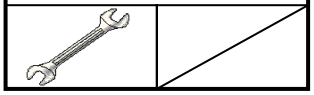
No. 3718-I-00

Information Notice

SUBJECT: GENERAL

Tightening torque application procedures for self-locking nuts

For the attention of



AIRCRAFT CONCERNED	Version(s)	
	Civil	Military
EC120	B	
AS350	B, BA, BB, B1, B2, B3, D	L1
AS550		A2, C2, C3, U2
AS355	E, F, F1, F2, N, NP	
AS555		AF, AN, SN, UF, UN, AP
EC130	B4, T2	
SA365 / AS365	C1, C2, C3, N, N1, N2, N3	F, Fs, Fi, K, K2
AS565		MA, MB, SA, SB, UB, MBe
SA366		GA
EC155	B, B1	
SA330	J	Ba, L, Jm, S1, Sm
SA341	G	B, C, D, E, F, H
SA342	J	L, L1, M, M1, Ma
ALOUETTE II	313B, 3130, 318B, 318C, 3180	
ALOUETTE III	316B, 316C, 3160, 319B	
LAMA	315B	
EC225	LP	
EC725		AP
AS332	C, C1, L, L1, L2	B, B1, F1, M, M1
AS532		A2, U2, AC, AL, SC, UE, UL
EC175	B	
H160	B	
EC339		KUH/Surion
BO105	C (C23, CB, CB-4, CB-5), D (DB, DBS, DB-4, DBS-4, DBS-5), S (CS, CBS, CBS-4, CBS-5), LS A-3	CBS-5 KLH, E-4
MBB-BK117	A-1, A-3, A-4, B-1, B-2, C-1, C-2, C-2e, D-2, D-2m, D-3, D-3m	D-2m, D-3m
EC135	T1, T2, T2+, T3, P1, P2, P2+, P3, EC635 T1, EC635 T2+, EC635 T3, EC635 P2+, EC635 P3, T3H, P3H, EC635 T3H, EC635 P3H	

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The analysis of recent incidents encountered in operation has shown the need for a general reminder of the tightening torque application procedures for assemblies with bolts and nuts, and in particular the application of tightening torques that must be increased by the locking torque of self-locking nuts.

When a nut has a self-locking function, you are sometimes requested to measure its true locking torque to ensure the application of the useful tightening torque.
The necessity of measuring and adding the locking torque to the tightening torque is shown in the documentation by the following symbol:

	**Locking torque to be measured and added to the indicated tightening torque.**

If there is no such symbol, no locking torque is to be added to the indicated tightening torque.

Below is a reminder of the procedure for measuring the locking torque (refer to Work Card 20-02-05-404 (MTC)).
This procedure can be complied with during the tightening or loosening phase of the nut and requires that the locking section of the nut be fully engaged on the threads of the bolt.

Screw or unscrew the nut on the bolt using a dial torque wrench to read the locking torque value. The value to be taken into account is the value of the constant force after starting and before the bearing face of the nut comes into contact with the component to be tightened.

We also remind you that all the procedures for applying, checking and readjusting tightening torques are described in Work Card 20-02-05-404 (MTC) as well as in Service Letter No. 1809-00-06.