

**R44 SERVICE BULLETIN SB-88**

**DATE:** 8 December 2014

**TO:** R44 & R44 II Owners, Operators, and Maintenance Personnel

**SUBJECT:** Landing Gear Attach Nuts

**ROTORCRAFT AFFECTED:** R44 helicopters S/N 2353 thru 2374 and R44 II helicopters S/N 13661 thru 13747.

**TIME OF COMPLIANCE:** Within next 100 flight hours or by 28 February 2015, whichever occurs first.

**BACKGROUND:** RHC has received a report of a cracked NAS1291-7 nut attaching the landing gear assembly to the helicopter. For helicopters with affected landing gear, this bulletin requires replacing NAS1291-7 landing gear attach nuts with D210-7 nuts, drilling a vent hole in each cross tube, and installing clear plastic rain caps to facilitate fastener inspection.

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**COMPLIANCE PROCEDURE:**

1. If helicopter is equipped with C014 revision U or prior (aluminum-elbow) landing gear assembly, or C014 revision V or W (steel-elbow) landing gear assembly having (4) clear plastic rain caps on cross tubes, the requirements of this bulletin have been complied with. Proceed to step 7.
2. If helicopter is equipped with C014 revision V or W (steel-elbow) landing gear assembly having (4) aluminum rain caps on cross tubes, order (4) D210-7 nuts, (2) C247-3 rain caps, (2) F411-9 rain caps, and B270-1 sealant as required.
3. Using plastic scraper, remove sealant securing aluminum C247-2 and F411-6 rain caps to cross tubes. Remove and discard rain caps.
4. Using back-up wrench, loosen NAS1291-7 nuts attaching landing gear assembly to helicopter, but do not remove nuts. Hoist helicopter per R44 Maintenance Manual (MM) § 1.220. Remove and discard NAS1291-7 nuts and install (4) D210-7 nuts. Special torque fasteners to 66 ft-lb and torque stripe per MM Figure 2-1. Lower helicopter.
5. Refer to Figure 1. Lay out vent hole location on left side of C241-3 (aft) cross tube and left side of C241-4 (forward) cross tube as shown. Drill one 0.128 inch diameter hole in each cross tube and deburr. Clean up debris.
6. Install (2) C247-3 rain caps on aft cross tube and (2) F411-9 caps on forward cross tube (one cap each end, painted side against cross tube, window up) using B270-1 adhesive. Remove excess adhesive and allow to cure.
7. Make appropriate maintenance record entries.

(OVER)

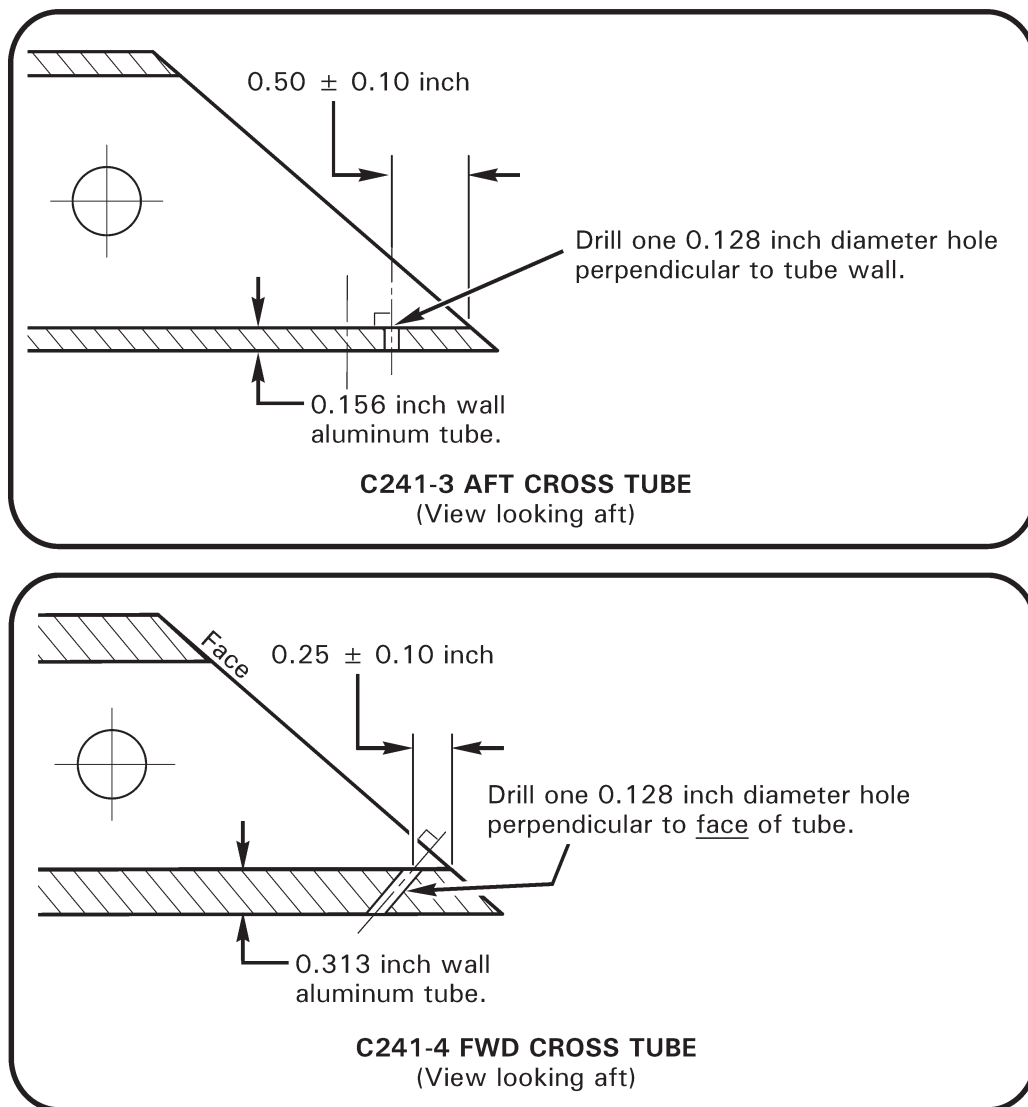
**APPROXIMATE COST:**

Parts:	(4) D210-7 nut	.....	\$ 14.00 each = \$ 56.00
	(2) C247-3 cap	.....	\$ 8.00 each = \$ 16.00
	(2) F411-9 cap	.....	\$ 8.00 each = \$ 16.00
	(1) B270-1 sealant	.....	\$ 28.50 each = \$ 28.50

**Total: \$ 116.50**

Procure parts from any R44 Dealer or Service Center, or order directly from [RHC Customer Service](#) via email, fax, or phone.

Labor: 3.0 man-hours.



**FIGURE 1**

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