



LEONARDO MALAYSIA SDN. BHD.

# WORK CARD

SERVICE ORDER NUMBER: 90025566

WORKCARD NUMBER: 2023/BGH/001-09

TITLE:

SB139-697 DATE: NOVEMBER 22, 2022 REV. : / - ATA 25 -  
KIT LIFE RAFTS 14 PAX P/N 4G2560F01011 (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

ENGINE HOURS:

302:40

ENGINE HOURS:

302:40

ENGINE HOURS:

ENGINE HOURS:

ENGINE HOURS:

N/A

NO SOURCE

TASK / REFERENCE

REMARKS

MECHANIC SIGN

\* AH SIGN & STAMP

DATE

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.



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1	-	<p><u>NOTE</u></p> <p>PERFORM STEPS 1 AND 2 ONLY IF PART II OF THE PRESENT SERVICE BULLETIN IS NOT PERFORMED IMMEDIATELY AFTER PART I.</p> <p>IN ACCORDANCE WITH AMP DIM 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.</p>	<p>SARTS FACTORY PREPARED.</p>		 	14/2/23
2	-	<p>IN ACCORDANCE WITH AMP DIM 39-A-06-41-00-00A-010A-A AND WITH REFERENCE TO FIGURES 15 THRU 19, REMOVE ALL EXTERNAL PANELS, INTERNAL PANELS AND INTERNAL LINERS AS REQUIRED TO GAIN ACCESS TO THE AREA AFFECTED BY THE INSTALLATION OF THE KIT LIFE RAFTS 14 PAX (AERAZUR) P/N 4G2560F01011.</p>	<p>SARTS FACTORY REMOVED.</p>		 	14/2/23
3	-	<p>WITH REFERENCE TO FIGURES 15 THRU 19 PERFORM THE LIFE RAFTS REMOVABLE PARTS P/N 3G2560A05911 AS DESCRIBED IN THE FOLLOWING PROCEDURE:</p> <p>3.1 WITH REFERENCE TO FIGURE 15, PERFORM LIFE RAFT LABEL INSTL P/N 3G1130A06611 AS DESCRIBED IN THE FOLLOWING PROCEDURE:</p> <p><u>NOTE</u></p> <p>THE COLOUR OF THREAD USED SHALL MATCH THE BACKGROUND COLOUR OF THE DECAL.</p> <p>3.1.1 WITH REFERENCE TO FIGURE 15 SECTION A-A, INSTALL N°2 LIFE RAFT LABELS LH P/N 3G1130A06551 IN THE INDICATED POSITIONS ON THE SOFT LINER. SEW DECALS ALL AROUND WITH COMMERCIAL NYLON THREAD.</p>	<p>N/A due TO SOFT LINERS NOT FITTED TO THIS A/C</p>	<p>N/A</p>	 	14/2/23

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NO	SOURCE	TASK / REFERENCE	REMARKS	MECHANIC SIGN	* AH SIGN & STAMP	DATE
		<p align="center"><b>NOTE</b></p> <p>THE COLOUR OF THREAD USED SHALL MATCH THE BACKGROUND COLOUR OF THE DECAL.</p> <p>3.1.1 WITH REFERENCE TO FIGURE 15 SECTION B-B, INSTALL N°2 LIFE RAFT LABELS RH P/N 3G1130A06451 IN THE INDICATED POSITIONS ON THE SOFT LINER. SEW DECALS ALL AROUND WITH COMMERCIAL NYLON THREAD.</p> <p>3.2 WITH REFERENCE TO FIGURES 16 THRU 19, PERFORM LIFE RAFTS INSTALLATION P/N 3G2560A05811 AS DESCRIBED IN THE FOLLOWING PROCEDURE:</p> <p>3.2.1 WITH REFERENCE TO FIGURE 16 FRONT VIEW, REMOVE MLG FWD LEFT FAIRING P/N 3G5339A00754 (OR SUCCESSIVE DASHES) AND THE MLG FWD RIGHT FAIRING P/N 3G5339A00654 (OR SUCCESSIVE DASHES). DISCARD FIXING HARDWARE.</p> <p>3.2.2 WITH REFERENCE TO FIGURE 16 SECTION B-B AND FIGURE 17 SECTION C-C, REMOVE EXISTING FASTENERS FROM THE INDICATED POSITIONS ON THE LEFT AND RIGHT SPONSONS.</p>	<p>N/A DOE TO SOFT LINERS NOT FITTED TO THIS A/C</p>	<p>N/A</p>	<p align="center"></p>	<p align="center">14/2/23</p>
		<p>3.2.2 WITH REFERENCE TO FIGURE 16 SECTION B-B AND FIGURE 17 SECTION C-C, REMOVE EXISTING FASTENERS FROM THE INDICATED POSITIONS ON THE LEFT AND RIGHT SPONSONS.</p>	<p>SPTS FACTORY REMOVED</p>	<p align="center">M</p>	<p align="center">M</p> <p align="center"></p>	<p align="center">15/2/23</p>
		<p align="center"><b>NOTE</b></p> <p>PERFORM THE FOLLOWING STEP 3.2.3 ONLY IF FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434 AND FAIRING LIFE RAFT ASSY FWD RH P/N 3G5260A29534 ARE PROVIDED.</p>				

