



SERVICE BULLETIN

DATE: 9 DECEMBER 2003
PAGE 1 OF 6

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TAILBOOM ASSEMBLY ATTACH FITTINGS AND UPPER LONGERONS INSPECTION

1. PLANNING INFORMATION

A. Aircraft Affected:

Model 600N Helicopters, serial number RN003 thru RN059.

B. Assembly/Components Affected By This Bulletin:

Tailboom Attach Fitting (P/N 500N3422-BSC, -3), Upper Longeron (P/N 500N3120-3, -4).

C. Reason:

Analysis of the tailboom attach fittings and the upper longerons indicate that cracks may occur. 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 adding inspection holes in the fuselage and recurring inspections of the tailboom attach fittings and upper longerons for cracks.

E. FAA Approval:

The technical design aspects of this Bulletin are FAA Approved.

F. Manpower:

Part 1: 2.0 man-hours, Part 2 and 3: 1.0 man-hour.

G. Time of Compliance

Perform the requirements of this Bulletin according to the indicated schedule:

NOTE: For helicopter serial numbers RN003 thru RN059; ensure upper left-hand (LH) and right-hand (RH) tailboom attach fitting inspection holes (L167/R167) have been installed per MDHI Service Bulletin SB600N-036, prior to accomplishing this Bulletin.

Part 1 Aft Fuselage Inspection Hole Installation and Initial Inspection.

- Perform before the next 100 flight hours after receipt of this Bulletin or before 28 February 2004, whichever occurs first.

Part 2 Tailboom Attach Fittings Recurring Inspection.

- Upper Tailboom Attach Fittings - Perform every 25 flight hours.
- Lower Tailboom Attach Fittings - Perform every 100 flight hours.

Part 3: Upper Longerons Recurring Inspection.

- Perform every 1,200 flight hours.

H. Interchangeability:

None

/// MANDATORY ////////////////////////////////////// MANDATORY ////////////////////////////////////// MANDATORY ///

DATE: 9 DECEMBER 2003
PAGE 2 OF 6

SERVICE BULLETIN

/// MANDATORY ////////////////////////////////////// MANDATORY ////////////////////////////////////// MANDATORY ///

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)	6	Commercial
Sealing compound MIL-S-8802, MIL-S-8516 (or equivalent)	Pro-Seal 890, PR1422 (or equivalent)	AR	Commercial
Nutplate, Tailboom Attachment	FBL10001-5 or FBL10001-6 (attach with CR3212-4 rivets)	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:

Handbook of Maintenance Instructions (CSP-HMI-2).

O. Points of Contact

For further assistance, contact your local MDHI Field Service Representative or contact the Field Service Department at MDHI, Mesa, Arizona.
Telephone 1-800-388-3378 or (480) 346-6387.
DATAFAX: (480) 346-6813.



SERVICE BULLETIN

DATE: 9 DECEMBER 2003

PAGE 3 OF 6

/// MANDATORY ////////////////////////////////////// MANDATORY ////////////////////////////////////// MANDATORY ///

2. ACCOMPLISHMENT INSTRUCTIONS

(Ref. Figure 1)

A. Part 1: Aft Fuselage Inspection Hole Installation and Initial Inspection

- (1). Add inspection holes and visually inspect lower LH and lower RH tailboom attach fittings.
 - (a). Locate, drill and deburr two 0.75 inch (19.05 mm) holes (L166/R166) for inspection of LH and RH lower tailboom attach fittings as shown.
 - (b). Remove all debris.
 - (c). Using bright light, visually inspect for cracks. Pay particular attention to area around aft rivet holes, as shown. No cracks are allowed. If any cracks are found, contact MDHI Field Service Department before next flight.
 - (d). Install plug button in each inspection hole and seal with sealing compound.
- (2). Add inspection holes and visually inspect upper LH and RH longerons.
 - (a). Locate, drill and deburr two 0.75 inch (19.05 mm) holes (L153/R153) for inspection of upper left-hand and right-hand longerons as shown.
 - (b). Remove all debris.
 - (c). Using bright light and mirror or borescope, inspect bottom surface of longerons for cracks. Pay particular attention to area around four rivet holes, as shown. No cracks are allowed. If any cracks are found, contact MDHI Field Service Department before next flight.
 - (d). Install plug button in each inspection hole and seal with sealing compound.
- (3). Add inspection holes for lower LH and RH longerons.
 - (a). Locate, drill and deburr two 0.75 inch (19.05 mm) holes (L158/R158) for inspection of lower left-hand and right-hand longerons as shown.
 - (b). Remove all debris.
 - (c). Install plug button in each lower longeron inspection hole and seal with sealing compound.
 - (d). Refer to CSP-HMI-2, Section 05-20-20, Special Inspections for inspection requirements for lower LH and RH longerons.

B. Part 2: Tailboom Attach Fittings Recurring Inspection.

- (1). Remove plug buttons from inspection holes L167/R167 (upper fittings) or L166/R166 (lower fittings), as required.
- (2). Using bright light, visually inspect upper fittings and angles or lower fittings, as required, for cracks. Pay particular attention to area around aft rivet holes, as shown. No cracks are allowed. If any cracks are found, contact MDHI Field Service Department before next flight.
- (3). Using bright light, visually inspect tailboom attach nutplates for thread damage and cracks. Cracks would appear from top of self-locking nut split to base of nut. Replace nutplate if threads are damaged or cracked.

