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AgustaWestland Products

SERVICE BULLETIN

N° 139-545

DATE: June 11, 2020

REV. : A - February 16, 2021

TITLE

ATA 78 - EXHAUST RETROMOD

REVISION LOG

Part II of Rev. A corresponds to the previous issue of this SB.

Revision A is issued in order to introduce the FWD exhaust retromod P/N 3G7810P02311 described in Part I.

1. PLANNING INFORMATION

A. EFFECTIVITY

Part I: All forward exhaust assemblies P/N 3G7810A00332 and P/N 3G7810A00232 not already equipped with forward exhaust reinforcements P/N 3G7810A17351, P/N 3G7810A17451, P/N 3G7810A17552 and P/N 3G7810A17652 (refer to Figure 6 for reinforcement identification) installed on AW139 helicopters from S/N 31400 up to S/N 31904, S/N 31944 and S/N 31951 from S/N 41300 up to S/N 41586 and from S/N 41801 to 41804 or kept in stock only before installing them on the helicopter

Part II: All rear ejector assemblies P/N 3G7810A02132 and P/N 3G7810A02232 not already equipped with rear ejectors reinforcements P/N 3G7810A17952, P/N 3G7810A19251 and P/N 3G7810A19351 (refer to Figures 9 and 13 for reinforcement identification) installed on AW139 helicopters from S/N 31400 up to S/N 31904, S/N 31944 and S/N 31951, from S/N 41300 up to S/N 41586 and from S/N 41801 to 41804 or kept in stock only before installing them on the helicopter.

B. COMPLIANCE

At Customer's option.

C. CONCURRENT REQUIREMENTS

N.A.

D. REASON

This Service Bulletin is issued in order to provide the necessary instruction on how to perform the FWD exhaust retromod P/N 3G7810P02311 and the rear ejector retromod P/N 3G7810P01811.

E. DESCRIPTION

Part I of this Service Bulletin provides the instruction to reinforce the forward exhaust LH P/N 3G7810A00332 and forward exhaust RH P/N 3G7810A00232 in order to be aligned with the latest design configuration.

Part II of this Service Bulletin provides the instruction to reinforce the LH rear ejector assy P/N 3G7810A02132 and RH rear ejector assy P/N 3G7810A02232 in order to be aligned with the latest design configuration.

F. APPROVAL

The technical content of this Service Bulletin is approved under the authority of DOA nr. EASA.21.J.005. For helicopters registered under other Aviation Authorities, before

applying the Service Bulletin, applicable Aviation Authority approval must be checked within Leonardo Helicopters customer portal.

EASA states mandatory compliance with inspections, modifications or technical directives and related time of compliance by means of relevant Airworthiness Directives.

If an aircraft listed in the effectivity embodies a modification or repair not LHD certified and affecting the content of this Service Bulletin, it is responsibility of the Owner/Operator to obtain a formal approval by Aviation Authority having jurisdiction on the aircraft, for any adaptation necessary before incorporation of the present Service Bulletin.

G. MANPOWER

To comply with this Service Bulletin, the following MMH are deemed necessary:

Part I: approximately thirty-two (32) MMH;

Part II: approximately sixteen (16) MMH.

MMH are based on hands-on time and can change with personnel and facilities available.

H. WEIGHT AND BALANCE

PART I

WEIGHT (kg)	0.497	
	ARM (mm)	**MOMENT (kgmm)**
LONGITUDINAL BALANCE	7320	3638
LATERAL BALANCE	0.0	0.0

PART II

WEIGHT (kg)	0.986	
	ARM (mm)	**MOMENT (kgmm)**
LONGITUDINAL BALANCE	7927	7816
LATERAL BALANCE	0.0	0.0

I. REFERENCES

1) PUBLICATIONS

DATA MODULE		DESCRIPTION	PART
DM01	39-A-00-20-00-00A-120A-A	Helicopter on ground for a safe maintenance.	All
DM02	39-A-06-41-00-00A-010A-A	Access doors and panels - General data.	All
DM03	39-E-78-10-04-00A-520A-A	Left exhaust duct - Remove procedure	I

DATA MODULE		DESCRIPTION	PART
DM04	39-E-78-10-04-00A-720A-A	Left exhaust duct - Install procedure	I
DM05	39-E-78-10-06-00A-520A-A	Right exhaust duct - Remove procedure	I
DM06	39-E-78-10-06-00A-720A-A	Right exhaust duct - Install procedure	I
DM07	39-E-78-10-01-00A-520A-A	Rear exhaust module - Remove procedure	II
DM08	39-E-78-10-01-00A-720A-A	Rear exhaust module - Install procedure	II
DM09	39-E-78-10-01-01A-520A-B	Left/right ejector (rear exhaust module) - Remove procedure	II
DM10	39-E-78-10-01-01A-720A-B	Left/right ejector (rear exhaust module) - Install procedure	II

2) ACRONYMS

AMDI	Aircraft Material Data Information
AMP	Aircraft Maintenance Publication
DM	Data Module
DOA	Design Organization Approval
EASA	European Aviation Safety Agency
FWD	Forward
IPD	Illustrated Part Data
ITEP	Illustrated tool and equipment publication
LHD	Leonardo Helicopters
MMH	Maintenance Man Hours

3) ANNEX

N.A.

J. PUBLICATIONS AFFECTED

AW139 IPD.

K. SOFTWARE ACCOMPLISHMENT SUMMARY

N.A.