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		<p>3.2.3 WITH REFERENCE TO FIGURES 18 AND 19, PERFORM SOFT COVER FAIRING LIFE RAFT RETRO MOD P/N 3G5260P00611 AS DESCRIBED IN THE FOLLOWING PROCEDURE:</p> <p>3.2.3.1 WITH REFERENCE TO FIGURE 18 VIEW A, REMOVE N°2 EXISTING RIVET P/N MS20426AD6-7 FROM THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434.</p> <p>3.2.3.2 WITH REFERENCE TO FIGURE 18 VIEW A, FILL AND PLUG THE TWO EXISTING HOLES WITH ADHESIVE EA 956 AERO (C193).</p> <p>3.2.3.3 WITH REFERENCE TO FIGURE 18 VIEW A, APPLY N°2 PLYS OF CARBON FIBER G0801 7 1020 (C555): N°1 PLY ON EXTERNAL SURFACE AND N°1 PLY ON INTERNAL SURFACE OF THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434. BOND WITH ADHESIVE EA9309NA (C231).</p> <p>3.2.3.4 WITH REFERENCE TO FIGURE 18 VIEW A AND VIEW B, REMOVE THE COVER ASSY LH P/N 3G5260A36432 AND FIXING HARDWARE (N°9 RIVETS P/N MS20470A3-4 AND N°9 WASHERS P/N NAS1149CN216R) FROM THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434. CLEAN THE SURFACE.</p> <p>3.2.3.5 WITH REFERENCE TO FIGURE 19 VIEW C, SECTION D AND VIEW E, INTERPOSE ADHESIVE (C111) BETWEEN THE HANDLE COVER P/N 3G5260L02332 AND THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434 AND LOCATE THE HANDLE COVER IN THE INDICATED POSITION.</p>	<p>N/A. P/N NOT PROVIDED. REFER TO NOTE.</p> <p>N/A. REFER TO ABOVE REMARK.</p> <p>N/A. REFER TO ABOVE REMARK.</p> <p>N/A. REFER TO ABOVE REMARK.</p> <p>N/A. REFER TO ABOVE REMARK.</p>	<p>N/A</p> <p>N/A</p> <p>N/A</p> <p>N/A</p> <p>N/A</p>	    	<p>14/2/23</p> <p>14/2/23</p> <p>14/2/23</p> <p>14/2/23</p> <p>14/2/23</p>





