

EAGLE TECHNICAL BULLETIN

REF. TCCA STC: SH14-47
REF. FAA STC: SR03496NY

Eagle Service Bulletin Number: **TB-E407-789-3**

Purpose: Repair of inlet cowl installed with AFS filter (STC: SH04-34/SR09368RC).

Eligible Serial Numbers: All serial numbers.

Compliance: Should be incorporated if an AFS filter (STC: SH04-34/SR09368RC) has previously been installed on the aircraft.

Description: Eagle Copters has designed this repair to the inlet cowl of any Bell 407 previously installed with an AFS filter (STC: SH04-34/SR09368RC). This is necessary to make a Bell 407 eligible for application of STC SH14-47/SR03496NY. Compliance with this technical bulletin requires the parts listed in Table 1 below.

Parts List: Table 1

QTY. -011	PART NUMBER	DESCRIPTION
X	TB-E407-789-3-011	INLET COWL REPAIR KIT
1	0789-03-219-1	INNER DOUBLER
1	0789-03-219-3	EXTERNAL FILLER
1	0789-03-219-5	CLOSEOUT
1	0789-03-219-7	OUTER ANGLE
1	0789-03-219-9	INNER ANGLE
1	0789-03-219-11	SMALL PACKER
1	0789-03-219-13	MEDIUM PACKER
1	0789-03-219-15	LARGE PACKER
21	CR3213-4	RIVET
14	CR3243-4	RIVET
6	MS20426AD3	RIVET
A/R	MS20426AD4	RIVET
1	MS21061L3	NUT, SELF-LOCKING, PLATE, ONE LUG
3	MS21075L08N	NUT, SELF-LOCKING, REDUCED RIVET SPACING
7	NAS1097AD6	RIVET

Weight and Balance: Weight and Balance change to the aircraft is accomplished as part of STC SH14-47/SR03496NY.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
	D. SHEPHERD (DE # 02)
DATE:	16.04.05
CERT. NO.:	SH14-47
ISSUE NO.:	1

A	INITIAL RELEASE	DJS	16.04.05
REV.	DESCRIPTION	BY	DATE
DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TECHNICAL BULLETIN	NTS
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Procedure:

Note: All 0789-03-219 parts may be require additional forming and/or trimming to properly fit the inlet cowl.

1. Remove air inlet cowl and AFS filter per ICA-E407-789, Chapter 53, Section 7 and STC: SH04-34/SR09368RC.
2. Remove existing anchor nuts in locations specified on Figure 2.
3. Align 0789-03-219-1 Inner Doubler with inner face of cutout in the inlet cowl skin for best fit and maintain edge distance on all holes as shown in Figure 1.
4. Transfer drill existing $\phi 0.098"$, $\phi 0.129"$ and $\phi 0.194"$ holes from aircraft skin to 0789-03-219-1 Inner Doubler as shown in Figure 1.
5. Pitch new holes $\phi 0.129"$ between existing fastener holes to maintain 0.8"-1.3" pitch.

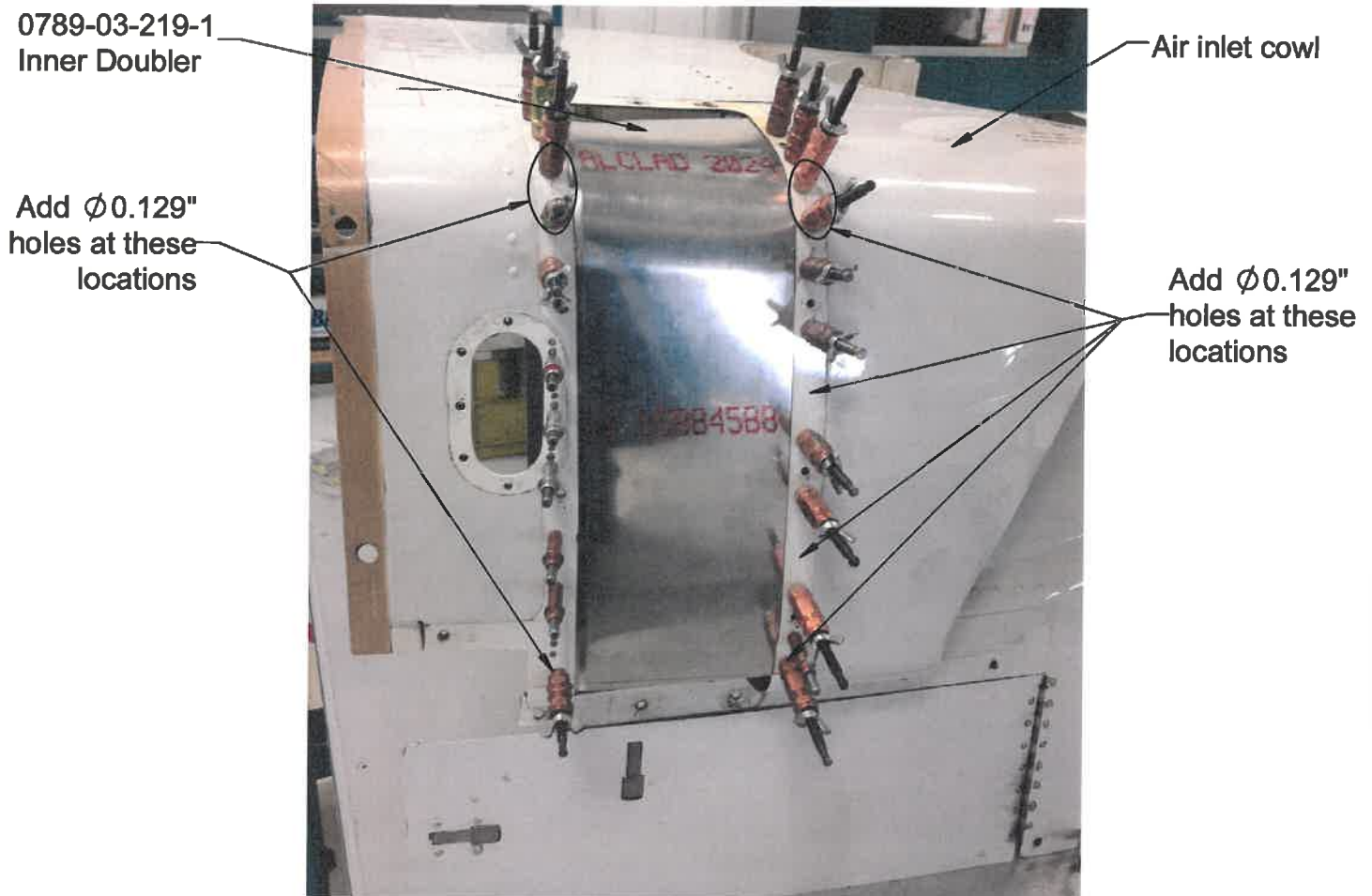


Figure 1: 0789-03-219-1 Inner Doubler Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 2 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS#	TECHNICAL BULLETIN	NTS
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6. Locate 0789-03-219-7 Outer Angle and 0789-03-219-9 Inner Angle to obtain best fit and align with edges of skin cutout per Figure 2.
7. Transfer drill $\phi 0.129$ " and $\phi 0.194$ " holes from aircraft outer skin to 0789-03-219-7 Outer Angle. Transfer drill holes from aircraft inner skin to 0789-03-219-9 Inner Angle per Figure 2.
8. Cutout existing aircraft skin per 0789-02-057 (see IIN-E407-789 for details).

