



LEONARDO MALAYSIA SDN.BHD.

WORK CARD

SERVICE ORDER NUMBER:

90025566

WORKCARD NUMBER:

2023/BGH/001-15

TITLE:

SB 139-680 DATE: JANUARY 10, 2023 REV. : / - ATA 23 - ICS CABIN (12-15 PAX) RIGID LINERS KIT INSTALLATION (PART II)

CUSTOMER:

LEONARDO HELICOPTER ITALY (LHI)

REGISTRATION:

9M-BGH

AIRFRAME HOURS:

302:40

#1 ENGINE

SERIAL NUMBER:

PCE-KB1931

#2 ENGINE

SERIAL NUMBER:

PCE-KB1885

APU

SERIAL NUMBER:

N/A

SERIAL NUMBER:

31763

LANDINGS:

850

HOURS:

302:40

HOURS:

302:40

HOURS:

N/A

NO	SOURCE	TASK / REFERENCE	REMARKS	MECHANIC SIGN	* AH SIGN & STAMP	DATE
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NOTE: FOR FIGURE(S), REFER TO IETP / ENGINE MANUAL / AD / SB.

ACCOMPLISHMENT INSTRUCTIONS







GENERAL NOTES

- A) PLACE AN IDENTIFICATION TAG ON ALL COMPONENTS THAT ARE RE-USABLE, INCLUDING THE ATTACHING HARDWARE THAT HAS BEEN REMOVED TO GAIN ACCESS TO THE MODIFICATION AREA AND ADEQUATELY PROTECT THEM UNTIL THEIR LATER REUSE.
- B) SHAPE THE CABLES IN ORDER TO PREVENT INTERFERENCE WITH THE STRUCTURE AND THE OTHER EXISTING INSTALLATIONS, USING WHERE NECESSARY SUITABLE LACING CORDS AND PLASTIC CABLE TIEDOWN.
- C) EXERCISE EXTREME CARE DURING DRILLING OPERATIONS TO PREVENT INSTRUMENTS, CABLES AND HOSES DAMAGE.
- D) AFTER DRILLING, REMOVE ALL SWARF AND SHARP EDGES. APPLY ON BARE METAL A LIGHT FILM OF PRIMER UNLESS THE HOLE IS USED FOR GROUND CONNECTION.
- E) DURING THE INSTALLATION OF BONDING BRAIDS OR COMPONENTS REQUIRING GROUNDING, CLEAN THE SURFACE STRUCTURE IN ORDER TO OBTAIN A GOOD GROUND CONTACT.
- F) LET ADHESIVE CURE AT ROOM TEMPERATURE FOR AT LEAST 24 HOURS UNLESS OTHERWISE SPECIFIED.
- G) EXPOSED THREAD SURFACE AND NUT MUST BE PROTECTED USING A LAYER OF TECTYL ACCORDING TO MIL-C-16173 GRADE I.
- H) ALL LENGTHS ARE IN MM.















PARTS / MATERIAL USED / COMPONENT CHANGE RECORD HAVE BEEN RAISED AND ATTACHED.

CALIBRATED / SPECIAL TOOLS RECORD SHEET HAVE BEEN RAISED AND ATTACHED.

* APPROVAL HOLDER HAVE VERIFIED THAT ALL TOOLS, EQUIPMENT AND OTHER EXTRANEIOUS PART OF MATERIALS ARE CLEARED AND ALL TASKS OR INSPECTIONS HAVE BEEN CARRIED OUT TO THE REQUIRED STANDARD. TASK HAS BEEN PERFORMED I.A.W MAINTENANCE MANUAL SPECIFIED IN WORKPACK INDEX LM/QA/GEN/01.

