

AIRBUS HELICOPTERS CANADA LIMITED

**SUBJECT:**

Required maintenance for the Rear Cross Tube Maintenance Step (P/N 350-500604).

**APPLICABILITY :**

 Aircraft with the subject modification embodied in accordance with TCCA STC  
 No. SH98-43 or any relevant foreign approvals.

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PREPARED BY:			
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REV 0 ACCEPTED (Civil A/W Authority)	(As per ICA Compliance Check Sheet) <i>C. Timmins</i>	10 <sup>th</sup> Dec, 2014	TCCA
REV 0 RELEASED BY:	P. Sharpe <i>P. Sharpe</i>	11 DEC 2014	AHCA ENGINEERING

**RECORD OF REVISIONS**

Rev.	Pages at this Revision	Description, Reason Changed Pages	Prepared (name and date)	Checked (name and date)	App'd/Acc'd (Civil A/W Authority) (name and date)	Released (name and date)
0	1 through 10	Original Issue	D. Kerr 3 August 2011	C. Timmins 3 August 2011	N/A	P. Sharpe 22 April 2013
1	1 through 11	Revised company logo, replaced ECL with AHCA. Added LH and RH abbreviations. Removed sealant P/N PR 1422 B2. Revised Section 2 to incorporate all Airworthiness Limitations statements. Revised Sec. 4 maintenance procedures from 100 FH to 150 FH inspections. Revised inspection schedules. (Pages 3 to 10)	See page 1.	See page 1.	See page 1.	See page 1.

NOTE: Revisions to this document will be distributed to operators of this equipment by the STC holder.  
 NOTE: Revised portions of affected pages are identified by a vertical black line in the margin adjacent to the change.  
 NOTE: Minor changes are released in accordance with TCCA-ACCEPTED CAR 521.154 procedures (ref. DAPM-E-0001).

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**1. GENERAL**

- A. The Rear Cross Tube Maintenance Step attaches to the existing skid tube. The Rear Cross Tube Maintenance Step has a non-slip surface on top providing a safe foot placement for maintenance personnel. Refer to Figure 1 for General Layout.

The Rear Cross Tube Maintenance Step is for on-ground operations only and is not to be used while in flight.

The Rear Cross Tube Maintenance Step is installed in accordance with Master Drawing List MDL-98-002.

- B. These Instructions for Continued Airworthiness are applicable to aircraft with the subject modification embodied.