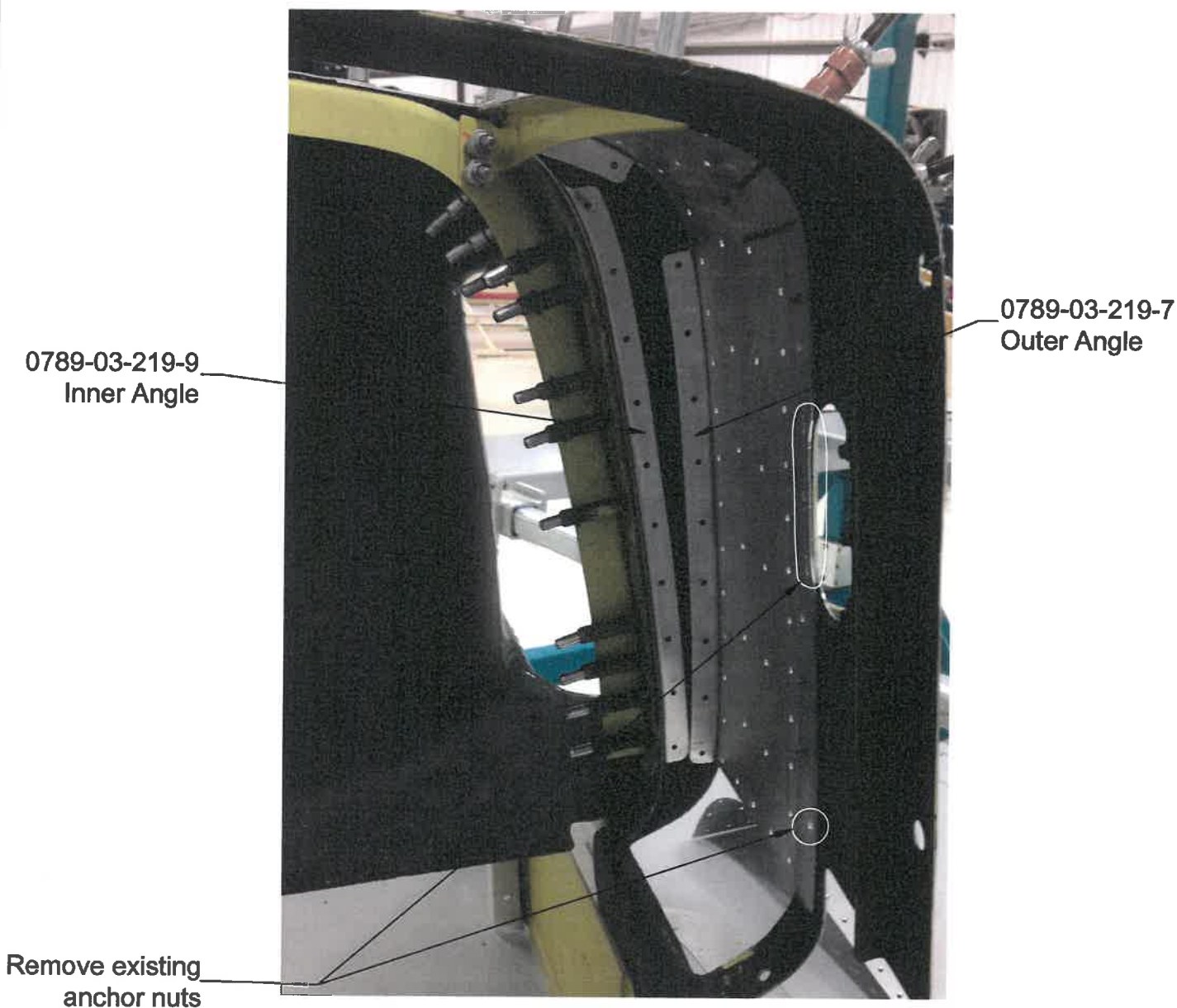


Figure 2: 0789-03-219-7/-9 Angle Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 3 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TECHNICAL BULLETIN	NTS
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9. Fit 0789-03-219-3 External Filler to doubler. Trim to maintain minimum 0.032" gap with existing skin per Figure 3.
10. Transfer drill 16X ϕ .098" pilot holes from 0789-03-219-3 External Filler to 0789-03-219-1 Inner Doubler as shown in Figure 3.
11. Pitch in ϕ .098" perimeter holes as required through 0789-03-219-3 External Filler and 0789-03-219-1 Inner Doubler, maintaining edge distance of 0.35" and 0.8"-1.3" pitch as shown in Figure 3.

