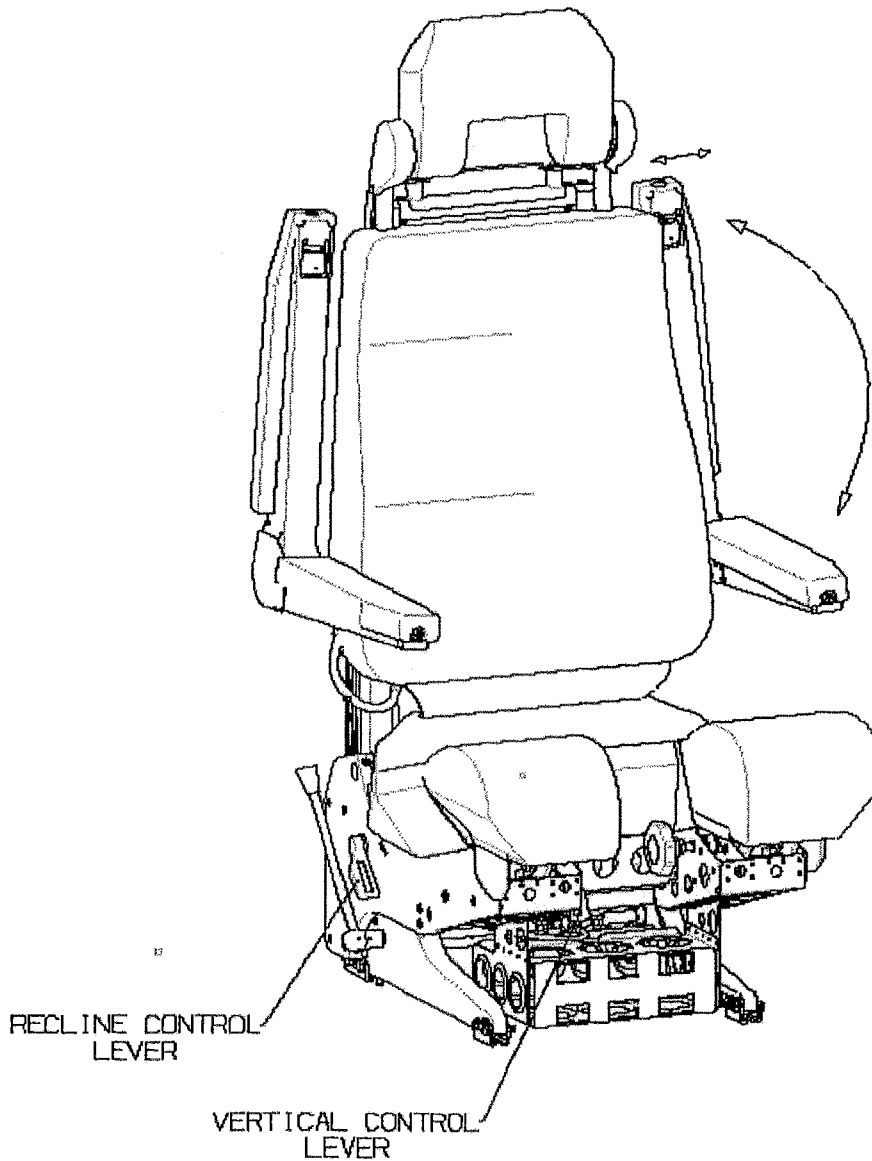


FIGURE 1
(Seat shown in Fully Down Position)

