

SERVICE BULLETIN

RECOMMENDED No. 05.96

SUBJECT : TIME LIMITS / MAINTENANCE CHECKS
 Modification and Monitoring of the Tightening Torque of the Splined Bush Attachment Bolts on the Main Rotor Hub.

Corresponds to MOD 072323

LIST OF EFFECTIVE PAGES

- (1) Page Revision Code
 - R: Revised, to be replaced
 - N: New, to be inserted
 - D: Deleted, to be destroyed

CHAP/Sequence No.	PAGE	DATE	(1)	CHAP/Sequence No.	PAGE	DATE	(1)
05.96.P5	01	99-28	N				
05.96	1	99-28	N				
05.96	2	99-28	N				
05.96	3	99-28	N				
05.96	4	99-28	N				
05.96	5	99-28	N				

LIST OF APPROVED REVISIONS Not applicable	REVISION No. 0 APPROVED Date: June 16, 1999
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1. PLANNING INFORMATION

A. Effectivity

Main rotor Hub P/Nos.: 3130S12.30.000 all dash numbers / 3130S12.40.000 all dash numbers.
 3130S12.50.000 all dash numbers / 3160S12.10.000 all dash numbers.
 3160S12.20.000 all dash numbers.

B. Reason

To improve the security of the 3 attachment bolts of the main rotor head splined bushes by increasing the tightening torque.
 EUROCOPTER recommends compliance with this Service Bulletin.

C. Description

Tightening torque of the 3 bolts increased after prior check.
 Tightening torque of the attachment bolts readjusted periodically.

D. Compliance

At the works : Not applicable.

Retrofit action : By the operator on receipt of this Service Bulletin.

- a) At the next aircraft "T" inspection:
 - Comply with paragraph 2.B.(1).

NOTE : without exceeding 400 MRH operating hours from receipt of this Service Bulletin.

Then:

- b) every 400 MRH operating hours
 - comply with paragraph 2.B.(2).

Spares stored at the customer's facilities: before installation in the aircraft:

On all MRH:

- which do not incorporate MOD 072323:
 - . Comply with paragraph 2.B.
 - . Record embodiment of MOD 072323 on the equipment log card.
- which incorporate MOD 072323 :
 - . Comply with paragraph 2.B.(2).

E. Approval

The information or instructions relate to change: MOD 072323 which was approved on January 29, 1999 by the DGAC.

Approval is limited to civil version helicopters subject to an Airworthiness Certificate.

The information or instructions contained in this Service Bulletin were approved on June 16, 1999 under the authority of DGAC Design Organisation Approval No. F.JA.01.

F. Manpower

Qualification : 2 mechanics, 3 hours in all.

G. Material - Cost - Availability

Not applicable.

H. Tooling - Cost - Availability

Not applicable.

I. Weight and Balance

Not applicable.

J. Effect on Electrical Loads

None.

K. References

Standard Practices Manual (MTC) : 20.02.05.404,
20.02.09.101,
20.02.09.102.

Maintenance Manual (MDE): 57.20.401 or
57.2.401.

2. ACCOMPLISHMENT INSTRUCTIONS

A. General

Not applicable.

B. Operational Procedure

1. Increase in the tightening torque of the 3 bolts (V) which secure splined bushes (C)
(as per FIGURE 1, View A), (corresponds to MOD 072323).

- Remove the MRH as per work card 57.20.401 or 57.2.401.
- Remove bolts (V) (remove and check the bolts one by one).
- Check for possible cracks as per (MTC 20.02.09.101 or 20.02.09.102), using dye penetrant inspection or magna flux inspection, especially in the bolt head-to-bolt shaft connection area.

NOTE : Any bolt affected by a crack is to be scrapped and replaced with a new bolt, see paragraph 3.B.

- Fit bolts (V) (checked or new) which secure the splined bushes.
- Apply new dry tightening torque of 8 to 10 m.daN (as per FIGURE 1, View B).
- Install the MRH as per work card 57.20.401 or 57.2.401.

2. Readjustment of the tightening torque of the 3 bolts (V) which secure splined bushes (C)
(as per FIGURE 1, View B).

Adjust the dry tightening torque to 8 to 10 m.daN as per MTC 20.02.05.404, paragraph 1.2.2.

C. Identification

Record compliance with this Service Bulletin on the MRH equipment log card.

D. Operating and Maintenance Instructions

Refer to the Master Servicing Recommendations (PRE).

