

# WORK ORDER

## 82970000071

### SAP

### (SMI)

<b>A/C Reg :</b>	<b>9M-LKE</b>
<b>A/C S/N :</b>	<b>8297</b>
<b>A/C Type :</b>	<b>AS 350 B3</b>

Schedule Maintenance Inspection/Defect Rectification	Man Hours
- 660H//24M - ASB 62.00.42 R0 para 3.B.2.b	
- 15H /7D ENG INSPECTION	
- 10H /7D A/F INSPECTION	


**SUMMARY WORK ORDER SIGNOFF SHEET**

CUSTOMER	A/C Registration	A/C MSN	Work Order No
KIHUAT TIMBER (M) SDN. BHD.	9M-LKE	8297	82970000071

**MI No:** AD 2018-0206 R0 (PO) **MI Title :** MAIN ROTOR – MAST UPPER BEARING SEALANT BEAD / INNER RACE RETAINING RINGS – INSPECTION

**Work Description :**  
Affected part: Equipped Main Rotor (M/R) shafts also named Main Rotor Mast (MRM), having Part Number (P/N) 350A37-1290-XX (where XX can be any numerical combination) and a s/n as listed in the applicable ASB, except those that have been subject to a specific inspection, confirming that the upper bearing inner race retaining rings are installed correctly.


<b>Life</b>	0:00AH 0M	<b>Work Card</b>	AD 2018-0206 R0
<b>Work Card Task Reference</b>			N/A

Task n°	Due at	Dup Insp	Tech Sign	Eng Sign	Eng Stamp	Date	Remarks/Action Taken
Task n° : LKE0001  AS350-MAIN ROTOR SHAFT P/N : 350A37-1290-04 S/N : FR2794	759:12AH 17/09/2020	N/A	7 AHM 455	<i>[Signature]</i>		15/09/2020	Found Satisfactory

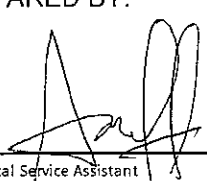
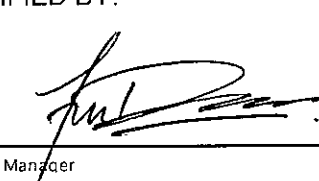
**MI No:** ASB 62.00.42 R0 (PO) **MI Title :** CHECK OF THE BEARING RETAINING RINGS OF THE MAIN ROTOR MAST

**Work Description :**  
The purpose of this ALERT SERVICE BULLETIN is to ensure the presence and proper installation of the two bearing retaining rings on the main rotor mast.

<b>Life</b>	0:00AH 0M	<b>Work Card</b>	ASB NO. 62.00.42 R0
<b>Work Card Task Reference</b>			N/A



Task n°	Due at	Dup Insp	Tech Sign	Eng Sign	Eng Stamp	Date	Remarks/Action Taken
Task n° : LKE0002  AS350-MAIN ROTOR SHAFT P/N : 350A37-1290-04 S/N : FR2794	759:12AH 17/09/2020	N/A	7 AHM 455	<i>[Signature]</i>		15/09/2020	Found Satisfactory

"Certifies that the work specified, except as otherwise specified was carried out i.a.w CAAM Part 145 and in that respect the aircraft/ aircraft component is considered ready to release to service."

