



SERVICE BULLETIN

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SEALING OF INTERFACES OF ABRASION STRIP AND MAIN ROTOR BLADE SKIN

1. PLANNING INFORMATION

A. MODELS AFFECTED:

500C Model 369H Series Helicopters equipped with PN 369A1100 Main Rotor Blade Assemblies with Serial Nos below BU65.

B. PREFACE:

The information given in this Service Information Notice lists a procedure for sealing of interfaces of abrasion strip and main rotor blade Skin to inhibit corrosion and/or adhesive erosion.

C. TIME OF COMPLIANCE:

When main rotor blade(s) show visual signs of adhesive erosion at interface with abrasion strip.

D. FAA APPROVAL:

FAA/DER APPROVED 2 February 1981

E. WEIGHT AND BALANCE:

Weight and balance not affected

F. MATERIALS:

| MATERIALS | |
|----------------------------------------------------------------|--------------------------------------------------------------------------------------------------|
| Nomenclature | Source |
| Solvent – M-114M, or Methyl Ethyl Ketone (MEK), TT-M-261 | J.B. Moore Company, 1 605 Ventura Blvd., Encino, CA 91436 |
| Adhesive – EC2216 B/A, | 3M Company, 6411 Randlph, Los Angeles, CA 90045 |
| Sealant – PR1436G, Class B-2 or PR1422G, Class B | Products Research and Chemical Corporation, 2919 Empire Avenue, Burbank, CA 91504 |
| Release agent – TC7-527, or 225, | EPD Industries, 2055 E. 223 Street, Long Beach, CA 90810 Ram Chemical Company, Gardena, CA |
| Printer, zinc chromate | |

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G. TOOLS AND EQUIPMENT:

| TOOLS AND EQUIPMENT | |
|-----------------------------------|--------|
| Nomenclature | Source |
| Sealant applicator gun or spatula | |

2. PROCEDURE

- a. Remove screw and tip cap from main rotor blade.
- b. Remove any loose or cracked sealant or adhesive from areas of main rotor blade shown in Figure 1.

WARNING MEK is flammable, Use in well ventilated area and away from smoke and flame.

- c. Clean areas to be sealed with clean cloth moistened with M-114M solvent. For hard to clean problem areas MEK solvent may be used. Wipe surface dry before solvent evaporates.
- d. Prepare EC2216 B/A adhesive per manufacturer's instructions.
- e. Apply head of adhesive to interface of abrasion strip and blade skin as shown in Figure 1. Ensure that there are no gaps or bridges in bead. Cure adhesive per manufacturer's instructions.
- f. Seal tip cap as follows: (See Figure 1)
 1. Apply release agent to inside of tip cap per manufacturer's instructions.
 2. Prepare and apply a 0.010 to 0.020 inch coating of PR136G Class B- 2 or PR1422G Class B sealant to laying surfaces per manufacturer's instructions.
 3. Attach tip cap to blade and install screw with zinc chromate primer.
 4. Wipe off squeezed out sealant flush with surface.

NOTE: To inhibit moisture entering bond joint of abrasion strip after initial application, reapply sealant, when sealant is worn away or becomes cracked.

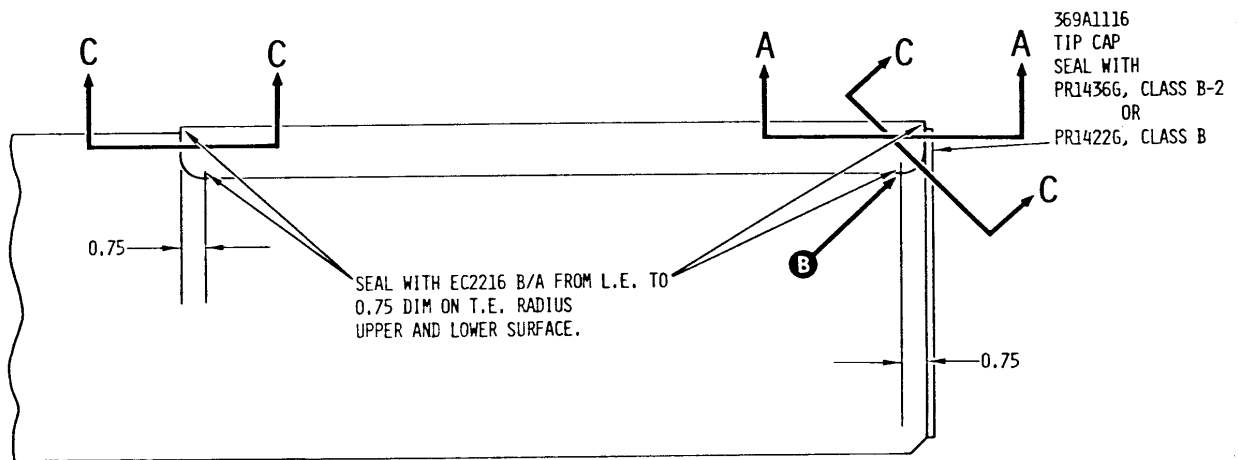
- g. Record compliance with this Service Information Notice in Compliance Record of helicopter Log Book.

