MAINTENANCE REPAIR & OVERHAUL SERVICES
Airbus Helicopters Canada
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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.
Support and Services

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.
One - Stop - Shop

Airbus Helicopters Canada’s level I-IV Repair and Overhaul (R&O) Department is certified for component repair and overhaul for the EC120, EC130, AS350, AS355, BO105 and BK117 as well as, repair of hydraulic packs for the BO105 and BK117.

All Airbus Helicopters Canada R&O department personnel are trained and certified to the highest standards by Airbus Helicopters. Airbus Helicopters Canada’s Repair & Overhaul shop is equipped with:

- Dynamic transmission run-in stands and test benches - EC120, EC130, AS350, AS355
- Hydraulic stand for BK117 and BO105 hydraulic modules.
- Airbus Helicopters special 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.

**Repairs available with dual certification (EASA, TCCA & FAA)**
## Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>EC120</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Upper Housing</td>
</tr>
<tr>
<td>Part #</td>
<td>C632A1111-XXX</td>
</tr>
<tr>
<td>Repair</td>
<td>Bore and bush</td>
</tr>
</tbody>
</table>

### Before and After Images

<table>
<thead>
<tr>
<th>Model</th>
<th>EC120</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Center Housing</td>
</tr>
<tr>
<td>Part #</td>
<td>C632A2116-XXX</td>
</tr>
<tr>
<td>Repair</td>
<td>Corrosion in holes</td>
</tr>
</tbody>
</table>

### Before and After Images
## Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>AS350 / AS355 / EC130</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Starflex Bushing</td>
</tr>
<tr>
<td>Part #</td>
<td>350A31-1917-XX &amp; 350A31-1918-00</td>
</tr>
<tr>
<td>Repair</td>
<td>Removal of worn-out bushings</td>
</tr>
<tr>
<td></td>
<td>Installation of new bushings</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
</tr>
</tbody>
</table>
Dynamic Component Machining Capabilities

Model: AS350 / AS355 / EC130
Part: Star, non-rotating
Part #: 350A37-1002-XX
Repair:
- Worn mounting ears / stirrups
- Bore and bush
Dynamic Component Machining Capabilities

Model: AS350 / AS355 / EC130
Part: Main Case
Part #: 350A32-3121-XX
Repaired:
- Corroded flanges / holes
- Bore & sleeve (72 mm) pinion bearing bore
- Bore & sleeve (126 mm) input housing bore
- Input Flange housing corrosion

Before

After
Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>AS350 / AS355 / EC130</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Lower Case</td>
</tr>
<tr>
<td>Part #</td>
<td>350A32-3119-XX</td>
</tr>
</tbody>
</table>
| Repair      | - Worn/undersize bearing mounting diameter  
               - Bi-directional faces  
               - Flanges / holes |

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) |
Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>AS350 / AS355 / EC130</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Transmission Cross Beam</td>
</tr>
<tr>
<td>Part #</td>
<td>350A38-1018-XX, 350A38-1040-20</td>
</tr>
<tr>
<td>Repair</td>
<td>Bore and bush</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Model</th>
<th>Part</th>
<th>Part #</th>
<th>Repair</th>
</tr>
</thead>
<tbody>
<tr>
<td>AS355</td>
<td>Combining Gearbox</td>
<td>355A0210-XX / 355A0200-XX</td>
<td>- Corrosion - Worn / oversized bearing bores</td>
</tr>
<tr>
<td>BO105</td>
<td>Transmission Top Case</td>
<td>4638-201-XXX</td>
<td>Corroded mounting holes</td>
</tr>
<tr>
<td>BO105</td>
<td>Mast</td>
<td>4619-305-XXX</td>
<td>- Corrosion on mounting face - Replacement of mast moments / bridge</td>
</tr>
</tbody>
</table>
## Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>BO105</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Transmission Center Case</td>
</tr>
<tr>
<td>Part #</td>
<td>4638-201-0030</td>
</tr>
</tbody>
</table>
| Repair      | - Tail rotor bore; fan bore; axillary bore  
              - Seal seat  
              - Corroded mounting holes and flange surface |

Before
![Before Image]

After
![After Image]

<table>
<thead>
<tr>
<th>Model</th>
<th>BO105 / BK117</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Lower Housing</td>
</tr>
<tr>
<td>Part #</td>
<td>4638-201-XXX</td>
</tr>
</tbody>
</table>
| Repair      | - Corroded flange surface  
              - Bolt holes |

