

Service Bulletin

Starair Aircraft Co., Ltd.

Document No.: 2023-SA60L-52-01

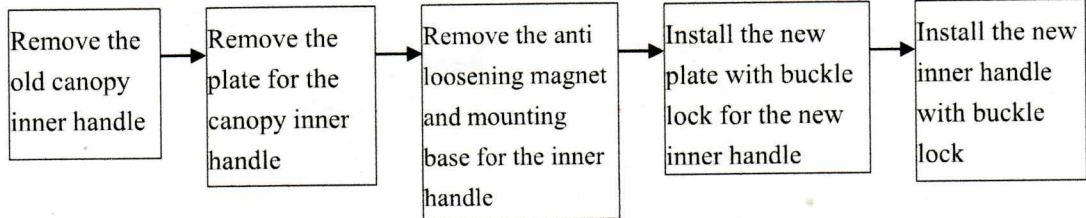
Ver.: 01

Date: October 27, 2023

Subject	Replacement of components of the inner handle of the canopy lock
Category	Important
Applicability	This bulletin applies to the Aurora SA60L series and Aurora SA70L series light sport aircraft listed in Attached Table 1.
Finish Time	Aircraft within the scope of application must be done the work required by this service bulletin completely before July 31, 2024.
Reason	<p>The anti loosening method used for the canopy lock of Aurora SA60L series and Aurora SA70L series aircraft is based on the principle of mechanical linkage over dead center and the method of magnet adsorption. According to feedback from the user, due to vibration or arm contact during flight, the canopy lock may become partially released (the handle lock pin does not come out of the lock hole). To avoid the situation mentioned above, Aircraft within the scope of application are required to replace the handle components of the canopy lock according to the required actions of this bulletin (at their own expense) .</p> <p>Issue Date: October 27, 2023 Effective Date: October 27, 2023</p>

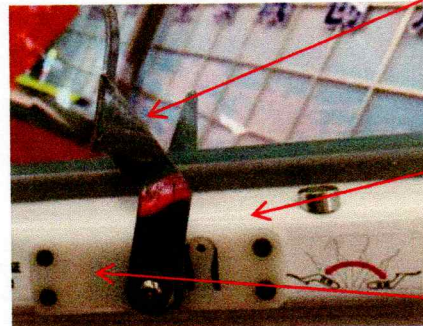


A. Follow the steps below to replace the inner handle of the canopy lock.



B. The schematic diagrams before and after replacing the inner handle of the canopy lock are as follows.

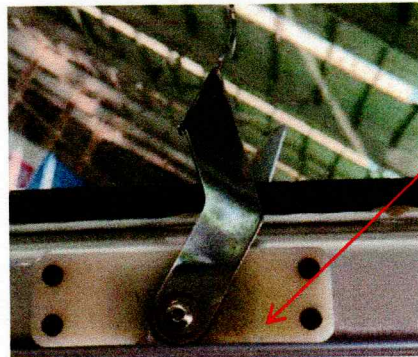
Required
Action(s)



302040000370 inner handle1
302040000371 inner handle 2

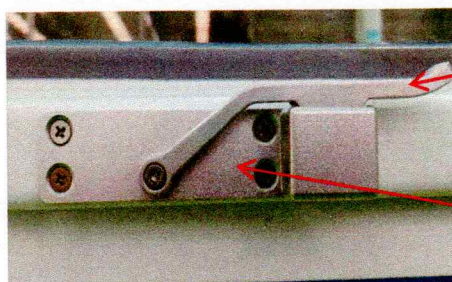
750906000308 magnet with holes14
302990002597 magnet mounting base for Canopy

Type 1 of nylon plate:
316810100005 Left nylon plate
302040000371 Right nylon plate



Type 2、3 of nylon plate:
316810100018 Nylon plate
307990000213 Plate

Before replacing



3168000017 Left inner haddle
3168000006 Right inner haddle

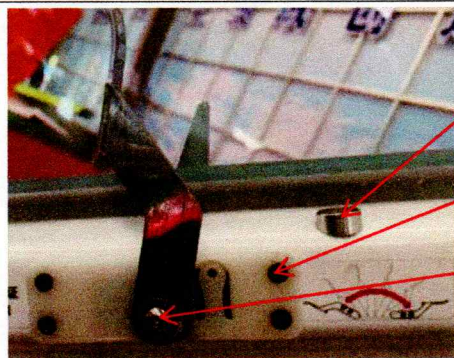
3168000019 Plate for left inner haddle
3168000018 Plate for right inner haddle

After replacing

C. The steps for replacing the inner handle of the canopy lock are as follows:

1. Removal of the inner handle, plate, and magnet of the old canopy.

As shown in the following figure, remove mounting screws of the inner handle, nylon plate, and magnet in sequence.



