

# ALERT SERVICE BULLETIN

**TITLE:** Emergency Exit Windows - Replacement of jettisonable windows and seals on the sliding doors and fixed panels

**SB Type:** Corrective measure

### APPLICABILITY

Model:	EC155
Version:	B, B1
Helicopters PRE MOD:	0752C74
Component affected:	365A25-8022-41 and 365A25-8022-42 and 365A25-8022-26 and 365A25-8022-27 and 365A25-8022-28 and 365A25-8022-29

### COMPLIANCE: MANDATORY

Comply with this ALERT SERVICE BULLETIN during the next maintenance operation and without exceeding 600FH / 2Y following receipt of this ALERT SERVICE BULLETIN.

### SUMMARY

The purpose of this Alert Service Bulletin is to replace the jettisonable windows and seals on the sliding doors and fixed panels.

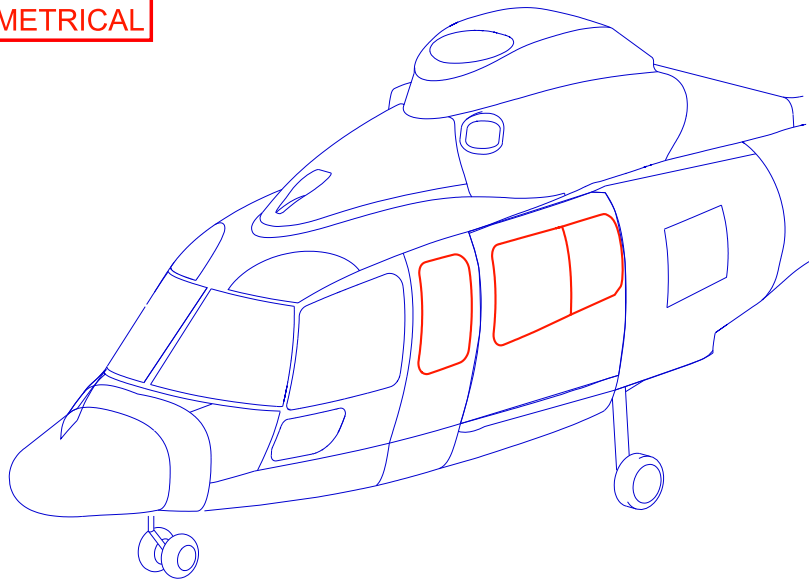
### GENERAL EVALUATION

Evaluation table			
Perform once	YES	Accomplish recurring	NO

US Export Control - No US content. This Item does not contain any U.S. origin ITAR or EAR content.  
FR Export Control - Not Listed. This Item is not listed against the EC regulations in the EU/FR.

#### GENERAL ILLUSTRATION

LH SHOWN  
RH SYMMETRICAL



## PLANNING INFORMATION

### 1. REASON

Airbus Helicopters has decided to carry out additional tests concerning jettisoning of windows on Dolphin aircraft.

The tests have shown that the jettisoning forces measured are not corresponding to maximum jettisoning effort requirements.

A modification consisting in changing the current windows and poly-chloroprene seals by new windows with different thickness and silicone seals has been identified.

Consequently, this Alert Service Bulletin makes it mandatory to apply the new windows and jettisonable silicone seals on sliding doors and fixed panels.

The technical data and instructions contained in this Alert Service Bulletin refer to the modification 0752C74.

### 2. DESCRIPTION

This Alert Service Bulletin provides instructions to:

- Remove the jettisonable windows and seals on sliding doors and fixed panels
- Install the new jettisonable windows and silicone seals on sliding doors and fixed panels
- Install the new labels on fixed panels and sliding doors.

### 3. CONFIGURATION DEFINITION

Not applicable.

### 4. CONCURRENT REQUIREMENTS

Not applicable.

### 5. APPROVAL

The technical content of this document is approved under the authority of the Design Organization Approval ref. EASA. 21J.700.

For helicopters operated outside the terrain regulated by the EASA, the application of this document is subject to validation provided by the responsible aviation authority of the state of registry.