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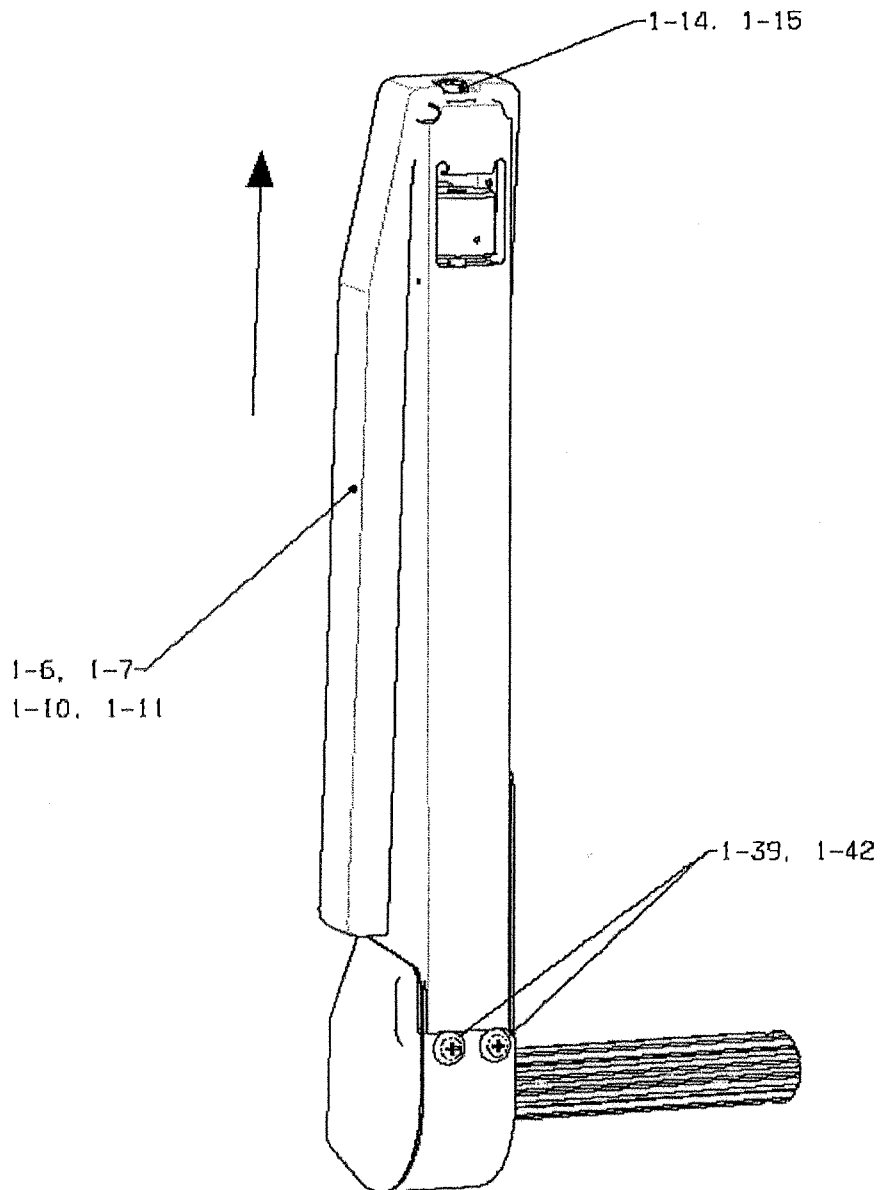


FIGURE 2
(Rest of seat not shown for clarity)

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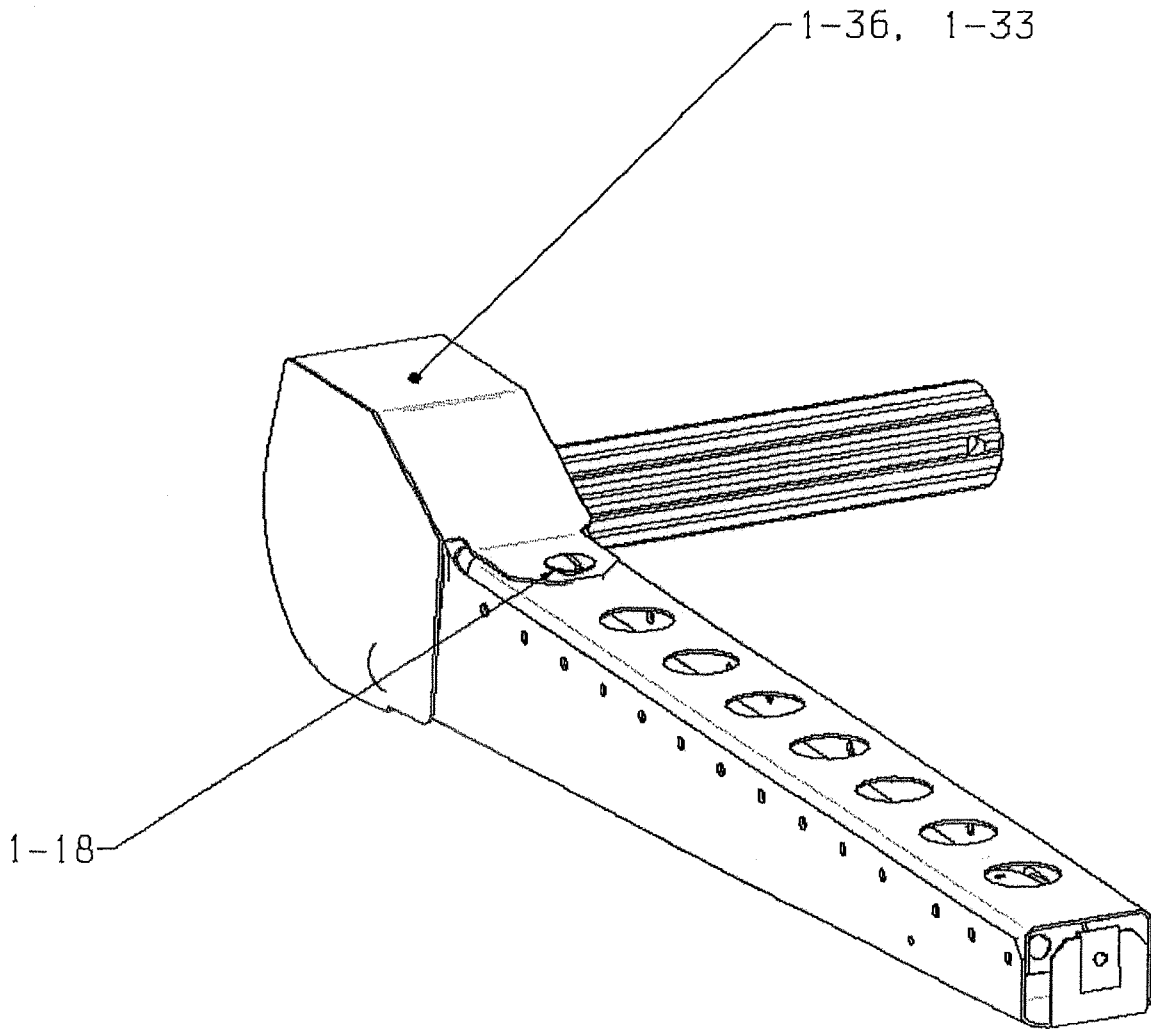


