



DYNAMIC COMPONENTS:  
REPAIR & OVERHAUL  
AND MACHINING



Airbus Helicopters Canada prides itself on its comprehensive support and services solutions. In addition to being certified for overhauls of dynamic components, Airbus Helicopters Canada also has the capabilities to perform repairs and machining in-house.

This integrated approach to repairs and overhauls is the result of Airbus Helicopters Canada's commitment to quality, efficiency, and customer service.

The result - [customer savings in time and money.](#)

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# Support and Services

## Maintenance - Repair - Overhaul - Customization

To keep aircraft operating at peak performance, Airbus Helicopters Canada offers an extensive range of support and service solutions. Airbus Helicopters Canada is committed to providing customers with a high level of support, to ensure that specific requirements are met.

Over the years, Airbus Helicopters Canada has developed a wide array of industry-leading inspections, repairs, overhauls, and exchange programs to offer services suited to the customers' specific needs while striving for maximum availability of their aircraft.

With use of one of Airbus Helicopters Canada's comprehensive support & service programs, Canadian operators will benefit from the Airbus Helicopters knowledge base, workmanship, processes and network.



## Repair & Overhaul

### One - Stop - Shop

Airbus Helicopters Canada's level I-IV Repair and Overhaul (R&O) department is certified for all dynamic components, mechanical assemblies and hydraulic systems for the EC120, AS350, AS355, EC130, BO105 and BK117.

All Airbus Helicopters Canada R&O department personnel are licensed AME's and/or Airbus Helicopters trained. AHCA's Repair & Overhaul shop is equipped with:

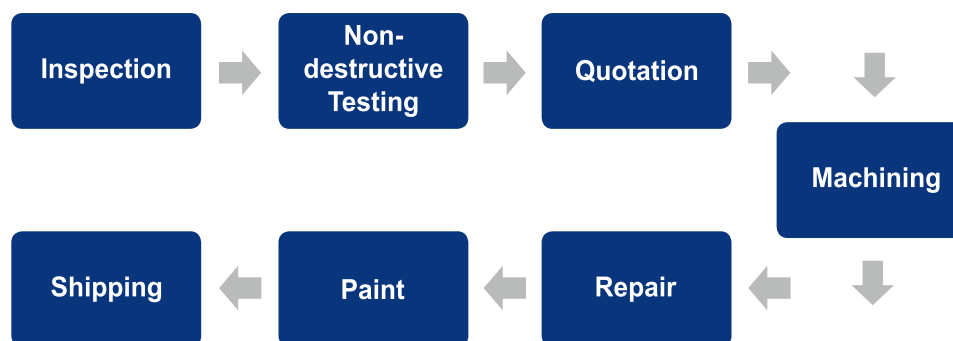
Dynamic transmission run-in stands and test benches - EC120, EC130, AS350, AS355

Transmission static load stands - EC120, AS350, AS355

Hydraulic pump and component test stand capable of static pressures up to 550 bar and dynamic pressures up to 220 bar at 20 litres/minute - BK117 and BO105

Airbus Helicopters issued tools

Fully equipped machine shop



As part of Airbus Helicopters Canada's repair and overhaul processes, repairs and machining on a wide range of parts and sub-assemblies are performed in-house—saving customers time and money.

# Dynamic Component Machining Capabilities

**Model** EC120  
**Part** Upper Housing  
**Part #** C632A1111-XXX  
**Repair** Bore and bush

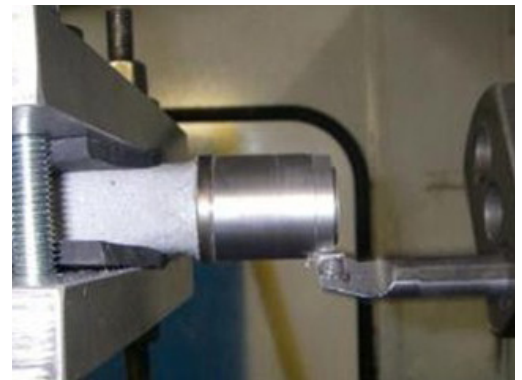
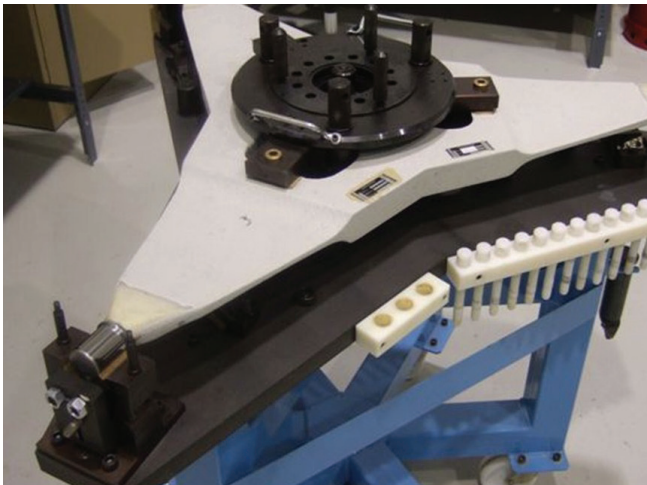