2. MATERIAL INFORMATION

A. REQUIRED MATERIALS

1) PARTS

PART I

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
1	**3G7810P02311**		**FWD EXHAUST RETROMOD**	**REF**	**.**		-
2	3G7810A17351		FWD LH exhaust upper reinforcement	1	..		139-545L2
3	3G7810A17451		FWD RH exhaust upper reinforcement	1	..		139-545L2
4	3G7810A17552		FWD LH exhaust lateral reinforcement	1	..		139-545L2
5	3G7810A17652		FWD RH exhaust lateral reinforcement	1	..		139-545L2
6	MS20615-3M3		Rivet	0.1 kg	..		139-545L2
7	MS20615-3M3R		Rivet	8	..		139-545L2
8	MS20615-3M4		Rivet	0.1 kg	..		139-545L2
9	MS20615-3M4R		Rivet	2	..		139-545L2
10	MS20615-4M5		Rivet	0.1 kg	..		139-545L2
11	MS20615-4M5R		Rivet	9	..		139-545L2
12	MS20615-4M6		Rivet	0.1 kg	..		139-545L2
13	MS20615-4M6R		Rivet	0.1 kg	..		139-545L2
14	MS20615-4M7		Rivet	0.1 kg	..		139-545L2
15	NAS1097U3-3		Rivet	4	..		139-545L2

PART II

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
16	**3G7810P01811**		**REAR EJECTOR RETROMOD**	**REF**	**.**		-
17	3G7810A17952	3G7810A17952M01 or 3G7810A17952M02	Rear ejector reinforcement	2	..		139-545L1
18	3G7810A19251		Rear ejector reinforcement	2	..		139-545L1
19	3G7810A19351		Rear ejector reinforcement	2	..		139-545L1
20	A297A04TW02		Rivet	2	..		139-545L1
21	MS20615-3M3		Rivet	0.1 kg	..		139-545L1
22	MS20615-3M3R		Rivet	100	..		139-545L1
23	MS20615-4M4R		Rivet	38	..		139-545L1

2) CONSUMABLES

Refer to AMDI for the consumable materials required to comply with the AMP DM referenced in the accomplishment instructions.

3) LOGISTIC MATRIX

In order to apply this Service Bulletin, the following Logistic P/N can be ordered in accordance with the applicable notes:

LOGISTIC P/N	Q.TY (PER HELO)	NOTE	PART
139-545L1	1		II
139-545L2	1		I

B. SPECIAL TOOLS

Refer to ITEP for the special tools required to comply with the AMP DM referenced in the accomplishment instructions.

C. INDUSTRY SUPPORT INFORMATION

Product enhancement.

3. 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 re-use.

b) Exercise extreme care during drilling operations to prevent instruments, cables and hoses damage.

c) 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.

d) Exposed thread surface and nut must be protected using a layer of tectyl according to MIL-C-16173 grade I (P/N 891 D, Class I).

e) All lengths are in mm.

PART I

NOTE

Steps 1 thru 4 are not applicable for components kept in stock.

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.
2. In accordance with AMP DM 39-A-06-41-00-00A-010A-A and with reference to Figure 1, gain access to the area affected by the installation.
3. In accordance with AMP DM 39-E-78-10-01-00A-520A-A and with reference to Figure 1, remove the rear exhaust module from the helicopter.
4. In accordance with AMP DM 39-E-78-10-04-00A-520A-A and DM 39-E-78-10-06-00A-520A-A and with reference to Figure 11, remove FWD exhaust LH P/N 3G7810A00332 and FWD exhaust RH P/N 3G7810A00232 from the helicopter.

NOTE

Step 5 applies both to LH and RH FWD exhausts.

5. With reference to Figures 1 thru 7 perform the forward exhaust retromod P/N 3G7810P02311 for one side as described in the following procedure:

5.1 With reference to Figure 3 View B (parts to remove), in the indicated positions, drill out n°11 rivets P/N MS20615-4M5 and rivet P/N MS20615-4M5R to remove oil breather flange LH P/N 3G7810A15951 or oil breather flange RH P/N 3G7810A16051. Retain oil breather flange for later reuse.

5.2 With reference to Figure 3 View B (parts to remove), in the indicated positions, drill out n°6 rivets P/N MS20615-4M6 to remove side bracket P/N 3G7810A10751. Retain side bracket for later reuse.

5.3 With reference to Figure 3 View B (parts to remove), in the indicated positions, drill out n°2 rivets P/N MS20615-3M4 and rivet P/N MS20615-3M3R.

5.4 With reference to Figure 3 View B (parts to remove) and Figure 15, perform the indicated cut-outs on the LH holed stiffener P/N 3G7810A15151 or RH holed stiffener P/N 3G7810A15651.

5.5 With reference to Figure 4 View B (parts to install), install FWD LH exhaust lateral reinforcement P/N 3G7810A17552 or FWD RH exhaust lateral reinforcement P/N 3G7810A17652 by means of n°21 rivets P/N MS20615-3M3, n°8 rivets P/N MS20615-3M3R and n°3 rivets P/N MS20615-3M4.

5.6 With reference to Figure 4 View B (parts to install) and Figure 16 View F, reinstall oil breather flange LH P/N 3G7810A15951 or oil breather flange RH P/N 3G7810A16051 by means of n°11 rivets P/N MS20615-4M5 and rivet P/N MS20615-4M5R.