Magnet mounting screw

Nylon plate mounting screw

Inner handle mounting screw

2. Sub assembly of the buckle lock for Left/Right Inner Handle plate. (Complete this step before leaving Starair Aircraft Co.,Ltd.)

a、 As shown in the following figures, place the protruding side of the buckle lock inward into the slot of the inner handle plate, screw in (701309004029 screw M4X8-ZnD GB/T 818), adjust the buckle lock so that the bottom surface of the buckle lock is tightly attached to the bottom surface of slot of the inner handle plate.

b、 After adjustment, remove (701309004029 screw M4X8-ZnD GB/T 818), apply Loctite 243, and tighten it with a cross screwdriver.

c、 Assemble the inner handle on the other side in the same way as above.

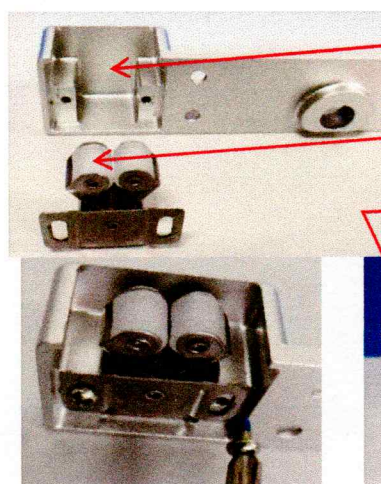
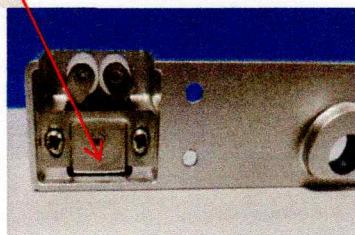


Plate slot

The protruding face of the buckle lock

The bottom surface of the buckle lock is tightly attached

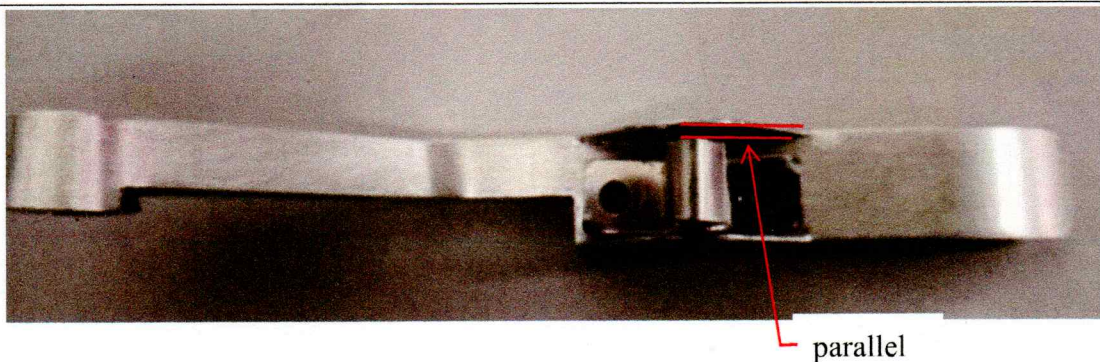


3. Installation of buckle of the left/right inner handle. (Complete this step before leaving Starair Aircraft Co.,Ltd.)

a、 As shown in the following figures, align the buckle with the installation hole of the inner handle, screw in (701309004003 screw M4X6-A2-70 GB/T 818), adjust the buckle so that the side of the buckle is parallel to the side of the inner handle.

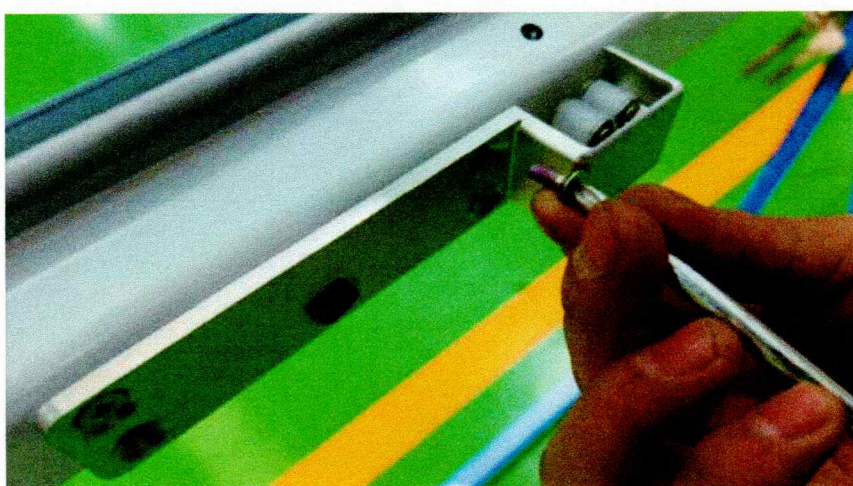
b、 After adjustment, remove (701309004003 screw M4X6-A2-70 GB/T 818), apply Loctite 243, and tighten it with a cross screwdriver.