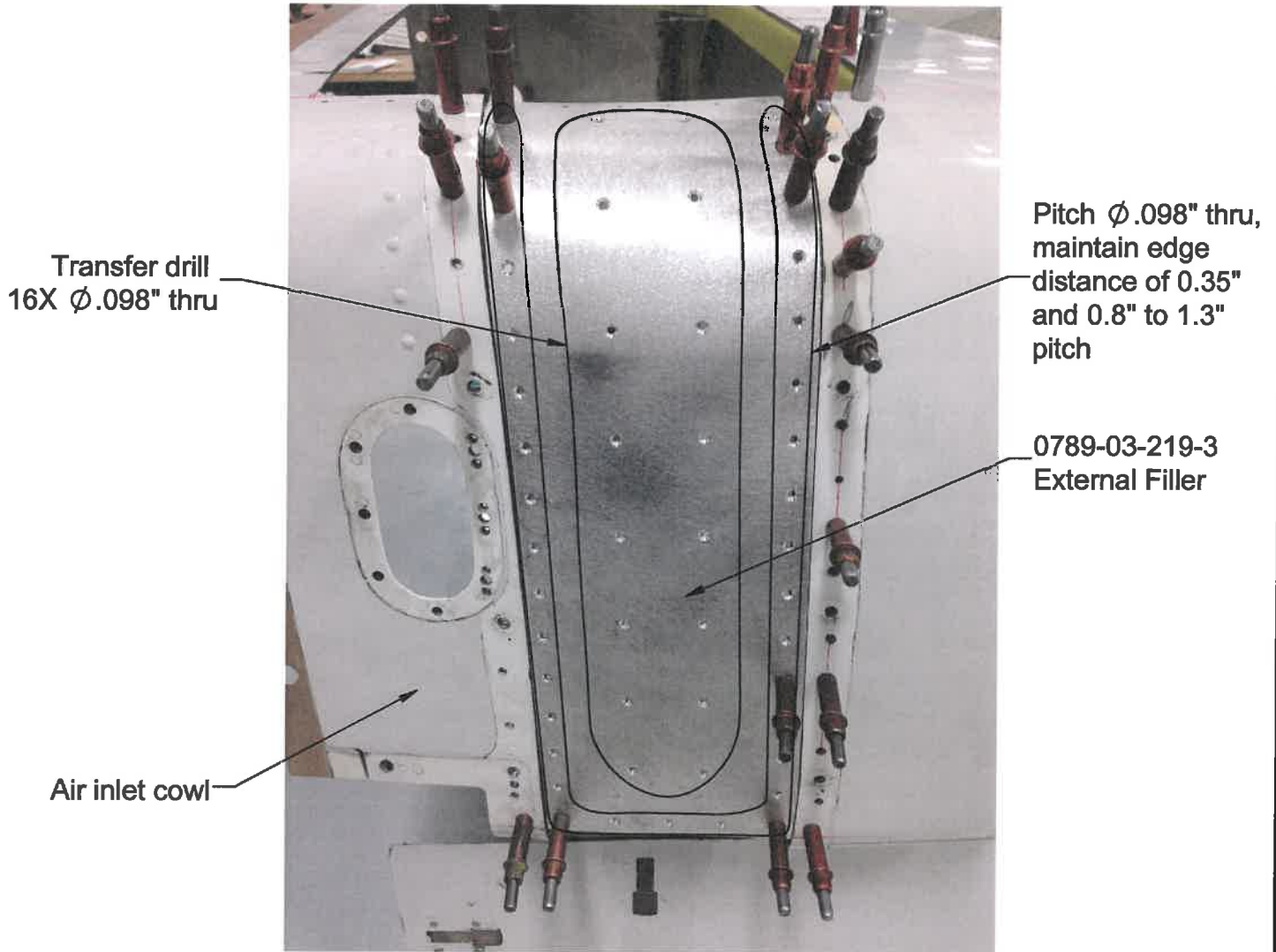


Figure 3: 0789-03-219-3 External Filler Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
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CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 4 OF 9
APPROVED	HS	TITLE	SCALE
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12. Locate 0789-03-219-5 Closeout against 0789-03-219-7 Outer Angle and 0789-03-219-9 Inner Angle as shown in Figure 4.
13. Pitch in $\phi .098$ " perimeter holes as required in 0789-03-219-5 Closeout, maintaining edge distance of 0.25" and 0.8"-1.3" pitch as shown in Figure 4.
14. Transfer drill $\phi .098$ " holes from 0789-03-219-5 Closeout to 0789-03-219-7 Outer Angle and 0789-03-219-9 Inner Angle as shown in Figure 2 and Figure 4.

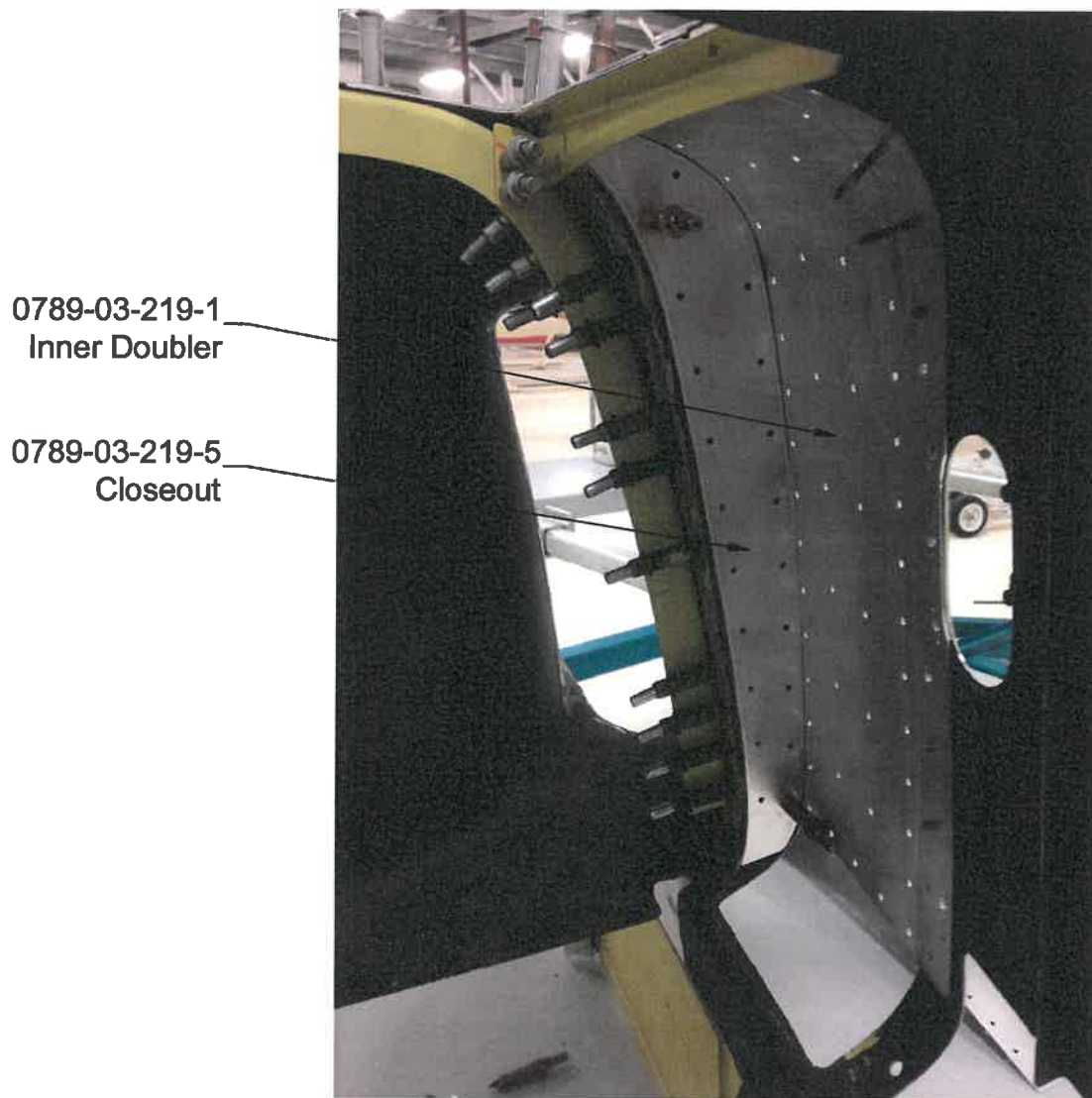


Figure 4: 0789-03-219-5 Closeout Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 5 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-#	TECHNICAL BULLETIN	NTS
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15. Locate 0789-03-054-2 Angle per 0789-02-050 (see IIN-E407-789 for details). Fit 0789-03-219-11, 0789-03-219-13 and 0789-03-219-15 Packers between 0789-03-054-2 Angle and aircraft skin/doubler per Figure 5.
16. Upsize all pilot holes in 0789-03-219-3 External Filler to 0789-03-219-1 Inner Doubler to $\phi 0.129$ " and deburr all holes.