FIGURE 3
(Inboard Armrest only, Rest of seat not shown for clarity)

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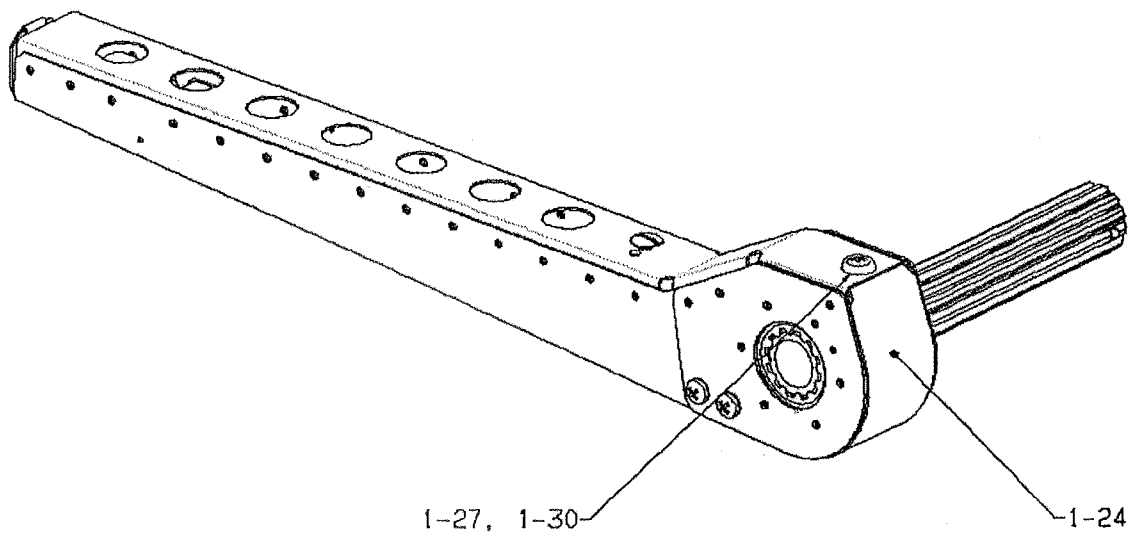


FIGURE 4
(Outboard Armrest only, Rest of seat not shown for clarity)