<b>Engineering Services Instruction</b>		No. Of Pages : <u>17</u>												
1. AIRCRAFT /ENGINE /EQUIPMENT TYPE: AS350 B3	2. ATA CHAPTER: 62 3. EFFECTIVITY: 9M-LKE (S/N: 8297)													
4. DESCRIPTION: This ESI provides instruction for the check of two bearing retaining rings i.a.w. ASB AS350-62.00.42 R0 para 3.B.2.b. to comply with EASA AD 2018-0206 R0.														
5. REFERENCES / SOURCE DOC: 1. EASA AD 2018-0206 R0 2. ASB AS350-62.00.42 R0														
6. REASON: The absence of one of the two bearing retaining rings on the main rotor mast can result in damage to the main rotor mast and surrounding elements.														
7. REASON FOR REVISION: Initial.														
8. COMPLIANCE: <u>Once:</u> Before 17 September 2020 i.a.w. ASB AS350-62.00.42 R0 para 3.B.2.b. // EASA AD 2018-0206 R0.														
9. AFFECTED DEPARTMENT														
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 5%;">No.</th> <th style="width: 40%;">Department</th> <th style="width: 55%;">Task</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1.</td> <td>CAMO</td> <td>-Distribute work order for ESI/AS350B3/249 to be carried out. - To update Aircraft Log Book, Notice to Crew (NtC), Envision, and mod record book.</td> </tr> <tr> <td style="text-align: center;">2.</td> <td>Program &amp; Planning (P&amp;P)</td> <td>To ensure special tools per Appendix 1 of this ESI are available.</td> </tr> <tr> <td style="text-align: center;">3.</td> <td>Maintenance</td> <td>To carry out the instruction in accordance with ESI/AS350B3/249.</td> </tr> </tbody> </table>			No.	Department	Task	1.	CAMO	-Distribute work order for ESI/AS350B3/249 to be carried out. - To update Aircraft Log Book, Notice to Crew (NtC), Envision, and mod record book.	2.	Program & Planning (P&P)	To ensure special tools per Appendix 1 of this ESI are available.	3.	Maintenance	To carry out the instruction in accordance with ESI/AS350B3/249.
No.	Department	Task												
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2.	Program & Planning (P&P)	To ensure special tools per Appendix 1 of this ESI are available.												
3.	Maintenance	To carry out the instruction in accordance with ESI/AS350B3/249.												
Note: Please refer to continuation sheet (if applicable)														
PREPARED BY:   X _____ Technical Service Assistant  Ariff Imran MAZLAN DATE: 10 September 2020	VERIFIED BY:   X _____ CAM Manager  Muhammad Imran ISMAIL DATE: 11 Sep 2020													

10. \* The work recorded above has been carried out in accordance with the requirements of the \*\* Malaysian Civil Aviation Regulation / FAA Regulations / \_\_\_\_\_ for the time being in force and in that respect the aircraft / equipment is considered fit for Release to Service.  
\*\* Delete as required.




1. General

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
1.1	Read and comply with the safety instructions on helicopters parked in a repair shop as per Work Card 20.07.02.201 (MTC).  Remarks: <u>FOUND SATISFACTION</u>	<u>f</u>	<u>AHM 455</u>	<u>f</u>		<u>14/9/2020</u>
1.2	Observe all safety precautions and notes appropriate to this task in accordance with ASB AS350-62.00.42 R0.  Remarks: <u>FOUND SATISFACTION</u>	<u>f</u>	<u>AHM 455</u>	<u>f</u>		<u>14/9/2020</u>

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Aircraft Registration : 9M-LKE ; S/N : 8237




2. Preliminary steps (i.a.w. ASB AS350-62.00.42 R0 para 3.B.1.)

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
2.1	Park the helicopter in a hangar. Remarks: <u>Found Saris Saris GPM</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/9/2020</u>
2.2	Install the appropriate access equipment. Remarks: <u>Found Saris Saris GPM</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/9/2020</u>
2.3	Remove the equipment and furnishings necessary for proper access to the various work zones. Remarks: <u>Found Saris Saris GPM</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/9/2020</u>

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3. Check of the two bearing retaining rings (Figure 1, Figure 2, Figure 3, Figure 4) (i.a.w. ASB AS350-62.00.42 R0 para 3.B.2.b)

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.1	<p>Procedure with the main rotor mast (c) removal: Remove the main rotor mast (c) as per Task 62-31-00,4-1 (AMM),</p> <p>Remarks: <u>N/A ENDOSCOPIC PROCEDURE APPLIED. S</u>  <u>REFER PARA 3.4.</u></p>					
3.2	<p>Ensure the presence and proper positioning (in their groove) of the two bearing retaining rings (a) over the entire circumference of the main rotor mast (c) (Figure 2 Details C and D (bearing retaining rings poorly positioned) and Figure 3 Details C and D (correct positioning of the bearing retaining rings)),</p> <p>Remarks: <u>N/A MAIN ROTOR NOT REMOVED. S</u> </p>					
3.3	<p>If and only if the two bearing retaining rings (a) are present and correctly positioned, install the main rotor mast (c) as per Task 62-31-00,4-1 (AMM).</p> <p>Remarks: <u>N/A MAIN ROTOR NOT REMOVED. S</u> </p>					





