



**ECCN**  
**9E991**

# **AERONAUTICAL ACCESSORIES, INC.**

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## **ALERT SERVICE BULLETIN** **ASB No. AA-06025**

**SUBJECT:** **Replacement Handle Kit**  
P/N 407-564-033 / 407-564-034

**MODELS AFFECTED:** Bell Helicopter Textron Model 407 with  
Aeronautical Accessories, Inc.  
P/N 407-564-101 / 407-564-102  
Passenger Photo Window Assembly installed  
in accordance with STC SR09324RC or  
STC SR09324RC-D.

**COMPLIANCE:** This bulletin shall be complied with within 50 Flight  
Hours of receipt.

**DESCRIPTION:** This Alert Service Bulletin is being issued in  
response to reports of Passenger Photo Window  
Slider Assemblies becoming dislodged from their  
tracks and departing the aircraft while in flight.

**FAA/DER APPROVAL:** The engineering design data represented by this  
Alert Service Bulletin complies with applicable  
Federal Aviation Regulations and is FAA  
approved.

**MANPOWER:** Approximately 2.0 hours.

**IF OWNERSHIP OF AIRCRAFT HAS CHANGED, PLEASE FORWARD THIS BULLETIN TO NEW OWNER**

**ALERT SERVICE BULLETIN  
Passenger Photo Window Assembly  
Replacement Handle Kit**

**MATERIAL:**

The following materials are required to comply with this bulletin:

407-564-033 Replacement Handle Kit (L/H)  
407-564-034 Replacement Handle Kit (R/H)

<u>Qty</u> <u>-033</u>	<u>Qty</u> <u>-034</u>	<b>Part Number</b>	<b>Description</b>
1		407-564-205	Handle Assembly L/H
	1	407-564-206	Handle Assembly R/H
1	1	407-564-207	Shim Assembly
1	1	407-552-050	Angle
1	1	56-10-301-20	Plunger
4	4	90-003-30B	Trim Nut
2	2	140-001-11	Washer
2	2	MS20426AD3-4	Rivet
4	4	MS35215-56	Screw
4	4	NAS1149B0332HB	Washer
1	1	099-050-171	Adhesive (Loctite 262)

This kit is available from Aeronautical Accessories, Inc. at no cost.  
Contact AAI Sales Department at 1-800-251-7094.

**REQUIRED TOOLS:**

No special tools required

**WEIGHT AND BALANCE:**

Net weight change per Replacement Handle Kit:

+ .11 lbs (+.05 kg)

**PUBLICATIONS AFFECTED:**

Report Number AA-01093, Instructions for Continued Airworthiness

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**Passenger Photo Window Assembly**  
**Replacement Handle Kit**

**PART I – ACCOMPLISHMENT INSTRUCTIONS**

**NOTE**

Passenger Photo Window Assembly removal from aircraft is not required to perform this modification.

1. Remove and discard the screws, washers and nuts attaching the Handle Assembly to the slider assembly.
2. Position Slider Assembly into full-closed (fwd) position.
3. With the Slider Assembly in the full-closed (fwd) position, temporarily place the Shim Assembly (407-564-207) on the inside of the Slider Assembly, between the slide window and the new Handle Assembly, (407-564-205/-206) as shown in Figures 1 and 2. The Shim Assembly can be formed to match the contour of the Slider Assembly/Handle Assembly. Ensure there is a gap of at least .06 inches between the Shim Assembly and the window opening. Slight trimming of the Shim Assembly may be necessary to maintain this gap. Ensure that the Shim Assembly is centrally located in relation to the Slider Assembly.

**NOTE**

To ease in the execution of the next step, mark the location of the Shim Assembly on the Handle Assembly.

4. Once the location has been determined, remove the Shim Assembly and Handle Assembly from the Slider Assembly. Using the Handle Assembly as a guide, and ensuring that the contour is maintained, match drill the holes to the Shim Assembly, using a #10 (.193-.199 dia) drill bit.