## 6. MANPOWER

### NOTE

The Purpose of Man Hours is to give Airbus Helicopters customers a guideline for maintenance scheduling. It is not a contractual information.

### 6.1. Manpower for procedure

Number of Persons	Qualification	Estimated Man Hours
2	Mechanical technician	24h

## 7. WEIGHT AND BALANCE

Weight (kg)	Longitudinal moment (kg.m) X	Lateral moment (kg.m) Y
+ 4,3	+ 14,41	0

## 8. ELECTRICAL LOAD DATA

Not applicable.

## 9. DOCUMENTATION AFFECTED

Aircraft Maintenance Manual (AMM)

Illustrated Parts Catalog (IPC)

Master Servicing Manual (MSM)

The changes to the Instructions for Continued Airworthiness (ICA) that are required as a result of this Service Bulletin will be incorporated in the next Normal Revision. Refer to DN.105.0025 until the information is available in the published technical documentation.

## 10. MATERIAL INFORMATION

### 10.1. Price

For information about the price of the modification kits and/or components, or for aid, contact the Airbus Helicopters Network Sales and Customer Relations Department.

### 10.2. Availability

Contact the Sales and Customer Relations Department to know the delivery lead times.

### 10.3. Procurement

Send an order for the necessary quantities to the Airbus Helicopters Network Sales Department.

You can send an order for the consumables from the AirbusWorld Marketplace through e-ordering.

If you cannot get access to e-ordering, please contact your Logistic Focal Point.

### 10.4. Mixability

It is not allowed to mix before and after modification components on the helicopter.

### 10.5. LIST OF NEW MATERIALS

Material Kit List					
Kit Designation		Kit Reference			
Kit Content					
Item	Designation	Reference	MFC	QTY	See Notes
1	PANEL LH	365A25-8449-20	F0210	1	(1)
2	PANEL RH	365A25-8449-21	F0210	1	(1)
3	SEAL FIXED PANEL	365A25-8450-2051	F0210	2	(1)
NOTE(S)					
(1)	PREMOD 0756B31				
(2)	POSTMOD 0756B31				

Material Kit List					
Kit Designation		Kit Reference			
Kit Content					
Item	Designation	Reference	MFC	QTY	See Notes
4	SEAL KEY FIXED PANEL	365A25-8450-2351	F0210	4	(1)
5	FIXED PANEL WINDOW RH	369K25-6111-21	F0210	1	(2)
6	FIXED PANEL WINDOW LH	369K25-6110-21	F0210	1	(2)
7	SEAL KEY FIXED PANEL	369K25-6202-2151	F0210	4	(2)
8	SEAL FIXED PANEL	369K25-6201-2151	F0210	2	(2)
9	PANEL FRONT LH SLIDING DOOR	365A25-8449-22	F0210	1	
10	PANEL FRONT RH SLIDING DOOR	365A25-8449-23	F0210	1	
11	SEAL FRONT SLIDING DOOR	365A25-8450-2151	F0210	2	
12	SEAL KEY FRONT SLIDING DOOR	365A25-8450-2451	F0210	4	
13	PANEL REAR LH SLIDING DOOR	365A25-8449-24	F0210	1	
14	PANEL REAR RH SLIDING DOOR	365A25-8449-25	F0210	1	
15	SEAL REAR SLIDING DOOR	365A25-8450-2251	F0210	2	
16	SEAL KEY REAR SLIDING DOOR	365A25-8450-2551	F0210	4	
17	TAPE EXTRACTION	332A23-0520-07	F0210	6	
18	TAPE EXTRACTION KEY	332A23-0520-04	F0210	6	
19	WASHER	332A23-0520-25	F0210	12	
NOTE(S)					
(1) PREMOD 0756B31					
(2) POSTMOD 0756B31					

