



TECHNICAL BULLETIN

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RAIN GUTTER MODIFICATION

* Supersedes Service Letter SL900-023R1, dated 3 January 1997.

1. PLANNING INFORMATION

A. Aircraft Affected:

All MD900 helicopters.

B. Assembly/Components Affected By This Bulletin:

Track Assembly, LH, Door Upper (P/N 900F2305803-105), Track Assembly, RH, Door Upper (P/N 900F2305803-106).

C. Reason:

Leakage around the upper left and right-hand cabin doors has been reported.

D. Description:

Procedures in this Bulletin provide owners and operators with information pertaining to installation of additional rain gutters to prevent leakage.

E. FAA Approval:

The technical design aspects of this Bulletin are FAA Approved.

F. Manpower:

Eight (8.0) man-hours.

G. Time of Compliance

Customer option, at owner/operator discretion.

H. Interchangeability:

None

I. Material/Part Availability:

Parts/supplies may be purchased from MDHI or locally from commercial sources.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
2024-T3 Aluminum Sheet .025 Thick		AR	Commercial
Primer, Epoxy MIL-P-23377		AR	Commercial
Paint, Top Coat (to Match Modified Area)		AR	Commercial
Sandpaper, 280 Grit or Finer		AR	Commercial

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REPLACEMENT PARTS/SUPPLIES (Cont.)			
Nomenclature	Part No.	Qty.	Source
Chemical Film, Iridite or Equivalent		AR	Commercial
Rivet	NAS1919M04S	AR	Commercial
Rivet	MS20426AD3	AR	Commercial
Rivet	MS20426AD3	AR	Commercial
Rivet	MS20470AD3	AR	Commercial
Decal, No Step	MHS5814-12 (or equivalent)	4	MDHI/Commercial

J. Warranty Policy:

N/A

K. Tooling:

N/A

L. Weight and Balance:

N/A

M. Electrical Load Data:

N/A

N. Other Publications Affected:

N/A

O. 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) 346-6387. DATAFAX: (480) 346-6813.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Prepare Aircraft

- (1). Remove three vertical blind rivets immediately forward of forward end of door track.
- (2). Remove flush rivets attaching aft door track roller guide.
- (3). Remove any other flush rivets in the door track that would interfere with rain gutter installation.

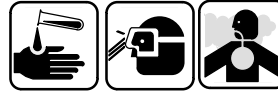
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B. Fabricate rain gutter and Flashing:

(Ref. Figure 1 and Figure 2)

CAUTION: Protective Equipment



- (1). Cut aluminum sheet to match flat patterns.
- (2). Break all sharp edges.

NOTE: Check aircraft for existing hole locations that might interfere with pilot hole locations, and adjust rivet pattern as necessary.

- (3). Locate and drill pilot holes in rain gutter flat pattern.
- (4). Deburr all holes.
- (5). Bend flat patterns to match detail parts.

C. INSTALL RAIN GUTTER AND FLASHING:

(Ref. Figure 1)

- (1). Locate rain gutter on top of door track and drill through any existing holes in door track and cleco in place.
- (2). Drill pilot holes through rain gutter and door track, cleco in place.
- (3). Locate flashing on top of rain gutter aligning front foot over existing three holes in fuselage and placing the inboard edge up under the existing rain gutter.

NOTE: Some hand forming of the flashing is required to make flashing foot contour to fuselage.

- (4). Transfer existing holes from door track, rain gutter, and fuselage to flashing.
- (5). Remove rain gutter and flashing.

NOTE: The three forward rivets attaching the rain gutter to the flashing are not flush rivets.

- (6). Deburr all holes, and countersink all holes in underside of door track to 100°.

CAUTION: Chemical Film



- (7). Apply chemical film to door track rivet holes, rain gutter, and flashing per manufacturers instructions.

CAUTION: Epoxy Primer and Coating



- (8). Paint rain gutter and flashing with primer and allow to dry.

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NOTE: Place a bead of sealant under existing rain gutter prior to installation of flashing (Ref. Figure 1 view A).

- (9). Rivet rain gutter and flashing to aircraft using same size and type rivets as removed. Install all rivets with wet epoxy primer. All new rivets to remain number three in diameter.