5.7 With reference to Figure 4 View B (parts to install) and Figure 16 View F, reinstall side bracket P/N 3G7810A10751 by means of n°4 rivets P/N MS20615-4M6R and n°2 rivets P/N MS20615-4M7.

5.8 With reference to Figure 7 View G (parts to remove), in the indicated positions, drill out n°8 rivets P/N MS20615-4M5 to remove upper bracket LH P/N 3G7810A10652 or upper bracket RH P/N 3G7810A11452. Retain upper bracket for later reuse.

5.9 With reference to Figure 7 View G (parts to remove), in the indicated positions, drill out n°4 rivets P/N NAS1097U3-3, n°2 rivets P/N MS20615-3M4 and n°2 rivets P/N MS20615-3M3 to remove closure plate P/N 3G7810A14851. Discard closure plate.

5.10 With reference to Figure 7 View G (parts to remove), in the indicated positions, drill out n°10 rivets P/N MS20615-3M3R.

5.11 With reference to Figure 7 View G (parts to install), install FWD LH exhaust upper reinforcement P/N 3G7810A17351 or FWD RH exhaust upper reinforcement P/N 3G7810A17451 by means of n°34 rivets P/N MS20615-3M3, n°12 rivets P/N MS20615-3M4 and n°4 rivets P/N NAS1097U3-3.

5.12 With reference to Figure 7 View G (parts to install) and Figure 16 View F, reinstall upper bracket LH P/N 3G7810A10652 or upper bracket RH P/N 3G7810A11452 by means of n°8 rivets P/N MS20615-4M5R.

6. Repeat step 5 for the symmetric side.
7. With reference to Figure 2, remark FWD exhaust LH P/N 3G7810A00332 as “P/N 3G7810A00332 REV.B" by means of ink marking rubber stamp method.
8. With reference to Figure 2, remark FWD exhaust RH P/N 3G7810A00232 as “P/N 3G7810A00232 REV.B" by means of ink marking rubber stamp method.
9. In accordance with AMP DM 39-E-78-10-04-00A-720A-A and DM 39-E-78-10-06-00A-720A-A and with reference to Figure 1, reinstall FWD exhaust LH P/N 3G7810A00332 and FWD exhaust RH P/N 3G7810A00232 on the helicopter.

NOTE

Perform the following steps 10 and 11 only if Part II of this Service Bulletin is not intended to be embodied immediately after Part I.

10. In accordance with AMP DM 39-E-78-10-01-01A-720A-B and with reference to Figure 1, reinstall LH rear ejector assy P/N 3G7810A02132 and RH rear ejector assy P/N 3G7810A02232 on the rear exhaust module.
11. In accordance with AMP DM 39-E-78-10-01-00A-720A-A and with reference to Figure 1, reinstall the rear exhaust module on the helicopter.
12. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
13. Return the helicopter to flight configuration and record for compliance with Part I of this Service Bulletin on the helicopter logbook.
14. Send the attached compliance form to the following mail box:

    engineering.support.lhd@leonardocompany.com

    As an alternative, gain access to My Communications section on Leonardo WebPortal and compile the “Service Bulletin Application Communication”.

PART II

NOTE

Steps 1 thru 3 are not applicable for components kept in stock.

NOTE

Perform the following steps 1 thru 3 only if Part II of this Service Bulletin has not been embodied immediately after Part I, otherwise skip to step 4

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.
2. In accordance with AMP DM 39-A-06-41-00-00A-010A-A and with reference to Figure 8, gain access to the area affected by the installation.
3. In accordance with AMP DM 39-E-78-10-01-00A-520A-A and with reference to Figure 8, remove the rear exhaust module from the helicopter.

NOTE

Step 4 is not applicable for rear ejector assy kept in stock.

4. In accordance with AMP DM 39-E-78-10-01-01A-520A-B and with reference to Figure 8, remove the LH rear ejector assy P/N 3G7810A02132 and RH rear ejector assy P/N 3G7810A02232 from the rear exhaust module.

NOTE

Step 5 applies both to LH and RH rear ejectors .

5. With reference to Figures 9 thru 17 perform the rear ejector retromod P/N 3G7810P01811 for one side as described in the following procedure:
   - 5.1 With reference to Figure 11 (LH) or to Figure 9 (RH), temporarily locate the rear exhaust reinforcement P/N 3G7810A19351 on the cylindrical pipe P/N 3G7810A06152.
   - 5.2 With reference to Figure 11 View D (LH) or to Figure 16 View M (RH), using reinforcement with n°25 pilot holes as a template, drill n°25 rivet holes Ø 2.36 ÷ 2.62 through the reinforcement and the cylindrical pipe.
   - 5.3 With reference to Figure 12 (LH) or to Figure 15 (RH), temporarily locate the rear exhaust reinforcement P/N 3G7810A19251 on the cylindrical pipe P/N 3G7810A06152.

5.4 With reference to Figure 12 View E (LH) or to Figure 15 View N (RH), using reinforcement with n°25 pilot holes as a template, drill n°25 rivet holes Ø 2.36 ÷ 2.62 through the reinforcement and the cylindrical pipe.

NOTE

Perform step 5.5 only for LH side

5.5 With reference to Figure 12 Section F-F, drill out the existing rivets from the cylindrical pipe P/N 3G7810A06152 to remove external cup assy exhaust LH P/N 3G7810A14331, central cup assy exhaust P/N 3G7810A16431 and internal cup assy exhaust LH P/N 3G7810A14131. Retain cup assemblies for later reuse.

