



# SERVICE BULLETIN

DATE: 3 MARCH 1980

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## HORIZONTAL STABILIZER ASSEMBLY —ADDING DRAIN HOLES AND SEALING DOUBLER EDGES

### 1. PLANNING INFORMATION

#### A. MODELS AFFECTED:

500D Model 369D Helicopter Serial No. 0003D through 0534D All PN 369D23601 and PN 421-087 Horizontal Stabilizer Assemblies in Spares Inventory at Date of this Notice

#### B. PREFACE:

The information given in this Service Information Notice lists a procedure for incorporating drain holes in the lower surface of the horizontal stabilizer assembly, to provide drainage for possible water seepage. Instructions are also provided for sealing the upper and lower doubler edges, and any gaps between the doublers and stabilizer skin, to prevent water from collecting and freezing during cold weather operation.

It is to be noted. that the stabilizer tip plates have an infinite life. When replacing the stabilizer, the tip plates may be reinstalled as condition warrants.

#### C. TIME OF COMPLIANCE:

Shall be accomplished at next Annual or 300-Hour Inspection Shall be accomplished prior to installation of above affected Spares. Horizontal Stabilizer Assembly on Helicopter

#### D. FAA APPROVAL:

FAA APPROVED

#### E. WEIGHT AND BALANCE DATA:

Weight and balance not affected

#### F. REFERENCE:

500D Basic HMI-Volume I, Issued 15 September 1976; Revision No. 3, 15 March 1979  
500D Basic HMI-Volume II, Issued 15 September 1976; Revision No. 2, 1 November 197

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## G. TOOLS AND EQUIPMENT

TOOLS AND EQUIPMENT	
Nomenclature	
Drill motor, portable	
Drill bit – #10	

## H. MATERIALS:

MATERIALS		
Nomenclature		Source
Sealant	PR1221B2 or equivalent	Product Re search, Burbank, CA
Naphtha, aliphatic	TT-N-95	Commercial

## 2. PROCEDURE

- a. Remove horizontal stabilizer assembly, per HMI-Vol I.
- b. Support horizontal stabilizer with lower surface facing upwards.
- c. Mark and drill three No. 10 drain holes in lower surface of stabilizer, at dimensions shown in Figure 1.
- d. Seal all edges of lower doubler and any gaps between doubler and stabilizer skin, as shown in Figure 2. Leave drain holes open. Remove excess sealant With cloth and naphtha.
- e. Reposition stabilizer assembly with upper surface facing upwards.
- f. Seal all edges of both upper doublers as shown. Remove excess sealant with cloth and naphtha.
- g. Seal holes at leading and trailing edges of horizontal stabilizer adjacent to tip plates, LH and RH sides, as shown in Figure 1. Also seal holes in trailing edge of stabilizer at each side of light bracket, as shown in Figure 2.
- h. Repaint sealed areas; check that drain holes are open.
- i. Reinstall horizontal stabilizer assembly, per HMI-Vol I.
- j. Record compliance with this Service Notice in Compliance Record of helicopter Log Book.