Material Kit List					
Kit Designation			Kit Reference		
Kit Content					
Item	Designation	Reference	MFC	QTY	See Notes
20	COUNTERSUNK HEAD SCREW	22256BC040018L	F0210	6	
21	SELF-LOCKING HEX NUT	ASN52320BH040N	F0210	6	
22	FLAT WASHER	23111AG040LE	F0210	6	
23	FASTENER PRESSURE	MS27980-7N	F0210	6	
24	EXTRACTOR	365A25-8022-17	F0210	6	
25	LABEL	365A00-0932-58	F0210	6	
26	STRAP 1 FIXED PANEL ASSY	369K25-6203-00	F0210	2	(2)
27	STRAP 2 FIXED PANEL ASSY	369K25-6204-00	F0210	2	(2)
NOTE(S)					
(1) PREMOD 0756B31					
(2) POSTMOD 0756B31					

Individual Spares List				
Item	Designation	Reference	MFC	QTY
None				

Consumables, Materials and Expendables			
Designation	Reference	MFC	QTY
Adhesive	CM606	-	As required
Sealing compound	CM612	-	As required
Adhesive	CM674	-	As required

Special Tools				
Item	Designation	Reference	MFC	QTY
None				

#### 10.6. LIST OF EXISTING PARTS

REMOVED SPARE PARTS	
Old Reference	Designation
365A25-8022-41	FIXED PANEL LH
365A25-8022-42	FIXED PANEL RH
365A25-8022-26	PANEL FRONT LH SLIDING DOOR
365A25-8022-27	PANEL FRONT RH SLIDING DOOR
365A25-8022-28	PANEL REAR LH SLIDING DOOR
365A25-8022-29	PANEL REAR RH SLIDING DOOR
706A39-8210-07	WINDOW JETTISONABLE SEAL
706A39-8210-02	SEAL KEY

#### 11. ACCOMPLISHMENT INSTRUCTION

Comply with the accomplishment procedure [56-50-0001, 933](#).

#### 12. ADDITIONAL INFORMATION

Not applicable.

End of section



## ACCOMPLISHMENT PROCEDURE 56-50-0001, 933

### 1. APPLICABILITY

Model:	EC155
Version:	B, B1
Helicopters PRE MOD:	0752C74
Component affected:	365A25-8022-41 and 365A25-8022-42 and 365A25-8022-26 and 365A25-8022-27 and 365A25-8022-28 and 365A25-8022-29

### 2. GENERAL INFORMATION

Acronym / Abbreviation List

FOD - Foreign Object Debris

MTC - Manuel des Techniques Courantes (Standard Practices Manual)

### 3. PRELIMINARY REQUIREMENTS

#### 3.1. Applicable Documents

- Helicopter parked in a repair shop - Safety instructions [MTC 20-07-02-201](#)
- Removal / Installation Jettisonable Window Fixed panels [AMM 56-20-00-062A](#)
- Removal / Installation Jettisonable Window Fixed panels POSTMOD 0752C74 [AMM 56-20-00-062B](#)
- Removal / Installation Jettisonable Window on a sliding door [AMM 56-30-00-062A](#)
- Removal / Installation Jettisonable Window on a sliding door POSTMOD 0752C74 [AMM 56-30-00-062B](#)

#### 3.2. Set up

- Park the helicopter in a hangar, refer to [MTC 20-07-02-201](#)
- Install appropriate means of access

#### 3.3. Special Tools

None

#### 3.4. Consumables, Materials and Expendables

Designation	Reference	MFC	QTY
Adhesive	CM 606	-	1
Sealing compound	CM 612	-	1
Adhesive	CM 674	-	1

#### 3.5. Spares

Designation	Reference	MFC	QTY
PANEL LH	365A25-8449-20	F0210	1
PANEL RH	365A25-8449-21	F0210	1
SEAL FIXED PANEL	365A25-8450-2051	F0210	2
SEAL KEY FIXED PANEL	365A25-8450-2351	F0210	4
FIXED PANEL WINDOW RH	369K25-6111-21	F0210	1
FIXED PANEL WINDOW LH	369K25-6110-21	F0210	1
SEAL KEY FIXED PANEL	369K25-6202-2151	F0210	4
SEAL FIXED PANEL	369K25-6201-2151	F0210	2
PANEL FRONT LH SLIDING DOOR	365A25-8449-22	F0210	1
PANEL FRONT RH SLIDING DOOR	365A25-8449-23	F0210	1
SEAL FRONT SLIDING DOOR	365A25-8450-2151	F0210	2
SEAL KEY FRONT SLIDING DOOR	365A25-8450-2451	F0210	4
PANEL REAR LH SLIDING DOOR	365A25-8449-24	F0210	1
PANEL REAR RH SLIDING DOOR	365A25-8449-25	F0210	1
SEAL REAR SLIDING DOOR	365A25-8450-2251	F0210	2
SEAL KEY REAR SLIDING DOOR	365A25-8450-2551	F0210	4
TAPE EXTRACTION	332A23-0520-07	F0210	6
TAPE EXTRACTION KEY	332A23-0520-04	F0210	6
WASHER	332A23-0520-25	F0210	12