c、 Install the inner handle on the other side in the same way as above.



4. Installation of left/right inner handle plate.

As shown in the following figure, insert the camshaft into the hole of the inner handle plate, align the installation hole of the inner handle with the fixing hole of the canopy, and screw (701312004210 countersunk head tapping screw ST4.2X13 GB/T 846) into the installation hole of the inner handle plate. If the thread inside the canopy frame slides during disassembly, use a hand electrical drill to enlarge the diameter of the countersunk holes of (3168000019 left inner handle plate) and (3168000018 right inner handle plate) to D5, and then screw (7110000805 countersunk head tapping screw ST4.8X12 GB/T846) into the installation hole of the inner handle plate. Tighten it with a cross screwdriver.



5. Installation of the Left/Right Inner Handle .

a、As shown in the following figures, align the direction of the inner handle and outer handle of the canopy. Insert the waist-shaped groove into the gap of the camshaft,

apply Loctite 243, and then screw in (701302005068 screw M5X12-A2-70 GB/T 70.1). Tighten it with a 4mm hex socket wrench, with a torque of 3.8Nm

b、Pull the inner handle backwards to the limit position, confirm that the buckle of the inner handle can be fully engaged and locked inside the buckle lock, and ensure that there is no interference between the inner and outer handles and the canopy frame when the canopy is locked and unlocked.



The buckle of the inner handle be fully engaged and locked inside the buckle lock

D. Materials required to implement this service bulletin

1. Dismantled parts:

No.	Material No.	Name	quantity
1	316810100018	Nylon plate	2
2	307990000213	Plate	2
3	316810100005	Left nylon plate	1
4	302040000371	Night nylon plate	1
5	701312004210	Countersunk head tapping screw ST4.2X13 GB/T 846	8
6	701323005007	Screw M5X8-A2-70 GB70.2	2
7	302040000370	Inner haddle 1	1
8	302040000371	Inner haddle 2	1
9	701310004012	Screw M4X10-A2-70 GB/T 819.1	2
10	750906000308	magnet with holes 14	2
11	302990002597	Magnet mounting base for Canop	2

2. Replacement parts:

No.	Material No.	Name	quantity
1	3168000019	Left inner haddle plate	1
2	3168000017	Left inner haddle	1
3	3168000018	Right inner haddle plate	1
4	3168000006	Right inner haddle	1
5	701312004210	Countersunk head tapping screw ST4.2X13 GB/T 846	8
6	701302005068	Screw M5X12-A2-70 GB/T 70.1	2
7	7150000006	Stainless push-pull type ball buckle lock325	2
8	701309004003	Screw M4X6-A2-70 GB/T 818	4
9	701309004029	Screw M4X8-ZnD GB/T 818	4

Reference Documents	8168AAFJ0002 "Aurora SA60L&Aurora SA60L-iS Maintenance Manual" A0 Edition 8J33AAFJ0002 "Aurora SA70L Maintenance Manual" A0 Edition		
Tools	4mm hexagonal socket wrench, cross screwdriver, Torque wrench		
Weight and Balance Impact	None		
Special tools and equipment	None		
Contact Information	contacts: Peng Liang	phone number: 4006635288	mail address: safety@sunward.cc
Approval	This service bulletin has been approved by the airworthiness management department of Civil Aviation Administration of China.		