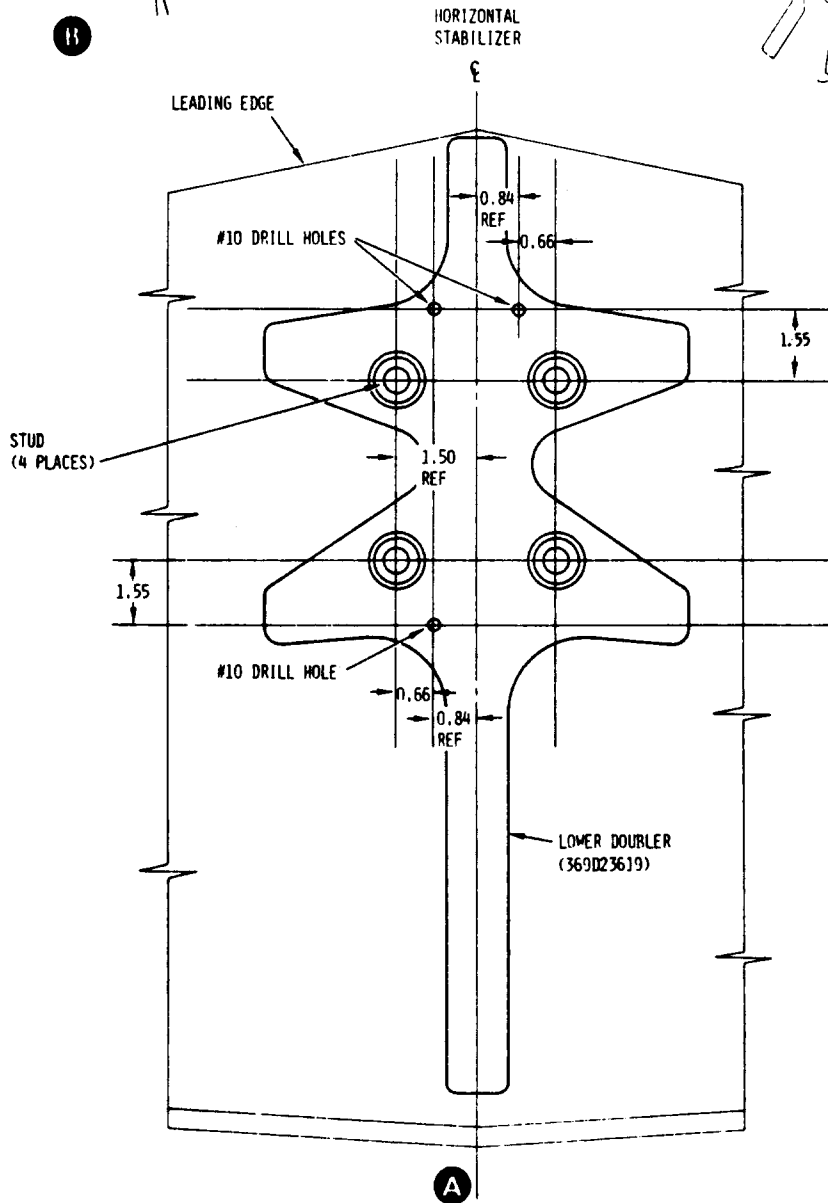
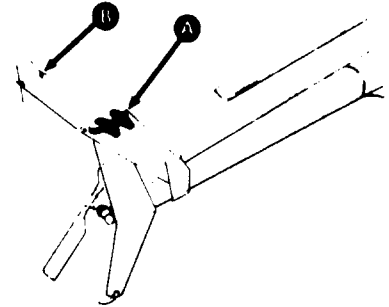
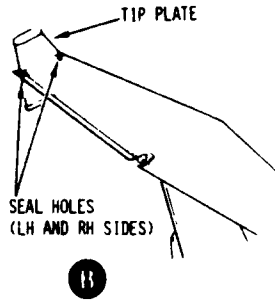
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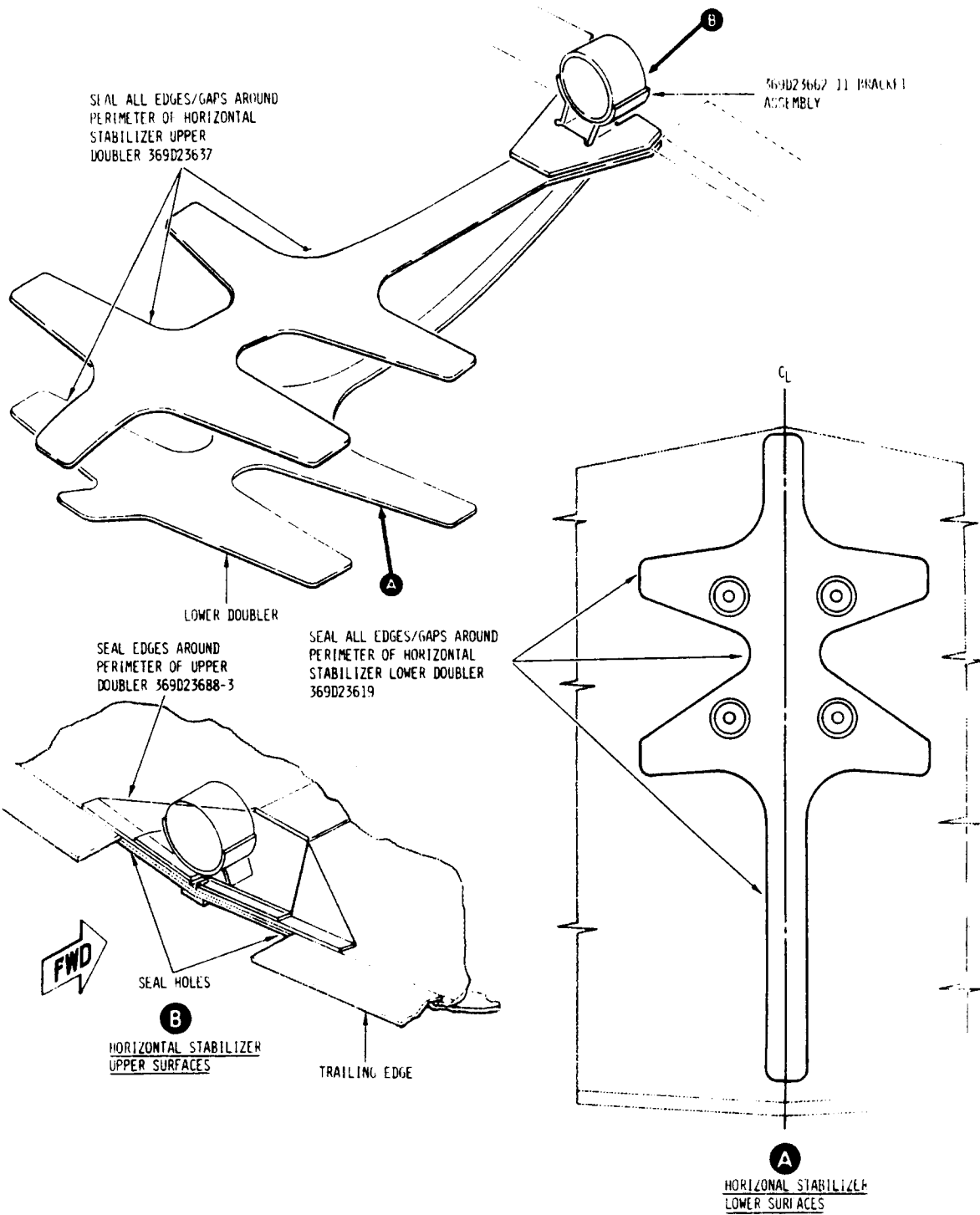
**Figure 1. Drilling of Drain Holes, Horizontal Stabilizer Lower Surface**

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**Figure 2. Horizontal Stabilizer - Sealing of Doubler Edges**

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