CAUTION: Sealing Compound



(Ref. Figure 1)

- (10). Seal all edges with sealant and build a dam of sealant in door track inside flashing overhang.
- (11). Touch up top coat to match aircraft.
- (12). Install NO STEP decal (or equivalent) to upper surface of flashing, two places each side.

3. IDENTIFICATION

N/A

4. DISPOSITION OF PARTS REMOVED

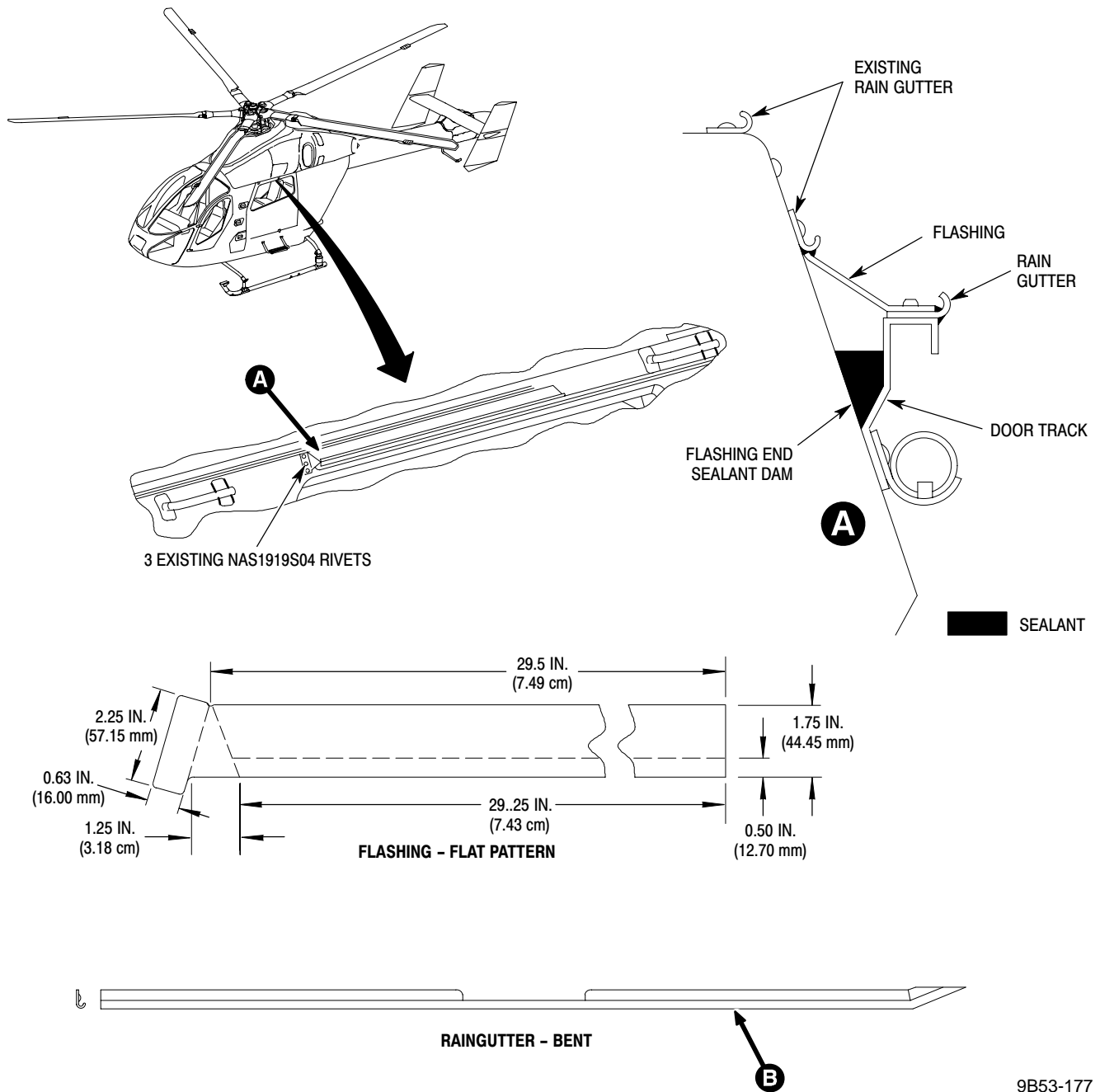
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5. COMPLIANCE RECORD

Record compliance to this Technical Bulletin in the Compliance Record section of the helicopter Log Book.