**NOTE**

For proper alignment, the holes must be drilled while the Shim Assembly is formed to match the contour of the Handle Assembly.

5. Install the Shim Assembly and Handle Assembly on the Slider Assembly with hardware, as shown in Figures 1 and 2.
6. Install the Plunger (56-10-301-20) into the Angle (407-552-050) using Adhesive (099-050-171), as shown in Figure 1.
7. With the Slider Assembly in the full-closed position, center the Angle assembly on the Handle Assembly.
8. Ensuring proper engagement of the Plunger inside the Stop, transfer the hole pattern from the Angle to the Handle Assembly (Ref. Figure 2).

**NOTE**

The Angle may need to be turned upside down and shims may need to be added behind the Angle to ensure proper engagement with existing Stop Assembly.

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9. Drill the Handle Assembly using a #30 drill bit and countersink 100° x .179 diameter.
10. Install Rivets (MS20426AD3-4) and Washers (140-001-11) to secure the Angle Assembly to the Handle Assembly.

**NOTE**

Longer rivets may be required if shims were added to position the Angle.

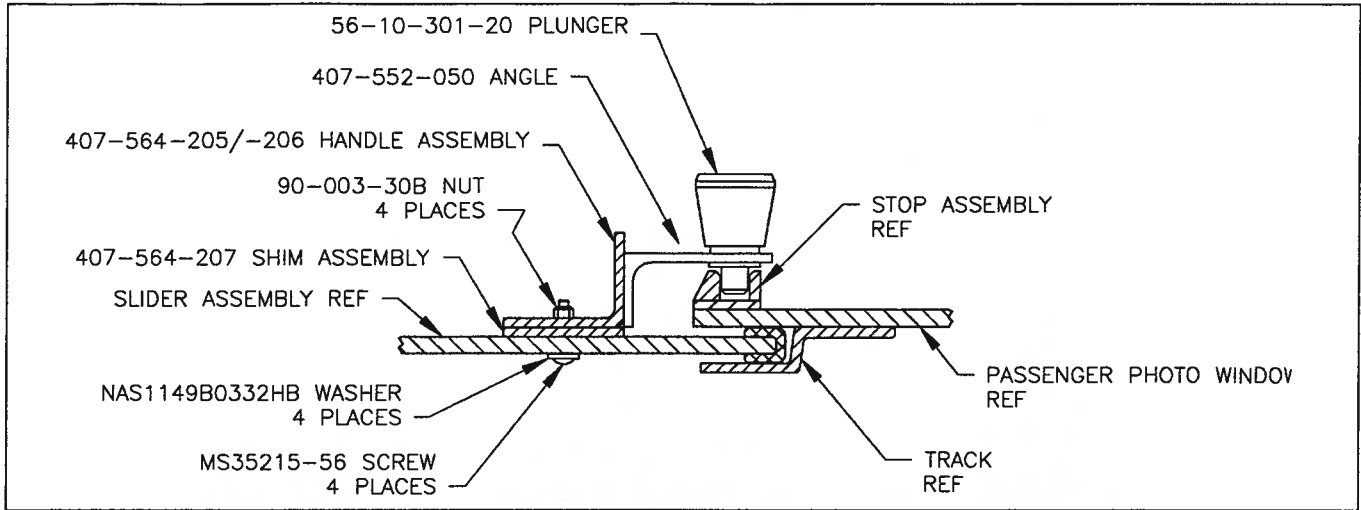
11. Repeat for opposite side, if Passenger Photo Window is installed.
12. Modification complete.