NO	SOURCE	TASK / REFERENCE	REMARKS	MECHANIC SIGN	* AH SIGN & STAMP	DATE	
1	-	IN ACCORDANCE WITH AMP DM 39-A-00-20-00-00A-120A-A, PREPARE THE HELICOPTER ON GROUND FOR A SAFE MAINTENANCE. DISCONNECT THE BATTERY, ALL ELECTRICAL POWER SOURCES AND/OR THE EXTERNAL POWER SUPPLY.	SATISFACTORY SAFE.			10/3/23	
2	-	IN ACCORDANCE WITH AMP DM 39-A-06-41-00-00A-010A-A AND WITH REFERENCE TO FIGURE 10, 15, 18 AND 19, REMOVE ALL EXTERNAL PANELS, INTERNAL PANELS AND INTERNAL LINERS AS REQUIRED TO GAIN ACCESS TO THE AREA AFFECTED BY THE INSTALLATION AND PERFORM THE LINER VARIANT P/N 3G2580P32311 AS DESCRIBED IN THE FOLLOWING PROCEDURE:	SATISFACTORY REMOVED.				
		<p style="text-align: center;">NOTE</p> PERFORM THE FOLLOWING STEP 2.1 TO ALLOW HEELS LIGHT INSTALLATION ON THE LINER.					10/3/23
		2.1 WITH REFERENCE TO FIGURE 10, PERFORM THE WINDOW LINER ASSY LH UPPER REWORKED P/N 3G2580P32131 AS DESCRIBED IN THE FOLLOWING PROCEDURE: 2.1.1 WITH REFERENCE TO FIGURE 10, PERFORM THE INDICATED CUTOUTS ON THE WINDOW LINER ASSY LH UPPER REWORKED P/N 3G5306P49931. 2.1.2 REMARK THE PART AS P/N 3G2580P32131.	SATISFACTORY CUT OUT.				
			SATISFACTORY REMASURED			10/3/23	













<input type="checkbox"/> PARTS / MATERIAL USED / COMPONENT CHANGE RECORD HAVE BEEN RAISED AND ATTACHED.	<input type="checkbox"/> CALIBRATED / SPECIAL TOOLS RECORD SHEET HAVE BEEN RAISED AND ATTACHED.
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NO	SOURCE	TASK / REFERENCE	REMARKS	MECHANIC SIGN	* AH SIGN & STAMP	DATE
		2.2 WITH REFERENCE TO FIGURE 19 VIEW G-G AND VIEW J-J, REMOVE THE BUBBLE WINDOW LINER UPR RH P/N 3G2580P07631, THE COVER ASSY P/N 3G2580A19131 AND THE PENDANT CLOSURE P/N 3G5316A40851 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.3 WITH REFERENCE TO FIGURE 19 VIEW G-G, REMOVE THE ANGULAR ASSY RH P/N 3G2580A20832 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.4 WITH REFERENCE TO FIGURE 19 VIEW G-G, REMOVE THE RH LOUVER P/N 3G2580A10252, THE BUBBLE WINDOW LINER LWR RH P/N 3G2580P07831 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.5 WITH REFERENCE TO FIGURE 18 VIEW H-H AND VIEW K-K, REMOVE THE WINDOW LINER LH UPPER P/N 3G2580P07431 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.6 WITH REFERENCE TO FIGURE 18 VIEW H-H, REMOVE THE ANGULAR ASSY LH P/N 3G2580A20732 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.7 WITH REFERENCE TO FIGURE 18 VIEW H-H, REMOVE THE LH LOUVER P/N 3G2580A10152, THE BUBBLE WINDOW LINER LWR LH P/N 3G2580P07731 AND RELEVANT HARDWARE. RETAIN HARDWARE FOR LATER REUSE.	SATISFACTORY REMOVED.			10/3/23
		2.8 WITH REFERENCE TO FIGURE 19 VIEW G-G, INSTALL THE WINDOW LINER UPR RH P/N 3G2580P04132 BY MEANS OF EXISTING FASTENERS. RE-INSTALL THE COVER ASSY P/N 3G2580A19131 AND THE PENDANT CLOSURE P/N 3G5316A40851 BY MEANS OF EXISTING HARDWARE.	SATISFACTORY INSTALLED.			10/3/23

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CALIBRATED / SPECIAL TOOLS RECORD SHEET HAVE BEEN RAISED AND ATTACHED.

