



SERVICE BULLETIN EQUIPMENT / FURNISHINGS

FLIGHT COMPARTMENT

**CONFIGURATION
CHANGE**

PILATUS PC-12

SERVICE BULLETIN NUMBER

318-25-06

ISSUE 3

ISSUED BY:

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

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



SERVICE BULLETIN

TRANSMITTAL SHEET

THIS PAGE TRANSMITS A REVISION TO SERVICE BULLETIN

NUMBER 318-25-06

THIS REVISION DATED 10th June 2011
PLACE THIS PAGE UNDER FRONT SHEET OF SERVICE BULLETIN

REASON FOR REVISION Change to part number in Mod Kit.

PREVIOUS ISSUES 2 DATE: 27th May 2011

PROCEDURE Discard Front page and pages 9, 10, 11 and 12, at issue 2.
Replace with issue 3

DETAIL OF CHANGE

PAGE No.	ISSUE No.	DESCRIPTION OF CHANGE
Front Page	3	Document issue raised from 2 to 3.
Page 9	3	Item 20 part number and keyword revised
Page 10	3	Item 20 part number and keyword revised
Page 11	3	Item 20 part number and keyword revised
Page 12	3	Item 20 part number and keyword revised

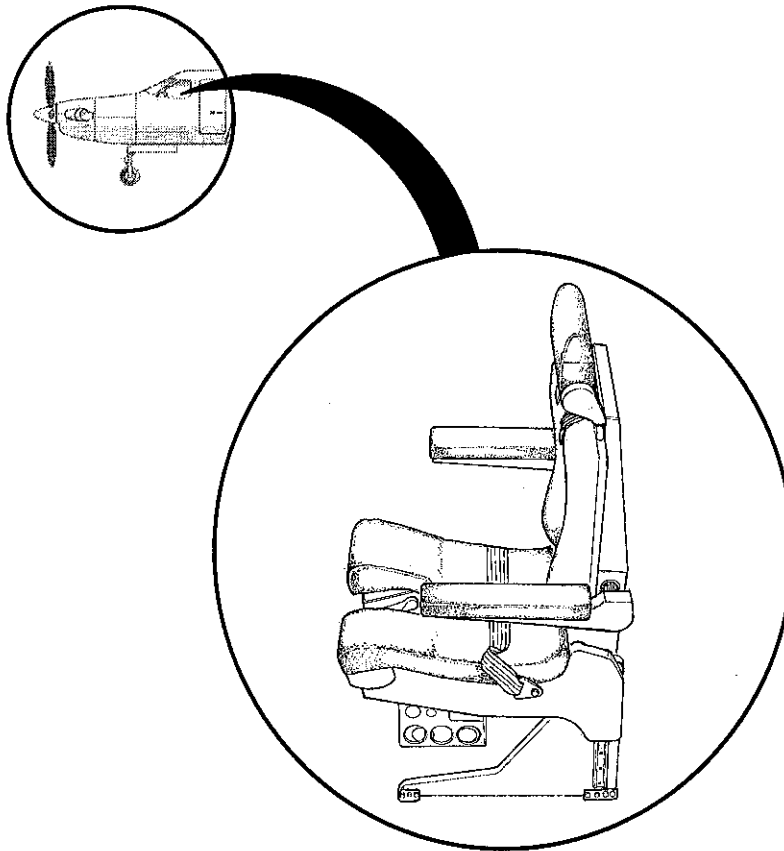
COMPILED BY: S. Earthy
S. EARTHY
PRODUCT SUPPORT ENGINEER

APPROVED BY: W. Barnes
W. BARNES
PRODUCT SUPPORT MANAGER



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LOCATION OF SERVICE BULLETIN CONTENT

COMPILED BY: _____
S. EARTHY
PRODUCT SUPPORT ENGINEER

APPROVED BY: _____
W. BARNES
PRODUCT SUPPORT MANAGER



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PLANNING INFORMATION

Effectivity

Pilatus PC-12 aircraft fitted with Ipeco pilot and co-pilot seats of the following part numbers:-

	Ipeco Part No.	Pilatus Part No.
Pilot Seat:	3A318-0007-00-1	959.30.01.135
	3A318-0007-01-1	959.30.01.135
Co-pilot Seat	3A318-0008-00-1	959.30.01.136
	3A318-0008-01-1	959.30.01.136

Classification

Operator's discretion

Reason

To allow the operator to reconfigure the seat as follows:

3A318-0007-00-1 to a 3A318-0007-00-3.

3A318-0008-00-1 to a 3A318-0008-00-3.

3A318-0007-01-1 to a 3A318-0007-01-3.

3A318-0008-01-1 to a 3A318-0008-01-3.