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		<p align="center"><u>NOTE</u></p> <p>RELATE THE COVER TO EXISTING HOLES OF THE RIVETS PREVIOUSLY REMOVED.</p> <p>3.2.3.6 WITH REFERENCE TO FIGURE 19 VIEW C, SECTION D-D AND VIEW E, INSTALL THE HANDLE COVER P/N 3G5260L02332 ON THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434 BY MEANS OF N°9 RIVETS P/N A297A04TW04. FILL ALL AROUND WITH SEALANT MC-780 (C465).</p> <p>3.2.3.7 REPEAT STEPS 3.2.3.1 THRU 3.2.3.6 ON THE FAIRING LIFE ASSY FWD RH P/N 3G5260A29534 TO:</p> <ul style="list-style-type: none"> <li>• REMOVE THE COVER ASSY RH P/N 3G5260A36532 AND INSTALL THE HANDLE COVER P/N 3G5260L02332;</li> <li>• REMOVE N°2 RIVETS MS20426AD6-7 AND FILL EXISTING HOLES.</li> </ul> <p align="center"><u>NOTE</u></p> <p>IF NECESSARY, REWORK SPACER THICKNESS IN ACCORDANCE WITH THE EXISTING GAP BETWEEN THE LIFE RAFT AND THE FAIRING.</p> <p>3.2.4 WITH REFERENCE TO FIGURE 16 SECTION B-B AND FIGURE 17 SECTION C-C, INTERPOSE A LAYER OF SILICONE ADHESIVE BETWEEN THE TEFLON SPACER AND THE STRUCTURE OF THE LEFT SPONSON. USE ADHESIVE RTV 732 (C126).</p>	<p>N/A, REFER ABOVE REMARK.</p> <p>N/A, REFER TO ABOVE REMARK. TASK N/A.</p>	<p>N/A</p> <p>N/A</p>	 	<p>14/2/23</p> <p>14/2/23</p>
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<p>* APPROVAL HOLDER HAVE VERIFIED THAT ALL TOOLS, EQUIPMENT AND OTHER EXTRANEOUS 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.</p>						






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		3.2.5 WITH REFERENCE TO FIGURES 16 AND 17 AND IN ACCORDANCE WITH THE APPLICABLE STEPS OF AMP DM 39-D-25-62-01-00A-720A-K, INSTALL THE LH LIFE RAFT ASSY P/N 3G2560V00531 ON THE LEFT SPONSON BY MEANS OF N°2 BOLTS P/N NAS6703-11, N°4 BOLTS P/N NAS6703-10 AND N°6 WASHERS P/N NAS1149C0316R.	SATISFACTORILY INSTALLED	M		17/12/23
		3.2.6 WITH REFERENCE TO FIGURE 16 SECTION B-B, TEMPORARY LOCATE THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434 OR P/N 3G5260A29435 IN POSITION ON THE LEFT SPONSON AND ENLARGE PILOT HOLES UP TO Ø5.512±5.639 IN ACCORDANCE WITH THE EXISTING HOLES ON THE STRUCTURE.	SATISFACTORILY LOCATED AND ENLARGED HOLES	M		17/12/23
		3.2.7 WITH REFERENCE TO FIGURE 16 SECTION B-B, PREPARE THE SURFACE FOR BONDING IN THE INDICATED POSITION.	SATISFACTORILY PREPARED	M		17/12/23
		3.2.8 WITH REFERENCE TO FIGURE 16 FRONT VIEW AND SECTION B-B AND IN ACCORDANCE WITH AMP DM 39-D-25-62-06-00A-720A-K, INSTALL THE FAIRING LIFE RAFT ASSY FWD LH P/N 3G5260A29434 OR P/N 3G5260A29435 ON THE LH LIFE RAFT ASSY P/N 3G2560V00531 BY MEANS OF N°1 SCREW P/N A428A3C04, N°9 SCREWS P/N A428A3C05, N°3 SCREWS P/N A428A3C08, N°5 SCREWS P/N AN525-10R10 AND N°2 SCREWS P/N AN525-10R12.	SATISFACTORILY INSTALLED	M		17/12/23
		<b>NOTE</b> IF NECESSARY, REWORK SPACER THICKNESS IN ACCORDANCE WITH THE EXISTING GAP BETWEEN THE LIFE RAFT AND THE FAIRING.				

