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TECHNICAL BULLETIN

DATE: 1 JUNE 1979

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SUBJECT: INSTALLATION OF STAINLESS STEEL ABRASION TAPE, PN 369D21104 - MAIN ROTOR BLADE LEADING EDGE

MODELS AFFECTED: 500D Model 369D Helicopter Serial No. 0003D and subs

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: The information given in this Service Information Notice lists a procedure for installing stainless steel abrasion tape to the leading edge of the main rotor blades. Installation of the stainless steel abrasion tape is recommended for blades which are subject to a highly abrasive environment, so that blade life will not be reduced by erosion.

It is to be noted that Rotorcraft Flight Manual Supplement CSP-D-1S must be incorporated in the Flight Manual when helicopter is operated with Main Rotor Blade Abrasion Tape Kit Part No. 369D21104 installed.

REFERENCE PUBLICATIONS:

500D HMI - Volume I, Issued 15 September 1976; Revision No. 2, 27 November 1978.

500 D Rotorcraft Flight Manual Supplement No. CSP-D-1S, Dated 21 May 1979.

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PART LIST

Nomenclature	Part No.	Qty	Mfr
Abrasion tape, stainless steel (6.5 in. wide x 0.0027 in thick):			
30 ft length roll	87-369D21104	1	HH
or			
100 ft length roll	88-369D21104	1	HH

MATERIALS

Solvent - aliphatic naphtha	TT-N-95 (Standard No. 200 Thinner)	Commercial
Abrasive paper - 400 grit		Commercial

TOOLS AND EQUIPMENT

Heat gun or equivalent

INSTALLATION PROCEDURE - ABRASION TAPE

- a. Lightly abrade laying surface of main rotor blade with 400 grit abrasive paper. (See Figure 1.)
- b. Wipe faying surface of blade with solvent to eliminate grease or dirt film.
- c. Use heat gun or equivalent to warm blade laying surface; temperature is not to exceed 120°F.
- d. Remove backing and apply stainless steel abrasion tape to outboard leading edge of main rotor blade as follows:
 - 1). Apply the 6.50 inch wide and 24.00 inch long abrasion tape along blade leading edge, as shown, so that tape overlap over bottom and top of blade edge is equal.



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- 2). Smooth and press abrasive tape into place by hand, using heat gun or equivalent to maintain temperature.
- 3). Reapply pressure by hand following initial installation to ensure proper bonding; the abrasive tape must be free of surface wrinkles or air bubbles.

NOTE

A second abrasion tape may be applied on top of the first tape at owner/operator option, to facilitate future replacement when top tape becomes eroded. Perform step e below, if installation of second abrasion tape is desired for all blades.

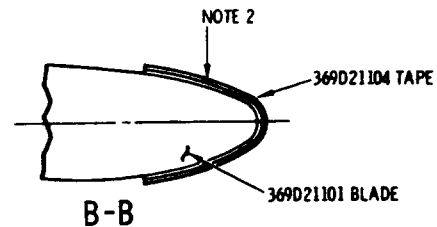
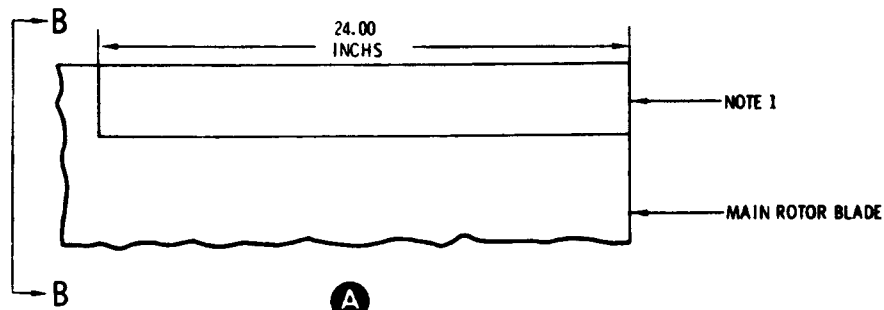
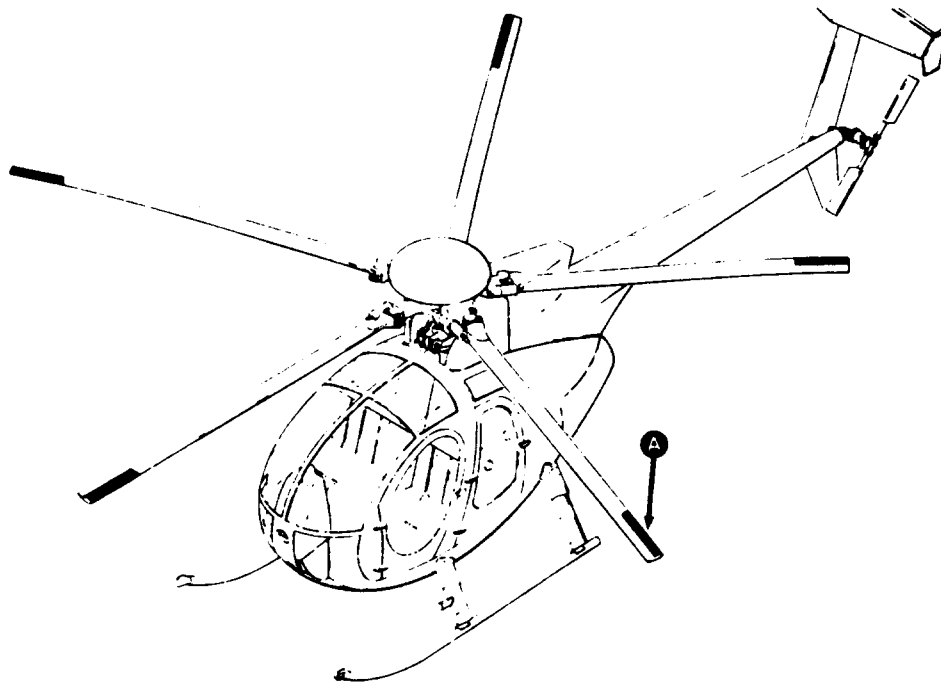
- e. Apply a second abrasion tape, by wiping surface of installed strip with solvent and repeating steps c and d above. Abrasion tape must be evenly aligned at top surface of blade as shown.
- f. Check installation of stainless steel abrasion tape for discrepancies.
- g. Insert RFM Supplement CSP-D-1S in Rotor craft Flight Manual, Section IX.

WEIGHT AND BALANCE:

Weight and balance not affected.

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NOTES:

1. END OF TAPE TO BE FLUSH WITH OUTBOARD END OF BLADE SKIN. TAPE TO BE SYMMETRICAL ABOUT LEADING EDGE.
2. ABRASION TAPE MUST BE ALIGNED AT TOP PART OF BLADE.

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Figure 1. Installation of Stainless Steel Abrasion Tape, PN 369D21104, Main Rotor Blade Leading Edge