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Aircraft Registration : 9M-LKE ; S/N : 0297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.4	<p><u>Endoscopic procedure without the main rotor mast (c) removal:</u> Check of the lower bearing retaining ring:</p> <p>Remarks: <u>Found Satisfactory</u></p>	<u>F</u>	<u>AHM 455</u>	<u>fyr.</u>		<u>14/9/2020</u>
3.5	<p>Remove and keep the "NR" sensor (not shown) as per Task 62-31-00,4-2 (AMM),</p> <p><i>NOTE 1: The number of peel shim elements (not shown) of the "NR" sensor must be identified in order to facilitate adjustment during assembly.</i></p> <p>Remarks: <u>Found Satisfactory</u></p>	<u>F</u>	<u>AHM 455</u>	<u>fyr.</u>		<u>14/9/2020</u>
3.6	<p>Insert the endoscope (zz) into the opening of the "NR" sensor,</p> <p><b>CAUTIONS: DO NOT INTERFERE WITH THE ENDOSCOPE (zz) AND THE PHONIC WHEEL WHILE THE MAIN ROTOR MAST IS ROTATING.</b></p> <p>Remarks: <u>Found Satisfactory</u></p>	<u>F</u>	<u>AHM 455</u>	<u>fyr.</u>		<u>14/9/2020</u>
3.7	<p>Slowly turn the main rotor mast (c),</p> <p>Remarks: <u>Found Satisfactory</u></p>	<u>F</u>	<u>AHM 455</u>	<u>fyr.</u>		<u>14/9/2020</u>

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Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.8	Ensure the presence and proper positioning (in its groove) of the lower bearing retaining ring (a) over the entire circumference of the main rotor mast (c) (Figure 2 Details C and D (bearing retaining rings poorly positioned) and Figure 3 Details C and D (correct positioning of the bearing retaining rings)),  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>flyi.</u>		<u>14/01/2020</u>
3.9	Install the "NR" sensor (not shown) as per Task 62-31-00,4-3 (AMM).  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>flyi.</u>		<u>14/01/2020</u>
3.10	<u>Check of the upper bearing retaining ring:</u> Protect the swashplate bearing and the space between the swashplate guide (d) and the main rotor mast (c) using adhesive (2) (Figure 4, Detail B),  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>flyi.</u>		<u>14/01/2020</u>
3.11	Remove the sealant bead (b) with the Plexiglas knife (xx),  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>flyi.</u>		<u>14/01/2020</u>

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Aircraft Registration : 9M-LKE ; S/N : 8297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.12	Remove the scissors driver as per the principle of Task 62-31-00,4-2 (AMM),  Remarks: <u>FOUND SATISFACTORY</u>		AHM 455			14/01/2020
3.13	Maintain the scissors driver on the upper sleeve with plastic clamps (vv),  Remarks: <u>FOUND SATISFACTORY</u>		AHM 455			14/01/2020
3.14	Remove the sealant bead on the main rotor mast (c) and scissors driver assembly using the Plexiglas knife (xx),  Remarks: <u>FOUND SATISFACTORY</u>		AHM 455			14/01/2020
3.14	Remove the fixed scissors on the swashplate guide side (d) as per the principle of Task 62-33-00,4-1 (AMM),  Remarks: <u>FOUND SATISFACTORY</u>		AHM 455			14/01/2020





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Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.15	Maintain the fixed scissors on the upper sleeve with plastic clamps (vv),  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/01/2020</u>
3.16	Remove and keep the swashplate guide's retaining washers and the pins,  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/01/2020</u>
3.17	Remove the adhesive (2) installed previously,  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/01/2020</u>
3.18	Slide the swashplate guide upward,  <b>CAUTION: CARE SHOULD BE TAKEN NOT TO DAMAGE THE BEARING SURFACE OF THE SCISSORS DRIVER AND THE TEFLON FABRIC.</b>  Remarks: <u>FOUND SATISFACTORY</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/01/2020</u>

