

SERVICE LETTER

DATE: 7 APRIL 2011

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* Supersedes Service Letter SL900-065R1, dated 15 October 2010. Changed to add washers Part Numbers (PN AN960JD616L) and (PN NAS1149D0663J).

INSTALLATION OF ENGINE GROUND STUDS

MODELS AFFECTED: MD900 helicopter serial numbers 900-00008 thru 900-000143.

This Service Letter is issued to recommend that operators inspect starter/generator ground studs for arcing, corrosion, and looseness at the next annual inspection. This inspection is necessary to find loose ground studs, or corrosion or arcing that can cause a starter/generator problem. The ground studs are located on the engine deck: right-hand GS402 at STA 225.45 BL 23.12 and left-hand GS403 at STA 228.67 BL -5.15 (ref. Figure 1).

If arcing or corrosion is found, the wire lug and its interfaces must be cleaned.

Corrosion cannot be more than **0.012 inch (0.30 mm) deep**. If corrosion on the doubler is more than this limit, contact the Field Service Department at MDHI, and remove and replace the doubler.

If no corrosion is found, but the grounding stud is loose, torque the ground stud to **110 in-lb (12.4 Nm)**.

If there is no arcing, corrosion, or looseness, inspect again at the next annual inspection.

To decrease the possibility of incorrect torque, MDHI will no longer use NAS1635-6-16 Phillips-head screws with three AN960JD616L flat washers at each of the starter/generator grounds. AN6C7A hex-head bolts with three NAS1149D0663J flat washers will be used as alternative ground studs on Rotorcraft SN 900-000144 and subsequent. AN6C7A bolts and NAS1149D0663J washers can be purchased commercially by the operator and can be installed on all rotorcraft without modification.

NOTE: If the NAS1635-6-16 screws and AN960JD616L washers are replaced with AN6C7A bolts and NAS1149D0663J washers, you do not have to do the next or future annual inspections.

NOTE: Electrical Bond Test is to be preformed, Class R. (Ref CSP-SPM-20-50-00).

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

Legend (Ref. Figure 1)

1. SCREW (NAS1635-6-16)
2. BOLT (AN6C7A)
3. WASHER (AN960JD616L)
4. WASHER (NAS1149D0663J)
5. LOCKWASHER (MS35338-141)
6. NUT (MS25082-6)
7. NUT (MS21042-6)
8. WIRING HARNESS (W141 SHOWN)

NOTE: If necessary add washer. (4).

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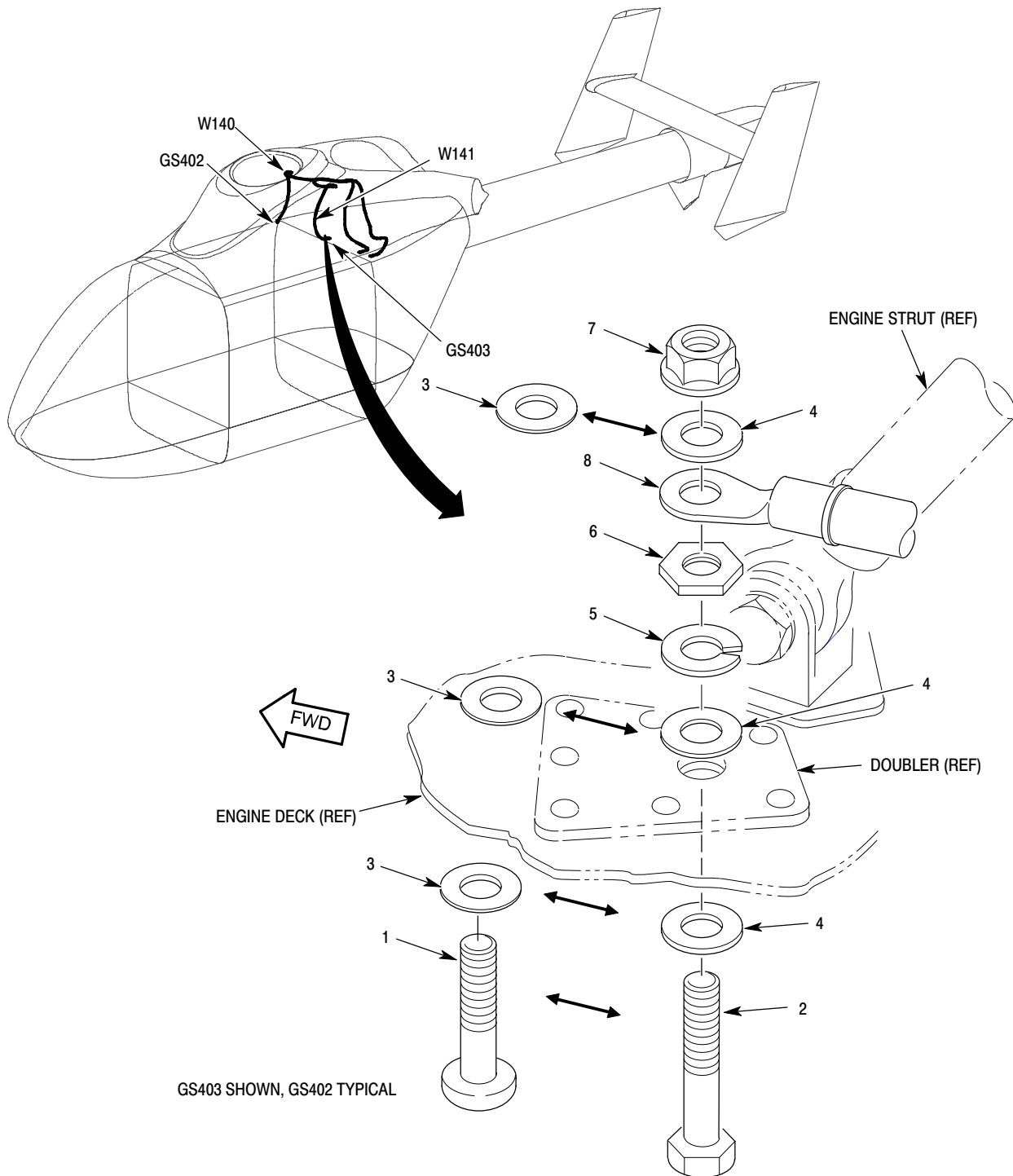


Figure 1. Stack-up of Ground Studs at GS402 and GS403

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