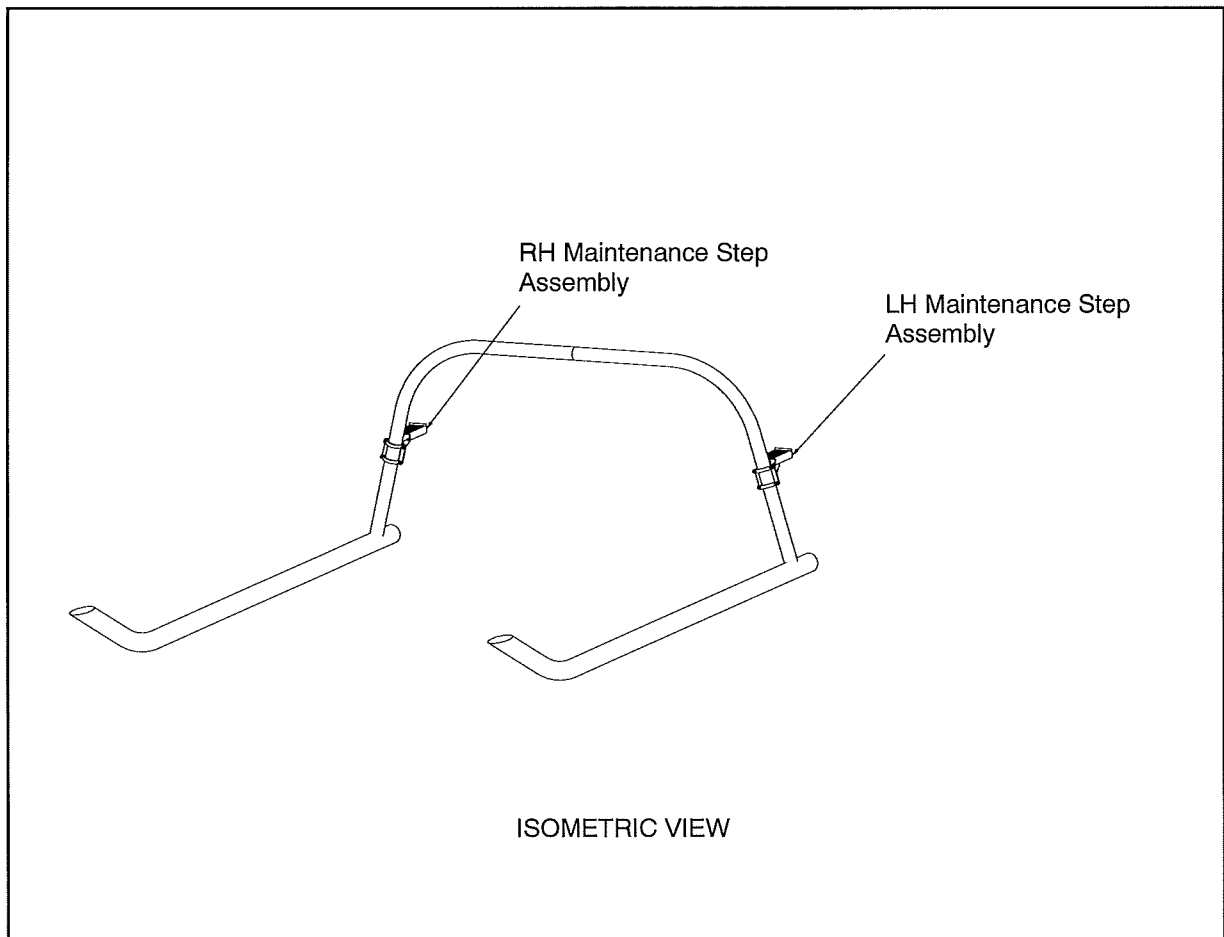
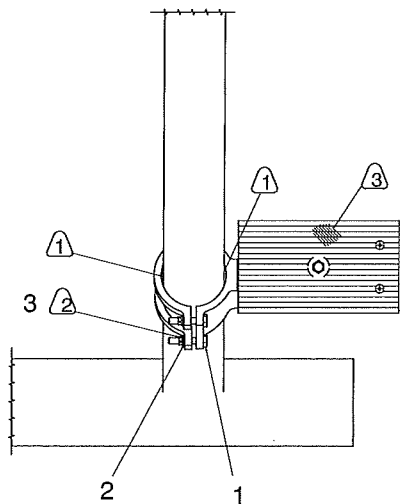


Figure 1 General Layout

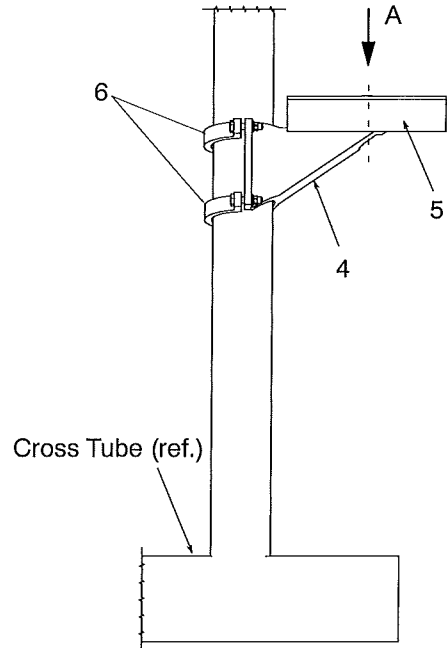
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Legend (for Figure 2)  
 Item Description

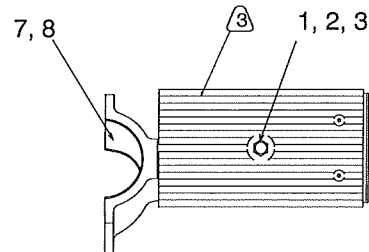
1. Screw
2. Washer
3. Self-Locking Nut
4. Rear Attachment
5. Maintenance Step
6. Rear Clamp Assembly
7. Rubber Spacer (P/N 350-500324.20)
8. Rubber Adhesive (P/N EC 847)
9. Tread Tape (P/N #510 Black-6")
10. Anti-Slip Paint (P/N X-1567)



SIDE VIEW  
 Showing LH Installation  
 (RH opposite)



SIDE VIEW  
 Showing LH Installation  
 (LH shown, RH opposite)



DETAIL A  
 View looking down on rail step,  
 cross tube not shown

- Ⓒ Apply anti-slip paint (10) to top surface of step.
- Ⓓ Evenly torque self-locking nuts (3) alternating between fasteners. Do not over tighten. Use torque as per MTC, Chapter 20.02.05.404.
- Ⓐ Apply tread tape (9) to faying (joining) surfaces.