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Aircraft Registration : 9M-LKE ; S/N : 8297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.19	Protect the lip seal, the main rotor mast (c) and the binding with adhesive (2),  Remarks: <u>Found Satisfactory</u>	<u>F</u>	AHM 455	<u>[Signature]</u>		<u>14/9/2020</u>
3.20	Remove the sealant bead with the Plexiglas knife (xx),  Remarks: <u>Found Satisfactory</u>	<u>F</u>	AHM 455	<u>[Signature]</u>		<u>14/9/2020</u>
3.21	Lift the O-ring,  <i>NOTE 2: If the O-ring is damaged, contact AHM CAMO.</i>  Remarks: <u>Found Satisfactory</u>	<u>F</u>	AHM 455	<u>[Signature]</u>		<u>14/9/2020</u>
3.22	Ensure the presence and proper positioning of the upper bearing retaining ring (a) (Figure 2 Details C and D (bearing retaining rings poorly positioned) and Figure 3 Details C and D (correct positioning of the bearing retaining rings)).  Remarks: <u>Found Satisfactory</u>	<u>F</u>	AHM 455	<u>[Signature]</u>		<u>14/9/2020</u>

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Aircraft Registration : 9M-LKE ; S/N : 8297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.23	If the two bearing retaining rings (a) are present and correctly positioned: Install the scissors driver as per the principle of Task 62-31-00,4-3 (AMM),  Remarks: <u>found satisfactory</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/9/2020</u>
3.24	Install the fixed scissors on the washplate guide side (d) as per the principle of Task 62-33-00,4-1 (AMM),  Remarks: <u>found satisfactory</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>14/9/2020</u>
3.25	Install and keep the washplate guide's attachment washers and pins,  Remarks: <u>found satisfactory</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>15/9/2020</u>
3.26	Discard the plastic clamps (vv).  Remarks: <u>found satisfactory</u>	<u>7</u>	<u>AHM 455</u>	<u>[Signature]</u>		<u>15/9/2020</u>

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Aircraft Registration : 9M-LKE ; S/N : 0297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
3.27	Perform the job completion as per paragraph 4.  Remarks: <u>FOUND SATISFA GARY</u>		AHM 455			15/10/2020
3.28	If one or both bearing retaining rings (a) are absent or incorrectly positioned: Comply with ESI/AS350B3/250.  Remarks: <u>nil FINDING. FOUND SATISFA GARY.</u>		144			15/10/2020

4. Final steps (i.a.w. ASB AS350-62.00.42 R0 para 3.B.3 and 3.B.4)

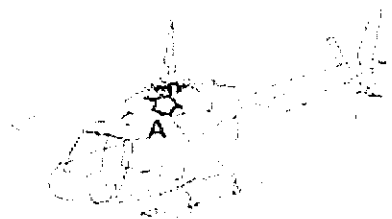
Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
4.1	Clean and recondition the work areas and the helicopter as per Work Card 20.07.03.408 (MTC).  Remarks: <u>FOUND SATISFA GARY</u>		AHM 455			15/10/2020

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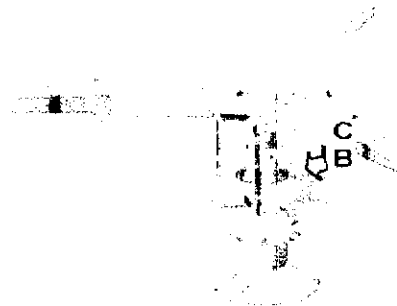
Aircraft Registration : 9M-445 ; S/N : 0297