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Description

Removal of existing seat pan structure assembly, seat pan cushion and cover and fitting with new parts to change the seat configuration.

Approval

The modification information contained in this Service Bulletin converts the seat from one certified configuration to another certified configuration, and as such this Bulletin does not require EASA or other regulatory agency approval.

Warranty

The actions listed in this Service Bulletin are not covered by Ipeco Warranty.

Manpower

The incorporation of this Service Bulletin is estimated to require 6 man-hours per seat.

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Material Cost and Availability

For seat part numbers 3A318-0007-00-1 Mod Kit – 2M800-0715

For seat part numbers 3A318-0008-00-1 Mod Kit – 2M800-0716

For seat part numbers 3A318-0007-01-1 Mod Kit – 2M800-0717

For seat part numbers 3A318-0008-01-1 Mod Kit – 2M800-0718

Instructions for ordering:-

Purchase Order to be issued to:-

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

Telephone: 01702 549371
E-Mail: sales@ipeco.co.uk

containing the following information:-

- Title and part number
- Quantity required
- Name of Airline/Operator
- Part number of seat

Parts will be shipped within 6–10 weeks after acceptance of Purchase Order.

Operators in the North American market should order from:-

Ipeco Inc
2275 Jefferson St.
Torrance
California 90501
USA

Telephone: 310 783 4700
E-Mail: sales@ipecoinc.com

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Weight

Not affected

Tooling

None

Software Accomplishment Summary

Not applicable

References

Component Maintenance Manual SM667 (25-11-52)

Component Maintenance Manual SM681 (25-11-66)

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Accomplishment Instructions

Note 1: Item numbers shown thus: - (*-**) refer to items from the Illustrated Parts List (part of CMM), i.e. (1-30) refers to Figure 1, Item 30.

Note 2: Item numbers shown thus: - (*) refer to items from the mod kit, see table 1.

Note 3: During disassembly all fasteners are to be retained with exception of Pin, Spirol Springs's, Nut Lock's, Circlip's, Pin, Split's and Cable Tie's.

1. The following instructions require the seat to be removed from the aircraft. Refer to the aircraft maintenance manual for details.
2. Remove Cover, Seat Pan Cushion (1-168) (1-171) and Cushion, Seat Pan (1-174) as detailed in CMM 25-11-52.
3. Remove and retain the Cover, Back Cushion (1-159) (1-162) and Cushion, Back (1-165) as detailed in CMM 25-11-52.
To prevent damage it is recommended to either suitably protect, or remove and retain the LH Cover, Armrest (1-11) (1-13), RH Cover, Armrest (1-7) (1-9) and Headrest (1-111) and all associated fasteners, as detailed in CMM 25-11-52.
4. Remove and retain the Seat Assy, Upper (3-69) (3-72) from the Seat Assy, Basic (3-1) (3-3) as detailed in CMM 25-11-52.
Retain the Base & Mechanism Assy (3-78), and associated fasteners. See note 3.
5. Remove and retain the Seat Pan & Mechanism Assy (4-78) (4-81) from the Seat Assy, Upper (4-1) (4-3) as detailed in CMM 25-11-52.
Retain the Structure Assy, Back (4-87) and associated fasteners. See note 3.
6. Remove and retain all mechanism components from the Seat Pan & Mechanism Assy (6-1) (6-3) as detailed in CMM 25-11-52, and associated fasteners. See note 3.
Discard the Structure Assy, Seat Pan (6-213) (6-216).

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7. Assemble the seat pan mechanism components retained in operation 6 into new Structure Assy, Seat Pan (1), as detailed in CMM 25-11-66, using the following new fasteners from the Mod Kit:
Pin, Spirol Spring 1:8 x 0.50, (4), Qty 1.
Pin, Spirol Spring 1:8 x 0.88, (5), Qty 1.
Pin, Spirol Spring 5:32 x 0.75, (6), Qty 2.
Pin, Spirol Spring 5:32 x 1.00, (7), Qty 1.
Pin, Spirol Spring 5:32 x 0.56, (8), Qty 2.
Nut, Lock 10-32UNF (10), Qty 13
Nut, Lock 8-32UNC, (11), Qty 4
Circlip, (13), Qty 1
8. Assemble the Seat Pan & Mechanism Assy (4-78) (4-81) into the Seat Assy, Upper (4-1) (4-3), using components and assemblies retained in operation 5, and the following new fasteners from the Mod Kit as detailed in CMM 25-11-66:
Pin, Spirol Spring 3:16 x 1.50, (9), Qty 2.
Nut, Lock 10-32UNF, (10), Qty 7.
9. Assemble the Seat Assy, Upper (3-69) (3-72) in to the Seat Assy, Basic (3-1) (3-3), using components and assemblies retained from operation 4, and the following new fasteners from the Mod Kit as detailed in CMM 25-11-66,:
Pin, Split 1:16 x 0.375, (14), Qty 2.
Pin, Split 3:32 x 0.625, (15), Qty 2.
Cable Tie, (12), Qty 1.
10. Check vertical operation of the seat as detailed in CMM 25-11-66 and adjust as required.
11. Attach Hook Fastener Self-Ad (16) and (17) to suit loop fastener positioning on Cushion Pan (2).
12. With the seat in the fully down position, note the position of the Label, TSO (1-267). Carefully remove Label, TSO (1-267). (CMM 25-11-52). Remove any adhesive residue using a locally sourced, suitable cleaning solvent. It is the responsibility of the operator to comply with all local regulatory and aviation authority regulations.
13. Attach Label, TSO Part Number (20) to the base structure back panel in position noted in previous operation.