**NOTES:**

Figure 2 Detail of Left Hand Maintenance Step

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**C. REFERENCES**

DOCUMENT	DOCUMENT TITLE
MTC	Standard Practices Manual

**D. ABBREVIATIONS & DEFINITIONS**

ABBREVIATION	DEFINITION
Acc'd	Accepted
AH	Airbus Helicopters (France)
AHCA	Airbus Helicopters Canada Limited
App'd	Approved
A/W	Airworthiness
CAR	Canadian Aviation Regulations
D	Days
DAPM	Design Approval Procedures Manual
FAA	Federal Aviation Authority
FH	Flight Hours
hrs	hours
LH	Left Hand
M	Months
MDL	Master Drawing List
P/N	Part Number
Qty.	Quantity
ref.	reference
Rev.	Revision
RH	Right Hand
STC	Supplementary Type Certificate
TCCA	Transport Canada Civil Authority

**E. UNITS OF MEASUREMENT**

ABBREVIATION / SYMBOL	UNIT OF MEASUREMENT
in	inch
kg	kilogram
lb	pound
m	meter

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**INSTRUCTIONS FOR CONTINUED  
AIRWORTHINESS  
REAR CROSS TUBE MAINTENANCE STEP  
AS 350 / AS 355**

**2. AIRWORTHINESS LIMITATIONS**

The Airworthiness Limitations section is approved by the Minister and specifies maintenance required by any applicable airworthiness or operating rule unless an alternative program has been approved by the Minister. Variations must also be approved.

The Airworthiness Limitations section is FAA approved and specifies inspections and other maintenance required under §§43.16 and 91.403 of Federal Aviation Regulations unless an alternative program has been FAA approved.

The airworthiness limitations section is approved and variations must also be approved.

No airworthiness limitations associated with this installation.

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**3. CONTROL AND OPERATION**

Control and operation of the aircraft remains unchanged.

**4. INSPECTION SCHEDULE AND MAINTENANCE ACTION**
**NOTE:** Use torque per MTC, Chapter 20.02.05.404, unless otherwise specified.

**NOTE:** Instructions given below are for both LH and RH Maintenance Steps.

**4.1. INSPECTION SCHEDULE**

4.1.1. Every 150 FH or 12 M (Margins: 15 FH or 36 D) to coincide with the 150 FH or 12 M helicopter inspection, whichever occurs first:

ITEM	INSPECTION OR MAINTENANCE WORK	CORRECTIVE ACTION
A	- Check Rear Cross Tube Maintenance Steps shown in Figure 2 for: a. security	a. Secure as required.  Evenly torque the self-locking nuts (3) alternating between fasteners. Refer to Figure 2, NOTE 2. Use torque value as per MTC Chapter 20.02.05.404 . Do not over tighten.
B	- Visually inspect maintenance step (5), rear clamp assembly (6) and rear attachment (4), shown in Figure 2, for: a. cracking	a. No cracking is allowed. If cracking is found contact AHCA for replacement part.
C	- Check anti-slip paint (10), on maintenance step, (5), shown in Figure 2 for: a. condition	a. Clean area and reapply anti-slip paint (10), (P/N X-1567) in accordance with MTC, Chapter 20.03.08.401.