NOTE

Perform step 5.6 only for RH side

5.6 With reference to Figure 16 Section P-P, drill out the existing rivets from the cylindrical pipe P/N 3G7810A06152 to remove external cup assy exhaust RH P/N 3G7810A14431, central cup assy exhaust P/N 3G7810A16431 and internal cup assy exhaust RH P/N 3G7810A14231. Retain cup assemblies for later reuse.

5.7 With reference to Figure 10 Section T-T and Section C-C (LH) or to Figure 14 Section K-K and Section L-L (RH), temporarily locate the rear exhaust reinforcement P/N 3G7810A17952 inside the cylindrical pipe P/N 3G7810A06152.

5.8 With reference to Figure 2 and Figure 17, countermark n° 70 existing cylindrical pipe rivet holes on the rear exhaust reinforcement P/N 3G7810A17952.

5.9 With reference to Figure 17, drill n°50 rivet holes Ø 2.36 ÷ 2.62 and n°20 rivet holes Ø 3.18 ÷ 3.43 in the previously marked positions.

NOTE

Perform step 5.10 only if P/N 3G7810A17952M01 is provided.

5.10 With reference to Figure 17, drill n°42 pilot holes Ø 2.00 in the indicated positions on the rear exhaust reinforcement P/N 3G7810A17952.

5.11 With reference to Figure 9 Bottom View, temporarily locate the rear exhaust reinforcement P/N 3G7810A17952 and countermark n° 42 rivet holes on the cylindrical pipe P/N 3G7810A06152.

5.12 With reference to Figure 9 Bottom View, drill n°42 rivet holes Ø 2.36 ÷ 2.62 in the previously marked positions on the cylindrical pipe.

5.13 With reference to Figure 9 Bottom View, Figure 11 View D and Figure 12 View E, install rear exhaust reinforcements P/N 3G7810A17952, P/N 3G7810A19351 and P/N 3G7810A19251 by means of n°42 rivets P/N MS20615-3M3 and n°50 rivets P/N MS20615-3M3R.

NOTE

Perform step 5.14 only for LH side

5.14 With reference to Figure 10 View B and Figure 12 Section F-F, reinstall external cup assy exhaust LH P/N 3G7810A14331, central cup assy exhaust P/N 3G7810A16431 and internal cup assy exhaust LH P/N 3G7810A14131 by means of n°20 rivets P/N MS20615-4M4R.

NOTE

Perform step 5.15 only for RH side

5.15 With reference to Figure 14 View J and Figure 9 Section P-P, reinstall external cup assy exhaust RH P/N 3G7810A14431, central cup assy exhaust P/N 3G7810A16431 and internal cup assy exhaust RH P/N 3G7810A14231 by means of n°18 rivets P/N MS20615-4M4R and 2 rivets P/N A297A04TW02

6. Repeat step 5 for the symmetric side.
7. With reference to Figure 9, remark rear ejector assy LH P/N 3G7810A02132 as “P/N 3G7810A02132 REV.B" by means of ink marking rubber stamp method.
8. With reference to Figure 13, remark rear ejector assy RH P/N 3G7810A02232 as “P/N 3G7810A02232 REV.B" by means of ink marking rubber stamp method.
9. In accordance with AMP DM 39-E-78-10-01-01A-720A-B and with reference to Figure 8, reinstall the LH rear ejector assy P/N 3G7810A02132 and RH rear ejector assy P/N 3G7810A02232 on the rear exhaust module.
10. In accordance with AMP DM 39-E-78-10-01-00A-720A-A and with reference to Figure 8, reinstall the rear exhaust module on the helicopter.
11. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
12. Return the helicopter to flight configuration and record for compliance with Part II of this Service Bulletin on the helicopter logbook.
13. Send the attached compliance form to the following mail box:

    engineering.support.lhd@leonardocompany.com

    As an alternative, gain access to My Communications section on Leonardo WebPortal and compile the “Service Bulletin Application Communication”.