Any questions regarding this bulletin should be addressed to:

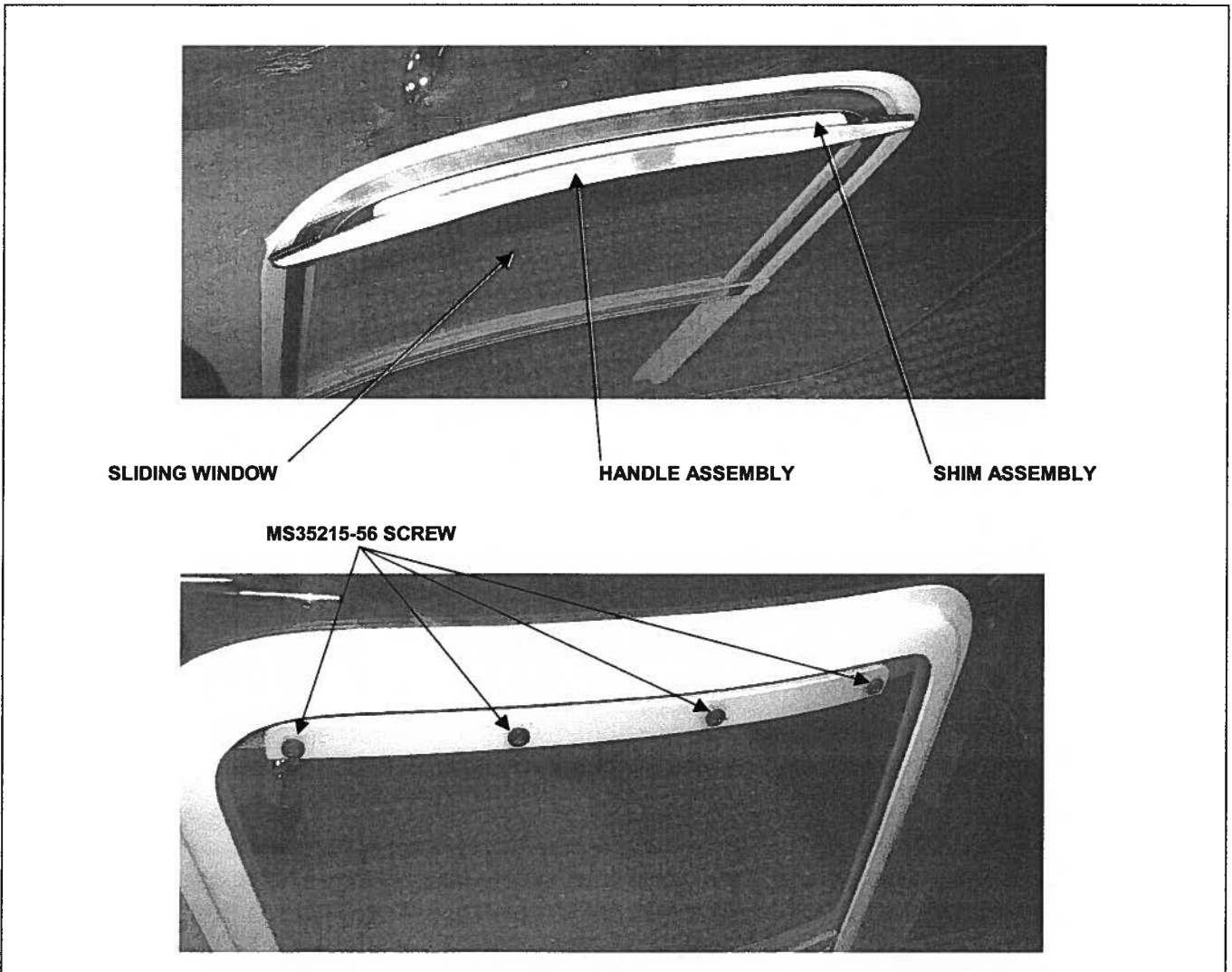
**AERONAUTICAL ACCESSORIES, INC.  
P.O. Box 3689  
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**PRODUCT SUPPORT  
1-800-251-7094**

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**FIGURE 1 – HANDLE ASSEMBLY INSTALLATION**



**FIGURE 2 – SLIDER ASSEMBLY INSTALLATION**