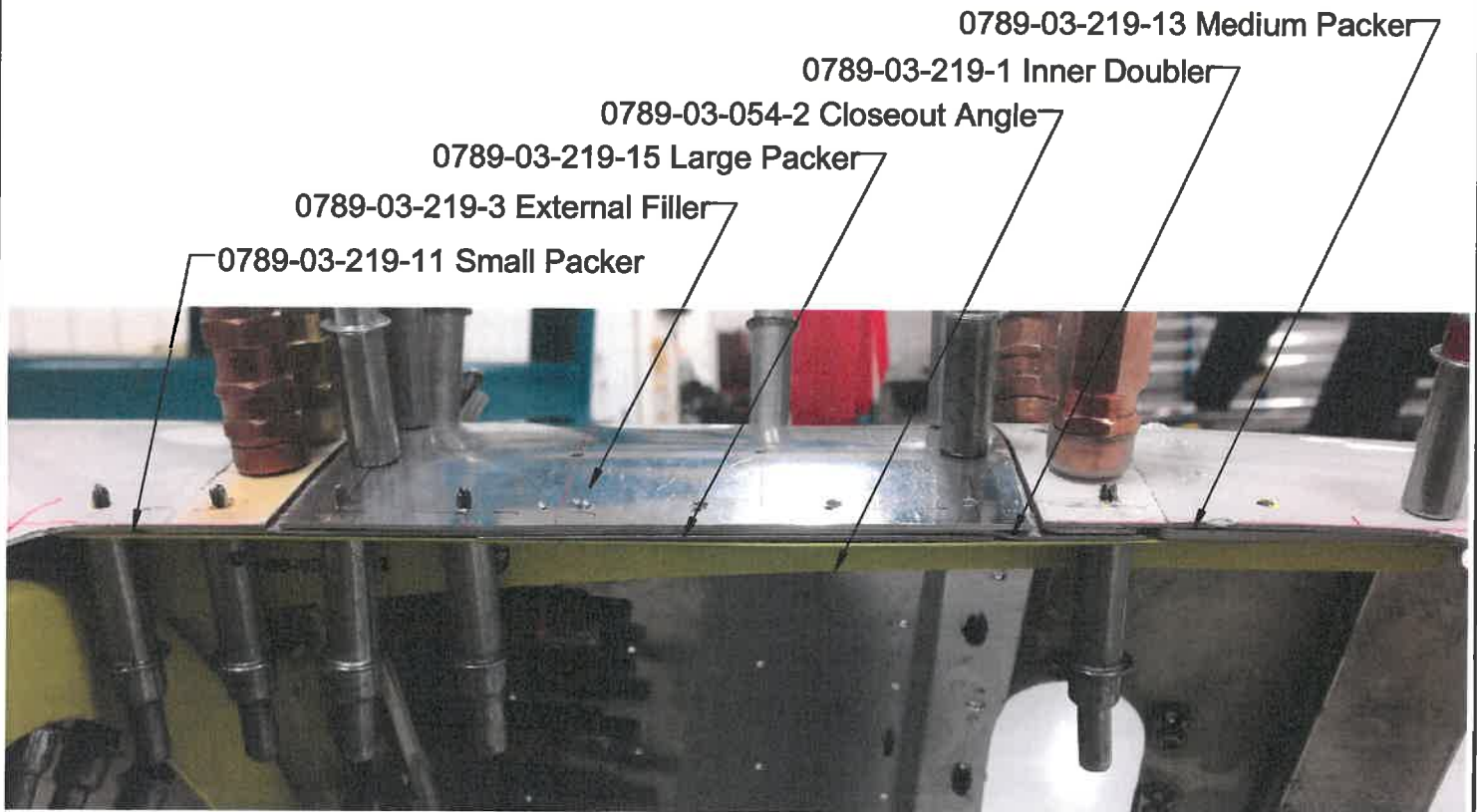


Figure 5: 0789-03-219-11/-13/-15 Packer Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 6 OF 9
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17. Countersink holes in 0789-03-219-3 External Filler and aircraft skin per the locations and dimensions shown in Figure 6.
18. Apply chemical conversion coating (alodine) to parts per MIL-C-5541 class 1A.
19. Prime parts per MIL-PRF-23377, type 1, class C and touch-up edges.
20. Assemble parts wet with PS 890 sealant (or equivalent).

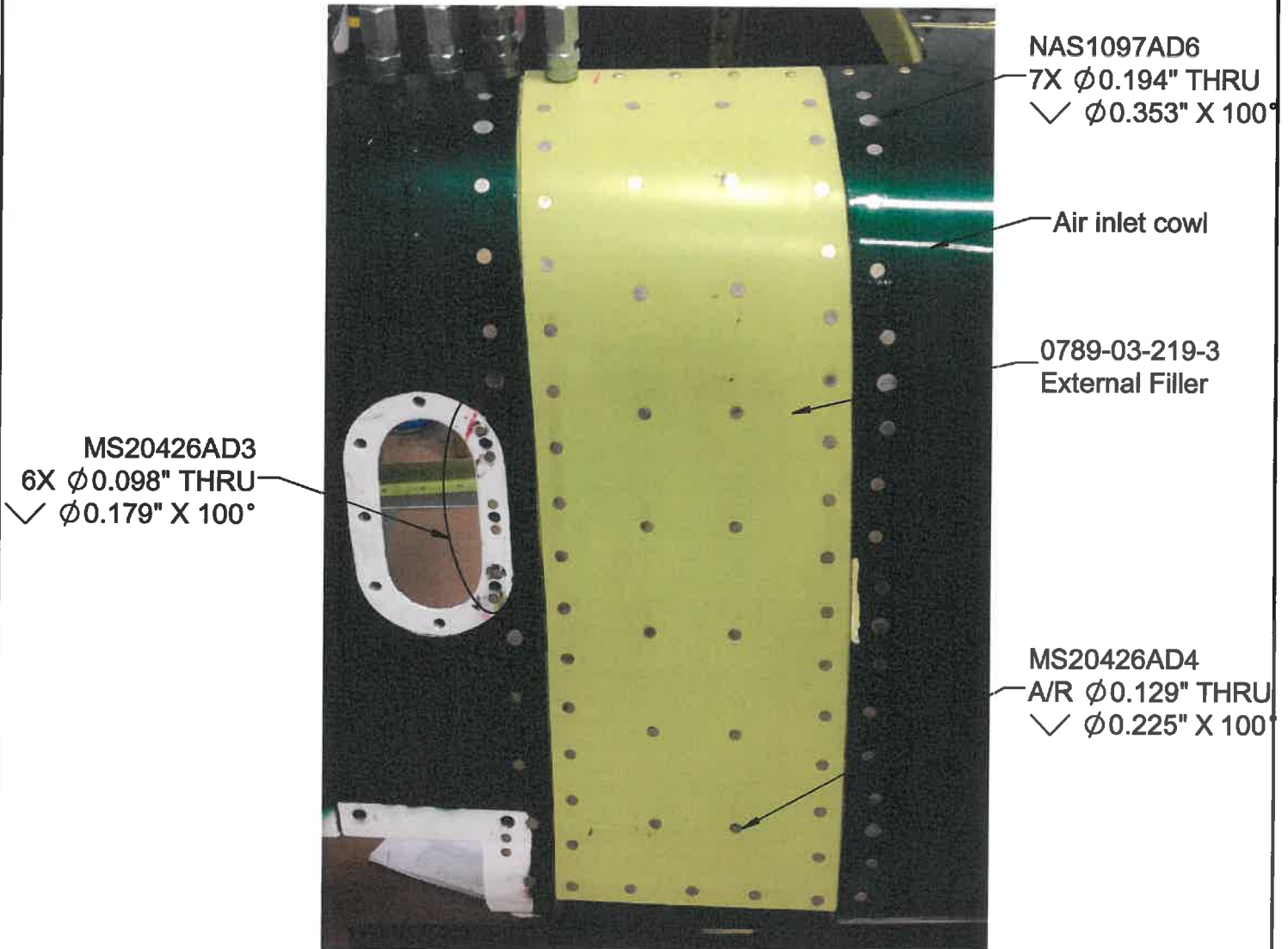


Figure 6: Outer Fastener Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 7 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TECHNICAL BULLETIN	NTS
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21. Install rivets and anchor nuts per AC43.13 as shown in Figure 6 and Figure 7.
22. Fillet seal edges of repair with PS 890 sealant (or equivalent).
23. Paint to match aircraft color and finish per Aircraft Maintenance Manual and/or ICA-E407-789.
24. Notify Eagle Copters that this Technical Bulletin has been accomplished by filling out the attached form (page 9) and emailing it back to Eagle Copters.
25. Make entry into aircraft technical reports to indicate TB-E407-789-3 has been completed.