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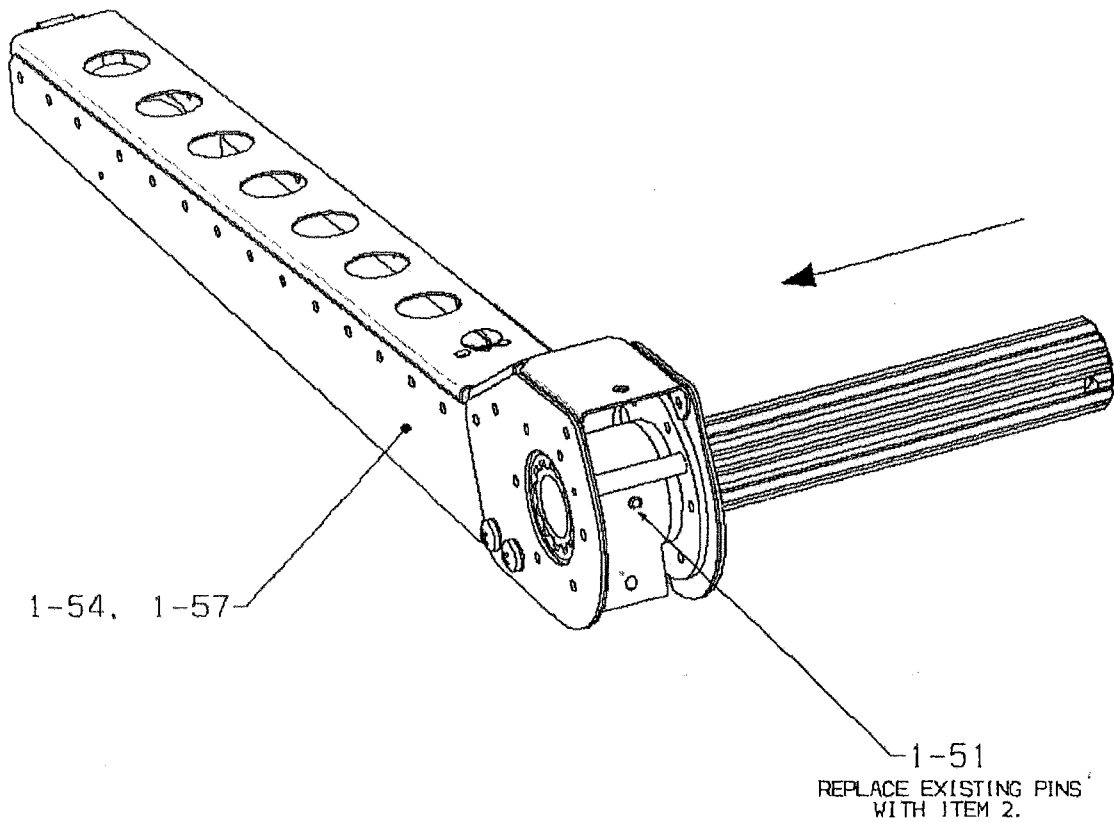
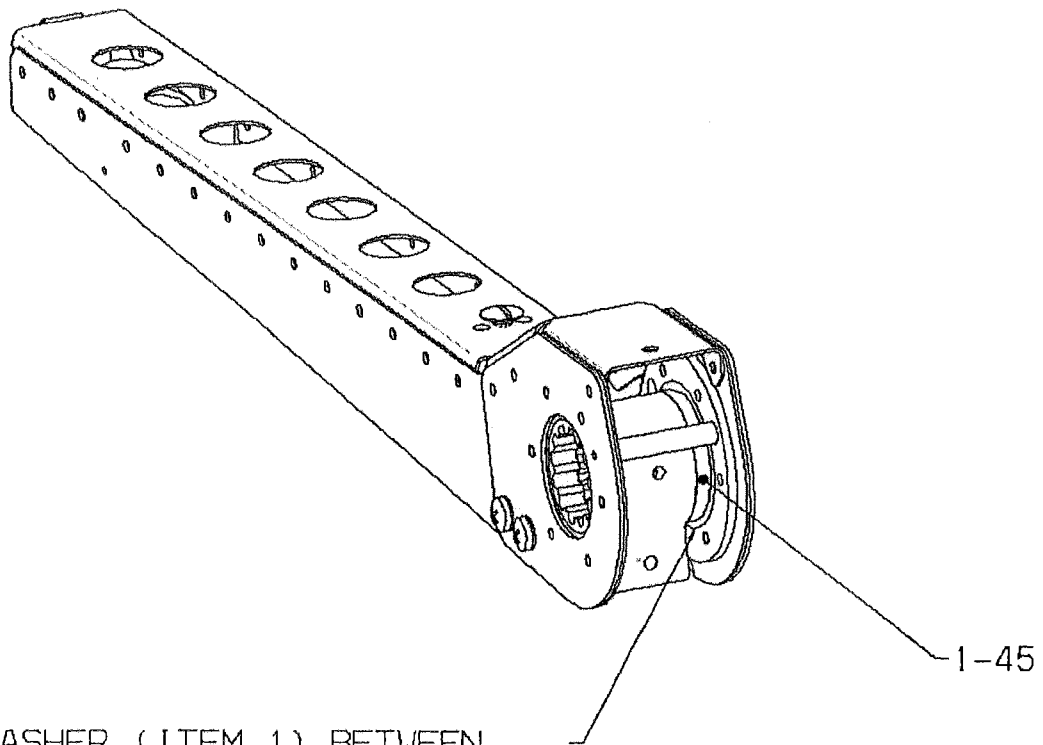