Designation	Reference	MFC	QTY
COUNTERSUNK HEAD SCREW	22256BC040018L	F0210	6
SELF-LOCKING HEX NUT	ASN52320BH040N	F0210	6
FLAT WASHER	23111AG040LE	F0210	6
FASTENER PRESSURE	MS27980-7N	F0210	6
EXTRACTOR	365A25-8022-17	F0210	6
LABEL	365A00-0932-58	F0210	6
STRAP 1 FIXED PANEL ASSY	369K25-6203-00	F0210	2
STRAP 2 FIXED PANEL ASSY	369K25-6204-00	F0210	2

#### 3.6. Safety conditions

##### **WARNING**

**BEFORE YOU START THE TASK, READ THE GENERAL SAFETY INSTRUCTIONS - PLEXIGLAS [AMM 56-00-00-911](#).**

##### **CAUTION**

**Make sure that you prevent all possible damage caused by Foreign Object Debris (FOD).**

## 4. PROCEDURE

- 4.1. Replacement of the jettisonable windows and seals on the sliding doors and fixed panels

### NOTE

The complete list of new material is in paragraph 9.5. LIST OF NEW MATERIALS

- 4.1.1. For LH and RH fixed panels

- 4.1.1.1. Remove the old jettisonable windows with their seal keys and seals on fixed panels, refer to [AMM 56-20-00-062A](#).

- 4.1.1.2. Installation on fixed panels

- 4.1.1.2.1. Installation PREMOD 0756B31

Install on LH fixed panel:

- The PANEL LH 365A25-8449-20 (1)
- The SEAL KEY FIXED PANEL 365A25-8450-2351 (4)
- The SEAL FIXED PANEL 365A25-8450-2051 (3).

Refer to [AMM 56-20-00-062B](#).

Install on RH fixed panel:

- The PANEL RH 365A25-8449-21 (2)
- The SEAL KEY FIXED PANEL 365A25-8450-2351 (4)
- The SEAL FIXED PANEL 365A25-8450-2051 (3).

Refer to [AMM 56-20-00-062B](#).

- 4.1.1.2.2. Installation POSTMOD 0756B31

Install on LH fixed panel:

- The FIXED PANEL WINDOW LH 369K25-6110-21 (6)
- The SEAL KEY FIXED PANEL 369K25-6202-2151 (7)
- The SEAL FIXED PANEL 369K25-6201-2151 (8).

