

SERVICE LETTER

DATE: 14 JANUARY 2010

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THRUSTER ASSEMBLY WASHER MODIFICATION

MODELS AFFECTED: All MD900 helicopters.

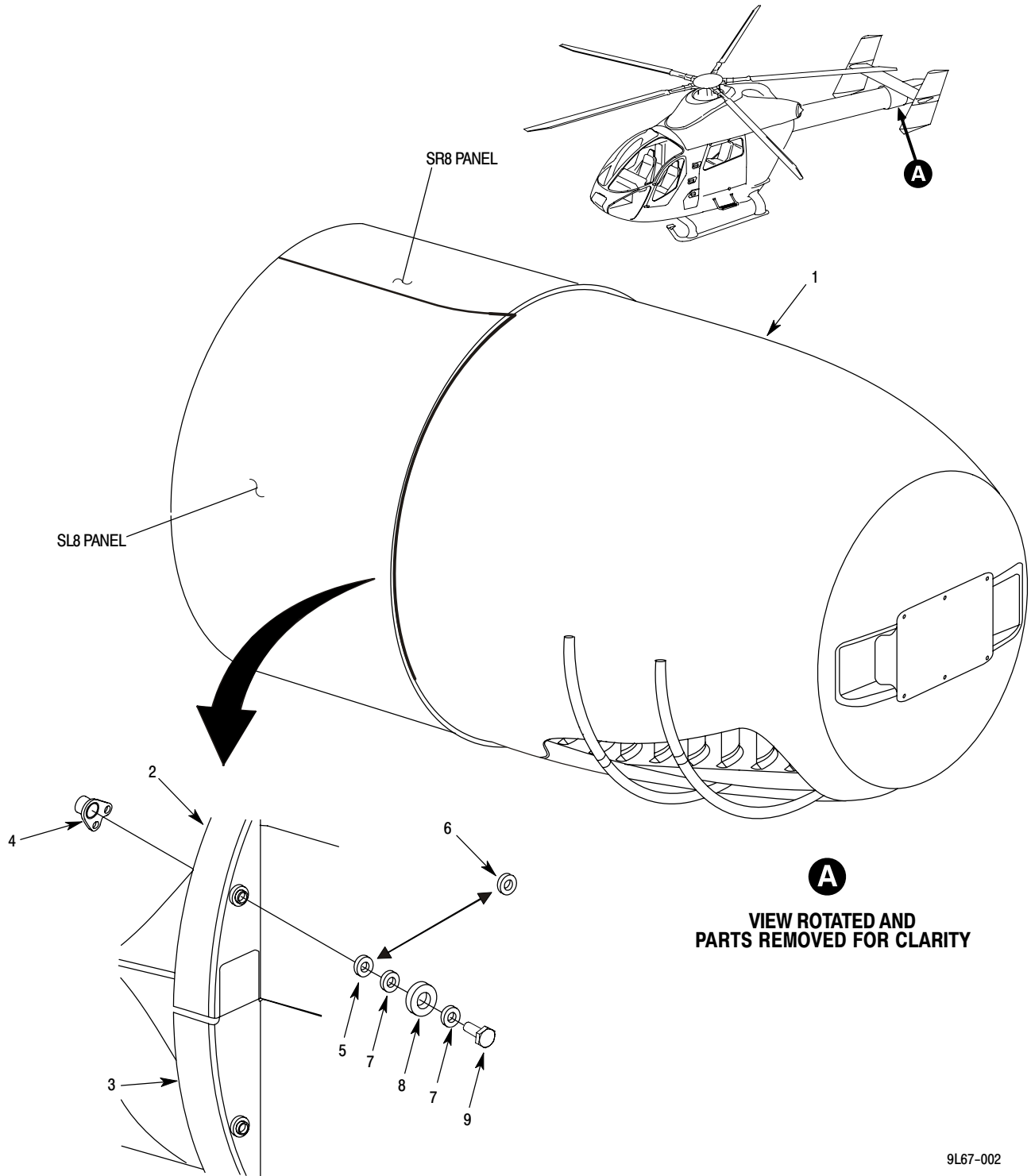
This service letter is issued to tell owners and operators that the control bearing (ref. Figure 1) for the rotating cone assembly may not move freely because the attaching bolts have been over-torqued during installation. Torque more than **30 in-lb (3.4 Nm)** can cause the nylon flat washers to extrude and cause an interference with bearing rotation. At the next bearing inspection/replacement interval, MDHI recommends the removal of flat nylon washers, PN NAS1515H3L (5), and their replacement with corrosion-resistant steel (CRES) flat washers, PN NAS1149C0363R (6). The CRES flat washers are thicker and provide increased clearance from the face of the thruster bulkhead.

At the next access to, or during scheduled maintenance to the control bearings, replace flat nylon washers with CRES flat washers. Install control bearings with new washer in the thruster assembly. Correctly torque bolts **15 to 20 in-lb (1.7 to 2.3 Nm)** plus run-on torque to get the correct locking torque on the nutplate. If it is necessary to remove remaining axial play of the stack-up, torque bolts to **24 in-lb (2.7 Nm)** maximum.

Legend (Ref. Figure 1)

1. ROTATING CONE ASSY
2. UPPER BULKHEAD ASSY
3. LOWER BULKHEAD ASSY
4. NUTPLATE
5. FLAT NYLON WASHER
6. CRES FLAT WASHER
7. FLAT WASHER
8. CONTROL BEARING
9. BOLT

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Figure 1. Location of Thruster Assembly Washer Modification

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