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14. With the seat in the fully up position carefully remove the existing nameplate, which is located on base structure back panel.
It is recommended to use a Ø3.30mm drill to remove the 4 attaching rivets.
15. After modification, operator should by vibro-etch or similar method, transfer all remaining information from the removed nameplate onto the nameplate (18) including local inspection stamp.
The removed nameplate should be destroyed by cutting into quarters.
16. Attach the completed Nameplate (18) to the back panel of the seat base structure using 4 off Rivet Dome HD 1:8 x 0.19 (19).
17. If removed during op 3, fit the LH Cover, Armrest (1-11) (1-13), RH Cover, Armrest (1-7) (1-9) and Headrest (1-111) using the retained fasteners as detailed in CMM 25-11-52.
18. Attach Cover, Back Cushion (1-159) (1-162) and Cushion, Back (1-165) as detailed in CMM 25-11-52.
19. Attach Cover Assy – Pan Cushion (3) and Pan Cushion Assy (2) as detailed in CMM 25-11-66.
20. Carry out operational checks as listed in CMM 25-11-66.

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MATERIAL INFORMATION

The materials listed in Table 1 are the full contents of 1 Mod Kit for seat part numbers 3A318-0007-00-1 (1 Mod Kit required per seat).

TABLE 1

ITEM No.	NEW PART NUMBER	KEYWORD	OLD PART NUMBER	QTY
1	0A318-0023L1	PAN STRUCTURE ASSY	0A318-0019L1	1
2	0A318-0569	PAN CUSHION ASSY	0A318-0203	1
3	0A318-0571CR	COVER ASSY – PAN CUSHION	0A318-0205CR	1
4	1A500-0648	PIN, SPIROL SPRING 1:8 X 0.50		1
5	1A500-0653	PIN, SPIROL SPRING 1:8 X 0.88		1
6	1A500-0658	PIN, SPIROL SPRING 5:32 X 0.75		2
7	1A500-0660	PIN, SPIROL SPRING 5:32 X 1.00		1
8	1A500-0665	PIN, SPIROL SPRING 5:32 X 0.56		2
9	1A500-0667	PIN, SPIROL SPRING 3:16 X 1.50		2
10	H14-3	NUT, LOCK 10-32UNF		20
11	H14L08	NUT, LOCK 8-32UNC		4
12	LK0X	CABLE TIE		1
13	N1500-0018APP	CIRCLIP		2
14	SP90C3	PIN, SPLIT 1:16 X 0.375		2
15	SP90E5	PIN, SPLIT 3:32 X 0.625		2
16	3A505-0013VA	HOOK FASTENER SELF-AD 30mm		0.50m
17	3A505-0015VA	HOOK FASTENER SELF-AD 50mm		0.25m
18	3A318-0581	NAMEPLATE – SB318-25-06		1
19	AGS2050-418BS	RIVET, DOME HD 1:8 X 0.19		4
20	3A318-0579	LABEL – TSO APPROVAL		1

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The materials listed in Table 2 are the full contents of 1 Mod Kit for seat part numbers, 3A318-0008-00-1 (1 Mod Kit required per seat).