Before
![Before Image]

After
![After Image]
Dynamic Component Machining Capabilities

<table>
<thead>
<tr>
<th>Model</th>
<th>BO105 / BK117</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Tail Rotor Gearbox Assembly</td>
</tr>
<tr>
<td>Part #</td>
<td>4639-310-XXX</td>
</tr>
<tr>
<td>Repair</td>
<td>- Oversize bolt holes</td>
</tr>
<tr>
<td></td>
<td>- Removal of corrosion and bush</td>
</tr>
<tr>
<td></td>
<td>- Bore surface</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Model</th>
<th>BO105</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part</td>
<td>Intermediate Gearbox Housing</td>
</tr>
<tr>
<td>Part #</td>
<td>4619-310-XXX</td>
</tr>
<tr>
<td>Repair</td>
<td>- Corroded chamfer surfaces</td>
</tr>
<tr>
<td></td>
<td>- Corroded bore surfaces</td>
</tr>
<tr>
<td></td>
<td>- Mounting lugs</td>
</tr>
</tbody>
</table>

Before

After
Airbus Helicopters Canada is certified for the repair and overhaul of all dynamic components and mechanical assemblies for the EC120, AS350/355, EC130, BO105, BK117 as well as an exchange pool for hydraulic servos for EC120, AS350/355 and an exchange/rental pool for all dynamic components. The following is a list of the main components.

<table>
<thead>
<tr>
<th>Component</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>AS350 / EC130</strong></td>
<td></td>
</tr>
<tr>
<td>Bevel Reduction Gearbox</td>
<td>350A32-0300-04/-05</td>
</tr>
<tr>
<td></td>
<td>350A32-0350-xx (EC130)</td>
</tr>
<tr>
<td>Oil Pump</td>
<td>350A32-0400-00</td>
</tr>
<tr>
<td>Rotor Brake</td>
<td>350A32-0500-02</td>
</tr>
<tr>
<td>Tail Rotor Gearbox</td>
<td>350A33-0200-05/06 &amp; 07</td>
</tr>
<tr>
<td></td>
<td>350A33-0210-00 (B3e)</td>
</tr>
<tr>
<td></td>
<td>350A33-0501-xx (EC130)</td>
</tr>
<tr>
<td></td>
<td>350A33-0502-xx</td>
</tr>
<tr>
<td>Epicyclic</td>
<td>350A32-0110-00 (4 Contact)</td>
</tr>
<tr>
<td></td>
<td>350A32-0100-10 (Timkin)</td>
</tr>
<tr>
<td></td>
<td>350A32-0120-00 (EC130)</td>
</tr>
<tr>
<td>Mast Assembly</td>
<td>355A37-0000</td>
</tr>
<tr>
<td></td>
<td>355A37-0005-06</td>
</tr>
<tr>
<td>Pitch Change Spider</td>
<td>350A33-2030-00</td>
</tr>
<tr>
<td>Ball End</td>
<td>350A33-2150-01</td>
</tr>
<tr>
<td>Scissor Link</td>
<td>350A37-1127-01/-02</td>
</tr>
<tr>
<td>Scissor Link</td>
<td>350A37-1126-01/-02</td>
</tr>
<tr>
<td>Pitch Link</td>
<td>350A33-2145-01</td>
</tr>
<tr>
<td><strong>EC120</strong></td>
<td></td>
</tr>
<tr>
<td>Epicyclic</td>
<td>C632A0101-xxx</td>
</tr>
<tr>
<td>Main Gearbox</td>
<td>C632A0201-xxx</td>
</tr>
<tr>
<td>Tail Rotor Gearbox</td>
<td>C652A0101-xxx</td>
</tr>
<tr>
<td>Scissor Link</td>
<td>C632A2006-103</td>
</tr>
<tr>
<td><strong>BK117 &amp; BO105</strong></td>
<td></td>
</tr>
<tr>
<td>Hydraulic Units</td>
<td>BK117-45020V-xxx &amp; BOCB-105-45028V-xxx</td>
</tr>
<tr>
<td></td>
<td>B0105-450121</td>
</tr>
</tbody>
</table>
# 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.
Blade Exchange & Repair Program
Personalized Repair Services
Airbus Helicopters workmanship
Maximum aircraft availability

Exchange Programs

Return damaged blades to Airbus Helicopters Canada and take advantage of one of our beneficial exchange programs

Airbus Helicopters Canada’s exchange programs offer personalized solutions that are both practical and cost-efficient while ensuring maximum flying time.