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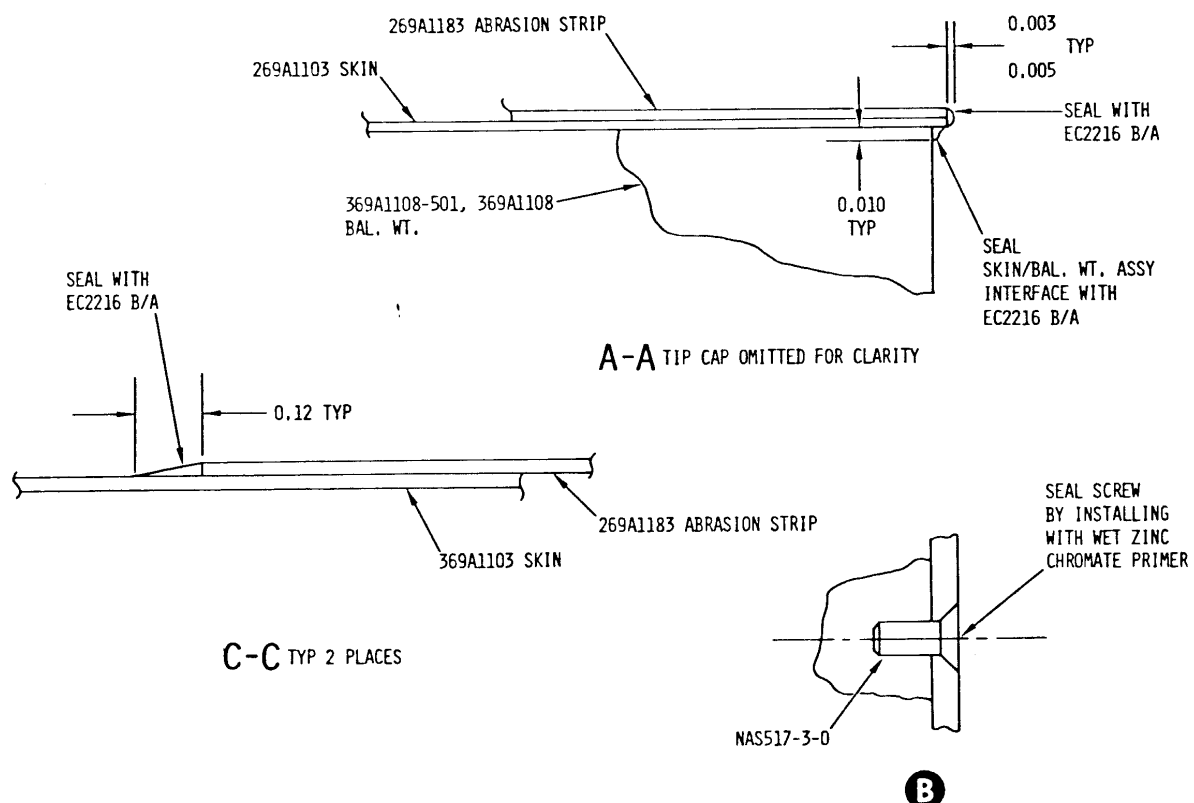
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369A1100 MAIN ROTOR BLADE ASSY



A-A TIP CAP OMITTED FOR CLARITY

C-C TYP 2 PLACES

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Figure 1. Sealing of Abrasion Strip and Tip Cap

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