**Model** EC120  
**Part** Center Housing  
**Part #** C632A2116-XXX  
**Repair** Corrosion in holes



# Dynamic Component Machining Capabilities

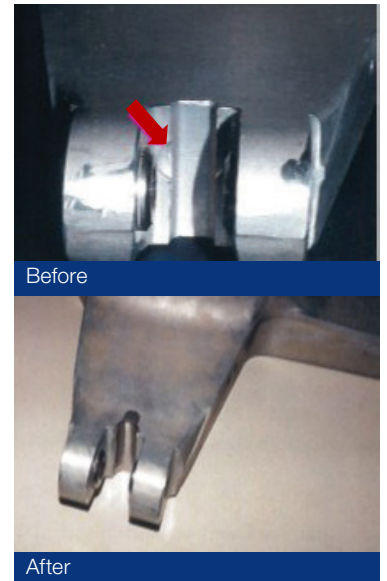
<b>Model</b>	AS350 / AS355 / EC130
<b>Part</b>	Starflex Bushing
<b>Part #</b>	350A31-1917-XX & 350A31-1918-00
<b>Repair</b>	Removal of worn-out bushings Installation of new bushings Certification





## Dynamic Component Machining Capabilities

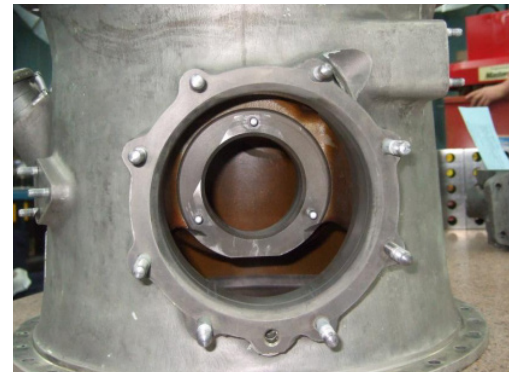
<b>Model</b>	AS350 / AS355 / EC130
<b>Part</b>	Star, non-rotating
<b>Part #</b>	350A37-1002-XX
<b>Repair</b>	<ul style="list-style-type: none"><li>- Worn mounting ears / stirrups</li><li>- Bore and bush</li></ul>





# Dynamic Component Machining Capabilities

<b>Model</b>	AS350 / AS355 / EC130
<b>Part</b>	Main Case
<b>Part #</b>	350A32-3121- XX
<b>Repair</b>	<ul style="list-style-type: none"><li>- Corroded flanges / holes</li><li>- Bore &amp; sleeve (72 mm) pinion bearing bore</li><li>- Bore &amp; sleeve (126 mm) input housing bore</li><li>- Input Flange housing corrosion</li></ul>



Before



After

## Dynamic Component Machining Capabilities

**Model** AS350 / AS355 / EC130  
**Part** Lower Case  
**Part #** 350A32-3119-XX  
**Repair**

- Worn/undersize bearing mounting diameter
- Bi-directional faces
- Flanges / holes



Before



After

**Model** AS350 / AS355 / EC130  
**Part** Main Mast (Timken or 4 Contact)  
**Part #** 350A37-1076-XX / 350A37-1290-XX  
**Repair**

- Worn/undersize bearing sleeve
- Worn bushings (12 apostels)
- Chamber wear (1076)



Before



After

# Dynamic Component Machining Capabilities

**Model** AS350  
**Part** Transmission Cross Beam  
**Part #** 350A38-1018-XX, 350A38-1040-20  
**Repair** Bore and bush



**Model** AS350 / AS355 / EC130  
**Part** Brake Disc  
**Part #** 350A32-3088-20  
**Repair** Wear on surface



## Dynamic Component Machining Capabilities

<b>Model</b>	AS355
<b>Part</b>	Combining Gearbox
<b>Part #</b>	355A0210-XX / 355A0200-XX
<b>Repair</b>	<ul style="list-style-type: none"><li>- Corrosion</li><li>- Worn / oversized bearing bores</li></ul>



<b>Model</b>	BO105
<b>Part</b>	Transmission Top Case
<b>Part #</b>	4638-201-XXX
<b>Repair</b>	Corroded mounting holes