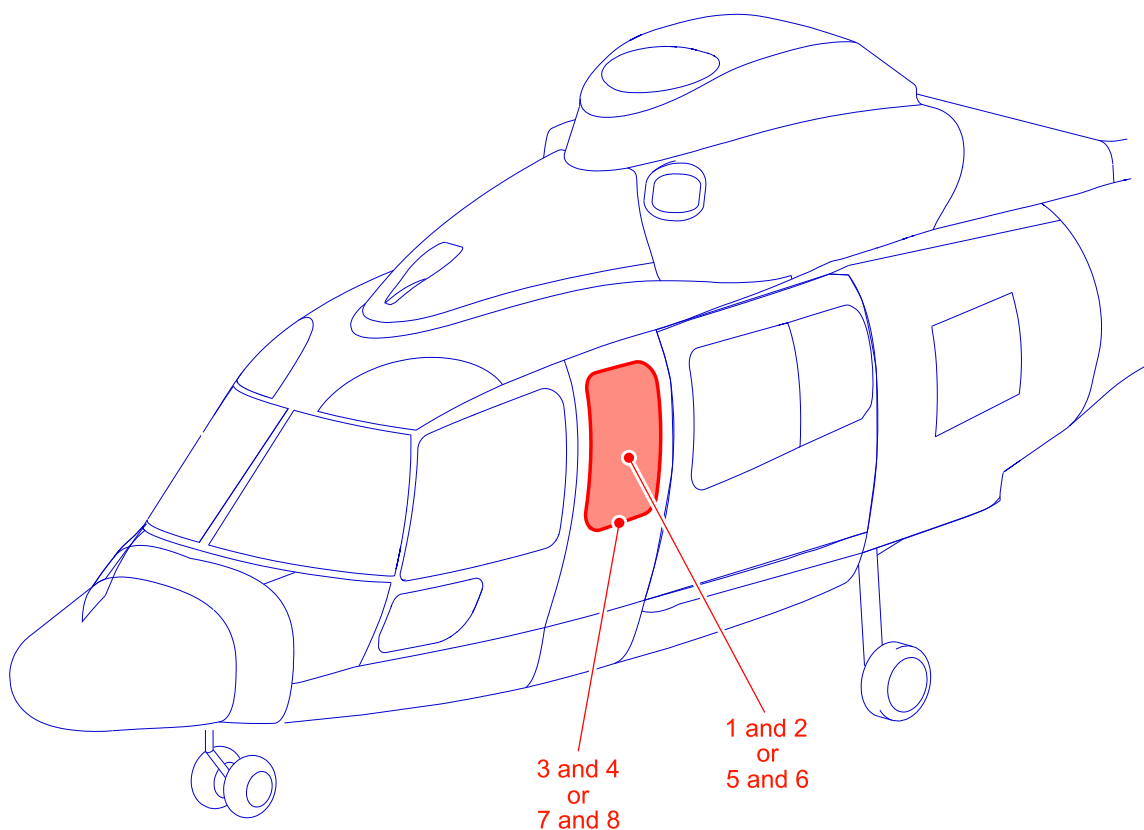
Refer to [AMM 56-20-00-062B](#).

Install on RH fixed panel:

- The FIXED PANEL WINDOW RH 369K25-6111-21 (5)
- The SEAL KEY FIXED PANEL 369K25-6202-2151 (7)
- The SEAL FIXED PANEL 369K25-6201-2151 (8).

Refer to [AMM 56-20-00-062B](#).

LH SHOWN  
RH SYMMETRICAL



**Figure 1**

4.1.2. For LH and RH sliding doors

4.1.2.1. Remove the old jettisonable windows with their seal keys and seals on sliding doors, refer to [AMM 56-30-00-062A](#).

4.1.2.2. Install on LH sliding doors:

- The PANEL FRONT LH SLIDING DOOR 365A25-8449-22 (9)
- The SEAL KEY FRONT SLIDING DOOR 365A25-8450-2451 (12)
- The SEAL FRONT SLIDING DOOR 365A25-8450-2151 (11)
- The PANEL REAR LH SLIDING DOOR 365A25-8449-24 (13)
- The SEAL KEY REAR SLIDING DOOR 365A25-8450-2551 (16)
- The SEAL REAR SLIDING DOOR 365A25-8450-2251 (15).

