

**R22 SERVICE LETTER SL-56**

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**R44 SERVICE LETTER SL-32**

**DATE:** 16 March 2007    **REVISION A:** 29 March 2007

**TO:** All R22 Owners, Operators, and Service Centers

**SUBJECT:** Main Rotor Blade Bond Inspection and Maintenance

**BACKGROUND:** Debonding of rotor blade skins can occur when the bond line is exposed due to erosion of the blade finish or when corrosion occurs on the internal aluminum tip cap. Proper inspection and protection of bonded areas is required.

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**COMPLIANCE PROCEDURE:** Refer to Figure on reverse.

1. Remove both main rotor blade tip covers. Using 10x magnification, visually inspect blade tip area inside covers. Tap test skin-to-tip cap bond joints on both upper and lower surfaces. If visual indications of corrosion or separation or any voids are detected, blade is unairworthy.
2. Using 10x magnification, visually inspect leading edge of any exposed (bare metal) blade skin at skin-to-spar bond line. Tap test all exposed skin-to-spar bonded areas. If any visual indications of separation or any voids are detected, blade is unairworthy.
3. Feather edge of paint bordering bare metal by hand-sanding spanwise with 220-grit or finer wet-or-dry aluminum-oxide or silicon-carbide abrasive paper. Do not remove metal.

**CAUTION**

Do NOT use power tools or chemical paint strippers to remove paint.

4. Mask area to prevent overspray contamination.
5. Clean bare metal to be painted with a lint-free cloth dampened with enamel cleaner.
6. Prime bare metal with at least two coats of epoxy primer. Scuff primer prior to applying new coat.

(over)

7. Apply flat black Dupont Imron 373-P-29950 and/or yellow Imron K0680HK polyurethane enamel (or equivalent) to primed area in accordance with paint manufacturer's recommendations. Dupont recommendations are available online at:

[http://performancecoatings.dupont.com/dpc/en/us/html/prodinfoemfleet/imron5000\\_2-8.pdf](http://performancecoatings.dupont.com/dpc/en/us/html/prodinfoemfleet/imron5000_2-8.pdf)

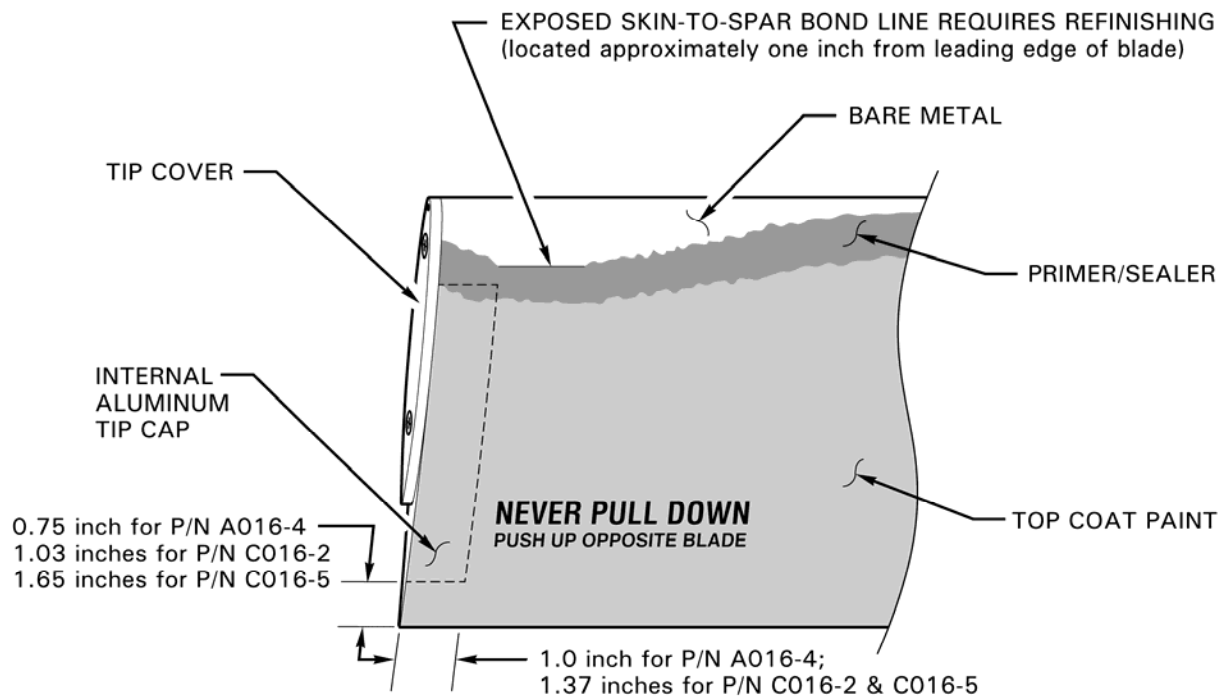
### CAUTION

If force-drying paint, do not exceed 175°F surface temperature on blade; monitor blade temperature by installing a P/N 110-2 Telatemp on blade skin.

### NOTE

Allow Imron paint to cure at least 72 hours before flying in erosive conditions (such as drizzle, rain, or dust).

8. Install blade tip covers.
9. Make appropriate maintenance record entries.



MAIN ROTOR BLADE LOWER SURFACE