Item	Work Required	Performed By		Inspected By - CRS*		
		Sign	Staff. No	Sign	Auth. No.	Date
4.2	Install the furnishings and equipment which were removed during preliminary steps (paragraph 2). Remarks: <u>Found Satisfactory</u>		AHM 455			15/12/2020
4.3	Remove the access equipment. Remarks: <u>Found Satisfactory</u>		AHM 455			15/12/2020
4.4	Set the helicopter into flight condition. Remarks: <u>Found Satisfactory</u>		AHM 455			15/12/2020
4.5	In case of absence or incorrect positioning of bearing retaining rings, contact AHM CAMO for further instructions. Remarks: <u>nil finding. found satisfactory</u>		144			15/12/2020

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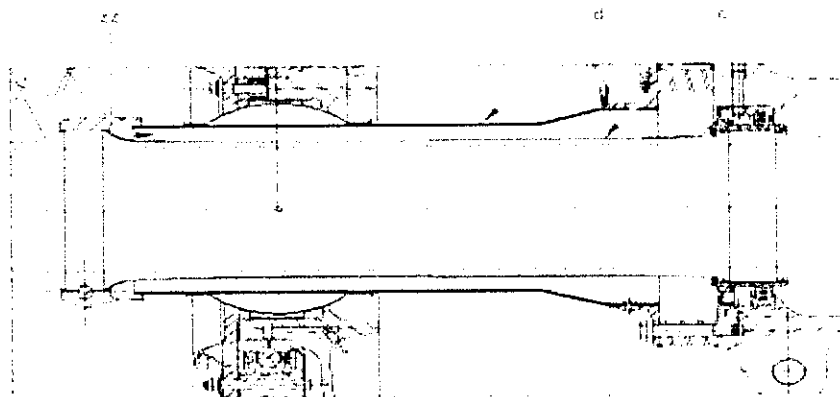