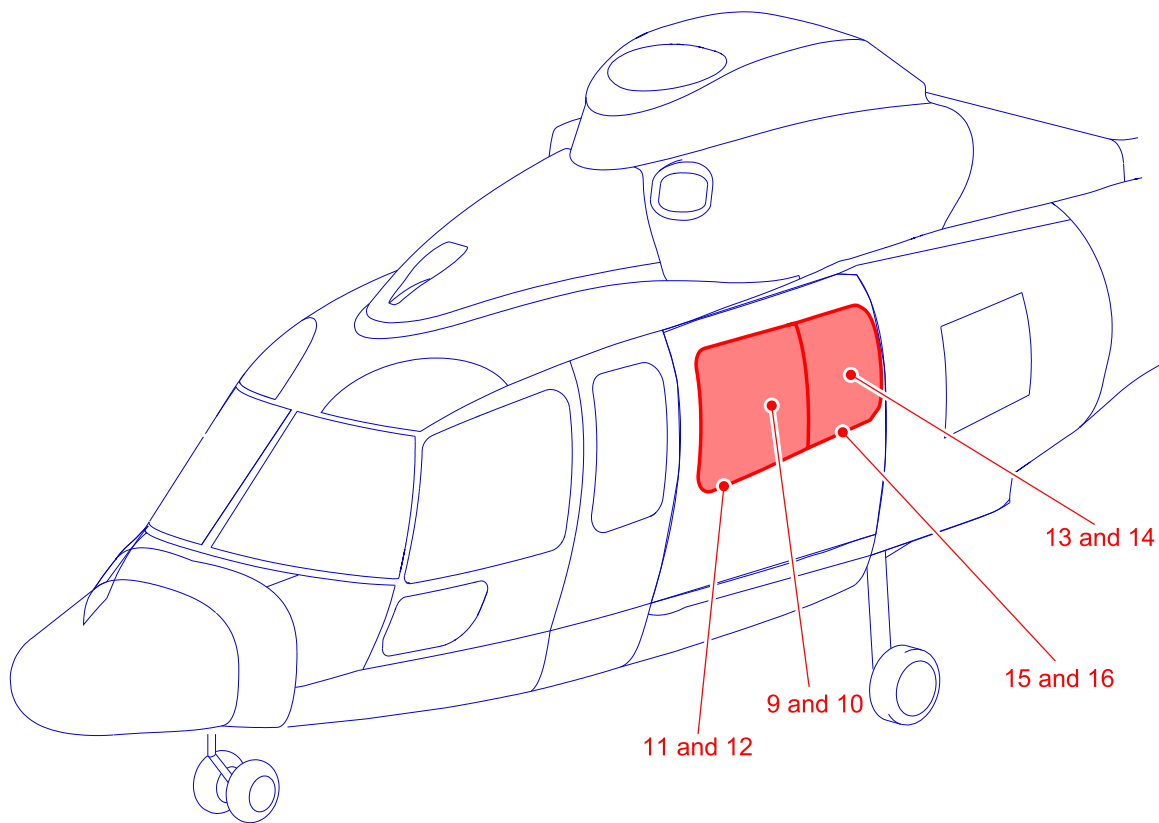
Refer to [AMM 56-30-00-062B](#).

Install on RH sliding doors:

- The PANEL FRONT RH SLIDING DOOR 365A25-8449-23 (10)
- The SEAL KEY FRONT SLIDING DOOR 365A25-8450-2451 (12)
- The SEAL FRONT SLIDING DOOR 365A25-8450-2151 (11)
- The PANEL REAR RH SLIDING DOOR 365A25-8449-25 (14)
- The SEAL KEY REAR SLIDING DOOR 365A25-8450-2551 (16)
- The SEAL REAR SLIDING DOOR 365A25-8450-2251 (15).

Refer to [AMM 56-30-00-062B](#).

