

R44

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SERVICE BULLETIN SB-53

DATE: 27 May 2004

TO: All R44 Owners, Operators, and Service Centers

SUBJECT: C046-18 Frame Tube

ROTORCRAFT AFFECTED: R44 Helicopters S/N 1160 thru 1395 except 1161, 1165, and 1198. R44 II Helicopters S/N 10001 thru 10381 except 10376 thru 10379.

TIME OF COMPLIANCE: Within next 25 flight hours or by 23 July 2004, whichever occurs first.

BACKGROUND: RHC has received reports of cracking of the aft tab of the C046-18 frame tube. Cracks may be due to a resonant vibration in the tube. Removing the short support tube at the forward end of the C046-18 tube will reduce vibratory loads in the tube. (Older frames do not have the short support tube.)

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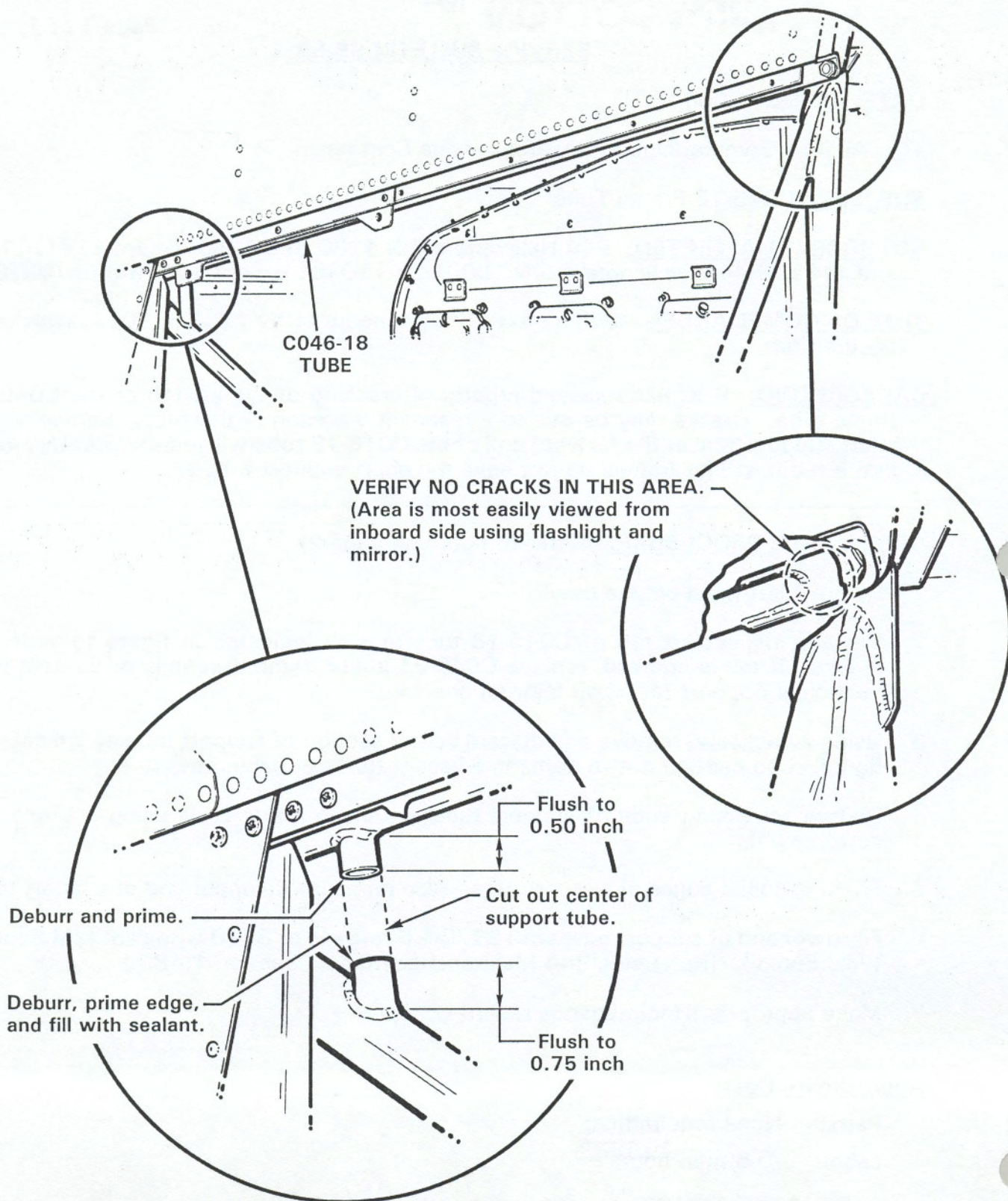
COMPLIANCE PROCEDURE: (Refer to figure on page 2)

1. Remove left-hand engine cowl.
2. Visually inspect aft tab of C046-18 tube in area indicated in figure to verify no cracks. If tab is cracked, replace C046-21 lower frame assembly or contact RHC Technical Support for repair instructions.
3. Using a hacksaw, remove and discard center section of support tube as indicated in figure. Use caution not to damage adjacent tubes or cabin structure.
4. De-burr remaining ends of support tube and clean inside ends using acetone and cotton swab.
5. Prime exposed edges of support tube. Also prime inside upper end of support tube.
6. Fill lower end of support tube with B270-1 (Pro-Seal) or B270-9 sealant (3M Scotch-Weld Epoxy). (Reference R44 Maintenance Manual Section 1.480.)
7. Make appropriate maintenance record entries.

Approximate Cost:

Parts: None required.

Labor: 0.5 man-hour.



THE DESIGN ENGINEERING ASPECTS OF THIS BULLETIN HAVE BEEN SHOWN TO COMPLY WITH APPLICABLE FEDERAL AVIATION REGULATIONS AND ARE FAA APPROVED.