**STANDARD EXCHANGE**
- P/N 355A11-0020-00 to 11
- P/N 355A11-0030-00 to 04
- P/N C621A1-0061-01 to 03
- P/N 350A11-0010-00 to 07
- P/N 355A12-0040-08 to 14
- P/N 355A12-0050-04 to 12

**UPGRADE EXCHANGE SETS**
- Upgrade of any repairable P/N 350A11-0010 to 355A11-0030-04
- Upgrade of any repairable P/N 355A11-0020 to 355A11-0030-04

**ZERO TAT EXCHANGE**
- Immediate delivery (upon blade availability)
- Price are determined based on core and exchanged blades
- Please send log cards of your blades for an offer

**Notes:**
- Standard Conditions of Services apply to the R&O Standard Exchange and Rentals.
- Additional conditions may apply, see your Airbus Helicopters Representative for more details.
- Lead time to be confirmed at time of order. Standard Exchange not offered as AOG or RUSH level of service.
- Blades repaired outside of the Airbus network not eligible
- Blades involved in incident/accident not eligible for exchange
Airbus Helicopters Canada offers a wide range of repair solutions for blades. By selecting Airbus Helicopters’ OEM repair services, operators benefit from extensive development, training, support and globally recognized workmanship.

**AS350 / AS355 MAIN ROTOR BLADE**
- Inspection after incident
- Inspection, refinish paint, and static balance (includes root tape)
- Inspection, paint touch-up, and static balance
- Replacement of outboarding leading edge
- Replacement of polyurethane lower surface
- Repair of skin reparation by resin injection

**AS350 / AS355 TAIL ROTOR BLADE**
- Inspection after incident
- Inspection, spar inspection, refinish and static balance
- Inspection, spar inspection, paint touch-up, static balance
- Replacement of stainless steel strip, bond strap

**EC120 MAIN ROTOR BLADE**
- Inspection, refinish paint, and static balance
- Replacement of #1 leading edge
- Replacement of #2 leading edge
- Replacement of #3 leading edge
- Replacement of #4 leading edge

**Blade/component repairs available with dual certification (TCCA & EASA).**
The Airbus Helicopters Canada Service Centre in Fort Erie, Ontario is able to provide comprehensive maintenance, repair and overhaul services such as:

- Light maintenance, troubleshooting and periodical inspections, up to major inspections
- Post server incident inspections
- External aircraft painting and interior refurbishment
- Modifications, customizations, aircraft retrofit, upgrades, and refurbishment

The facility offers complete turnkey aircraft maintenance services. Our fully qualified, factory-trained personnel are experts in maintaining the full family of Airbus Helicopters including those made by its predecessors Eurocopter, Aerospatiale and MBB.

Airbus Helicopters Canada is an AS 9100 registered company. Our Service Centre meets all the requirements for Transport Canada CAR Subpart 573, European EASA Part 145 and FAA FAR Part 145 acceptance. Other capabilities include sheet metal repair, avionics customization and composite part manufacturing and repair.

All Airbus Helicopters Canada maintenance personnel are either Transport Canada licensed Aircraft Maintenance Engineers (AME), qualified by Airbus Helicopters Canada or graduates of an accredited college AME program.

Our Service Centre capabilities also include avionics repairs, complete system upgrades, pilot static system certification, transponder integration/correlation checks, modifications and the ability to perform inspections for the AS350, AS355, EC120, EC130, EC135, BO105 and BK117.
Range of Services

**AS350**
- Aircraft Conversions AS350 B to BA, AS350 BA to B2
- Aircraft rebuilding and refurbishing
- Airframe field repairs
- Hard landing inspection and repair
- Composite repair

**AS350 / EC120 / EC130**
- Maintenance
- T and 12-year major inspections
- Optional equipment installation

**Benefits of using Airbus Helicopters Canada Service Centre include:**
- Access to technical specialists and engineering staff fully dedicated to Airbus Helicopter products in Canada.
- Support of Airbus Helicopter network in terms of design office, technical services and inspections.
- Dedicated team with decades of experience, whose primary focus is major inspections, rebuilds and conversions.
- Factory approved onsite main rotor and tail rotor blade repairs and dynamic components.
Contact Information

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**Customer Service Representative**
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