B



C

QUAD. HYDRAULIC SYSTEM



C

SINGLE HYDRAULIC SYSTEM

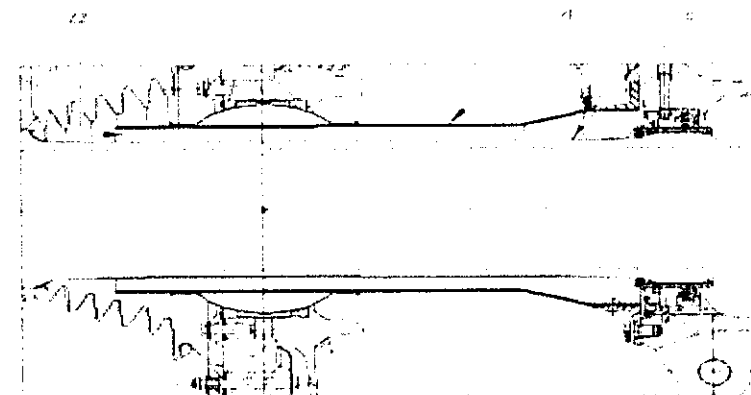


Figure 1 - Endoscopic inspection of the sealant bead

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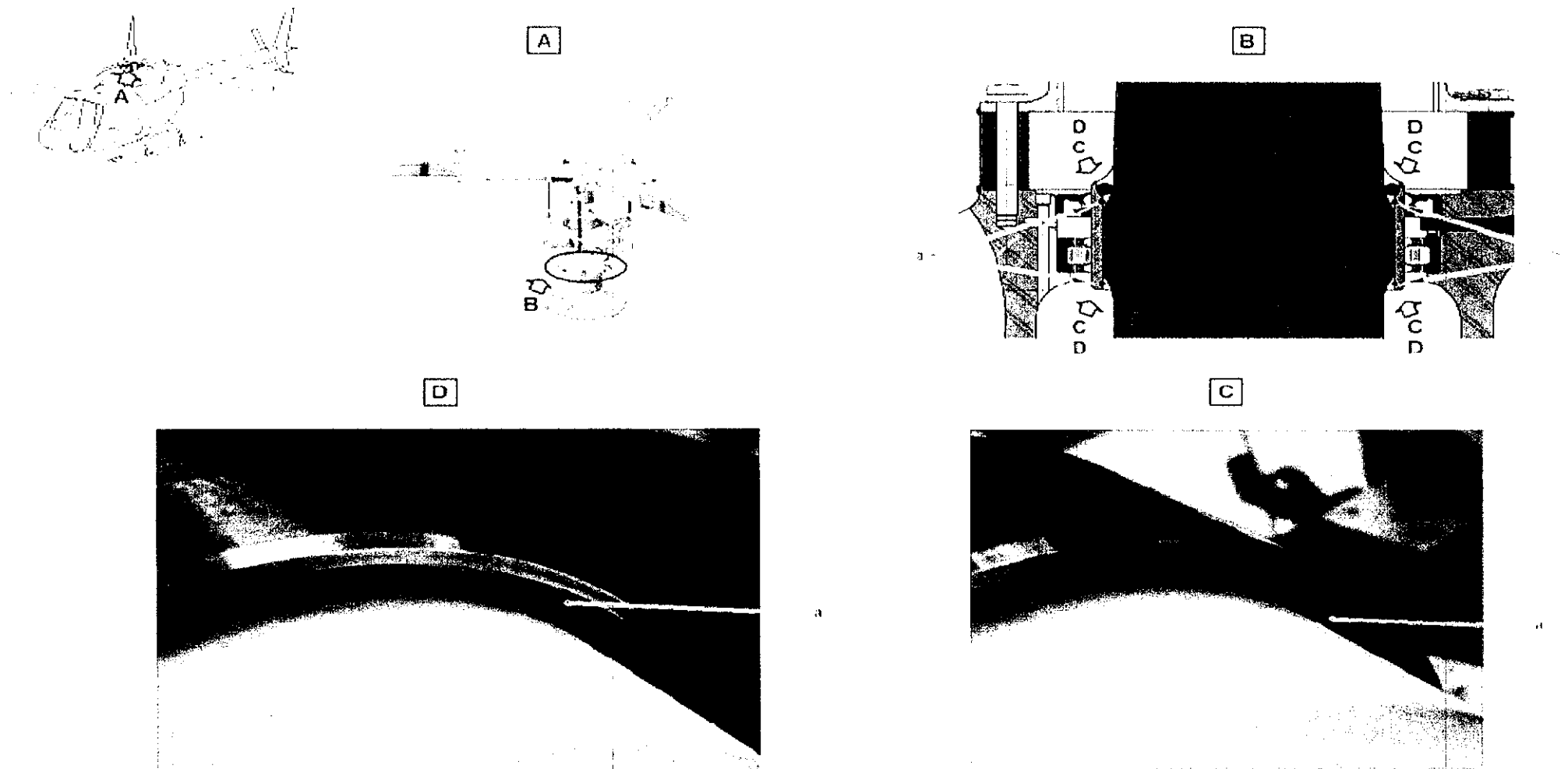


