



SERVICE DIRECTIVE BULLETIN

SERVICE DIRECTIVE BULLETIN (SDB) NO. T-065

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DATE: October 13, 2020

1. SUBJECT: Transmission Mount - Pylon Joint Cracks
2. MODEL: 480, 480B
3. EFFECTIVITY: S/N 5254 and prior
4. BACKGROUND:

Enstrom has received reports of cracks in the pylon joint under the forward left and right transmission mounts of three aircraft used in training operations. This SDB requires visual inspection for cracks in the pylon joint under each forward transmission mount.

5. COMPLIANCE:

Within the next 10 hours or at the next scheduled inspection, whichever occurs first, inspect the pylon for cracks in accordance with paragraph 6.

Additionally, aircraft with a service history of, or that are currently used for, flight training (particularly those aircraft with a high occurrence of practice emergency landings) or agricultural spray operations may be modified with a pylon joint reinforcement patch. Installation of the reinforcement patch is at the discretion of the operator/owner. Refer to SIL T-073 for installation information.

6. INSPECTION:

- 6.1 Access the forward pylon transmission mounts through the engine access doors.
- 6.2 Clean the pylon tubes and welds in the area of the transmission mount using a suitable solvent (refer to paragraph 7.1).
- 6.3 Using a borescope, light source, inspection mirror, as available, inspect the pylon tubes and joint welds for cracks (Figure 1 through Figure 6).
- 6.4 If an area is suspect, use a liquid penetrant method (ASTM E165) to confirm the presence of a crack.
 - 6.4.1 Enstrom Product Support may be contacted for assistance evaluating the indications from the liquid penetrant inspection.
- 6.5 If cracks are detected, contact Enstrom Product Support for the repair procedure.

7. PARTS:

7.1 Consumables:

Product	Description
Solvent	Common household cleaner/degreaser or non-corrosive (non-chlorinated) brake cleaner

8. TOOLS: Borescope, inspection mirror, and suitable light source, as applicable

9. ESTIMATED MAN HOURS: Visual Inspection - 30 minutes; Liquid penetrant inspection, as needed - 2 hours

10. WARRANTY: Per Enstrom warranty policy

11. WEIGHT CHANGE: N/A

12. LOG BOOK ENTRY: Enter compliance with this Service Directive Bulletin.

13. REPETITIVE INSPECTIONS:

13.1 Perform an inspection at 100 hour intervals per paragraph 6.

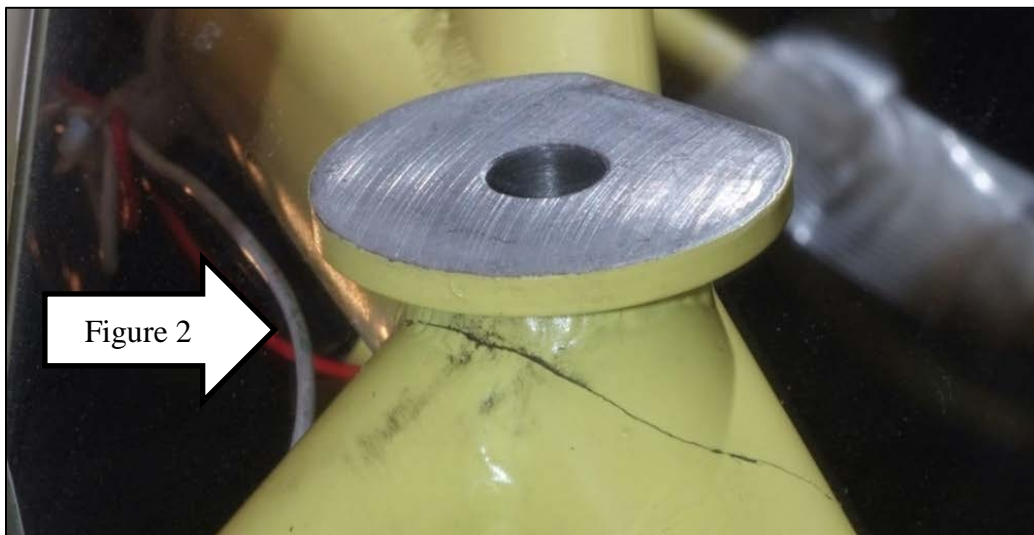
13.2 Installing the finger patch repair per SIL T-073 terminates the repetitive inspection requirement.