LH SHOWN  
RH SYMMETRICAL

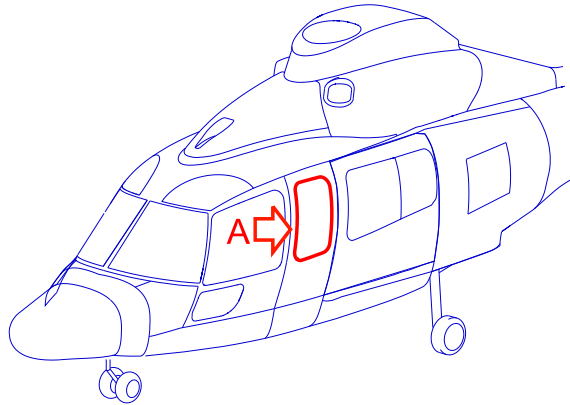


**Figure 2**



#### 4.2. Installation of labels

4.2.1. Install the LABEL 365A00-0932-58 (25) on fixed panels.



LH SHOWN  
RH SYMMETRICAL

A

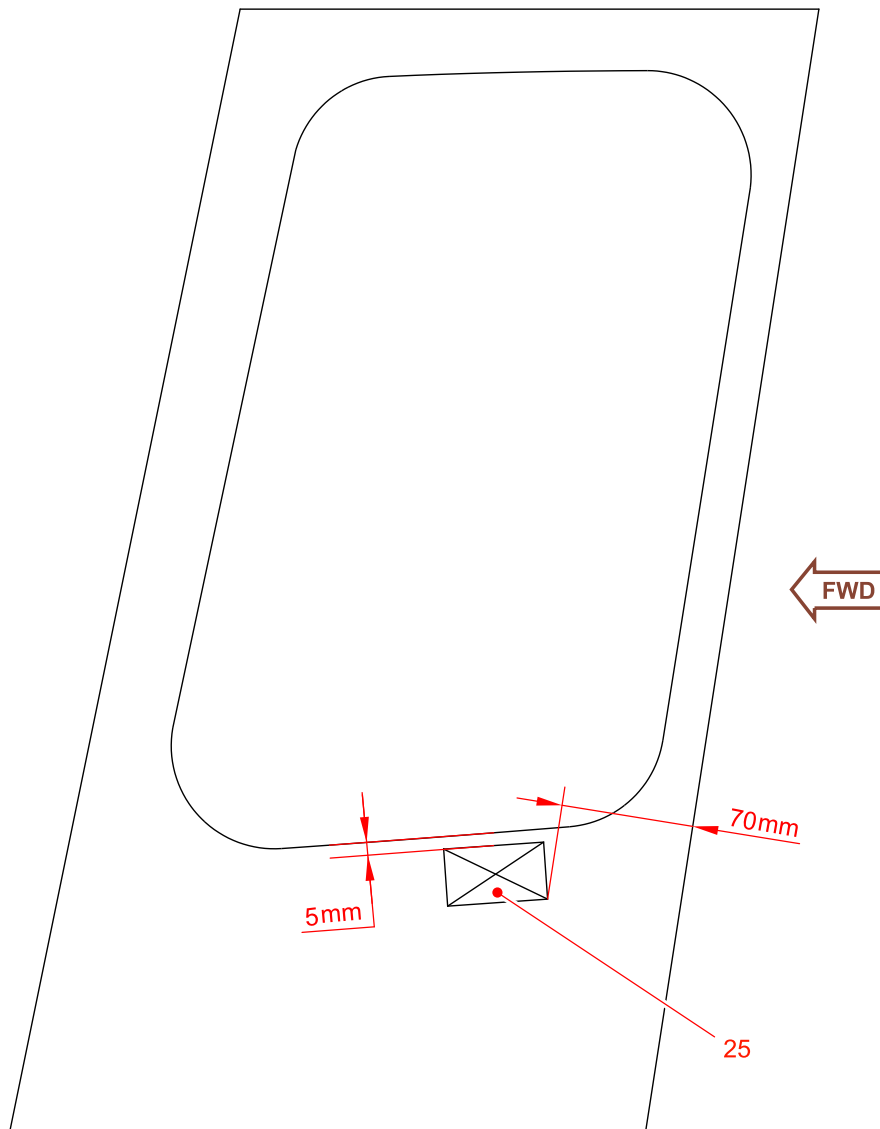
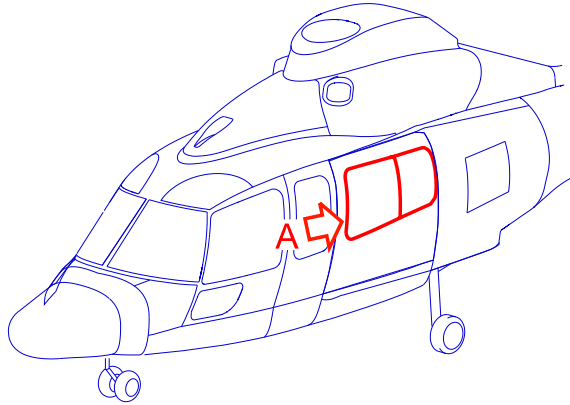


