



# SERVICE BULLETIN

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**MANDATORY**

## TAILBOOM ASSEMBLY ATTACH FITTING ONE TIME INSPECTION AND REPAIR

### 1. PLANNING INFORMATION

**A. Aircraft Affected:**

Model 600N Helicopters, serial number RN003 thru RN063.

**B. Assembly/Components Affected By This Bulletin:**

Tailboom Attach Fitting (P/N 500N3422), Angle (P/N 500N3429-6), Clip (P/N 500N3427-7).

**C. Reason:**

Some 600N helicopter operators have reported cracked upper right-hand tailboom attach fittings.

Failure to comply with this Bulletin may result in eventual loss of tailboom and control of the helicopter.

**D. Description:**

Procedures in this Bulletin provide owners and operators with information pertaining to inspecting the tailboom attach fittings and repair of damaged fittings.

**E. FAA Approval:**

The technical design aspects of this Bulletin are FAA Approved.

**F. Manpower:**

Part 1 Inspection 0.5 man-hours.  
Part 2 Inspection and repair 8.0 man-hours.

**G. Time of Compliance**

The Part 1 Inspection requirements of this Bulletin shall be accomplished within the next five (5) hours of helicopter operation after receipt of this Bulletin or within thirty (30) days of the issue date of this Bulletin, whichever occurs first.

The Part 2 Inspection and repair requirements of this Bulletin shall be accomplished within the next twenty-five (25) hours of helicopter operation after receipt of this Bulletin or within ninety (90) days of the issue date of this Bulletin, whichever occurs first.

**H. Interchangeability:**

None

**I. Material/Part Availability:**

Part/supplies may be purchased locally from commercial sources.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Plug, Button	NAS451-47 (or equivalent)	2	Commercial
Rivet	MS20426AD4	2	Commercial

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REPLACEMENT PARTS/SUPPLIES (Cont.)			
Nomenclature	Part No.	Qty.	Source
Rivet (Monel)	MS20615-4M	8	Commercial
Sealing compound MIL-S-8802, MIL-S-8516 (or equivalent)	Pro-Seal 890, PR1422 (or equivalent)	AR	Commercial
Primer	MIL-P-23377 TII, C2 (or equivalent non-chlorinated primer)	AR	Commercial
Stainless steel, 301 1/4 hard, 0.032-0.040 in. thick, 1 in. wide, length to fit	AMS5517 or MIL-S-5059	1	Commercial
Washer	AN960C516 or NAS1149C0563R	2	Commercial
Washer	AN960C616 or NAS1149C0663R	2	Commercial
Rivet, blind	NAS1720H4 or CR6223-4 CR6253-4 (over sized)	AR	Commercial
Nutplate, tailboom attachment	FBL10001-5 or FBL10001-6 (attach with CR3212-4 rivets)	AR	Commercial
Acid-Gel Passivate	Pasa-Jell 101 (or equivalent)	AR	Commercial

**J. Warranty Policy:**

Standard warranty applies.

**K. Tooling:**

N/A

**L. Weight and Balance:**

N/A

**M. Electrical Load Data:**

N/A

**N. Other Publications Affected:**

N/A

**O. Points of Contact**

For further assistance, contact your local MDHI Field Service Representative (refer to the latest revision of the "At Your Service" handbook for address and telephone numbers) or contact the Field Service Department at MDHI, Mesa, Arizona. Telephone 1-800-388-3378 or (480) 346-6387. DATAFAX: (480) 346-6813.

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## 2. ACCOMPLISHMENT INSTRUCTIONS

### A. Part 1 Inspection

- (1). Remove tailboom fairing
- (2). Shake tailboom and observe mating surfaces of tailboom and fuselage flange.
- (3). Using a 0.002 inch feeler gauge, check for gap between tailboom and fuselage flange within 0.60 inch (15.3 mm) of centerline of each of the four attach bolts.
- (4). If no movement of tailboom is observed at fuselage mating flange and no gap exists between tailboom and fuselage flange at any tailboom attach bolt, reinstall tailboom fairing.
- (5). If movement of tailboom is observed at fuselage mating flange and or a gap exists between tailboom and fuselage flange at any tailboom attach bolt, contact MDHI Field Service Dept. and perform Part 2 Inspection and Repair below, prior to next flight.