Figure 2 - Incorrect positioning of the bearing retaining rings

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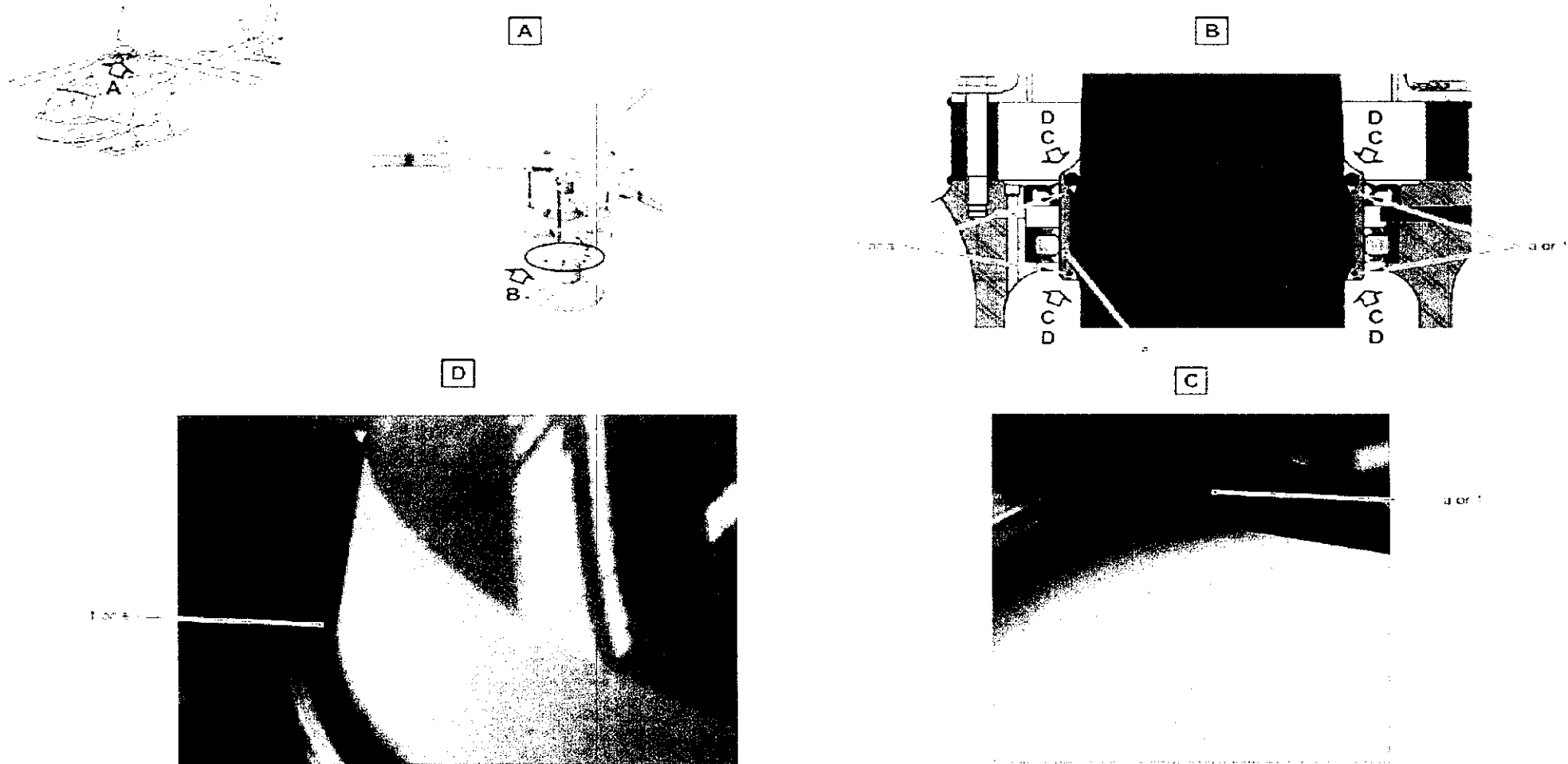


Figure 3 - Correct positioning of the bearing retaining rings

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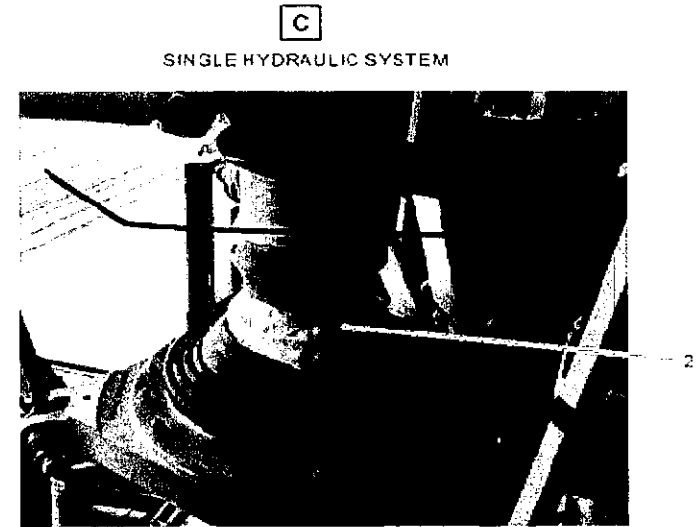
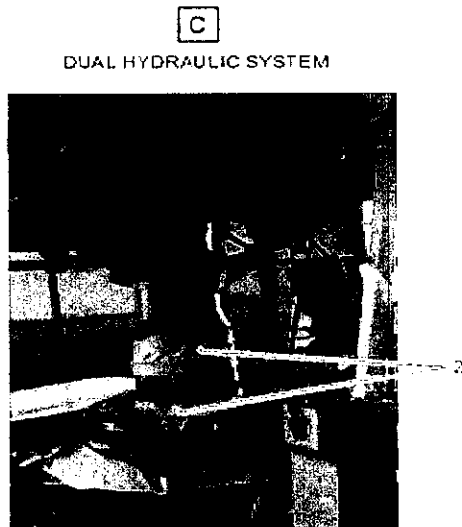
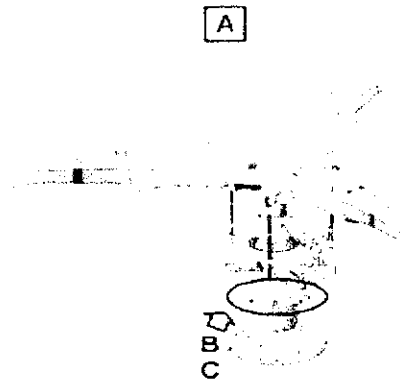