<b>Model</b>	BO105
<b>Part</b>	Mast
<b>Part #</b>	4619-305-XXX
<b>Repair</b>	<ul style="list-style-type: none"><li>- Corrosion on mounting face</li><li>- Replacement of mast momments / bridge</li></ul>

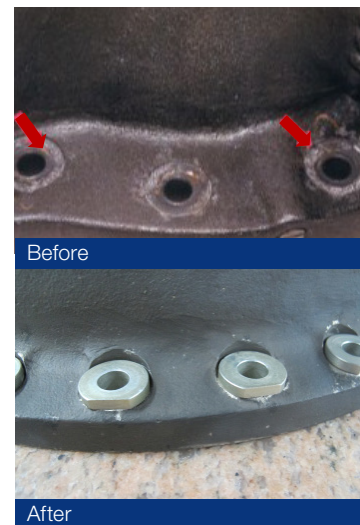




# Dynamic Component Machining Capabilities

**Model** BO105  
**Part** Transmission Center Case  
**Part #** 4638-201-0030  
**Repair**

- Tail rotor bore; fan bore; axillary bore
- Seal seat
- Corroded mounting holes and flange surface



**Model** BO105 / BK117  
**Part** Lower Housing  
**Part #** 4638-201-XXX  
**Repair**

- Corroded flange surface
- Bolt holes



# Dynamic Component Machining Capabilities

**Model** BO105  
**Part** Intermediate Gearbox Housing  
**Part #** 4619-310-XXX  
**Repair**

- Corroded chamfer surfaces
- Corroded bore surfaces
- Mounting lugs



Before



After

**Model** BO105 / BK117  
**Part** Tail Rotor Gearbox Assembly  
**Part #** 4639-310-XXX  
**Repair**

- Oversize bolt holes
- Removal of corrosion and bush
- Bore surface



Before



After

## Repair & Overhaul Capabilities

Airbus Helicopters Canada is certified for the repair and overhaul of all dynamic components, mechanical assemblies and hydraulic systems for the EC120, AS350, EC130, AS355, BO105 and BK117. The following is a list of the main components.

Component	Part Number
<b>AS350 / EC130</b>	
Bevel Reduction Gearbox	350A32-0300-04/-05 350A32-0350-xx (EC130)
Oil Pump	350A32-0400-00
Rotor Brake	350A32-0500-02
Tail Rotor Gearbox	350A33-0200-05/-06 & 07 350A33-0210-00 (B3e) 350A33-0501-xx (EC130) 350A33-0502-xx
Epicyclic	350A32-0110-00 (4 Contact) 350A32-0100-10 (Timkin) 350A32-0120-00 (EC130) 355A37-0000 355A37-0005-06
Mast Assembly	350A37-0003-xx (Timkin) 350A37-0004-xx (4 contact)
Pitch Change Spider	350A33-2030-00
Ball End	350A33-2150-01
Scissor Link	350A37-1127-01/-02 350A37-1126-01/-02
Pitch Link	350A33-2145-01
<b>EC120</b>	
Epicyclic	C632A0101-xxx
Main Gearbox	C632A0201-xxx
Tail Rotor Gearbox	C652A0101-xxx
Scissor Link	C632A2006-103
<b>BK117 &amp; BO105</b>	
Hydraulic Units	BK117-45020V-xxx & BK117-105-45028V-xxx B0105-450121



## Repair & Overhaul Capabilities

### AS355

Bevel Reduction Gearbox	355A32-0600-xx & 355A32-0601-00
Oil Pump	355A32-0700-02 & 355A32-0701-00
Combiner Gearbox	355A32-0200-XX 355A32-0210-XX & 355A32-0211-00
Tail Rotor Gearbox	350A33-0200-04/-05-07 & 350A33-0210-00
Epicyclic	350A32-0110-00(4contact) & 350A32-0120-00 350A32-0100-10(Timkin)
Pitch Change Spider	350A33-2030-00

### BK117

Intermediate GB	4639002XXX
Tail Rotor GB	4639003XXX

### BO105

Intermediate GB	4619002XXX
Tail Rotor GB	4619003XXX
Main Transmission	4638001XXX

Airbus Helicopters Canada also performs repairs and overhauls on a number of components not listed above. Some of these include: Shaft, Swashplate Guide, T/Rotor Drive Shaft (long/short), Starflex, Non-rotating Star, Crossbeam, Instruments, Shock Absorber, Anit-Vibe Support, Rotating Star, Input Housing, Fuel Probes, and Servos. Please contact your CSR for more information.

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## Contact Information

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