/// MANDATORY ////////////////////////////////////// MANDATORY ////////////////////////////////////// MANDATORY ///



SERVICE BULLETIN

MANDATORY

- (4). Install plug button in each inspection hole and seal with sealing compound.

C. Part 3: Upper Longerons Recurring Inspection.

- (1). Remove plug buttons from inspection holes L153/R153.
- (2). Using bright light and mirror or borescope, visually inspect bottom surface of longerons for cracks. Pay particular attention to area around four rivet holes, as shown. No cracks are allowed. If any cracks are found, contact MDHI Field Service Department before next flight.
- (3). Install plug button in each inspection hole and seal with sealing compound.

3. IDENTIFICATION

N/A

4. DISPOSITION OF PARTS REMOVED

N/A

5. COMPLIANCE RECORD

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

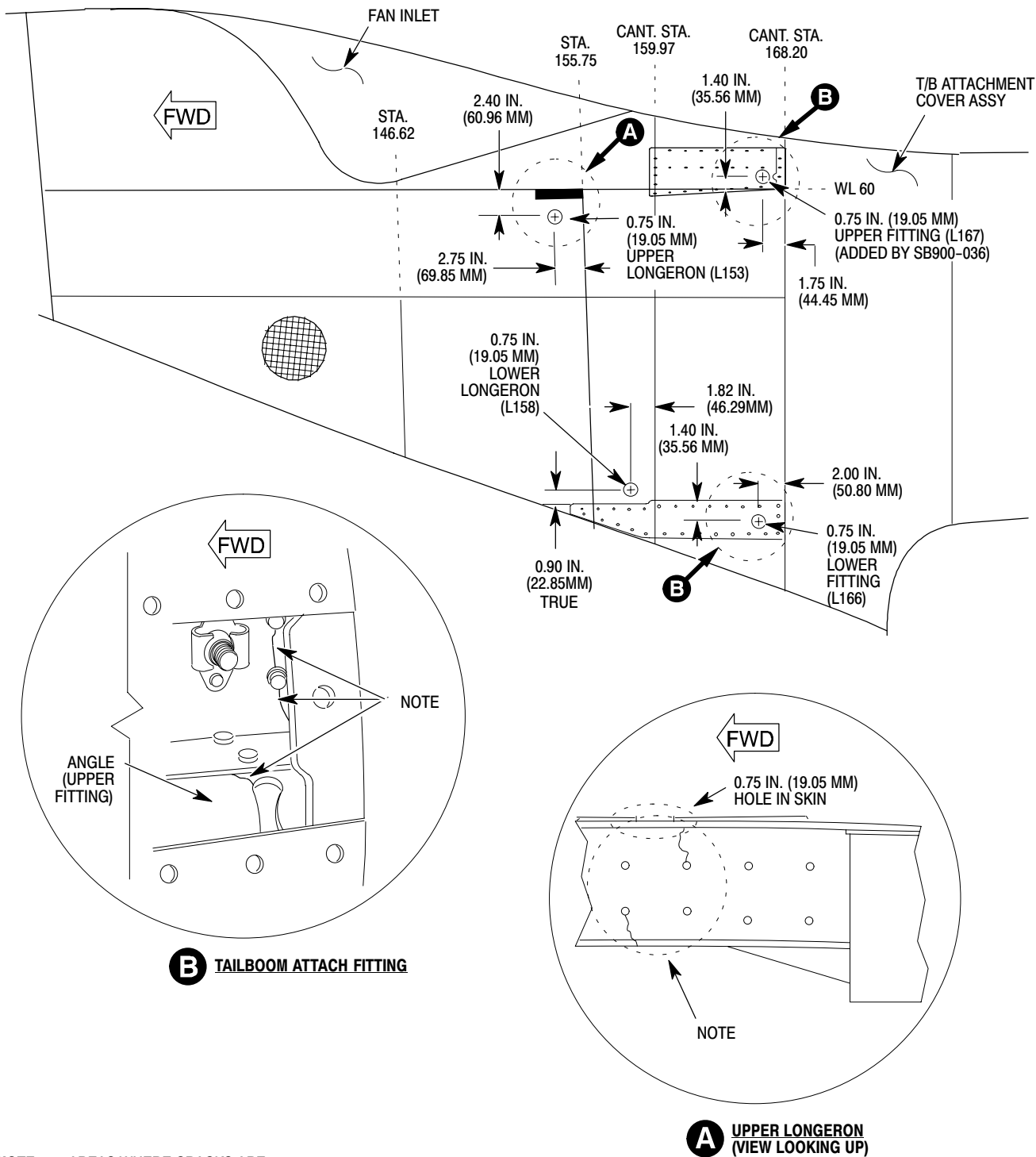
MANDATORY

SERVICE BULLETIN

DATE: 9 DECEMBER 2003

PAGE 5 OF 6

MANDATORY MANDATORY MANDATORY



NOTE: AREAS WHERE CRACKS ARE MOST LIKELY TO APPEAR.

88-803

Figure 1. Lower Tailboom Attach Fittings and Upper Longerons Inspection

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