Figure 4 - Endoscopic check of the bearing retaining rings

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## APPENDIX 1: MATERIAL INFORMATION

### A. NEW PARTS (IF REQUIRED)

No.	Keyword	Qty.	New P/N	Old P/N	Rem.
1	Ring, bearing retaining	2	350A37-1268-20	350A37-1268-20	Replacement, if necessary

### B. CONSUMABLES

As per Work Cards and Tasks mentioned in the ASB AS350-62.00.42 R0.

### C. SPECIAL TOOLS

No.	Keyword	Qty.	P/N	Item
1.	Endoscope	1	Commercial P/N	zz
2.	Dentist's mirror	1	Commercial P/N	yy
3.	Plexiglas knife	1	Commercial P/N	xx
4.	Adhesive tape (masking tape type)	1	Commercial P/N	ww
5.	Plastic clamp	AR	Commercial P/N	vv

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1. Work Order No.:

82970000071

2. Item	3. Defect / Work	4. Name & Date	5. Details of rectification with reference to approved data	6. Tech.	7. CRS #												
1.	Duplicate inspection to be carried out on rotating and non-rotating scissors installation          8. P/N Removed : 9. S/N Removed :	[Signature] 15/9/2020	Duplicate inspection performed in accordance with MDE 2.25 <table border="1" data-bbox="1142 359 1780 534"> <thead> <tr> <th></th> <th>Signature</th> <th>Approval Stamp</th> <th>Date/Time</th> </tr> </thead> <tbody> <tr> <td>1<sup>st</sup> inspection</td> <td>[Signature]</td> <td>[MST7 Stamp]</td> <td>15/9/2020 / 1500</td> </tr> <tr> <td>2<sup>nd</sup> inspection</td> <td>[Signature]</td> <td>[MST7 Stamp]</td> <td>15/9/2020 / 1515</td> </tr> </tbody> </table>    10. P/N Installed : 11. S/N Installed : 12. Manhours :		Signature	Approval Stamp	Date/Time	1 <sup>st</sup> inspection	[Signature]	[MST7 Stamp]	15/9/2020 / 1500	2 <sup>nd</sup> inspection	[Signature]	[MST7 Stamp]	15/9/2020 / 1515	Sign          ID No       Date    15/9/2020	Sign  [Signature]       App No  [MST7 Stamp]       Date    15/9/2020
	Signature	Approval Stamp	Date/Time														
1 <sup>st</sup> inspection	[Signature]	[MST7 Stamp]	15/9/2020 / 1500														
2 <sup>nd</sup> inspection	[Signature]	[MST7 Stamp]	15/9/2020 / 1515														
	8. P/N Removed : 9. S/N Removed :		10. P/N Installed : 11. S/N Installed : 12. Manhours :	Sign          ID No       Date    	Sign          App No       Date    												

13. # The work recorded above has been carried out in accordance with the requirements of the \* Malaysian Civil Aviation Regulations / FAA Regulations / \_\_\_\_\_ for the time being in force and in that respect the aircraft / equipment is considered fit for Release to Service.

\* Delete not applicable