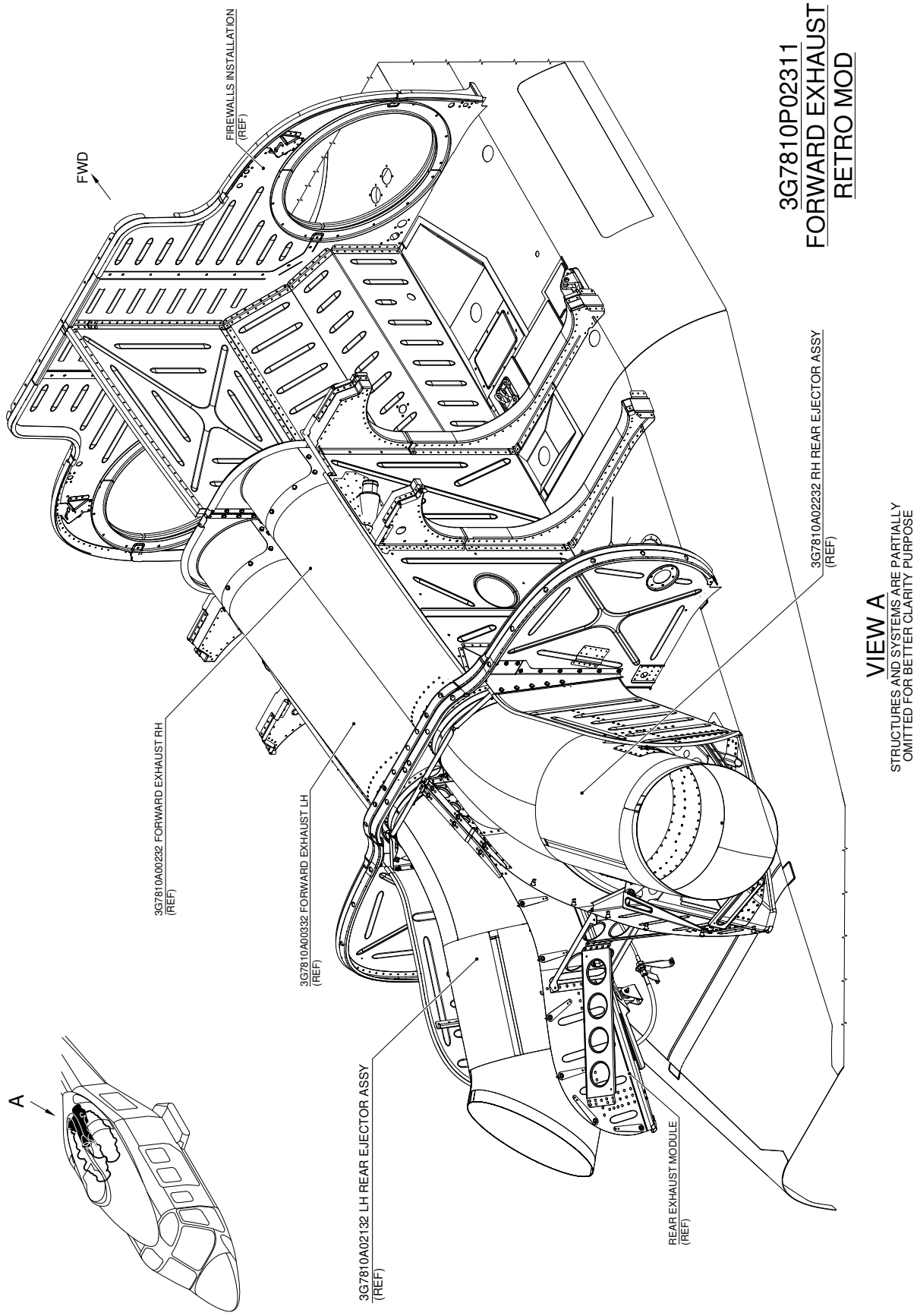

3G7810P02311
FORWARD EXHAUST
RETRO MOD
FWD
FIREWALLS INSTALLATION
(REF)
3G7810A02232 RH REAR EJECTOR ASSY
(REF)
VIEW A
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
3G7810A00232 FORWARD EXHAUST RH
(REF)
3G7810A00332 FORWARD EXHAUST LH
(REF)
A
3G7810A02132 LH REAR EJECTOR ASSY
(REF)
REAR EXHAUST MODULE
(REF)