FIGURE 5
(Rest of seat not shown for clarity)

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ADD WASHER (ITEM 1) BETWEEN
ARMREST ASSY (RH 1-54, LH 1-57)
AND BEARING ARMREST TUBE (1-48)

FIGURE 6
(Rest of seat not shown for clarity)

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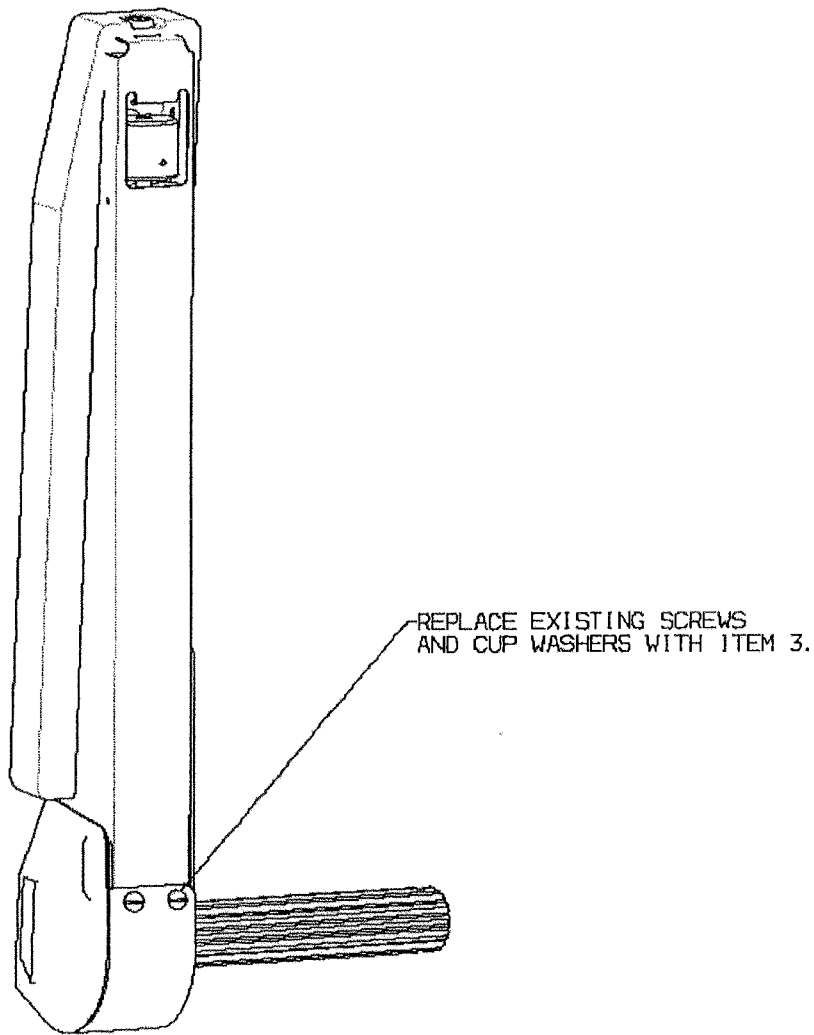


FIGURE 7
(Rest of seat not shown for clarity)

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MATERIAL INFORMATION

The materials listed in Table 1 are the full contents of one Mod Kit and are sufficient to modify one seat.

TABLE 1

ITEM No.	NEW PART NUMBER	KEYWORD	OLD PART NUMBER	QTY
1	3A318-0559	WASHER	-	2
2	1A500-0667	PIN, SPIROL SPRING 5:32 X 1.50	-	2
3	3A500-0247	SCREW, PAN HD SELF TAP No.8 x 0.75	3A500-0583 3A500-0325	4

Unless otherwise instructed in the Accomplishment Instructions section of this Service Bulletin all old parts removed from the seat are to be discarded.

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