Attached Table1: Aircraft with the Serial Number listed below are affected

No.	S/N	No.	S/N	No.	S/N
1	SA60LS00103	35	SA60LS00142	69	SA60LS00186
2	SA60LS00104	36	SA60LS00143	70	SA60LS00187
3	SA60LS00105	37	SA60LS00145	71	SA60LS00188
4	SA60LS00106	38	SA60LS00148	72	SA60LS00189
5	SA60LS00107	39	SA60LS00149	73	SA60LS00190
6	SA60LS00108	40	SA60LS00150	74	SA60LS00191
7	SA60LS00109	41	SA60LS00151	75	SA60LS00192
8	SA60LS00110	42	SA60LS00152	76	SA60LS00193
9	SA60LS00111	43	SA60LS00153	77	SA60LS00195
10	SA60LS00112	44	SA60LS00154	78	SA60LS00196
11	SA60LS00114	45	SA60LS00156	79	SA60LS00197
12	SA60LS00115	46	SA60LS00157	80	SA60LS00198
13	SA60LS00116	47	SA60LS00158	81	SA60LS00199
14	SA60LS00117	48	SA60LS00160	82	SA60LS00200
15	SA60LS00118	49	SA60LS00161	83	SA60LS00201
16	SA60LS00119	50	SA60LS00162	84	SA60LS00202
17	SA60LS00120	51	SA60LS00163	85	SA60LS00205
18	SA60LS00121	52	SA60LS00164	86	SA60LS00206
19	SA60LS00122	53	SA60LS00166	87	SA60LS00207
20	SA60LS00123	54	SA60LS00167	88	SA60LS00208
21	SA60LS00125	55	SA60LS00168	89	SA60LS00209
22	SA60LS00126	56	SA60LS00169	90	SA60LS00210
23	SA60LS00128	57	SA60LS00173	91	SA60LS00211
24	SA60LS00130	58	SA60LS00174	92	SA60LS00212
25	SA60LS00131	59	SA60LS00175	93	SA60LS00213
26	SA60LS00132	60	SA60LS00176	94	SA60LS00215
27	SA60LS00133	61	SA60LS00177	95	SA60LS00216
28	SA60LS00134	62	SA60LS00178	96	SA60LS00217
29	SA60LS00135	63	SA60LS00179	97	SA60LS00218
30	SA60LS00136	64	SA60LS00180	98	SA60LS00219
31	SA60LS00137	65	SA60LS00182	99	SA60LS00220
32	SA60LS00138	66	SA60LS00183	100	SA60LS00221
33	SA60LS00139	67	SA60LS00184	101	SA60LS00222
34	SA60LS00140	68	SA60LS00185	102	SA60LS00223

No.	S/N	No.	S/N	No.	S/N
103	SA60LS00225	135	SA60LS00263	167	SA60LS00302
104	SA60LS00226	136	SA60LS00265	168	SA60LS00303
105	SA60LS00227	137	SA60LS00266	169	SA60LS00305
106	SA60LS00228	138	SA60LS00267	170	SA60LS00306
107	SA60LS00230	139	SA60LS00268	171	SA60LS00307
108	SA60LS00231	140	SA60LS00269	172	SA60LS00308
109	SA60LS00232	141	SA60LS00270	173	SA60LS00309
110	SA60LS00233	142	SA60LS00271	174	SA60LS00310
111	SA60LS00235	143	SA60LS00272	175	SA60LS00311
112	SA60LS00236	144	SA60LS00273	176	SA60LS00312
113	SA60LS00237	145	SA60LS00275	177	SA60LS00313
114	SA60LS00238	146	SA60LS00276	178	SA60LS00315
115	SA60LS00239	147	SA60LS00277	179	SA60LS00317
116	SA60LS00240	148	SA60LS00280	180	SA60LS00318
117	SA60LS00241	149	SA60LS00281	181	SA60LS00319
118	SA60LS00242	150	SA60LS00282	182	SA60LS00320
119	SA60LS00243	151	SA60LS00283	183	SA60LS00321
120	SA60LS00245	152	SA60LS00285	184	SA60LS00322
121	SA60LS00246	153	SA60LS00286	185	SA60LS00323
122	SA60LS00247	154	SA60LS00287	186	SA60LS00325
123	SA60LS00248	155	SA60LS00288	187	SA60LS00326
124	SA60LS00249	156	SA60LS00290	188	SA60LS00327
125	SA60LS00251	157	SA60LS00291	189	SA60LS00328
126	SA60LS00252	158	SA60LS00292	190	SA60LS00329
127	SA60LS00255	159	SA60LS00293	191	SA70LS00102
128	SA60LS00256	160	SA60LS00295	192	SA70LS00103
129	SA60LS00257	161	SA60LS00296	193	SA70LS00105
130	SA60LS00258	162	SA60LS00297		----- END -----
131	SA60LS00259	163	SA60LS00298		
132	SA60LS00260	164	SA60LS00299		
133	SA60LS00261	165	SA60LS00300		
134	SA60LS00262	166	SA60LS00301		