Figure 1

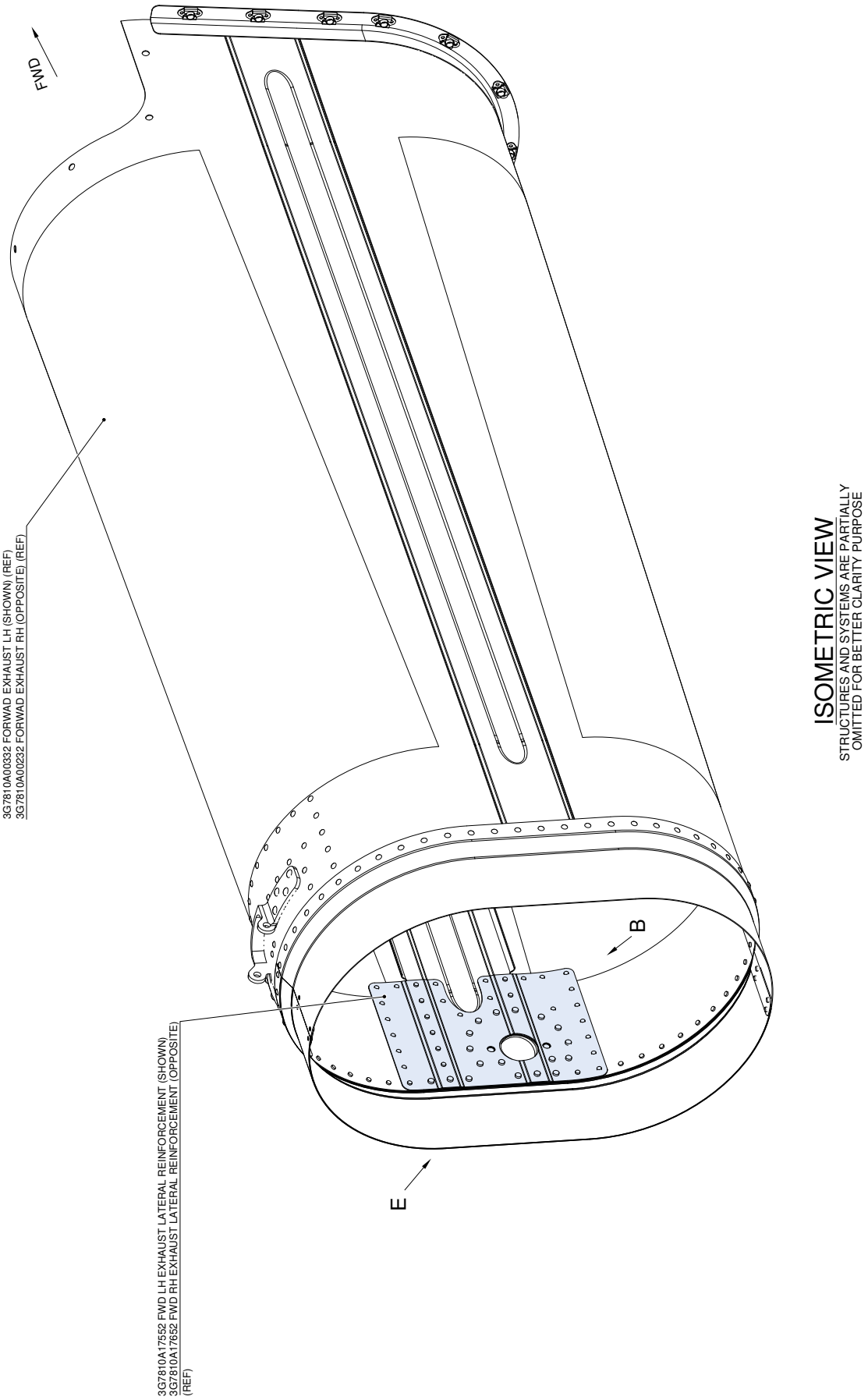

FWD
3G7810A00332 FORWAD EXHAUST LH (SHOWN) (REF)
3G7810A00232 FORWAD EXHAUST RH (OPPOSITE) (REF)
3G7810A17552 FWD LH EXHAUST LATERAL REINFORCEMENT (SHOWN)
3G7810A17652 FWD RH EXHAUST LATERAL REINFORCEMENT (OPPOSITE)
(REF)
B
E
ISOMETRIC VIEW
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 2