### B. Part 2 Inspection and Repair

- (1). Remove tailboom (Ref. CSP-HMI-2, Section 53-30-40, Tailboom Removal)

**NOTE:** Use standard sheet metal practices.

- (2). Drill out rivets attaching **upper** left-hand and right-hand access covers.  
(Ref. Figure 1)
- (3). Inspect upper left-hand and right-hand tailboom attach fittings.
  - (a). Using 10X magnification and bright light inspect for cracks. Pay particular attention to area around aft rivet holes. No cracks are allowed.
  - (b). If any cracks are found, contact MDHI Field Service Dept. for replacement instructions.
- (4). Inspect two (2) upper left and right-hand tailboom attach nutplates.
  - (a). Inspect for thread damage and cracks.
  - (b). Cracks would appear from top of self-locking nut split to base of nut.
  - (c). Replace nutplate if threads are damaged or cracked.
- (5). Inspect angle.
  - (a). Using 10X magnification and bright light inspect for cracks. No cracks are allowed.
  - (b). If any cracks are found on left-hand angle, contact MDHI Field Service Dept. for repair/replacement instructions.



Use caution when removing and installing monel rivets. Do not drive out stems with punch. Damage to fitting may occur.

- (c). If any cracks are found on right-hand angle, proceed as follows:

(Ref. Figure 2)

- 1). Drill out top three rows of rivets (six rivets) securing outer skin below tailboom attach fitting and pull skin to access angle.
- 2). Drill out rivets securing clip to angle and tailboom attach fuselage flange. Remove clip.
- 3). Fabricate new clip from 301 1/4 hard stainless steel, as shown. (Ref. Figure 3).
- 4). Install new clip with two (2) MS20426AD4 and eight (8) MS20615-4M rivets. Install rivets wet with primer. (Ref. Figure 2).

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(Ref. Figure 4)

- (6). Modify left-hand and right-hand access covers.
  - (a). Locate, drill and deburr 0.75 inch (19.05 mm) hole in each cover as shown.
  - (b). Install plug button in hole and seal with sealing compound.
- (7). Remove all debris and close outer skin using blind rivets.
- (8). Install modified left-hand and right-hand access covers with blind rivets.
- (9). Install tailboom (Ref. CSP-HMI-2, Section 53-30-40, Tailboom Installation) except add one washer to each tailboom bolt between tailboom and NAS1587 countersunk washer. Ensure that minimum of two threads extend past nutplate.
- (10). Using a 0.002 inch feeler gauge, check for gap between tailboom and fuselage flange within 0.60 inch (15.3 mm) of centerline of each of the four attach bolts.1 No gap allowed. If gap exists, contact MDHI Field Service Dept.
- (11). Install tailboom fairing

### 3. IDENTIFICATION

N/A

### 4. DISPOSITION OF PARTS REMOVED

Return to MDHI Field Service Dept.

