



SERVICE LETTER

DATE: 3 JANUARY 1997
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BAGGAGE DOOR WINDOW INSTALLATION

MODELS AFFECTED: All McDonnell Douglas Helicopter Systems (MDHS) MD900 Series Helicopters.

At the discretion of the owner/operator, the baggage door vent cover may be removed and replaced with transparent window material. Instructions in this Letter provide customers with details to modify the baggage door vent opening to eliminate airflow either in or out of the baggage area.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Window, Baggage Door	900P2250135-101	1	Field Fabricate Locally
Gasket, Door Window	900P2250136-101	1	Field Fabricate Locally
Doubler, Door Window	900P2250137-101	1	Field Fabricate Locally

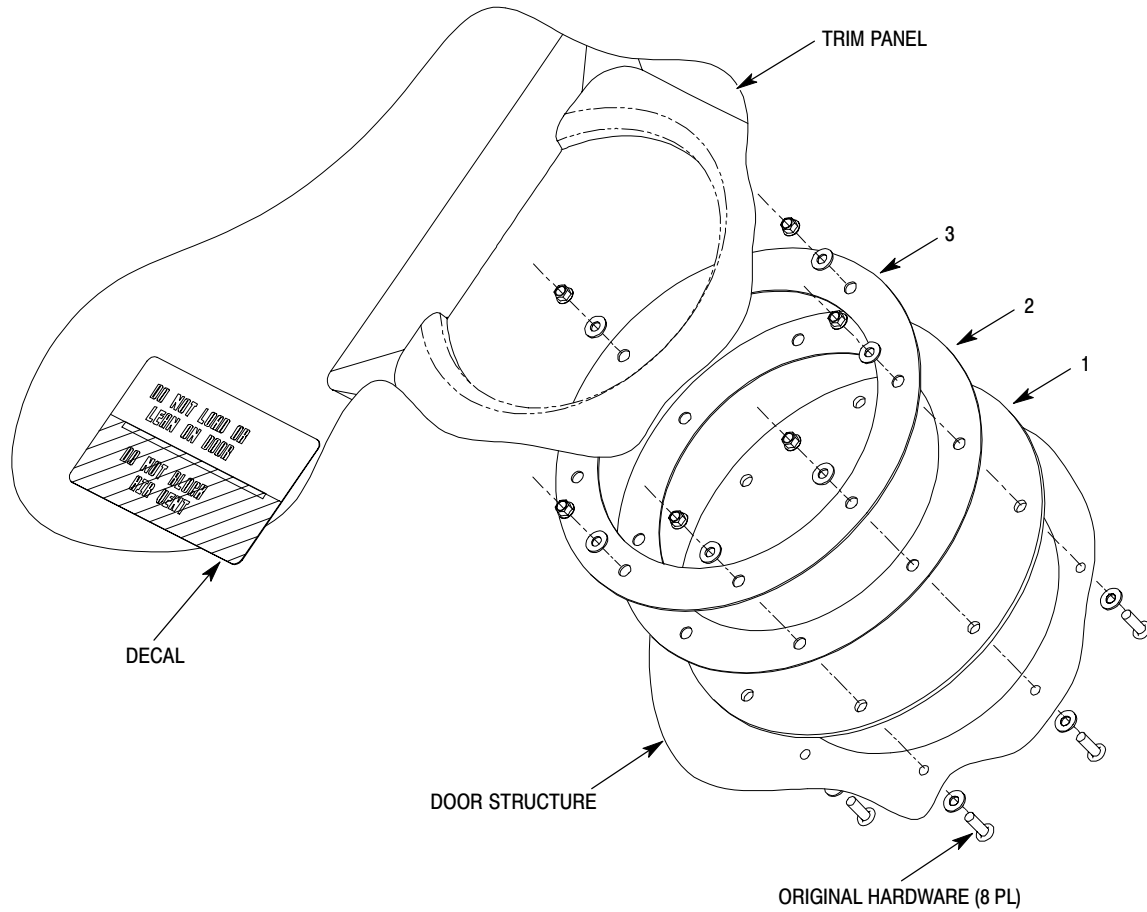
1. ACCOMPLISHMENT INSTRUCTIONS:

(Ref. Figure 1)

- A. Remove baggage door interior trim panel (Ref. CSP-900RMM-2, Section 25-50-00, Door Trim Panel Removal).
- B. Remove vent cover and retain original hardware for installation of window.
- C. Fabricate window, gasket and doubler per information in Figure 2.
- D. Install window (1), gasket (2) and doubler (3) onto door structure using original hardware per Figure 1.
- E. Install baggage door interior trim panel (Ref. CSP-900RMM-2, Section 25-50-00, Door Trim Panel Installation).
- F. Remove lower portion of existing decal, or paint over lower portion using flat black paint. Remaining decal should read: "Do Not Load Or Lean On Door."