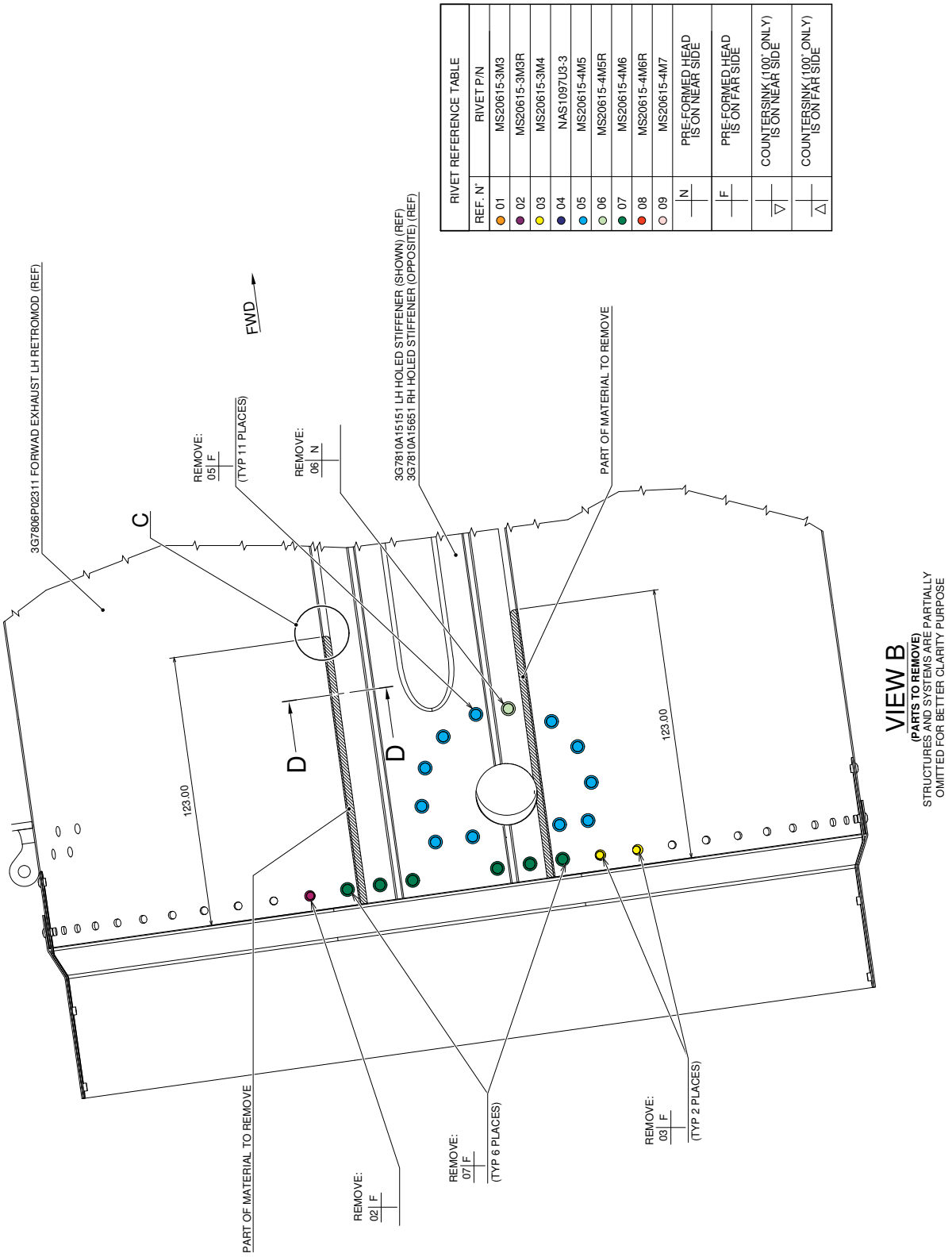
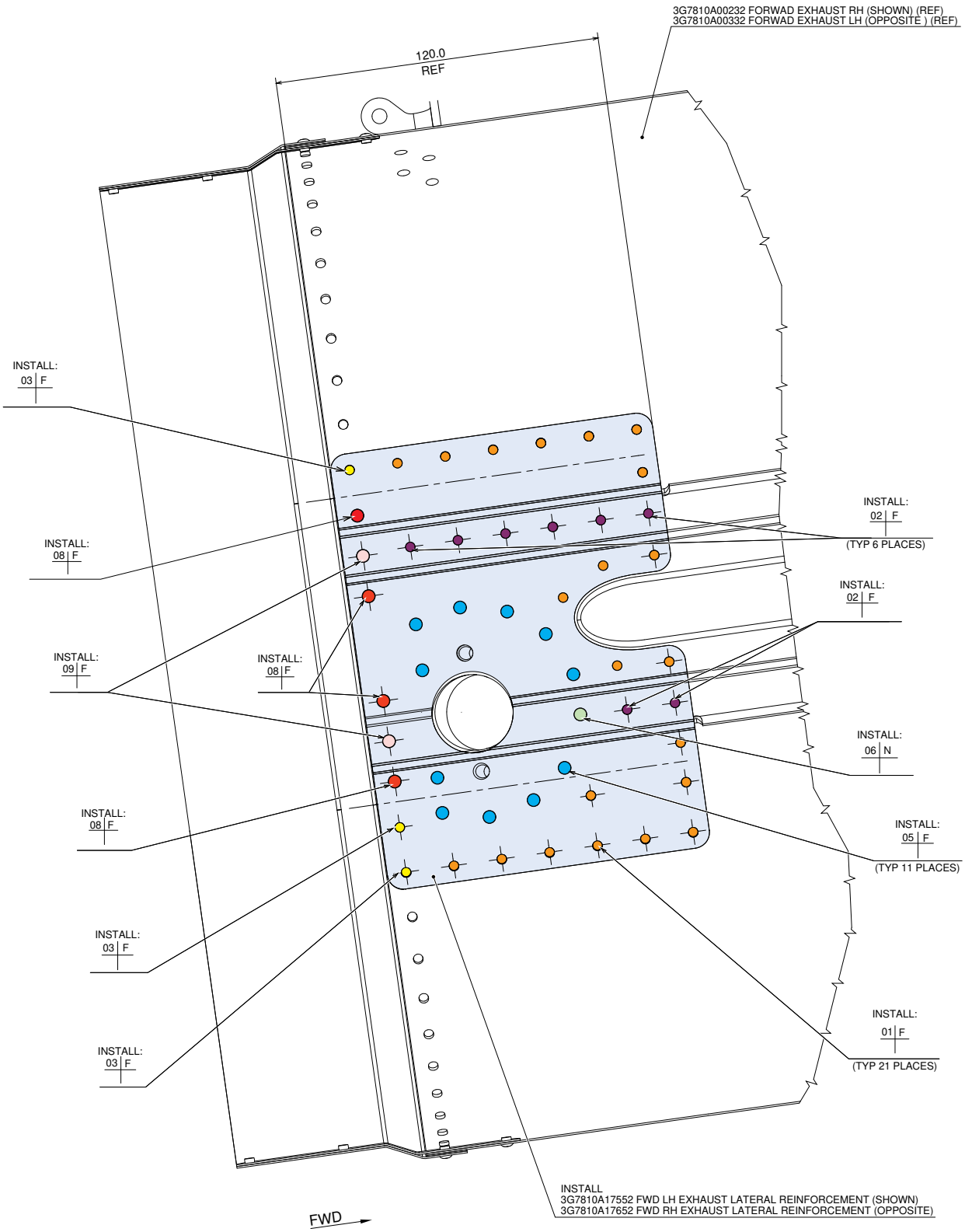

RIVET REFERENCE TABLE
REF. N°
RIVET P/N
01
MS20615-3M3
02
MS20615-3M3R
03
MS20615-3M4
04
NAS1097U3-3
05
MS20615-4M5
06
MS20615-4M5R
07
MS20615-4M6
08
MS20615-4M6R
09
MS20615-4M7
N
PRE-FORMED HEAD IS ON NEAR SIDE
F
PRE-FORMED HEAD IS ON FAR SIDE
COUNTERSINK (100° ONLY) IS ON NEAR SIDE
COUNTERSINK (100° ONLY) IS ON FAR SIDE
3G7806P02311 FORWAD EXHAUST LH RETROMOD (REF)
FWD
REMOVE: 05 F (TYP 11 PLACES)
REMOVE: 06 N
3G7810A15151 LH HOLED STIFFENER (SHOWN) (REF)
3G7810A15651 RH HOLED STIFFENER (OPPOSITE) (REF)
PART OF MATERIAL TO REMOVE
C
D
D
123.00
123.00
PART OF MATERIAL TO REMOVE
REMOVE: 02 F
REMOVE: 07 F (TYP 6 PLACES)
REMOVE: 03 F (TYP 2 PLACES)
VIEW B
(PARTS TO REMOVE)
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