Figure 3

4.2.2. Install the LABEL 365A00-0932-58 (25) on sliding doors.



LH SHOWN  
RH SYMMETRICAL

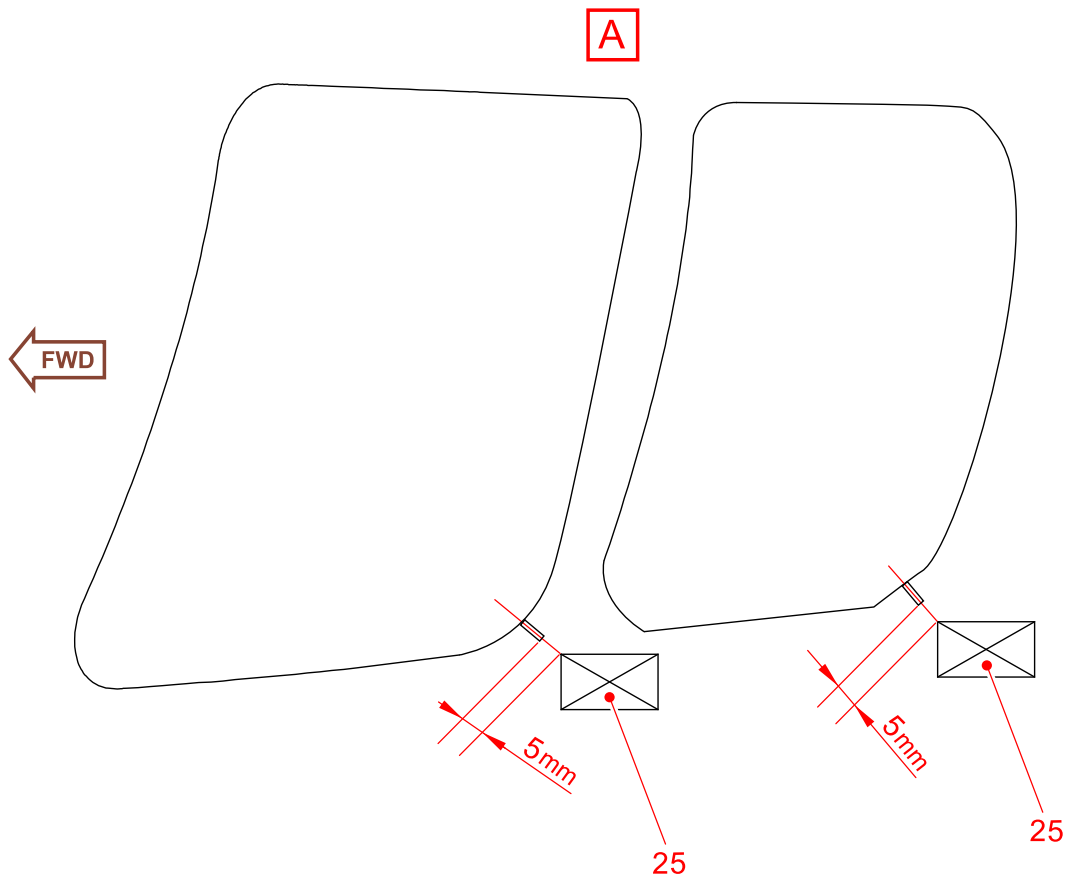


Figure 4

## 5. CLOSE UP

- 5.1. Remove all the tools, the materials and the equipment from your work area.
- 5.2. Record the new weight and moment in the applicable document.
- 5.3. Record the full compliance with this Alert Service Bulletin, with its issue number, in the helicopter documents and, if applicable, in the log card of the equipment or its next higher assembly.
- 5.4. Record the modification 0752C74 in the helicopter documents and if applicable, in the log card of the equipment or its next higher assembly.
- 5.5. Record compliance with this Alert Service Bulletin (see IN 3785-I-00 for instructions): QR code or hypertext link



[SB EC155-56-50-0001](#)

End of Service Bulletin