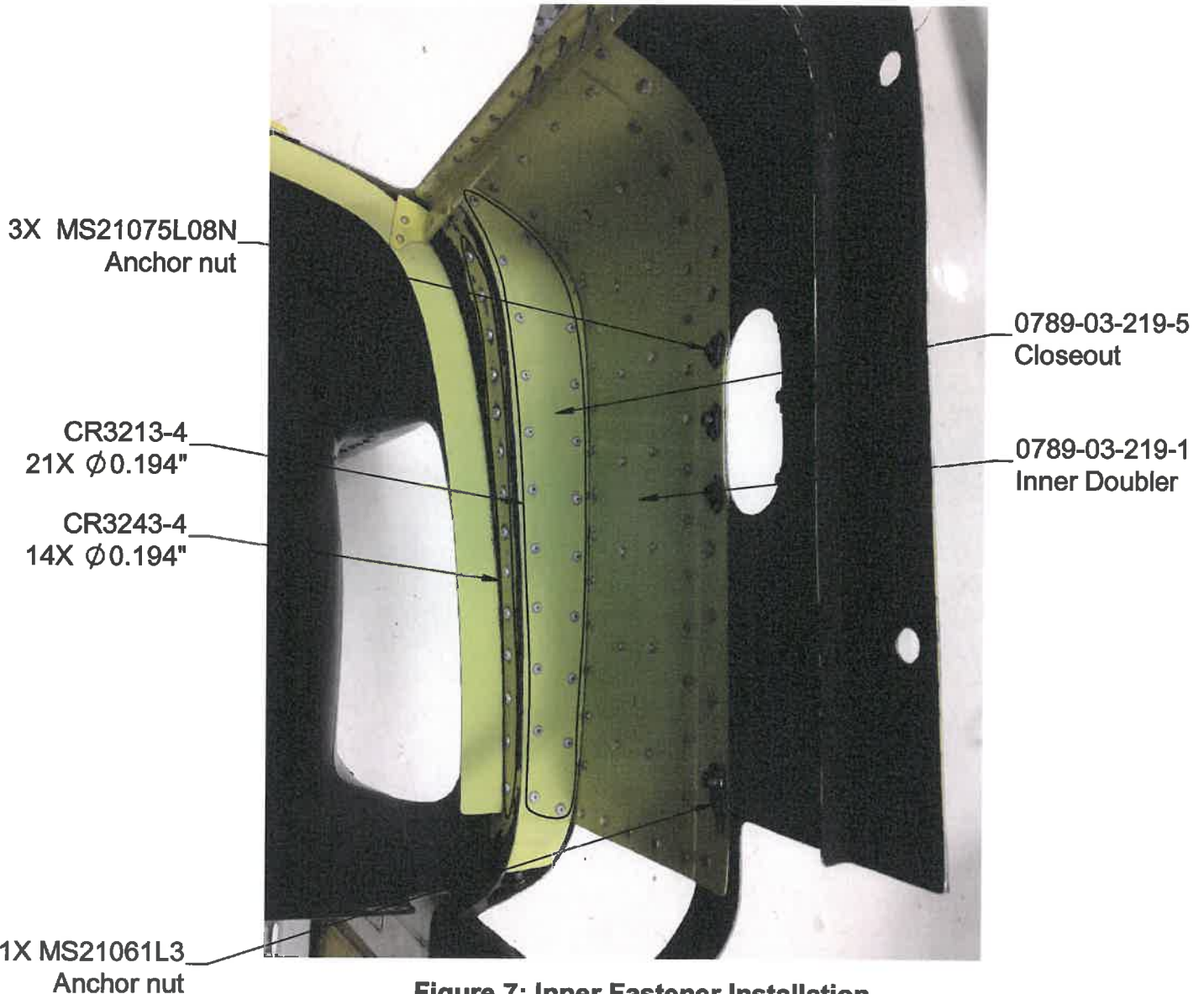


Figure 7: Inner Fastener Installation

DESIGN	N/A	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DJS		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 8 OF 9
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NOTIFY EAGLE COPTERS THAT THE TB-E407-789-3 HAS BEEN INCORPORATED INTO THE AIRCRAFT LISTED BELOW.

AIRCRAFT SERIAL NUMBER: _____

AIRCRAFT OWNER: _____

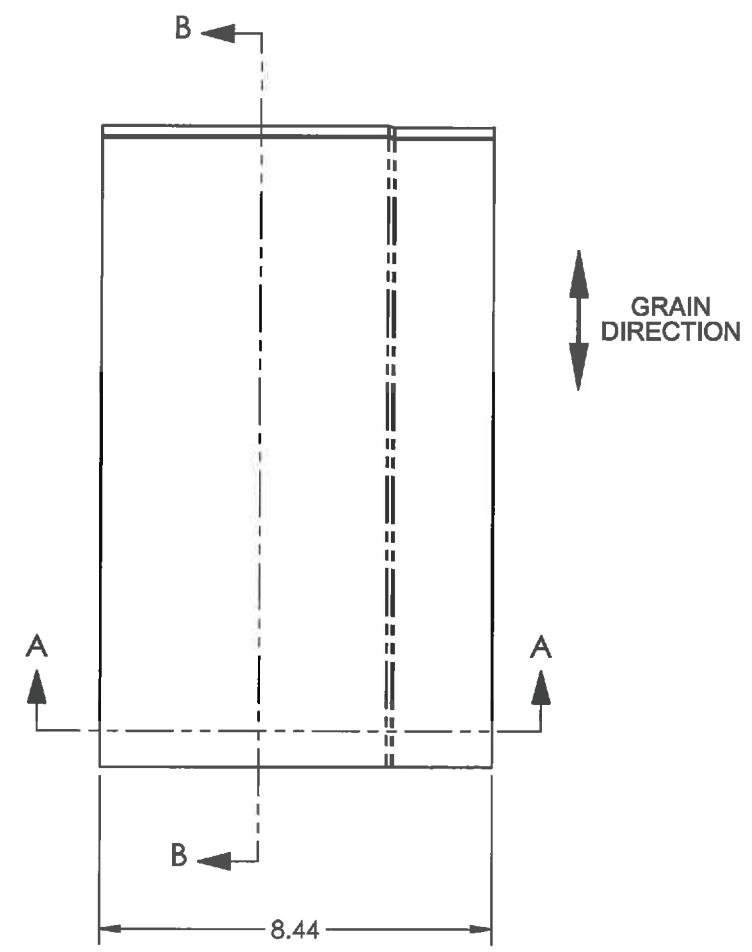
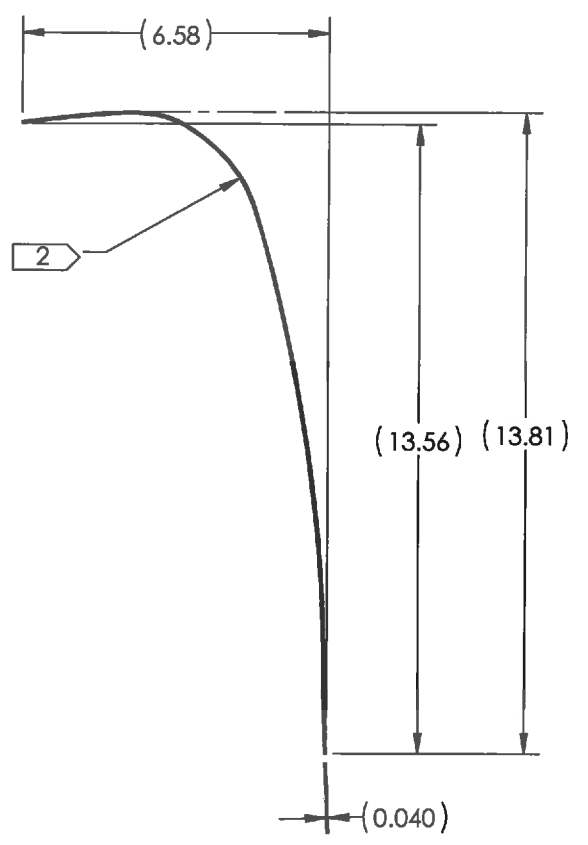
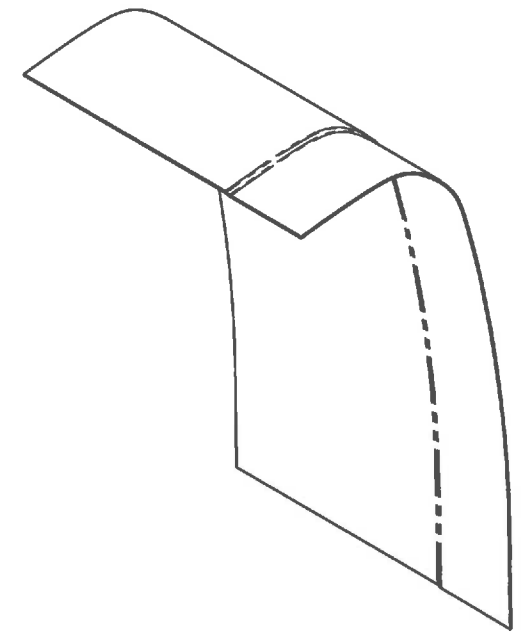
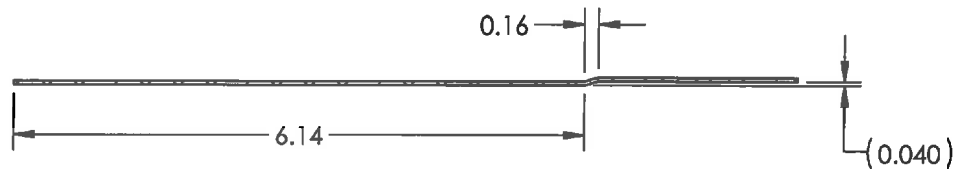
DATE TB-E407-789-3 WAS INCORPORATED ON THE ABOVE AIRCRAFT:

SIGNATURE OF PERSON RESPONSIBLE FOR ENTRY INTO AIRCRAFT TECHNICAL RECORD:

PRINT NAME OF PERSON RESPONSIBLE FOR ENTRY INTO AIRCRAFT TECHNICAL RECORD:

Email this page to: mboyce@eaglecopters.com

DESIGN	N/A	EAGLE COPTERS LTD	
DRAWN	DJS	CALGARY, ALBERTA, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	ASH	TB-E407-789-3	SHEET 9 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS 	TECHNICAL BULLETIN	NTS
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-1 INNER DOUBLER

RELEASED
16.05.06VS
ECN16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. FORM PART TO MATCH BELL 407 INLET COWL INNER SURFACE AT DONALDSON IBF CUTOUT.
3. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
7. WEIGHT: 0.60 lbs

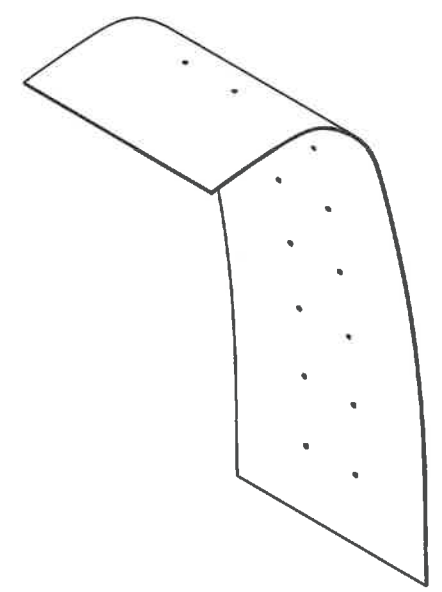
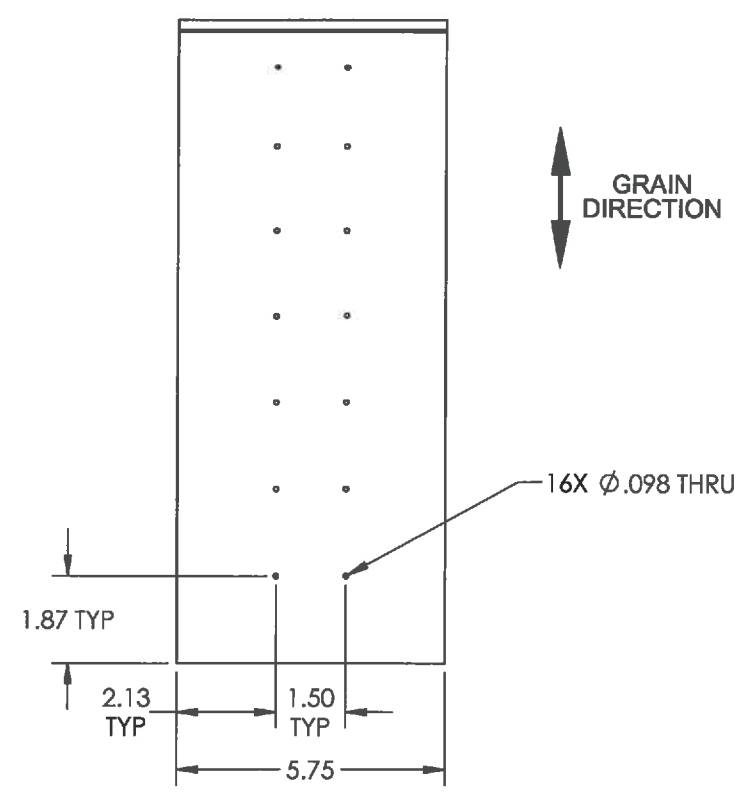
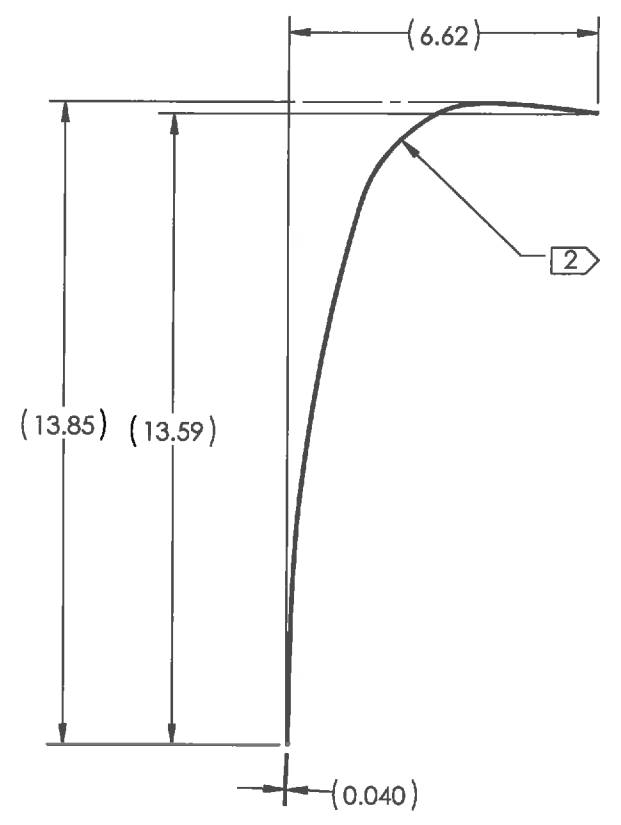
APPROVED

