



TECHNICAL BULLETIN

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VSCS ACTUATOR MOUNTING BRACKET REPAIR

1. PLANNING INFORMATION

A. Aircraft Affected:

All McDonnell Douglas Helicopter Systems (MDHS) MD900 helicopters, serial number 900-00010 thru 900-00051.

B. Assembly/Components Affected By This Notice:

VSCS actuator attach bracket part number 900F2341255-101.

C. Reason:

Aircraft in the field have experienced working of the VSCS actuator attach bracket attachment fasteners. Failure to repair this condition could result in the loss of control of the horizontal endplates on that side.

D. Description:

Procedures in this Bulletin provide owners and operators with instructions to replace their existing six (6) fastener VSCS actuator attach bracket part number 900F2341255-101 with an improved ten (10) fastener attach bracket part number 900F2341255-103, -104.

E. Time of Compliance:

Customer option, at the discretion of the owner/operator.

F. Classification:

Compliance with this Bulletin is a major alteration.

G. FAA Approval:

The technical design aspects of this Bulletin are FAA Approved.

H. Manpower:

Two (2) manhours.

I. Interchangeability:

None

J. Disposition of Parts Removed

Return to MDHS

K. Points of Contact

For further assistance, contact your local MDHI Field Service Representative (refer to the latest revision of the "At Your Service" handbook for address and telephone numbers) or contact the Field Service Department at MDHI, Mesa, Arizona. Telephone 1-800-388-3378 or (480) 891-6342. DATAFAX: (480) 891-6782.

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L. Material/Part Availability:

Contact MDHS Field Service Dept.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Actuator Attach Bracket, LH	900F2341255-103	1	The Boeing Co.
Actuator Attach Bracket, RH	900F2341255-104	1	The Boeing Co.
Rivet Installation Gun	230	1	Huck or Commercial
Rivet Pulling Head	99-680	1	Huck or Commercial
Cobalt Drill Bit	#19	5	Commercial
Primer	MIL-P-23377, T1, C1 (Boeing Ref. RM012212)	AR	The Boeing Co. or Crown Metro Greenville, SC (803) 277-1870 or DeSoto Aerospace Coatings, Inc. Berkeley, CA (818) 549-7823
Fastener, Blind Bolt	HS5912-05-05	10	The Boeing Co. or Commercial
Fastener, Blind Bolt	HS5912-06-05	AR	The Boeing Co. or Commercial

M. Warranty Policy:

None

N. Tooling:

N/A

O. Weight and Balance:

N/A

P. Electrical Load Data:

N/A

Q. Other Publications Affected:

Rotorcraft Maintenance Manual (CSP-900RMM-2, and CSP-900IPL-4).

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2. ACCOMPLISHMENT INSTRUCTIONS

This repair procedure is typical and may be used for either left or right VSCS actuator bracket.

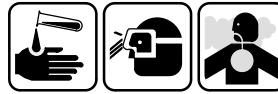
(Ref. Figure 1)

(1). Remove VSCS from inboard attach bracket (Ref. CSP-900RMM-2 Section 67-20-00).

(2). Remove existing VSCS actuator bracket.

NOTE: If bracket is attached with Visu-Loc fasteners, hold rivet head while drilling to prevent rotation of fastener.

Protective Equipment



- (a). Using a number 40 drill, drill through rivet center stem.
- (b). With a **0.094 inch (2.39mm)** punch, remove rivet stem lock ring.
- (c). Using a number 19 drill bit, drill through rivet body to a depth slightly greater than the thickness of the rivet head.
- (d). If rivet head has not come off, remove by inserting a **0.156 inch (3.96mm)** punch into the previously drilled hole and levering the rivet head until it breaks off.



Back up area adjacent to rivet with hard wood, or other suitable substance prior to driving out rivet body.

- (e). Using a **0.156 inch (3.96mm)** punch, drive the remainder of the rivet body out of the rivet hole.
- (f). Inspect hole diameter **0.167 inch (4.24mm)** maximum. If hole is above maximum limit, install next size larger fastener. Maximum fastener diameter not to exceed **0.199 inch (5.06 mm)**.

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- (3). Using new bracket locate bracket mounting holes in horizontal stabilizer assembly.



