SERVICE BULLETIN

MANDATORY MANDATORY MANDATORY

RIVETING TIP–CAP TO TAIL ROTOR BLADE

1. PLANNING INFORMATION

A. MODELS AFFECTED:

All 369H, 369HS, 369HE, 369HM, 369D, 369E and OH-6 Series helicopters having any PN 369A1613-7, 369A1613-503, 369D21613-11, 369D21613-41, 369D21613-51 or 369D21615 Tail Rotor Blade installed which has any of the following serial numbers, and any of the affected parts in spares inventory, as individual blades or as part of spare tailrotor assemblies.

Part Number	Serial Number	Part Number	Serial Number
369A1613-503	4148		0233
	4842		0368
369A1613-7	3636	369D21613-11,	1379
		41, -51	1766
369D21615	0081		1767
	0083		1905
	0084		1957
	0088		1958
	0101		1968
	0141		1975
	0142		1976
	0143		1982
	0144		2021
	0145		2022
	0146		2027
	0147		2038
	0148		2039
	0149		2040
	0150		2042
	0151		2043
	0152		2054
	0153		2055
	0154		2064
	0155		2075
	0156		2104
	0157		2108
	0158		2218
	0159		2219
	0160		2226

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Part Number	Serial Number	Part Number	Serial Number
369D21613-11, 41, -51 (continued)	2244		3350
	2251		3351
	2252		3352
	2298		3353
	2299		3354
	2303		3355
	2321		3356
	2351		3386
	2352		3407
	2361		3408
	2362		3437
	2399		3438
	2400		3439
	2939		3440
	2943		3441
	2944		3442
	2967		3443
	2978		3444
	2982		3445
	2983		3446
	2995		3447
	3008		3448
	3095		3449
	3129		3450
	3144		3451
	3179		3452
	3184		3453
	3205		3454
	3237		3455
	3271		3456
	3337		3476
	3338		3543
	3339		3548
	3341		3636
	3342		3642
	3343		3657
	3344		3658
	3345		3659
	3346		3660
	3347		3661
	3348		3662
	3349		

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Part Number	Serial Number	Part Number	Serial Number
			3855
369D21613-11,	3663		3856
41, -51	3664		3857
(continued)	3665		3858
	3666		3859
	3667		3860
	3668		3861
	3697		3862
	3698		3863
	3701		3864
	3702		3875
	3705		3876
	3706		3877
	3746		3878
	3793		3881
	3795		3882
	3804		3883
	3805		3884
	3806		3885
	3807		3886
	3808		3887
	3809		3888
	3810		3890
	3811		3896
	3812		4066
	3813		4107
	3837		4108
	3838		4113
	3839		4114
	3840		4115
	3841		4116
	3842		4117
	3843		4118
	3844		4129
	3845		4134
	3846		4135
	3847		4136
	3848		4137
	3849		4138
	3850		4141
	3851		4142
	3852		4159
	3853		4187
	3854		

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Part Number	Serial Number	Part Number	Serial Number
369D21613-11, 41, -51 (continued)	4188		4205
	4189		4206
	4190		4213
	4191		4214
	4192		4215
	4193		4216
	4194		4217
	4195		4218
	4196		4219
	4197		4220
	4198		4221
	4199		4222
	4200		4223
	4201		4224
	4202		4226
	4203		4288
	4204		4488

B. PREFACE:

This Service Notice gives procedures for riveting tip cap assemblies to the affected tail rotor blades. Debonding of the tip cap from the blade could occur, causing loss of the tip cap during operation of the helicopter.

C. TIME OF COMPLIANCE:

Shall be accomplished prior to further flight for all installed affected blades having more than 100 hours total time in service. Shall be accomplished within the next 25 hours of operation for all affected blades having less than 100 hours total time in service. Shall be accomplished prior to installation of any affected blade from spares.

D. FAA APPROVAL:

The resultant alteration to affected models as described by the procedures in this Notice has been shown to comply with Federal Aviation Regulations and is FAA Approved.

E. WEIGHT AND BALANCE:

Weight and balance not affected

F. REFERENCE:

Basic Handbook of Maintenance Instructions (CSP-H-2), Reissued 15 September 1981.
369D HMI Volume 1 (CSP-D-2), Reissued 15 January 1982; Revision 3, 15 August 1983.

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G. MATERIALS:

MATERIALS		
Nomenclature	**Spec**	**Source**
Rivet, Blind	NAS1739B4–2	Commercial
Primer, Zinc Chromate	TT–P–1757	Commercial
Epoxy, Clear		Commercial

H. TOOLS AND EQUIPMENT:

TOOLS AND EQUIPMENT	
Nomenclature	**Source**
Drill Motor, Portable	Commercial
Drill, No. 27	Commercial
Countersink, 100° ±1°, with No. 30 pilot	Commercial
Rivet Tool, Pneumatic, G–784 or G689	Cherry Rivet Division 1224 E. Warner Ave. Santa Ana, CA 92707 Phone: (714) 545–5511
Pulling Head, H681–4C	Cherry Rivet Division
Hand Riveter, G–36	Cherry Rivet Division
Pulling Head, H615–46	Cherry Rivet Division

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2. PROCEDURE

a. Remove blade from helicopter (Section 8, appropriate ref HMI).

b. Visually inspect tip cap-to-blade bonding for failure. If any evidence of debonding is noted, replace blade (Section 8, appropriate ref HMI).

CAUTION Handle blade carefully. Dents, nicks or scratches may cause balance problems at reinstallation, or make blade unserviceable.

c. With blade on a clean hard surface, measure and mark locations for rivet holes as shown in Figure 1.

d. Using No. 27 drill, carefully drill holes at locations marked on outboard and inboard surfaces of blade.

e. Using 100 ±1° countersink with No. 30 pilot, countersink holes to 0.035 inch maximum depth.

f. Apply zinc chromate primer to holes and install NAS1739B4-2 blind rivets while primer is wet.

g. Coat installed rivets with clear epoxy.

h. Reinstall blade on helicopter (Section 8, appropriate ref HMI).

i. Check and adjust tail rotor blade balance (Section 8, appropriate ref HMI).

j. Record compliance with this Notice in Compliance Record of helicopter Log Book.

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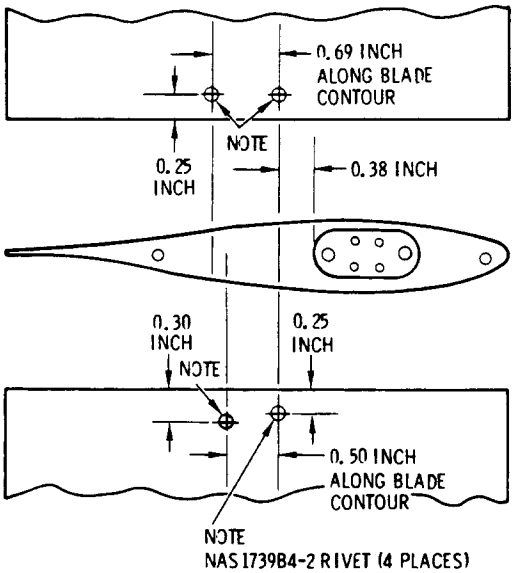

NOTE:
USE NO. 27 DRILL AND 100° COUNTERSINK WITH NO. 30 PILOT. COUNTERSINK TO MAXIMUM 0.035 INCH DEPTH. INSTALL NAS 1739B4-2 RIVET. SEAL RIVET WITH CLEAR EPOXY.

Figure 1. Installation - Tip Cap-To-Tail Rotor Blade

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