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		2.9 WITH REFERENCE TO FIGURE 19 VIEW G-G AND VIEW J-J, INSTALL THE WINDOW LINER RH LWR P/N 3G2580P06731 AND THE ANGULAR ASSY RH P/N 3G2580A20831 BY MEANS OF EXISTING HARDWARE AND FASTENER SNAP P/N MS27980-18B. RE-INSTALL THE LOUVER RH P/N 3G2580A10252 BY MEANS OF EXISTING HARDWARE.	SATISFACTORY INSTALLED.			10/3/23
		2.10 WITH REFERENCE TO FIGURE 18 VIEW H-H, INSTALL THE WINDOW LINER UPR LH P/N 3G2580P32131 BY MEANS OF EXISTING FASTENERS.	SATISFACTORY INSTALLED.			10/3/23
		2.11 WITH REFERENCE TO FIGURE 18 VIEW H-H AND VIEW K-K, INSTALL THE WINDOW LINER LH LWR P/N 3G2580P18231 BY MEANS OF EXISTING HARDWARE FASTENER SNAP P/N MS27980-18B. RE-INSTALL THE LOUVER LH P/N 3G2580A10152 BY MEANS OF EXISTING HARDWARE.	SATISFACTORY INSTALLED.			10/3/23
3	-	IN ACCORDANCE WITH AMP DM 39-A-06-41-00-00A-010A-A, RE-INSTALL ALL EXTERNAL PANELS, INTERNAL PANELS AND INTERNAL LINERS PREVIOUSLY REMOVED.	SATISFACTORY INSTALLED			10/3/23
4	-	IN ACCORDANCE WITH WEIGHT AND BALANCE CHANGES, UPDATE THE CHART A (SEE ROTORCRAFT FLIGHT MANUAL, PART II, SECTION 6).	FOR CAMO TO UPDATE AS APPLICABLE REFER TO W/C TOCS/ISCH/003-10 FOR AIRCRAFT WEIGHTING.			10/3/23
5	-	RETURN THE HELICOPTER TO FLIGHT CONFIGURATION AND RECORD FOR COMPLIANCE WITH PART II OF THIS SERVICE BULLETIN ON THE HELICOPTER LOGBOOK. SEND THE ATTACHED COMPLIANCE FORM TO THE FOLLOWING MAIL BOX: ENGINEERING.SUPPORT.LHD@LEONARDO.COM AS AN ALTERNATIVE, GAIN ACCESS TO MY COMMUNICATIONS SECTION ON LEONARDO WEBPORTAL AND COMPILE THE "SERVICE BULLETIN APPLICATION COMMUNICATION".	FOR CAMO TO TAKE NOTE AND PERFORM AS APPLICABLE.			10/3/23

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**PARTS / MATERIAL USED /
COMPONENT CHANGE RECORD**

WORKSHEET /
WORKCARD
NUMBER :

2022/BGH/001-15

SERVICE ORDER
NUMBER : 9 0 0 2 5

5 6 6

AIRFRAME
HOURS :

302:40

AIRCRAFT REGISTRATION :

9M-BGH

AIRCRAFT SERIAL NUMBER :

31763

LANDINGS :

850

PARTS / MATERIAL USED / COMPONENT CHANGE RECORD (IF APPLICABLE)

DESCRIPTION	PART NO.	REMOVED		INSTALLED		RELEASE DOCUMENT
		SERIAL NO.	TSN/TSO	SERIAL NO.	TSN/TSO	
WINDOW LINER MOD LWR LH X ICS (GREY 34	3G2580P18231CS02	N/A	N/A	N/A	N/A	AGU-2022-IT20-18243
WINDOW LINER RH LWR MOD FOR AV	3G2580P06731CS01	N/A	N/A	N/A	N/A	AGU-2022-IT20-17823
WINDOW LINER ASSY LH UP REW (GREY 347	3G5306P49931CS02	N/A	N/A	N/A	N/A	AGU-2022-IT20-18666
WINDOW LINER UPR RH MOD, HOIST	3G2580P04132CS01	N/A	N/A	N/A	N/A	AGU-2022-IT20-17821
ANGULAR ASSY RH GREY 3471	3G2580A20831CS01	N/A	N/A	N/A	N/A	AGU-2022-IT20-17835

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