TABLE 2

ITEM No.	NEW PART NUMBER	KEYWORD	OLD PART NUMBER	QTY
1	0A318-0024L1	PAN STRUCTURE ASSY	0A318-0020L1	1
2	0A318-0569	PAN CUSHION ASSY	0A318-0203	1
3	0A318-0571CR	COVER ASSY – PAN CUSHION	0A318-0205CR	1
4	1A500-0648	PIN, SPIROL SPRING 1:8 X 0.50		1
5	1A500-0653	PIN, SPIROL SPRING 1:8 X 0.88		1
6	1A500-0658	PIN, SPIROL SPRING 5:32 X 0.75		2
7	1A500-0660	PIN, SPIROL SPRING 5:32 X 1.00		1
8	1A500-0665	PIN, SPIROL SPRING 5:32 X 0.56		2
9	1A500-0667	PIN, SPIROL SPRING 3:16 X 1.50		2
10	H14-3	NUT, LOCK 10-32UNF		20
11	H14L08	NUT, LOCK 8-32UNC		4
12	LKOX	CABLE TIE		1
13	N1500-0018APP	CIRCLIP		2
14	SP90C3	PIN, SPLIT 1:16 X 0.375		2
15	SP90E5	PIN, SPLIT 3:32 X 0.625		2
16	3A505-0013VA	HOOK FASTENER SELF-AD 30mm		0.50m
17	3A505-0015VA	HOOK FASTENER SELF-AD 50mm		0.25m
18	3A318-0582	NAMEPLATE – SB318-25-06		1
19	AGS2050-418BS	RIVET, DOME HD 1:8 X 0.19		4
20	3A318-0579	LABEL – TSO APPROVAL		1

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The materials listed in Table 3 are the full contents of 1 Mod Kit for seat part numbers, 3A318-0007-01-1 (1 Mod Kit required per seat).

TABLE 3

ITEM No.	NEW PART NUMBER	KEYWORD	OLD PART NUMBER	QTY
1	0A318-0023L1	PAN STRUCTURE ASSY	0A318-0019L1	1
2	0A318-0569	PAN CUSHION ASSY	0A318-0203	1
3	0A318-0571EG	COVER ASSY – PAN CUSHION	0A318-0205EG	1
4	1A500-0648	PIN, SPIROL SPRING 1:8 X 0.50		1
5	1A500-0653	PIN, SPIROL SPRING 1:8 X 0.88		1
6	1A500-0658	PIN, SPIROL SPRING 5:32 X 0.75		2
7	1A500-0660	PIN, SPIROL SPRING 5:32 X 1.00		1
8	1A500-0665	PIN, SPIROL SPRING 5:32 X 0.56		2
9	1A500-0667	PIN, SPIROL SPRING 3:16 X 1.50		2
10	H14-3	NUT, LOCK 10-32UNF		20
11	H14L08	NUT, LOCK 8-32UNC		4
12	LKOX	CABLE TIE		1
13	N1500-0018APP	CIRCLIP		2
14	SP90C3	PIN, SPLIT 1:16 X 0.375		2
15	SP90E5	PIN, SPLIT 3:32 X 0.625		2
16	3A505-0013VA	HOOK FASTENER SELF-AD 30mm		0.50m
17	3A505-0015VA	HOOK FASTENER SELF-AD 50mm		0.25m
18	3A318-0583	NAMEPLATE – SB318-25-06		1
19	AGS2050-418BS	RIVET, DOME HD 1:8 X 0.19		4
20	3A318-0579	LABEL – TSO APPROVAL		1

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The materials listed in Table 4 are the full contents of 1 Mod Kit for seat part numbers, 3A318-0008-01-1 (1 Mod Kit required per seat).

TABLE 4

ITEM No.	NEW PART NUMBER	KEYWORD	OLD PART NUMBER	QTY
1	0A318-0024L1	PAN STRUCTURE ASSY	0A318-0020L1	1
2	0A318-0569	PAN CUSHION ASSY	0A318-0203	1
3	0A318-0571EG	COVER ASSY – PAN CUSHION	0A318-0205EG	1
4	1A500-0648	PIN, SPIROL SPRING 1:8 X 0.50		1
5	1A500-0653	PIN, SPIROL SPRING 1:8 X 0.88		1
6	1A500-0658	PIN, SPIROL SPRING 5:32 X 0.75		2
7	1A500-0660	PIN, SPIROL SPRING 5:32 X 1.00		1
8	1A500-0665	PIN, SPIROL SPRING 5:32 X 0.56		2
9	1A500-0667	PIN, SPIROL SPRING 3:16 X 1.50		2
10	H14-3	NUT, LOCK 10-32UNF		20
11	H14L08	NUT, LOCK 8-32UNC		4
12	LKOX	CABLE TIE		1
13	N1500-0018APP	CIRCLIP		2
14	SP90C3	PIN, SPLIT 1:16 X 0.375		2
15	SP90E5	PIN, SPLIT 3:32 X 0.625		2
16	3A505-0013VA	HOOK FASTENER SELF-AD 30mm		0.50m
17	3A505-0015VA	HOOK FASTENER SELF-AD 50mm		0.25m
18	3A318-0584	NAMEPLATE – SB318-25-06		1
19	AGS2050-418BS	RIVET, DOME HD 1:8 X 0.19		4
20	3A318-0579	LABEL – TSO APPROVAL		1

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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