**Figure 1. Photograph of Forward Left Mount with Transmission Installed
(Photo taken through engine access door)**



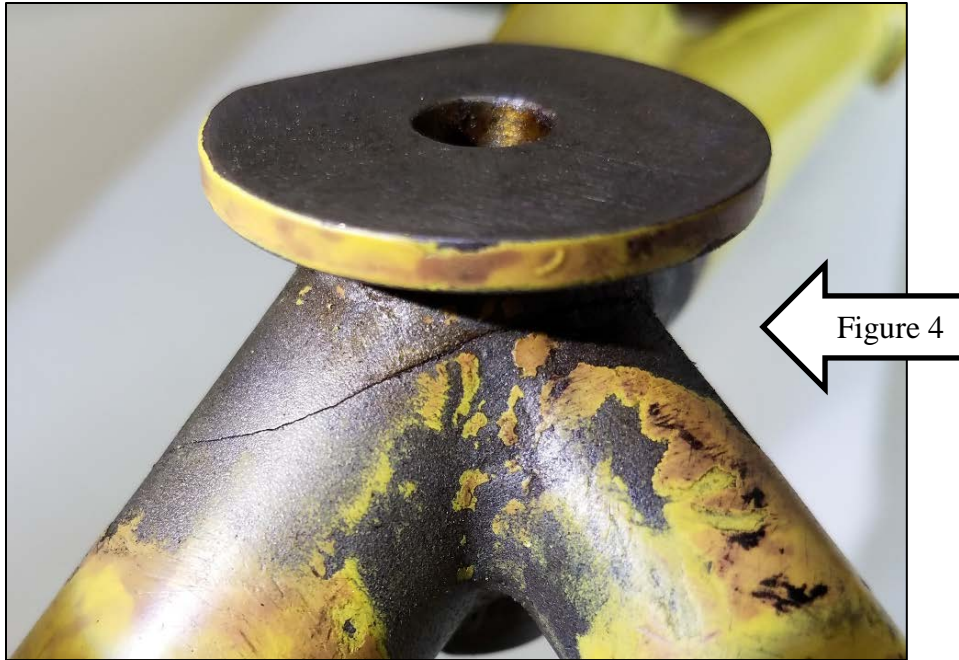
**Figure 2. Photograph of Cracked Area – Forward Left Mount
(Photo taken using a mirror)**



**Figure 3. Photograph of Cracked Area – Forward Left Mount - Rotated 90°
(Photo taken using a mirror)**



**Figure 4. Photograph of Cracked Area – Forward Left Mount
(Same area as in Figure 2 except mirror was not used; paint/epoxy primer removed)**



**Figure 5. Photograph of Cracked Area – Forward Left Mount - Rotated 90°
(Same area as is Figure 3 except mirror was not used; paint/epoxy primer removed)**

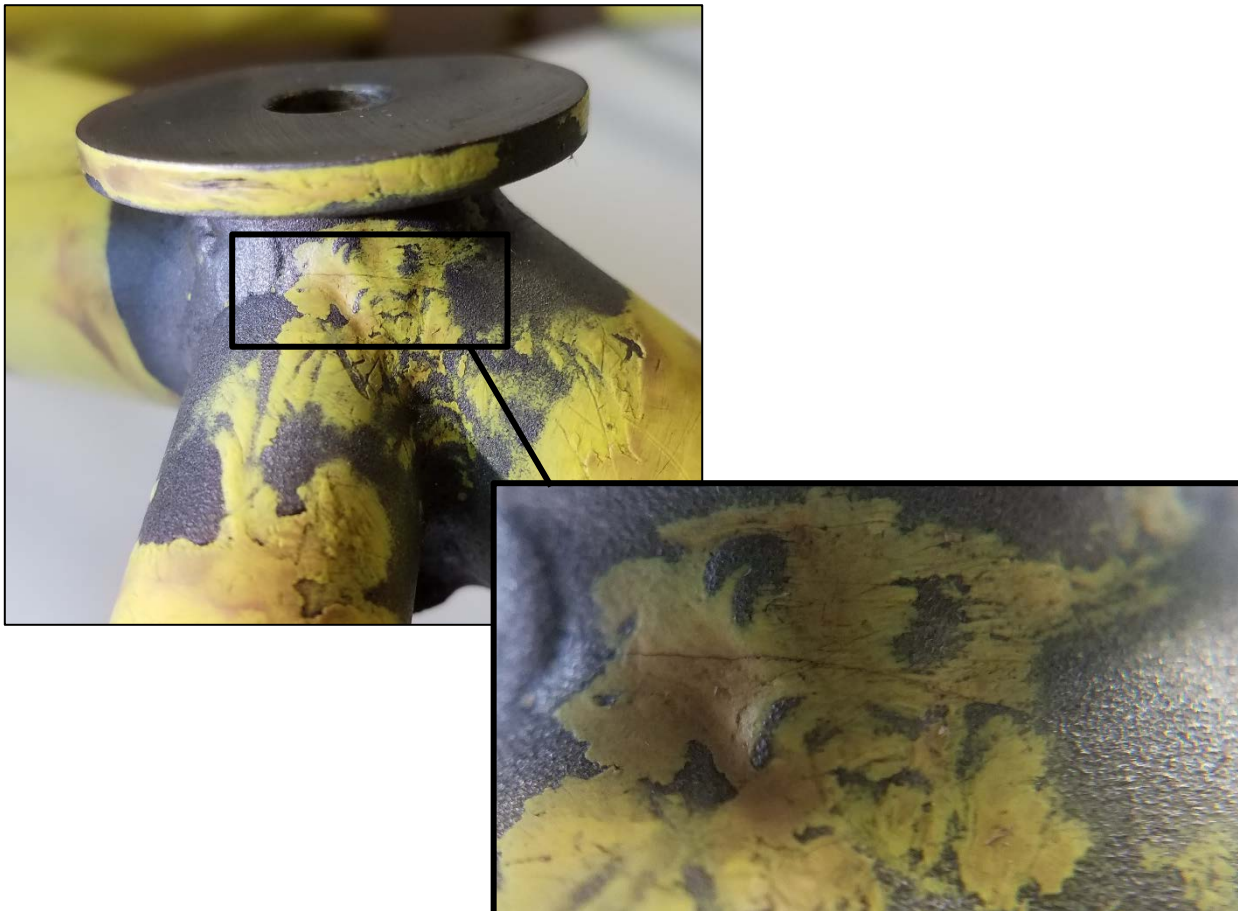


Figure 6. Forward Right Mount (paint/epoxy primer removed)