



TECHNICAL BULLETIN

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CABIN DOOR MODIFICATION

1. PLANNING INFORMATION

A. Aircraft Affected:

All MD900 helicopters.

B. Assembly/Components Affected By This Bulletin:

Cabin Door Assembly, LH (P/N 900F7305202-105, -107), Cabin Door Assembly, RH (P/N 900F7305202-106, -108).

C. Reason:

To allow flight with the cabin door(s) open at a sustained speed of up to 100 kts.

D. Description:

Procedures in this Bulletin provide owners and operators with information pertaining to modification of the LH and RH cabin doors to install strengthened upper fittings.

E. FAA Approval:

The technical design aspects of this Bulletin are FAA Approved.

F. Manpower:

6.0 man-hours.

G. Time of Compliance

Customer option, at owner/operator discretion.

H. Interchangeability:

None

I. Material/Part Availability:

Contact MDHI Parts Sales Dept.

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Fitting, Upper Cabin Door	900F2305223-1 11	4	MDHI
Decal, 100 kt Capability	900N2200052-101	4	MDHI
Pin-Rivet, Threaded, Protruding Shear Head, Hex Point	MHS5537V08-4	12	MDHI
Collar-Pin, Rivet, Threaded Al Alloy	MHS5540-08	12	MDHI
Sealant, Conductive (MDM16-1261)	Cho-bond 2165	AR	Chomerics, Inc. 77 Dragon Court Woburn, MA 01801 (781-935-4850)



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REPLACEMENT PARTS/SUPPLIES (Cont.)			
Nomenclature	Part No.	Qty.	Source
Cement, Epoxy	EC1300L	AR	3M Co. Bldg. 223-N 3M Center St. Paul MN 55144-1000 (612) 733-1110 (800) 362-3550
Epoxy, Clear	Epibond 1217	AR	Vantico, Inc. 4917 Dawn Avenue East Lansing MI 48823 (800) 367-8793

J. Warranty Policy:

Standard warranty policy applies.

K. Tooling:

N/A

L. Weight and Balance:

MODIFICATION	WEIGHT Pounds (kg)	LONGITUDINAL ARM Inches (cm)	LATERAL ARM Inches (cm)
Cabin Door Modification	0.8 (0.363)	189.35 (480.95)	0 (0)

M. Electrical Load Data:

N/A

N. Other Publications Affected:

Illustrated Parts List (CSP-900IPL-4)

CSP-900RFM-1, Rotorcraft Flight Manual (900 Configuration with PW206A).

CSP-900ERFM-1, Rotorcraft Flight Manual (900 Configuration with PW206E S/N 0041 & 0042).

CSP-900RFM207E-1, Rotorcraft Flight Manual (900 Configuration with PW207E).

CSP-902RFM-1, Rotorcraft Flight Manual (902 Configuration with PW206E).

CSP-902RFM207E-1, Rotorcraft Flight Manual (902 Configuration with PW207E).

O. 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.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Modification

- (1). Remove cabin doors (Ref. CSP-900RMM-2, Section 52-00-00, Cabin Door Assembly Removal).



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- (2). Remove and retain components from upper door fittings (Ref. CSP-900RMM-2, Section 52-00-00, Door Upper Fitting Components Removal).
- (3). Remove upper door fittings from cabin doors. Retain washers and laminated washers, discard pin rivets and collars.
- (4). Install new upper fittings on cabin doors using new pin rivets and collars and retained washers and laminated washers. Install pin rivets in forward fittings wet with conductive sealant.
- (5). Touch up finish, if required (Ref. CSP-SPM, Section 20-30-00, Application of Epoxy Primer (MIL-P-85582, Type 1, Class 2)).
- (6). Apply topcoat to new upper fittings and touched up areas (Ref. CSP-SPM, Section 20-30-00, Application of Polyurethane Coating (MIL-C-83286) or Application of Finish Enamel Coating (MDM15-1100)).
- (7). Install retained components on upper door fittings (Ref. CSP-900RMM-2, Section 52-00-00, Door Upper Fitting Components Installation).
- (8). Install 100 kt Capability decals.
 - (a). Install one decal on each upper door fitting using epoxy cement per manufacturer's instructions.
 - (b). Apply clear epoxy to placard per manufacturer's instructions.
- (9). Install cabin doors (Ref. CSP-900RMM-2, Section 52-00-00, Cabin Door Assembly Installation).