Table 1 Inspection Schedule and Maintenance Action  
 Every 150 FH or 12 M to coincide with the 150 FH or 12 M helicopter inspection, whichever occurs first

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**4. INSPECTION SCHEDULE AND MAINTENANCE ACTION (continued)**
**4.1. INSPECTION SCHEDULE**

4.1.2. Every 600 FH or 24 M (Margins: 60 FH or 73 D) to coincide with the 600 FH or 24 M helicopter inspection, whichever occurs first:

ITEM	INSPECTION OR MAINTENANCE WORK	CORRECTIVE ACTION
A	<ul style="list-style-type: none"> <li>- Check mounting hardware, items 1, 2 and 3 securing rear attachment (4) and rear clamp assembly (6, 2 places) to the cross tube shown in Figure 2 for:               <ul style="list-style-type: none"> <li>a. security</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>a. Secure as required. Evenly torque the self-locking nuts (3) alternating between fasteners. Use torque value as per MTC Chapter 20.02.05.404 . Do not over tighten.</li> </ul>
B	<ul style="list-style-type: none"> <li>- Check mounting hardware, items 1, 2 and 3 securing the maintenance step (5) to the rear attachment (4), shown in Figure 2 for:               <ul style="list-style-type: none"> <li>a. security</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>a. Secure as required.</li> </ul>
C	<ul style="list-style-type: none"> <li>- Check rubber spacer (7) located between rear attachment (4) and the cross tube shown in Figure 2 for:               <ul style="list-style-type: none"> <li>a. deterioration</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>a. If deterioration is found, contact AHCA for replacement part. Trim to fit rear attachment (4) and secure using rubber adhesive (8) in accordance with MTC, Chapter 20-06-01.404.</li> </ul>

Table 2 Inspection Schedule and Maintenance Action  
 Every 600 FH or 24 M to coincide with the 600 FH or 24 M helicopter inspection, whichever occurs first

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**AIRBUS HELICOPTERS CANADA LIMITED****5. REPLACEMENT COMPONENTS AND REPAIR / OVERHAUL INFORMATION**

Contact AHCA for replacement parts. No overhaul information required for this installation.

For replacement components contact:

Airbus Helicopters Canada Limited  
1100 Gilmore Road, P.O. Box 250  
Fort Erie, Ontario L2A 5M9 Canada  
Telephone: (905) 871-7772  
Telefax: (905) 871-3599

www.airbushelicopters.ca

**6. TROUBLESHOOTING**

There are no unique characteristics which require troubleshooting techniques.

**7. SPECIAL TOOLING**

No special test equipment or tools are required. Standard tools are adequate.

**8. REMOVAL AND REPLACEMENT**

**NOTE** Removal and Installation instructions are the same for both LH and RH Maintenance Steps.

**A. REMOVAL****1) REAR CROSS TUBE MAINTENANCE STEP (Refer to Figure 2)**

- a) Remove self-locking nuts (3, 2 places), washers (2, 2 places) and screws (1, 2 places) from the top and bottom rear clamp assembly (6, 2 places).
- b) Remove the Maintenance Step from the rear cross tube.

**B. REPLACEMENT**

**NOTE:** Use torque per MTC, Chapter 20.02.05.404, unless otherwise specified.

**1) REAR CROSS TUBE MAINTENANCE STEP (Refer to Figure 2 and Appendix A)**

- a) Replace existing tread tape (9) prior to installation, if necessary. Refer to Figure 1 and Appendix A, NOTE 1.
- b) Clean area and position the Maintenance Step onto the rear cross tube in accordance with Appendix A.
- c) Align the top rear clamp assembly and secure using screws (1, 2 places), washers (2, 2 places) and self-locking nuts (3, 2 places).
- d) Align the bottom rear clamp assembly and secure using screws (1, 2 places), washers (2, 2 places) and self-locking nuts (3, 2 places).

**NOTE** Evenly torque self-locking nuts ( 3) alternating between fasteners. Do not over tighten. Refer to Figure 2 and Appendix A, NOTE 2.

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**9. WEIGHT AND BALANCE DATA**

A. Removed Items

DESCRIPTION	WEIGHT		ARM		MOMENT	
	kg	lbs	m	in	kg m	lb in
Not applicable	0.00	0.0	0.00	0.0	0.00	0.0
Total	0.00	0.0	0.00	0.0	0.00	0.0

B. Added Items

DESCRIPTION	WEIGHT		ARM		MOMENT	
	kg	lbs	m	in	kg m	lb in
LH/RH Maintenance Step Assembly	2.20	4.9	4.22	166.3	9.29	806.8
Total	2.20	4.9	4.22	166.3	9.29	806.8

**10. PLACARDS AND MARKINGS**

There are no Placards and Markings with this modification.

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