

ANC22FA041

## **AIRWORTHINESS**

Group Chair's Factual Report - Attachment 1  
Phoenix Heliparts Work Order No. 1105

MAKE: Bell  
MODEL: 407  
S/N: 53118  
REG NO: N402SH  
WORK ORDER: 1105



**Phoenix Heliparts Inc.**  
3130 N Oakland, Suite 110  
Mesa, Arizona 85215 USA  
Phone: 480-965-7994

DATE: 7/3/2014  
A/C TSN: 14958  
TACH.

### Airframe Entries

- 2 Performed an A/C Preliminary and receiving Inspection. Reviewed Logbooks and photographed aircraft records. Performed verification of Aircraft Information; registration number, part number, serial number, general condition, obvious damage and the possibility that hidden damage inspection may be required.
- Found aircraft in the following condition:  
Aircraft in good condition. Engine, Transmission, Tailboom, and upper aft skin removed.
- Description of discrepancy found (if different than reported):  
Crack in LH engine pan longeron and in clip at RH engine pan longeron at fs 192.00
- Description of any additional material, equipment, tooling, data or personnel required by actual discrepancies versus what was reported:  
Procedure and hardware for replacement of LH engine pan longeron.
- Arrival Date: April 30, 2014, A/C Model: Bell 407, A/C Registration: N402SH, A/C S/N: 53118 TT: 14,956.2
- 3 Provided assistance for TB 407-12-96 Rev. A dated 14 Feb. 2012, performed the following steps of the Technical Bulletin Accomplishing Instructions- steps 5, 8 thru 25, 31 thru 34. Customer to comply with remaining items.  
Replaced damaged skin p/n 206-033-003-161 and LH and RH retainers P/N 407-030-740-116S and 407-030-740-115S with new customer supplied parts, Removed and installed referencing TB 407-12-96 Rev.A Dated 14 Feb. 2012 and BHT-All-SRM 3-3-1.
- 5 Removed L/H aft fuselage skin to gain access to the L/H engine pan longeron P/N 206-031-314-173, Removed cracked L/H engine pan longeron P/N 206-031-314-173 and installed new customer supplied longeron and Reinstalled L/H aft fuselage skin Referencing BHT-206-SRM-1 section 6 application 6-2-6. Determined to be a major Repair.
- 6 Repaired damaged frames at sta.167.33 and 179.66, and 192.00 LBL 13.00. Determined to be a major Repair.
- Repaired damaged frame at sta.167.33 ( P/N 206-032-303-129) by splicing in new frame section from LBL 7.75 to LBL 23.0. Fabricated upper splice repair from 7075T6 .032 P.O. 10256 referencing BHT-ALL-SRM 3-6-3, Fabricated lower splice from new frame segments and 7075T6.032 P.O.10256 referencing BHT-206-SRM-1 5.2.4. Treated and primed all repair parts referencing BHT-ALL-SPM 3-16.
- Repaired damaged frame at sta.179.66 by fabricating repair clip and shim from 7075T6.032 P.O.10256 increasing the dimensions of the clip to add fasteners around damage, repair clip replaces P/N 206-032-304-007 clip,fabricated repair doubler from 7075T6.032 P.O.10256 to repair damage to doubler P/N 206-032-304-029 referencing BHT-ALL-SRM 3-6-3 application C. Treated and primed all repair parts referencing BHT-ALL-SPM 3-16.
- Repaired damaged frame at sta.192.00 by fabricating a doubler from 2024T3.040 P.O.12839 for the forward side of the frame and a doubler for the aft side of frame from customer supplied 2024T3.032 referencing BHT-ALL-SRM 3-5-4. Fabricated replacement clips from 2024T3.040 P.O. 12839 P/N PH206-032-305-161, -162 and reinstalled, Treated and primed all repair parts referencing BHT-ALL-SPM 3-16.

#### Technicians Who Worked On The Items Listed Above:

Brandon Clausen, Donald Degray, Ismael De Larosa, Ryan Howe, Ted Manchego, Travis Plithoud

The work described in Work Order 1105, was performed in accordance with 14 CFR and with respect to that work, the article described in the referenced Work Order is approved for return to service. Pertinent details of the repair are on file at Phoenix Heliparts, Inc. Work Order No. 1105.

DATE: 7/3/2014

SIGNED

CRS#: X8HR308Y

Work Order: 1105

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