### 5. COMPLIANCE RECORD

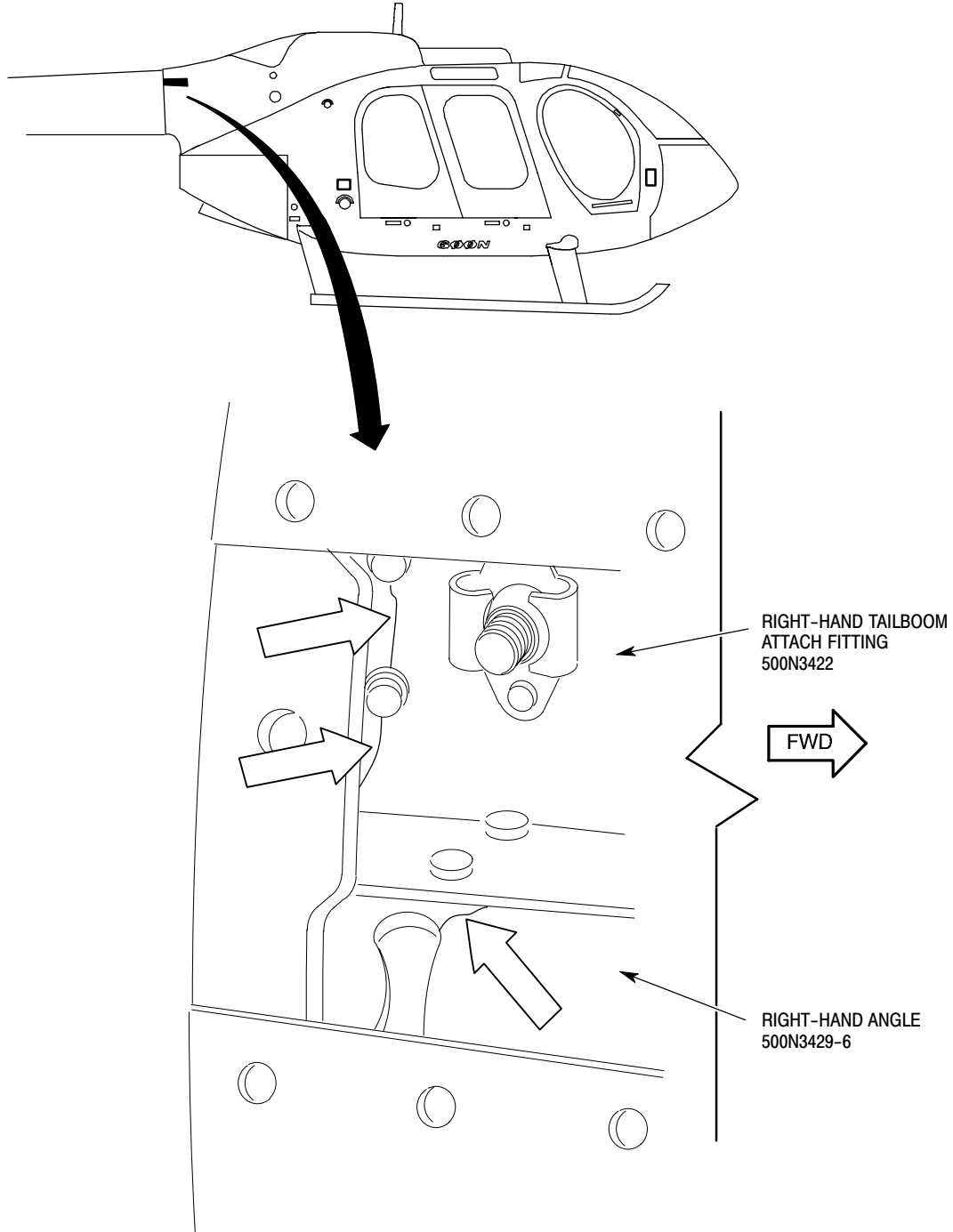
Record Compliance with this Service Bulletin in the Compliance Record section of the helicopter Log Book.

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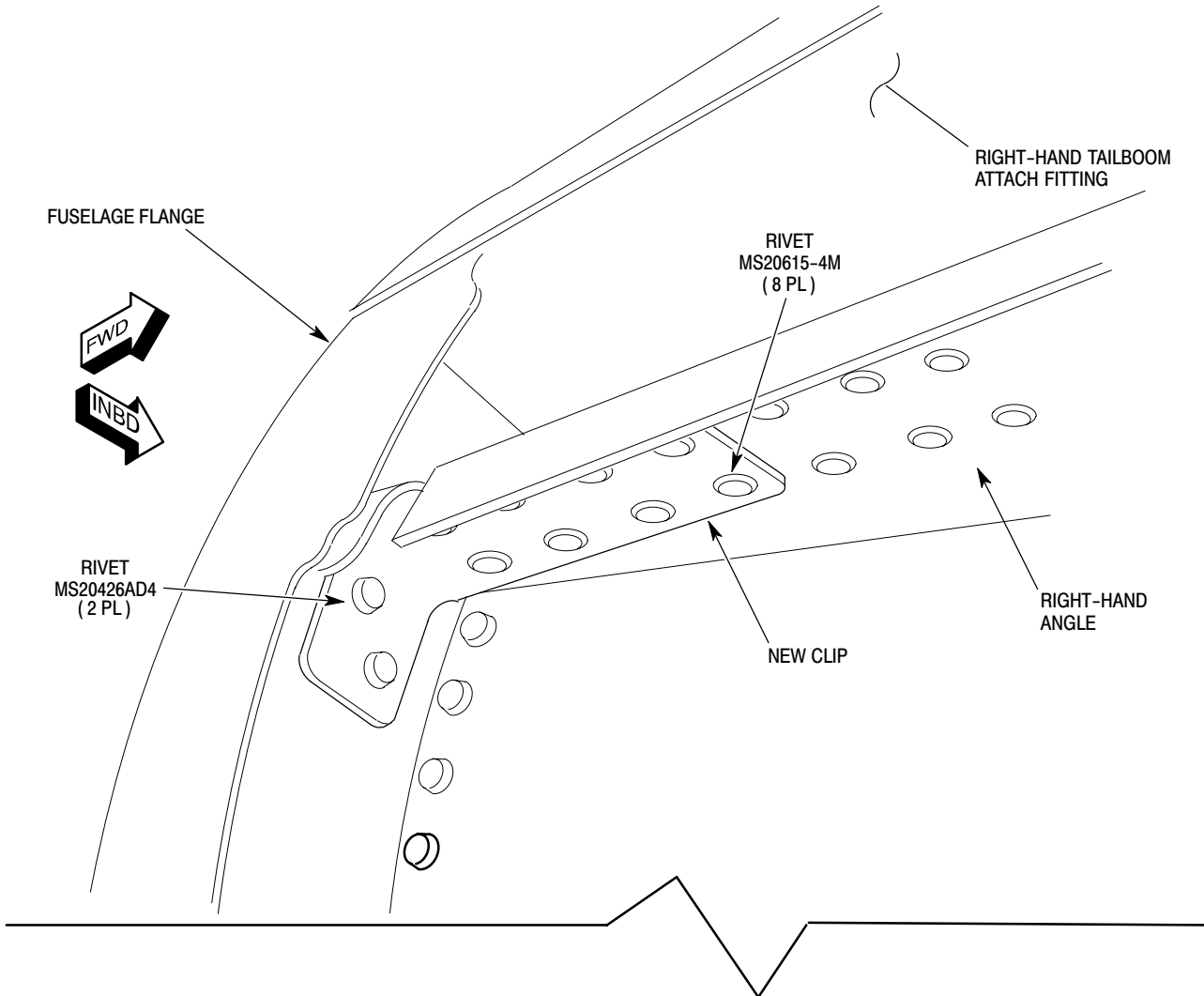
**Figure 1. Tailboom Attach Fitting and Angle Inspection**