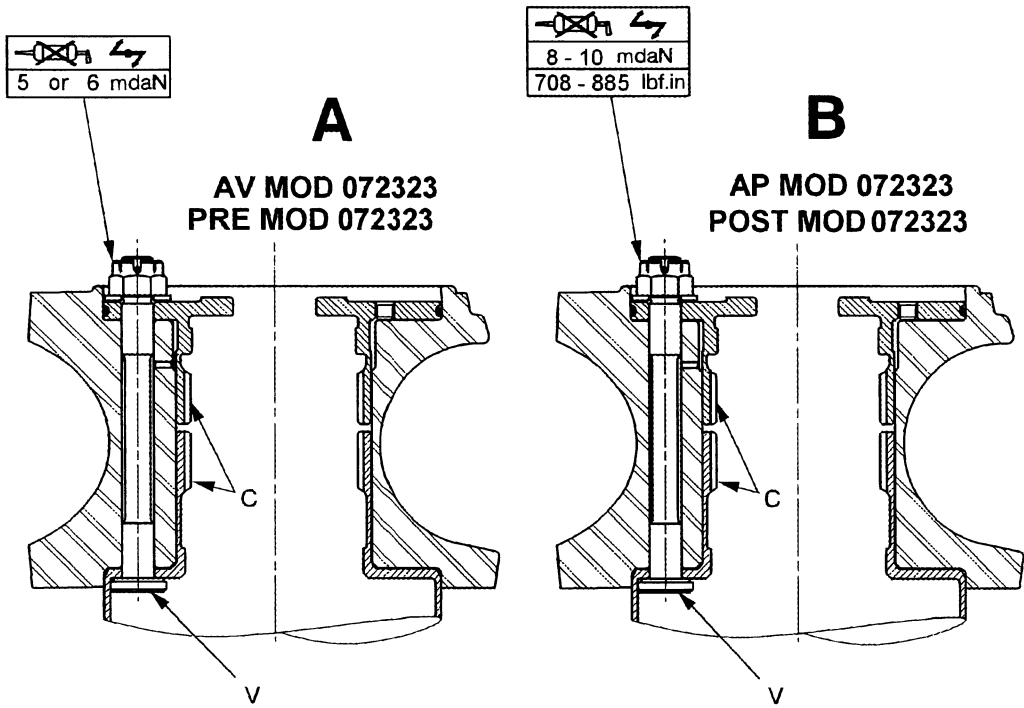
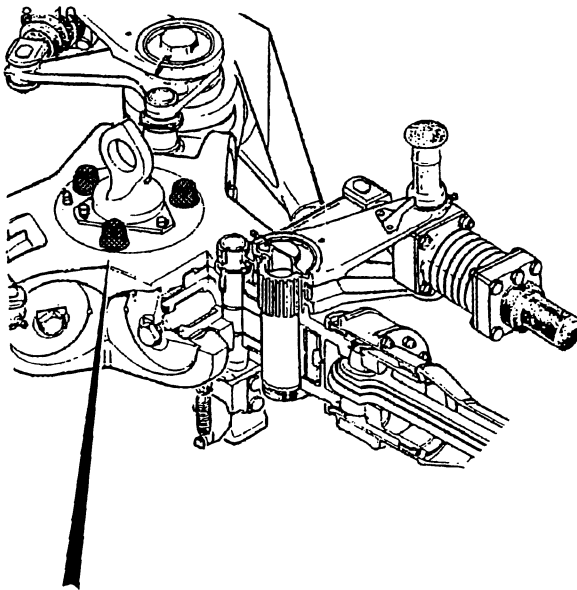


FIGURE 1

3130/3160

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3. MATERIAL INFORMATION

A. Basic Information

Not applicable.

B. Complete Bill of Material

New P/N	Qty	Item	Key Word	Former P/N	Instruction Disposition
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To be ordered as required (Versions 316/319/3160)

3160S12.10.003	A.r.		Bolt		
22420BC140L	A.r.		Nut		
23310AA030030L	A.r.		Split pin		
23113AGAG140LE	A.r.		Washer		

To be ordered as required (Versions 313/3130/318/3180)

3130S12.00.005	A.r.		Bolt		
22420BC140L	A.r.		Nut		
23310AA030030L	A.r.		Split pin		
23111AGAG140LE	A.r.		Washer		

C. Special Tools Required

Not applicable.

D. Procurement Conditions

Order as required. Refer to paragraph 3.B

from

EUROCOPTER
 Etablissement de Marignane
 Direction MAINTENANCE SUPPORT
 E/S.MR
 13725 MARIGNANE CEDEX (FRANCE)

NOTE I : For MANDATORY Service Bulletins, order by :

Telex : HELICOP 410 969F
 Fax : +(33).(0)4.42.85.99.96.

NOTE II IMPORTANT : On the purchase order, please specify the mode of transport, the destination and serial numbers of the aircraft to be modified.