

R22

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SERVICE BULLETIN SB-88A

DATE: 13 September 2000 (Supersedes R22 SB-88 dated 12 September 2000)

TO: All R22 Owners, Operators, and Service Centers

SUBJECT: A203-5 Yoke Replacement

ROTORCRAFT AFFECTED: R22 Helicopters S/N 0002 thru 2787.

TIME OF COMPLIANCE: By 31 December 2000.

BACKGROUND: RHC has received reports of cracks found in A203-5 yoke half assemblies. A203-5 Lots 24 thru 43 have been determined to be susceptible to stress-corrosion cracking and must be removed from service.

COMPLIANCE PROCEDURE:

NOTE: Use R22 Maintenance Manual (MM) change 21 dated Jun 2000 or later and R22 Illustrated Parts Catalog (IPC) revised Jun 2000 or later.

PART A: Determine A203-5 Lot number.

1. For R22 helicopters S/N 1722 thru 2787 equipped with original A203-5 yoke half assemblies, proceed directly to Part B.
2. For all other affected helicopters, determine Lot numbers by removing A203-5 yoke half assemblies and reading Lot number ink-stamped on mating faces of weight arms. Note location of chordwise balance weights for reinstallation.

NOTE: A203-1 yoke assemblies (blue-plastic bearings rather than spherical bearings) are not affected. No action is required for A203-1 yoke assemblies.

3. If both A203-5s are from Lot 10 thru 23 or Lot 44 or subsequent, reinstall per R22 MM Section 8.412(f). Attach A204-1 arm to yoke per R22 IPC Figure 7-15, and torque per R22 MM Section 1.320. Torque stripe all fasteners. Make appropriate maintenance record entries.
4. If either A203-5 yoke is from Lot 24 thru 43, if Lot is a letter code (for example: Lot BC), or if Lot is not legible, replace yoke half assemblies per Part B.

-OVER-

PART B: Replacement of affected A203-5 yoke half assemblies (Lots 24 thru 43).

1. Reference aircraft serial number and order KI-152 yoke replacement kit, which includes the following:

2 each	A203-7 yoke half assembly
1 each	NAS6604-24 bolt
2 each	NAS1149F0432P washer
1 each	MS21042L4 nut
1 each	B330-13 palnut

NOTE: A203-7 replaces A203-5 and uses NAS6604-24 bolt in place of NAS6605-8 bolt.

2. Remove A203-5 yoke half assemblies. Note location of chordwise balance weights.
3. Install A203-7 yoke half assemblies per R22 MM Section 8.412(f), except use NAS6604-24 bolt and hardware in place of NAS6605-8 bolt. Torque NAS6604-24 bolt per R22 MM Section 1.320. Track and balance is not required if same chordwise balance weights are reinstalled.
4. Attach A204-1 arm to yoke per R22 IPC Figure 7-15 and torque per R22 MM Section 1.320. Torque stripe all fasteners.
5. Scrap old yokes and make appropriate maintenance record entries.

Approximate Cost:

Parts: Part A: No parts required.
Part B: KI-152 kit special discounted price of \$150 if ordered by 31 December 2000. Order must include helicopter serial number to receive discount.

Labor: Part A: 0.3 manhour.
Part B: 0.5 manhour.