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**Figure 2. Clip Installation**

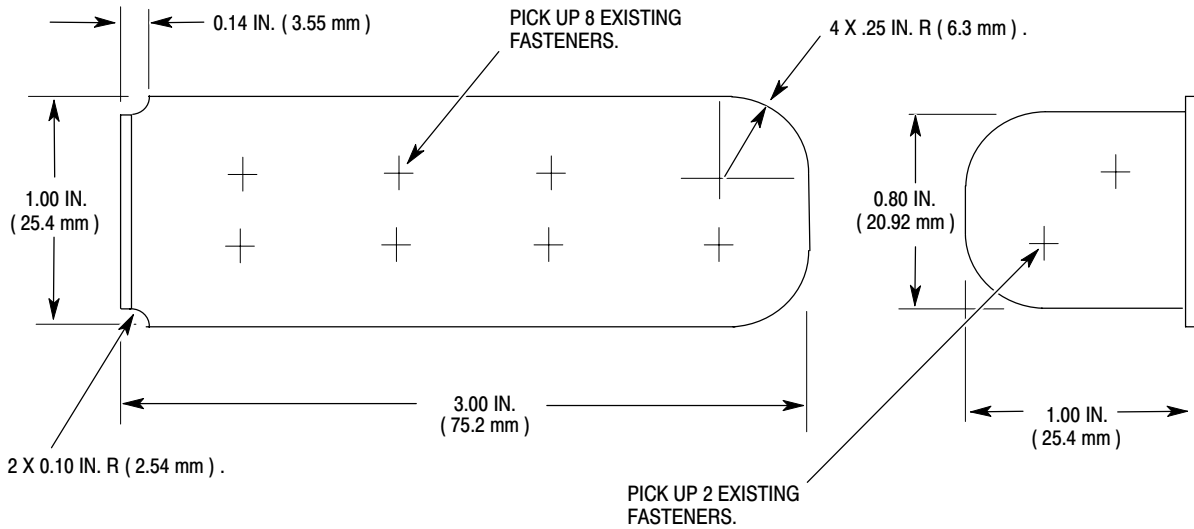
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MATERIAL: 301 CRES 1/4 HD AMS5517 0.032 OR 0.040 THICK.  
BEND RADIUS: 0.12 IN. R  
FINISH: ACID-GEL PASSIVATE AND EPOXY PRIME.