Back up area of new hole location with hard wood, or other suitable substance prior to drilling mounting holes.

- (4). Drill additional mounting rivet holes to a number 19 drill.
(5). Position bracket in horizontal stabilizer assembly.

Primer (C310)

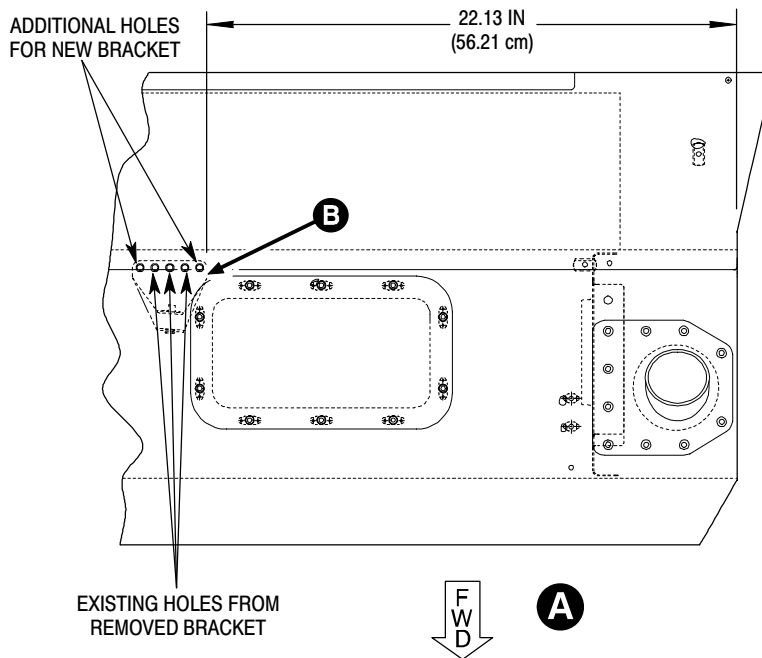
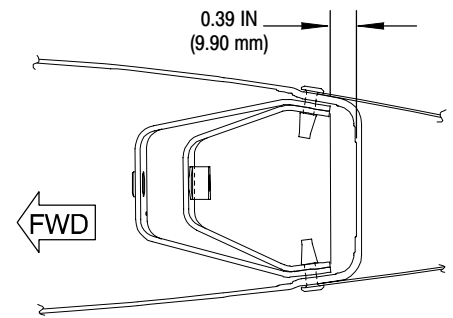
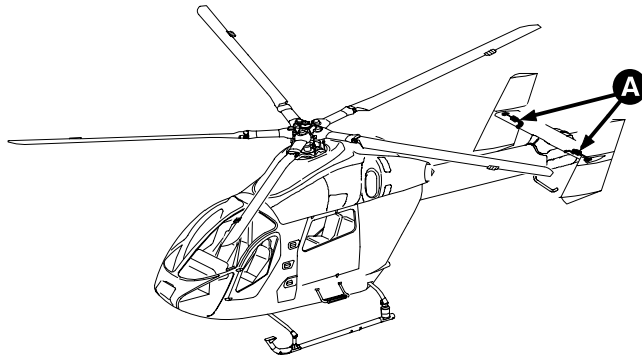


- (6). Install fasteners into horizontal stabilizer assembly and bracket. Wet install fasteners using primer MIL-P-23377.
(7). Connect VSCS actuator to new VSCS bracket (Ref. CSP-900RMM-2 Section 67-20-00).
(8). Perform a VSCS Operational Test (Ref. CSP-900RMM-2 Section 67-20-00).
(9). Record compliance to this Technical Bulletin in the Compliance Record section of the helicopter Log Book.

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B
LOOKING INBOARD
LEFT SIDE

9B53-076

Figure 1. VSCS Actuator Attach Bracket Replacement



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VSCS Actuator Mounting Bracket Repair

Parts Request Form: Please fill in the following information and return to MDHS for parts/supplies required for compliance. This form may be faxed to MDHS Warranty and Repair Department at (602) 891-3952.

Aircraft Ser. No.:

Aircraft Total Time:

Date:

Parts Required:

Part Ser. No. (if required):

Ship to: