



SERVICE BULLETIN

DATE: 6 MAY 2003

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MANDATORY

CABIN FLOOR ATTACH POINTS INSPECTION AND REWORK

1. PLANNING INFORMATION:

A. Aircraft Affected:

MD900 helicopters, serial number 900-00008 thru 900-00085, 900-00088 thru 900-00092, 900-00100 thru 900-00102.

B. Assembly/Components Affected By This Bulletin:

Left Keel Beam (P/N 900F2307525), Right Keel Beam (P/N 900F2307526)

C. Reason:

There have been reports of deformation and delamination of the composite material in the area of the center cabin floor attach holes in the left and right keel beams.

Failure to comply with instructions in this bulletin may result in damage to the floor support structure and floor panels.

D. Description:

Procedures in this Bulletin provide owners and operators with information pertaining to inspecting the left and right keel beams and if required, adding doublers on the lower surface of the left-hand and right-hand upper keel beam flanges.

E. Time of Compliance:

The requirements of this Bulletin shall be accomplished at the next annual inspection or no later than one (1) year after the issue date of this Bulletin, whichever occurs first.

F. FAA Approval:

The technical design aspects of this Bulletin are FAA Approved.

G. Manpower:

Forty (40) man-hours, if rework is required.

H. Interchangeability:

None

I. Material/Part Availability:

The parts/supplies listed below may be purchased locally from commercial sources.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Rivet	MS20605R3W	188	Commercial
Nutplate	NAS1474R3	94	Commercial

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REPLACEMENT PARTS/SUPPLIES (Cont.)			
Nomenclature	Part No.	Qty.	Source
Screw	NAS7903A04	94	Commercial
0.016 x 0.90 x 36.0 inch (0.4064 x 22.86 x 914.4 mm) 301 CRES Steel, 1/4 or 1/2 HD or 0.020 x 0.90 x 36.0 inch (0.508 x 22.86 x 914.4 mm) 301 CRES Steel, 1/4 or 1/2 HD		6	Commercial
Alcohol, Isopropyl		AR	Commercial
Primer, Epoxy (MIL-P-85585, Type 1, Class 2) or (MIL-P-23377, Type 1, Class C)		AR	Commercial
Acid-Gel Passivate	Pasa-Jell 101 (or equivalent)	AR	PRC-Desoto International, Inc. 5454 San Fernando Rd. Glendale, CA 91203 (818) 240-2060
Adhesive, Epoxy (MDM16-1068, Class 12)	EA9321 (or equivalent)	AR	Dexter Adhesive & Coating Systems, Hysol & Frekote Products One Dexter Dr. Seabrook, NH 03874-4018
Sandpaper, 180 grit		AR	Commercial
Solvent Cleaner	Desoclean 45	AR	PRC-Desoto International, Inc. 5454 San Fernando Rd. Glendale, CA 91203 (818) 240-2060
Epoxy Resin, Structural (MDM16-1 115, T3)	Redux 501	AR	Ciba-Geigy Corp. E. Lansing, MI (800) 367-8793

J. Warranty Policy:

If rework is required, MDHI will credit affected operators with up to forty (40) hours of labor warranty (spares credit).

K. Tooling:

N/A

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L. Weight and Balance:

N/A

M. Electrical Load Data:

N/A

N. Other Publications Affected:

Illustrated Parts List (CSP-900IPL-4)

2. ACCOMPLISHMENT INSTRUCTIONS:

A. Preparation Instructions

- (1). Remove cabin floor outboard panels (AL165 and AR165) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Panel Removal).
- (2). Remove cabin floor forward panel (A160) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Forward Panel Removal).
- (3). Remove cabin floor center panel (A170) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Panel Removal).
- (4). Remove cabin floor aft panel (A217) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Aft Removal).

B. Inspection Instructions

- (1). Lay a straight edge length-wise, across floor panel attach holes, on left-hand and right-hand keel beams.
- (2). Using a 0.002 inch (0.0508 mm) flat gauge, check for gaps between straight edge and keel beam between floor panel attach holes.
 - (a). If no gaps are present, reinstall floor panels, using original screws per paragraph D. Completion Instructions.
 - (b). If gaps are present, perform the rework instructions below.

C. Rework Instructions

- (1). Fabricate doublers.
 - (a). Fabricate six (6) doublers from 0.016 or 0.020 X 0.90 X 36.0 inch (0.4064 or 0.508 X 22.86 X 914.4 mm) 301 1/4 or 1/2 hard steel.
 - (b). Trim doublers (3 per keel beam) as required to center between nutplates on lower surface of upper flange of left-hand and right-hand keel beams and butt together on installation.
 - (c). Finish doublers with Acid-Gel Passivate per manufacturer's instructions.
- (2). Remove existing nutplates from lower surface of upper flange of left-hand and right-hand keel beams.
- (3). Lightly sand any cracked holes in upper flange of left-hand and right-hand keel beams to remove all loose fibers around holes.

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- (4). Resin wash sanded areas, as required, with structural epoxy resin per manufacturer's instructions.
- (5). Position doublers on lower surface of upper flange of left-hand and right-hand keel beams and clamp into place.
- (6). Match drill all nutplate retention holes and screw holes using #40 bit (0.098 inch (2.4892 mm)) diameter in doublers.
- (7). Remove clamps and doublers.
- (8). Ream screw holes in doublers to 0.191/0.197 inch (4.8514/5.0038 mm) diameter.
- (9). Deburr all holes in doublers.
- (10). Lightly abrade lower surface of upper flange of left-hand and right-hand keel beams with sandpaper until surface gloss of laminate is removed. Do not sand into fibers.
- (11). Prepare doublers for bonding.
 - (a). Wipe doublers with wiper dampened with solvent cleaner or isopropyl alcohol.
 - (b). Wipe dry with clean, dry wiper and air dry for 15 minutes at ambient temperature.
 (Ref. Figure 1)
- (12). Bond doublers in place on lower surface of upper flange of left-hand and right-hand keel beams.
 - (a). Use cleco fasteners to align nutplate rivet holes and secure doublers during bonding.
 - (b). Bond doublers with epoxy adhesive per manufacturer's instructions.
 - (c). Perform coin tap inspection on all doublers, no voids allowed (Ref. CSP-SPM, Section 20-90-00, Coin Tap Inspection).
- (13). Install new nutplates with rivets through keel beam flange and doublers. Install rivets wet with epoxy primer.

D. Completion Instructions

NOTE: Use new longer length screws to attach floor panels to reworked left-hand and right-hand keel beams in the following steps.

- (1). Install cabin floor aft panel (A217) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Aft Installation).
- (2). Install cabin floor center panel (A170) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Panel Installation).
- (3). Install cabin floor forward panel (A160) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Forward Panel Installation).
- (4). Install cabin floor outboard panels (AL165 and AR165) (Ref. CSP-900RMM-2, Section 53-20-00, Cabin Floor Center Panel Installation).

3. DISPOSITION OF PARTS REMOVED:

Scrap.

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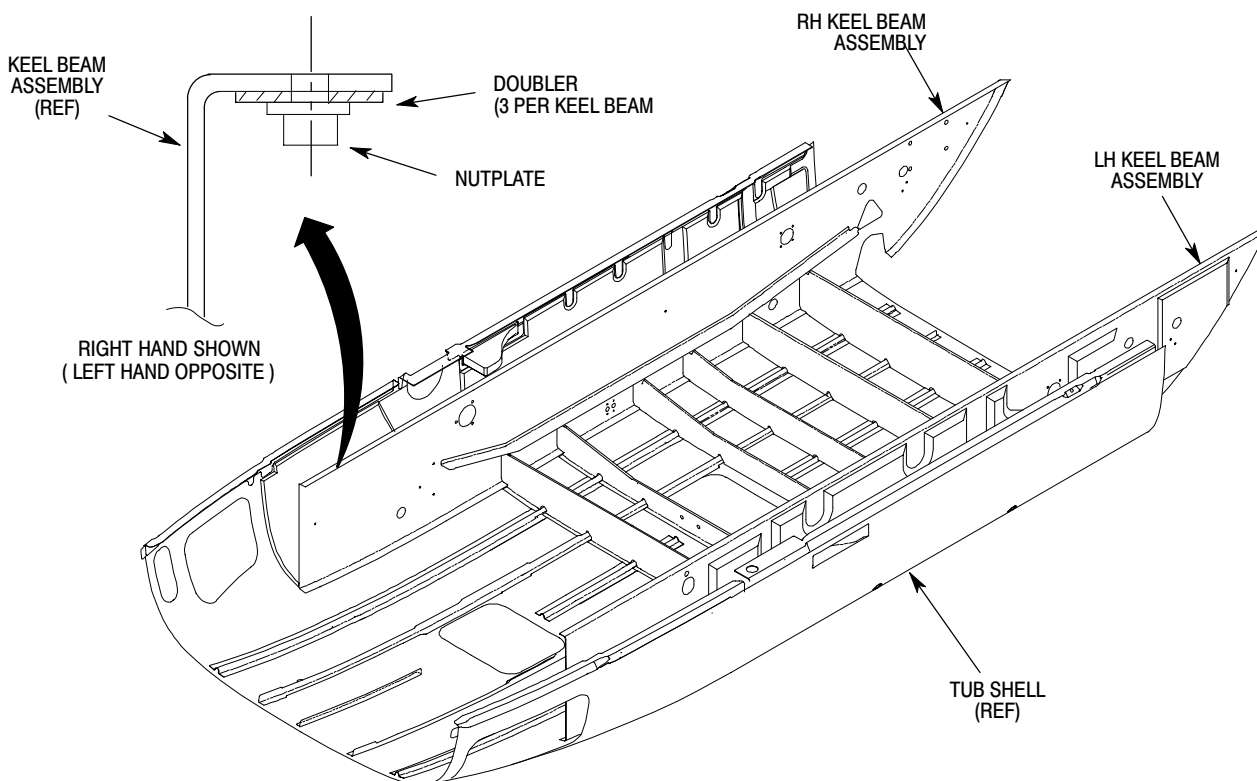
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4. COMPLIANCE RECORD:

Record compliance to this Service Bulletin in the Compliance Record section of the helicopter Log Book and complete and return the Bulletin Response Form.

5. 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.



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Figure 1. Installation of Doublers

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Bulletin Response Form: Please fill in the following information, and return to MDHI Field Service Department. This form may be faxed to MDHI Field Service Department at (480) 346-6813.

Operator or Company Name:

Name of Contact Person:

Address:

Telephone:

Fax:

Aircraft Ser. No.:

Aircraft Registration Number:

Date:

Date of Compliance:

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