**Figure 3. Fabrication of Clip**

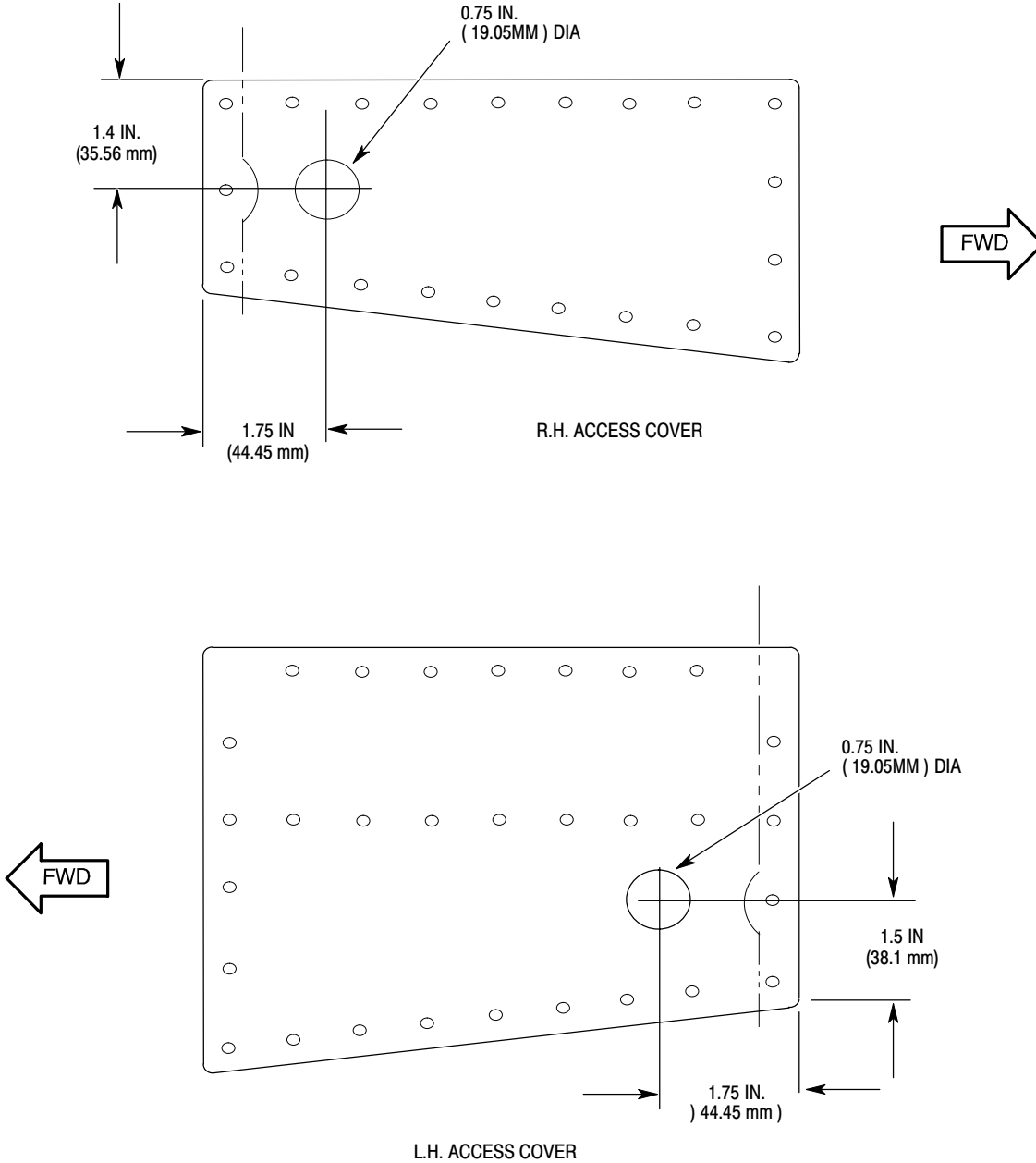
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**Figure 4. Modification of Access Panels**

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## BULLETIN TITTLE

**Bulletin Response Form:** Please fill in the following information, as applicable, and return to MDHI Field Service Department. This form may be faxed to MDHI Field Service Department at (480) 346-6813.

Operator or Company Name:

Name of Contact Person:

Address:

Telephone:

Fax:

Aircraft Ser. No.:

Aircraft Registration Number:

Date:

Date of Compliance:

Part 1. Comments/Information:

Part 2. Comments/Information:

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