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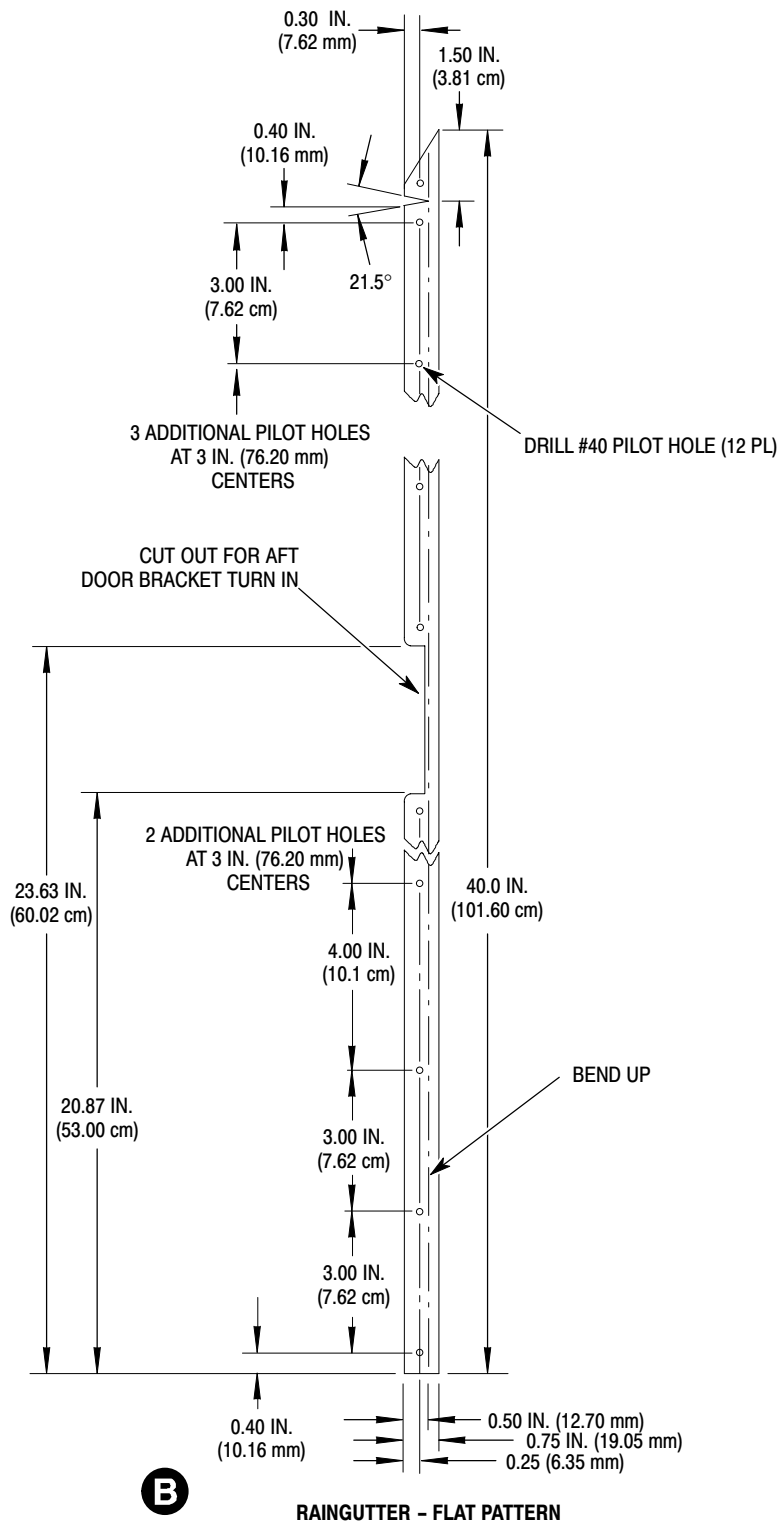
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Figure 1. Rain Gutter and Flashing Installation, and Flashing Detail

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Figure 2. Rain Gutter Flat Pattern