POINTS OF CONTACT: For further assistance, contact your local MDHS Field Service Representative (refer to the Business Development and Customer Support handbook for address and telephone numbers) or contact the Field Service Department at MDHS, Mesa, Arizona. Telephone: 1-800-388-3378 or (602) 891-6342. DATAFAX: (602)891-6782.

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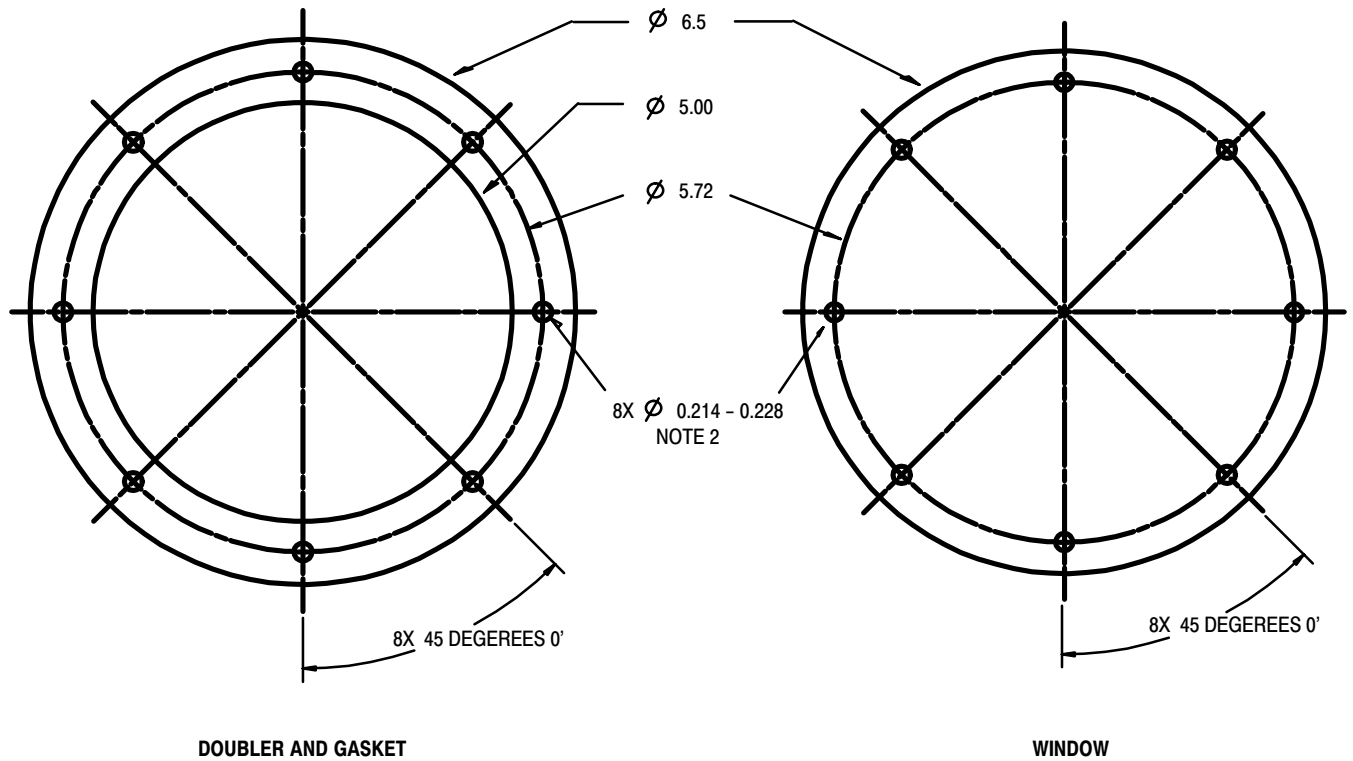
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- 1. WINDOW
- 2. GASKET
- 3. DOUBLER

Figure 1. Baggage Door Window Installation

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NOTES:

- NOTE 1: ALL DIMENSIONS ARE IN INCHES
- NOTE 2: USE EXISTING VENT AS TEMPLATE TO HELP DRILL HOLES
- NOTE 3: DOUBLER MATERIAL; AL-ALY SH ALCD, 2024-T3, 0.040 INCH THK, QQ-A-250/5 OR EQUIVALENT
- NOTE 4: GASKET MATERIAL; SILICONE SHEET, CL 2B GR 50 BLK, 0.031 INCH THK, ZZ-R-765 OR EQUIVALENT
- NOTE 5: WINDOW MATERIAL; CLEAR POLYCARBONATE PLASTIC SHEET, 0.090 INCH THK, AMS3611 OR EQUIVALENT

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Figure 2. Window, Doubler, Gasket, Fabrication and Layout