3. IDENTIFICATION

N/A

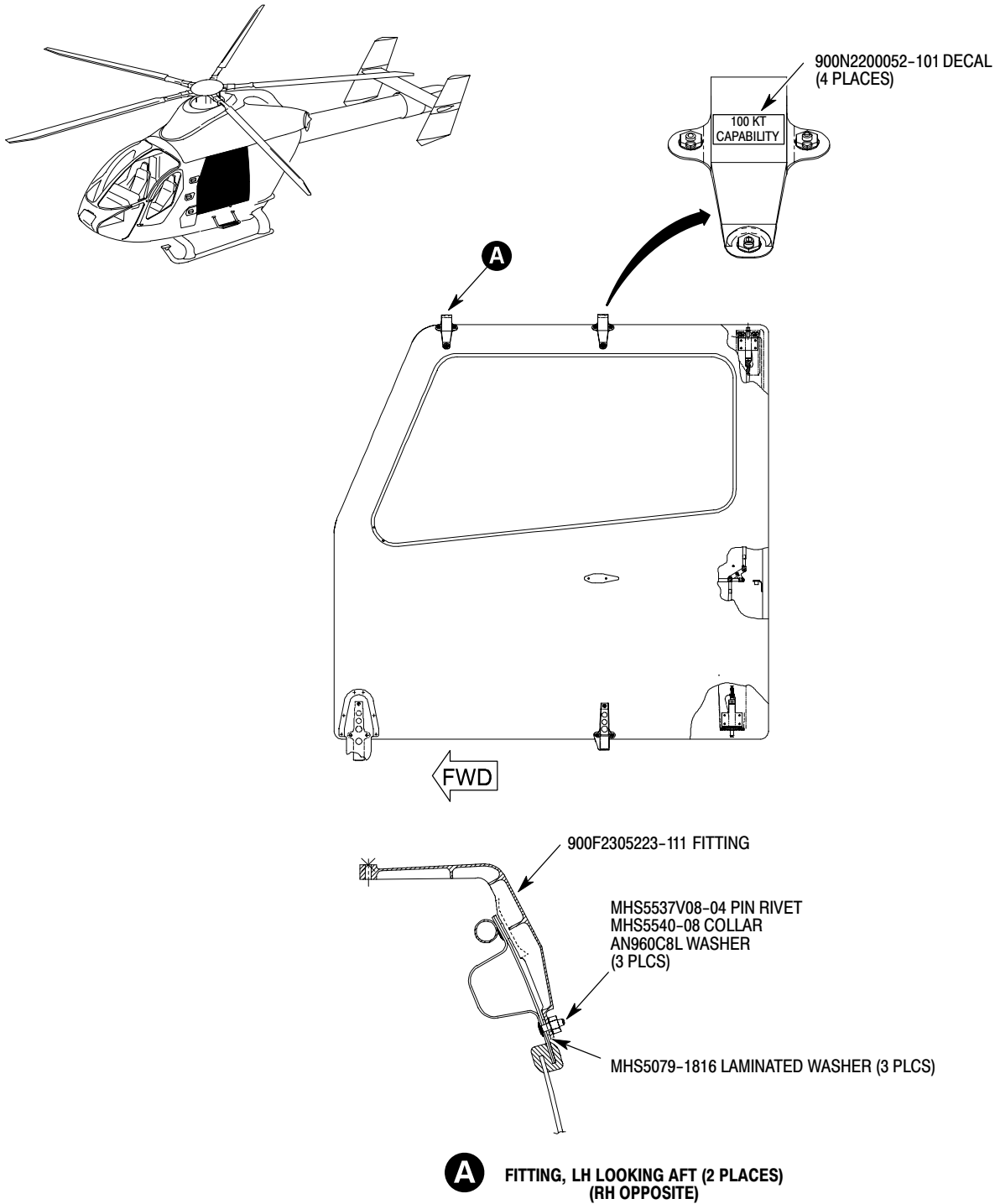
4. DISPOSITION OF PARTS REMOVED

Scrap

5. COMPLIANCE RECORD

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

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Figure 1. Cabin Door Modification