

**R22 SERVICE LETTER SL-81**

**R44 SERVICE LETTER SL-67**

**R66 SERVICE LETTER SL-25**

**DATE:** 25 June 2018

**TO:** R22-series, R44-series, & R66-series Dealers and Service Centers

**SUBJECT:** Component Maintenance Course

**BACKGROUND:** RHC's Component Maintenance Course supersedes the previously offered "Component Overhaul Course". The Component Maintenance Course greatly reduces the scope of allowable field work on R22 and R44 components and adds R66 components. Service Centers desiring to perform specialized Component Maintenance, including existing RHC-authorized "Component Overhaul" Service Centers, must meet new eligibility requirements described below.

---

**SUMMARY:**

Service Center Requirements:

- RHC-authorized R22, R44, or R66 Service Center
- FAA Part 145 Repair Station, or foreign equivalent
- Employ qualified technician listed on Repair Station Personnel Roster
- Own a set of Component Maintenance special tools listed on page 2 (tools are only available to Service Centers meeting preceding requirements)

Technician Qualifications:

- Repairman's certificate, Airframe-rated licensed technician, or foreign equivalent
- Completed Component Maintenance course, or previously completed both Session I & Session II "Component Overhaul" courses

The 3-day Component Maintenance Course provides training for the following:

- R22 Clutch maintenance procedures and 12-year inspection
- R22 Main gearbox upper sealed bearing replacement and 12-year inspection
- R22, R44, R66 MR blade assembly replacement procedures and 12-year inspection
- R22, R44, R66 Spindle & bearing assembly removal from, & installation in, MR blade
- R22, R44, R66 Spindle bearing replacement
- R44, R66 Hydraulic servo upper seal replacement

(OVER)

Changes to Instructions for Continued Airworthiness (ICA):

- Effective immediately, R22 & R44 Component Overhaul Manuals (COMs) are cancelled.
- A new Component Maintenance Manual will be provided during training.
- Service Centers meeting preceding requirements and employing a qualified technician must return COMs to RHC no later than 31 July 2018 for exchange at no charge.

For further information regarding tuition, scheduling, applications, and special tools, contact Mallory Kohler, Course Administrator at [courses@robinsonheli.com](mailto:courses@robinsonheli.com) or (310) 539-0508 ext. 151.

Component Maintenance Special Tools:

- (1) MT009-9 Main Rotor Static Balancing Fixture – Base Assembly
- (1) MT009-10 Main Rotor Static Balancing Fixture Assembly (R22)
- (1) MT105-1 Spindle Torquing Tool
- (1) MT124-1 Spanner Nut Socket
- (1) MT152-1 Spindle Removal and Installation Fixture
- (1) MT194-1 Main Rotor Spindle Nut Drill Fixture Assembly (R22)
- (1) MT194-2 Main Rotor Spindle Nut Drill Fixture Assembly (R44)
- (2) MT226-1 Bearing Pressing Tool – Clutch Assembly (R22)
- (1) MT227-1 Bearing Pressing Tool – Clutch Assembly (R22)
- (1) MT228-2 Pressing Tool, Long – Clutch Assembly (R22)
- (1) MT228-3 Pressing Tool, Short – Clutch Assembly (R22)
- (1) MT251-1 Mast Bearing Installation and Removal Tube – (R22)
- (1) MT263-1 Spindle Bearing Removal Fixture Assembly
- (1) MT377-9 Spindle Bearing Installation Support Assembly
- (1) MT515-1 Hydraulic Servo Seal Tools Kit
- (1) MT524-2 Main Rotor Static Balancing Fixture Assembly (R44)
- (1) MT555-1 Spindle Bearing Removal Tool Kit