TOLERANCES:	
X.X ± 0.100	ANGULAR ± 1/2°
X.XX ± 0.030	
X.XXX ± 0.010	
MATERIAL	
MATERIAL	2024-T3 CLAD
MATERIAL SPEC	QQ-A-250/5
STOCK SIZE	.040 THK
STOCK SIZE (CUT)	

A	INITIAL RELEASE	DJS	16.04.26
REV.	DESCRIPTION	BY	DATE
DESIGN	DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	KC	0789-03-219	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
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-3 EXTERNAL FILLER

RELEASED
16.05.06 VS
ECN 16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. FORM PART TO MATCH BELL 407 INLET COWL OUTER SURFACE AT IBF DONALDSON CUTOUT.
3. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
7. WEIGHT: 0.41 lbs

APPROVED

TOLERANCES: X.X ± 0.100 ANGULAR ± 1/2° X.XX ± 0.030 X.XXX ± 0.010		DESIGN	DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
MATERIAL MATERIAL 2024-T3 CLAD MATERIAL SPEC QQ-A-250/5 STOCK SIZE .040 THK STOCK SIZE (CUT)		DRAWN	AK	
		CHECKED	VS	REV. A
		MFG. APPR.	KC	SHEET 2 OF 6
		APPROVED	HS	TITLE DOUBLER
		DE APPR.	DS	SCALE NTS
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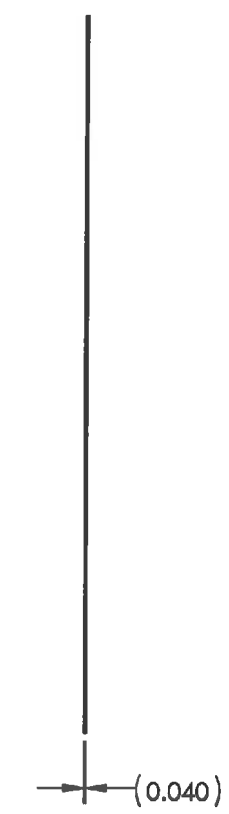
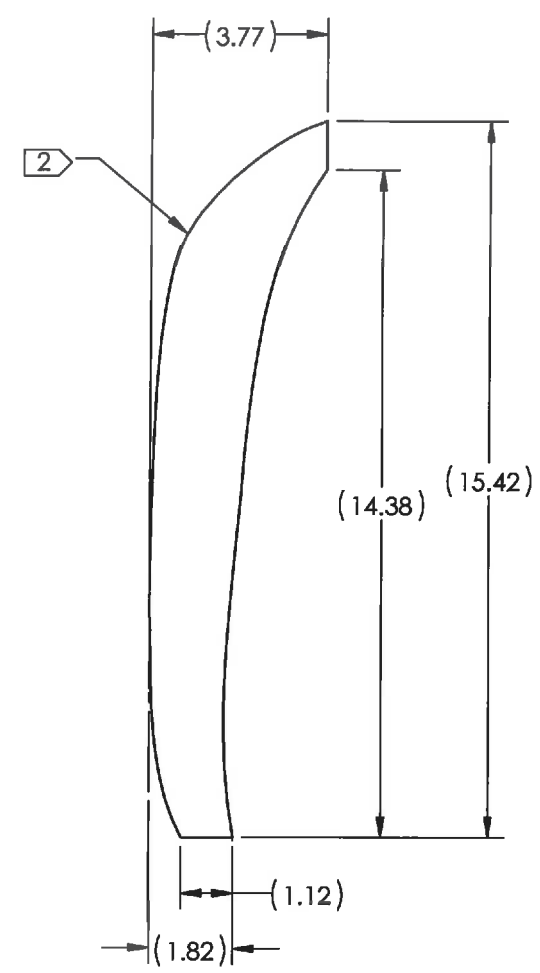
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-5 CLOSEOUT

RELEASED
 16.05.06 VS
 ECN 16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. CUT PART TO MATCH BELL 407 INLET COWL INNER SURFACE AT CUTOUT FWD EDGE.
3. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
7. WEIGHT: 0.11 lbs

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TOLERANCES: X.X ± 0.100 ANGULAR ± 1/2° X.XX ± 0.030 X.XXX ± 0.010		DESIGN DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
		DRAWN AK	
		CHECKED VS	DRAWING NO. 0789-03-219
		MFG. APPR. KC	REV. A SHEET 3 OF 6
MATERIAL		APPROVED HS	TITLE DOUBLER
MATERIAL	2024-T3 CLAD	DE APPR. DS	SCALE NTS
MATERIAL SPEC	QQ-A-250/5	DATE 16.04.26	COPYRIGHT © 2014 BY EAGLE COPTERS LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS LTD.
STOCK SIZE	.040 THK		
STOCK SIZE (CUT)			

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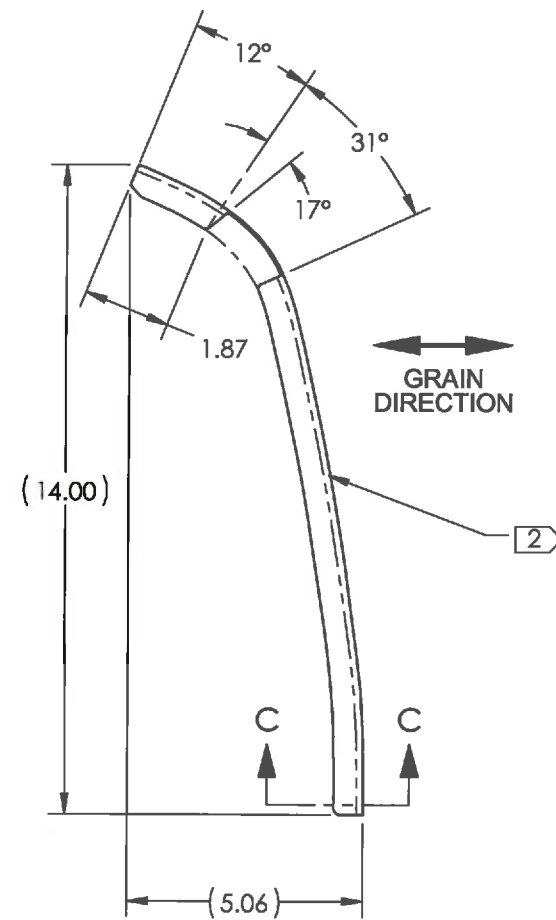
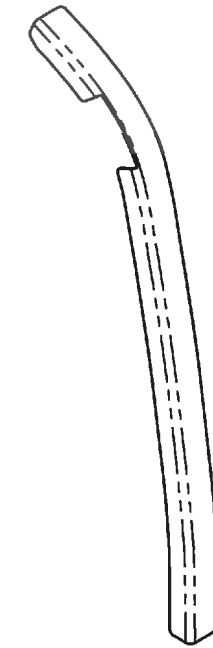
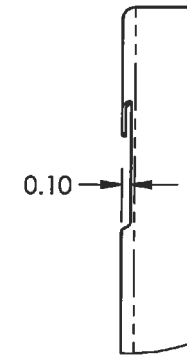
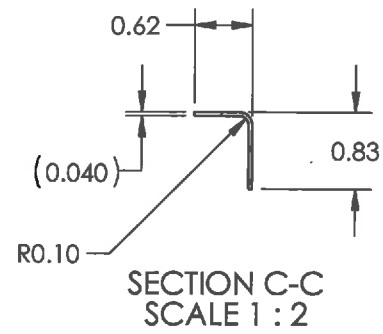
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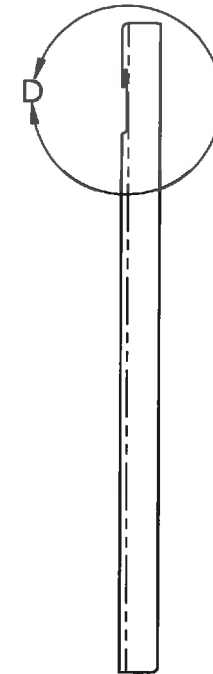
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DETAIL D
SCALE 1:2