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		<p>3.2.9 WITH REFERENCE TO FIGURE 16 SECTION B-B AND FIGURE 17 SECTION C-C, INTERPOSE A LAYER OF SILICONE ADHESIVE BETWEEN THE TEFLON SPACER AND THE STRUCTURE OF THE RIGHT SPONSON. USE ADHESIVE RTV 732 (C126).</p>	SATISFACTORY APPLIED	<i>DE</i>	<i>W</i> 	20/2/23
		<p>3.2.10 WITH REFERENCE TO FIGURES 16 AND 17 AND IN ACCORDANCE WITH THE APPLICABLE STEPS OF AMP DM 39-D-25-62-02-00A-720A-K, INSTALL THE RH LIFE RAFT ASSY P/N 3G2560V00631 ON THE RIGHT SPONSON BY MEANS OF N°2 BOLTS P/N NAS6703-11, N°4 BOLTS P/N NAS6703-10 AND N°6 WASHERS P/N NAS1149C0316R.</p>	SATISFACTORY INSTALLED	<i>DE</i>	<i>W</i> 	20/2/23
		<p>3.2.11 WITH REFERENCE TO FIGURE 16 SECTION B-B, TEMPORARY LOCATE THE FAIRING LIFE RAFT ASSY FWD RH P/N 3G5260A29534 OR P/N 3G5260A29535 IN POSITION ON THE RIGHT SPONSON AND ENLARGE PILOT HOLES UP TO Ø5.512±5.639 IN ACCORDANCE WITH THE EXISTING HOLES ON THE STRUCTURE.</p>	SATISFACTORY LOCATED AND ENLARGED HOLES	<i>DE</i>	<i>W</i> 	20/2/23
		<p>3.2.12 WITH REFERENCE TO FIGURE 16 SECTION B-B, PREPARE THE SURFACE FOR BONDING IN THE INDICATED POSITION.</p>	SATISFACTORY PREPARED	<i>DE</i>	<i>W</i> 	20/2/23
		<p>3.2.13 WITH REFERENCE TO FIGURE 16 FRONT VIEW AND SECTION B-B AND IN ACCORDANCE WITH AMP DM, INSTALL THE FAIRING LIFE RAFT ASSY FWD RH P/N 3G5260A29534 OR P/N 3G5260A29535 ON THE RH LIFE RAFT ASSY P/N 3G2560V00631 BY MEANS OF N°1 SCREW P/N A428A3C04, N°9 SCREWS P/N A428A3C05, N°3 SCREWS P/N A428A3C08, N°5 SCREWS P/N AN525-10R10 AND N°2 SCREWS P/N AN525-10R12.</p>	SATISFACTORY INSTALLED	<i>DE</i>	<i>W</i> 	20/2/23

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4	-	IN ACCORDANCE WITH AMP DMI 39-A-06-41-00-00A-010A-A, RE-INSTALL ALL EXTERNAL PANELS, INTERNAL PANELS AND INTERNAL LINERS PREVIOUSLY REMOVED.	SATISFACTORY RE-INSTALLED			10/13/23																
5	-	IN ACCORDANCE WITH WEIGHT AND BALANCE CHANGES, UPDATE THE CHART A (SEE ROTORCRAFT FLIGHT MANUAL, PART II, SECTION 6).	SATISFACTORY UPDATED. REFER TO WIS NO 12025/284/007-189.			10/13/23																
6	-	RETURN THE HELICOPTER TO FLIGHT CONFIGURATION AND RECORD FOR COMPLIANCE WITH PART II OF THIS SERVICE BULLETIN ON THE HELICOPTER LOGBOOK.	SATISFACTORY RETURNED TO FLIGHT CONFIGURATION. REFER TO UPDATE			10/13/23																
7	-	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".	SATISFACTORY REFER TO SEND THE COMPLIANCE FORM AS REQUESTED			10/13/23																
<p align="center"><b>INDEPENDENT INSPECTION / RE-INSPECTION I.A.W MOE 2.23</b></p> <p>DESCRIPTION OF CRITICAL MAINTENANCE TASK REQUIREMENT AREA:          TO CHECK THE CORRECT INSTALLATION OF MAIN AND ELEC LH AND RH LIFE RAFT ASSY AND ITS SECURITY</p> <p align="center"><b>AUTHORISATION HOLDER</b></p> <table border="1"> <tr> <td>NAME</td> <td>STAMP</td> <td>SIGNATURE</td> <td>DATE</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table> <p align="center"><b>INDEPENDENT INSPECTOR</b></p> <table border="1"> <tr> <td>NAME</td> <td>STAMP</td> <td>SIGNATURE</td> <td>DATE</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>							NAME	STAMP	SIGNATURE	DATE					NAME	STAMP	SIGNATURE	DATE				
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**SERVICE BULLETIN**

**N° 139-697**

**DATE:** November 22, 2022

**REV. :** /

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**TITLE**

**ATA 25 - KIT LIFE RAFTS 14 PAX P/N 4G2560F01011**

**REVISION LOG**

First Issue

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An appropriate entry should be made in the aircraft log book upon accomplishment.  
If ownership of aircraft has changed, please, forward to new owner.

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