-7 OUTER ANGLE

RELEASED
16.05.06 VS
ECN 16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. FORM PART TO MATCH BELL 407 INLET COWL INNER SURFACE AT CUTOUT FWD EDGE.
3. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
7. WEIGHT: 0.08 lbs

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TOLERANCES: X.X ± 0.100 ANGULAR ± 1/2° X.XX ± 0.030 X.XXX ± 0.010		DESIGN DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
MATERIAL 2024-T3 CLAD		DRAWN AK	
MATERIAL SPEC QQ-A-250/5		CHECKED VS	DRAWING NO. 0789-03-219
STOCK SIZE .040 THK		MFG. APPR. KC	REV. A SHEET 4 OF 6
STOCK SIZE (CUT)		APPROVED HS	TITLE DOUBLER
		DE APPR. DS	SCALE NTS
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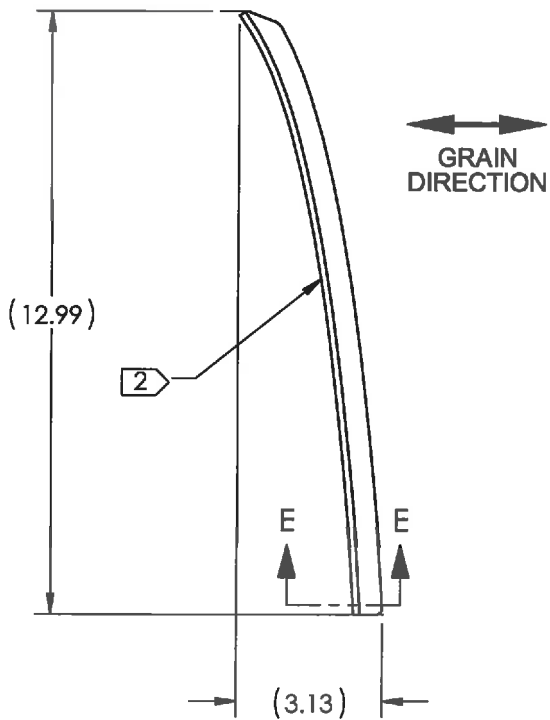
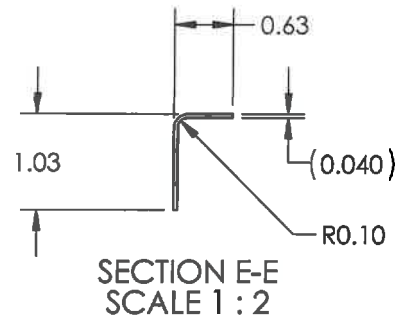
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-9 INNER ANGLE



RELEASED
16.05.06 VS
ECN 16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. FORM PART TO MATCH BELL 407 INLET COWL INNER SURFACE AT CUTOUT FWD EDGE.
3. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
7. WEIGHT: 0.08 lbs

APPROVED

TOLERANCES: X.X ± 0.100 ANGULAR ± 1/2° X.XX ± 0.030 X.XXX ± 0.010		DESIGN DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
MATERIAL MATERIAL 2024-T3 CLAD MATERIAL SPEC QQ-A-250/5 STOCK SIZE .040 THK STOCK SIZE (CUT)		DRAWN AK	
		CHECKED MFG. APPR.	REV. A SHEET 5 OF 6
		APPROVED DE APPR.	TITLE DOUBLER
		DATE 16.04.26	SCALE NTS
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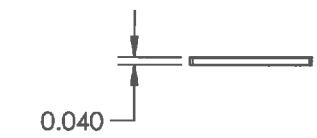
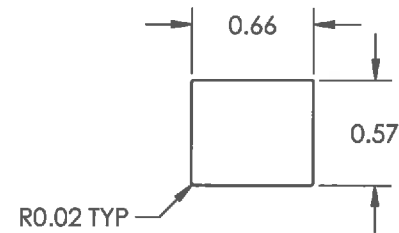
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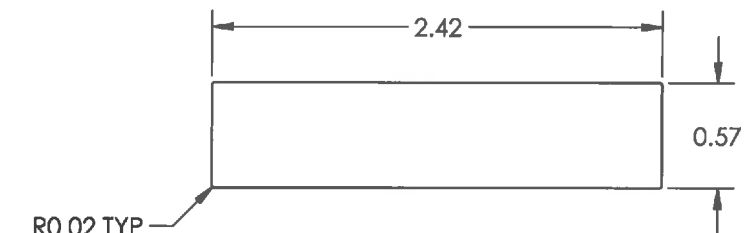
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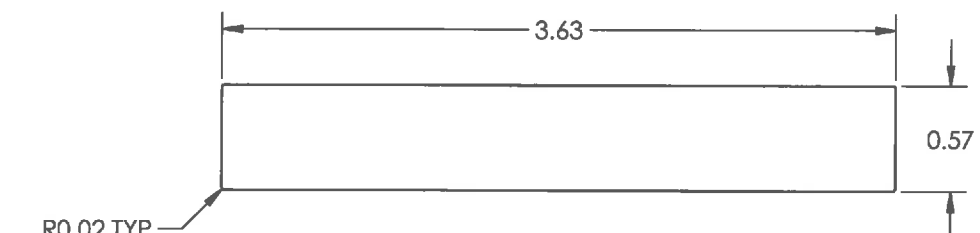
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-11 SMALL PACKER



-13 MEDIUM PACKER



-15 LARGE PACKER

RELEASED
16.05.06 VS
ECN 16-575

NOTES:

1. ALTERNATE MATERIAL 2024-T3 PER QQ-A-250/4.
2. FINISH: CHEMICAL CONVERSION COATING (ALODINE) PER MIL-C-5541, CLASS 1A. APPLY TWO COATS OF EPOXY PRIMER PER MIL-PRF-23377, TYPE 1, CLASS C.
3. UNITS: INCHES UNLESS OTHERWISE NOTED
4. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5. IDENTIFICATION: IDENTIFY WITH PART NUMBER USING INDELIBLE INK (RUBBER STAMP) OR LASER ETCH (0.002 DEPTH). CHARACTER HEIGHT 0.08 MIN.
6. WEIGHT: 0.00 lbs

APPROVED

TOLERANCES: X.X ± 0.100 ANGULAR ± 1/2° X.XX ± 0.030 X.XXX ± 0.010		DESIGN DJS	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA
MATERIAL 2024-T3 CLAD		DRAWN AK	
MATERIAL SPEC QQ-A-250/5		CHECKED VS	DRAWING NO. 0789-03-219
STOCK SIZE		MFG. APPR. KC	REV. A SHEET 6 OF 6
STOCK SIZE (CUT)		APPROVED HS	TITLE DOUBLER
		DE APPR. DS	SCALE NTS
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