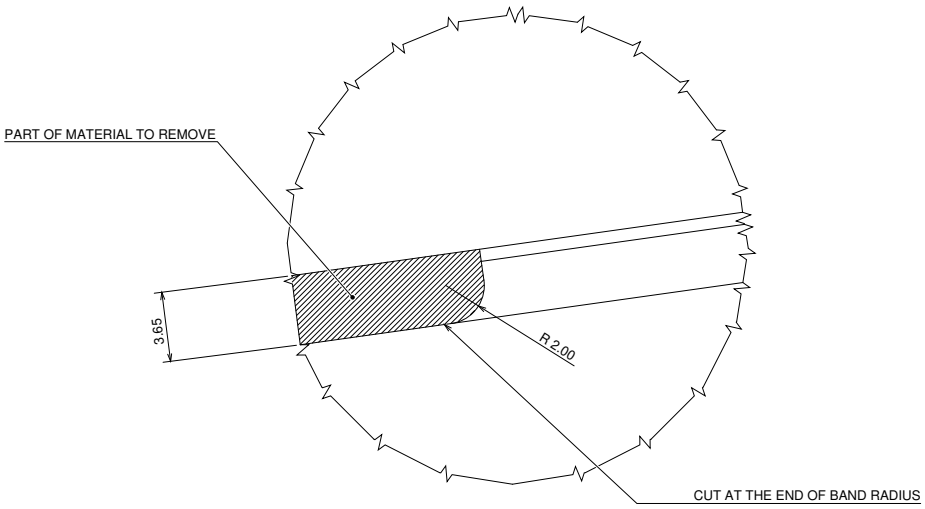
Figure 3



VIEW B

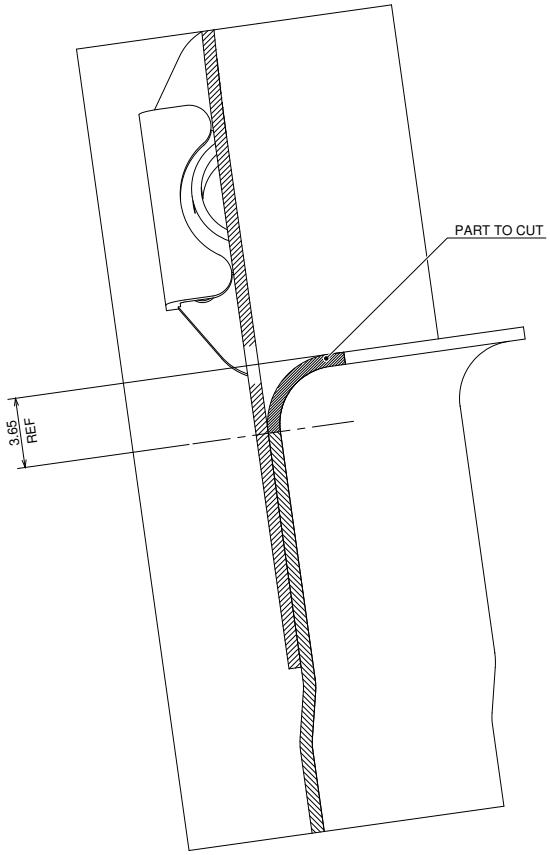
(PARTS TO INSTALL)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 4



DETAIL C

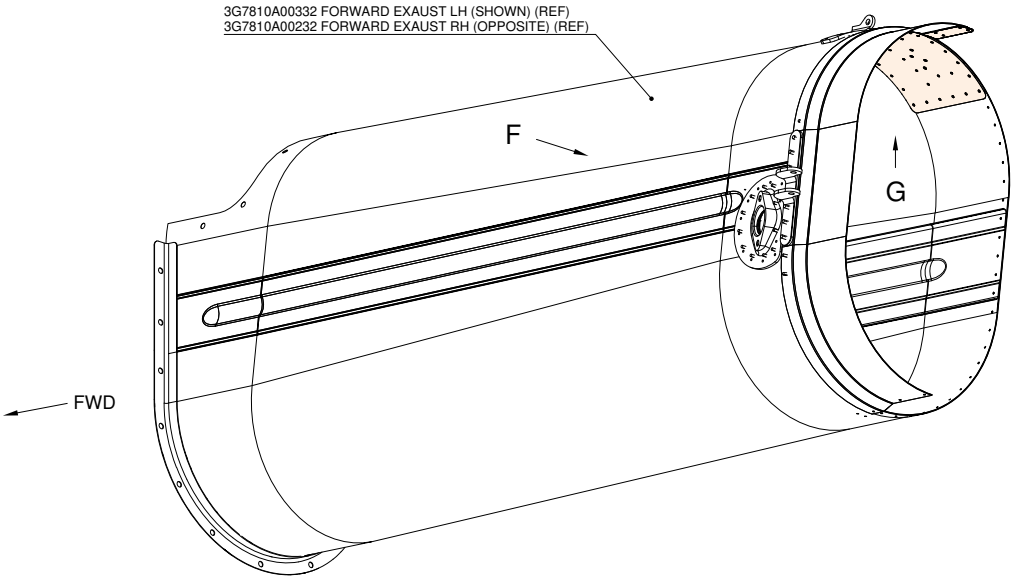
(TYP BOTH SIDES)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



SECTION D-D

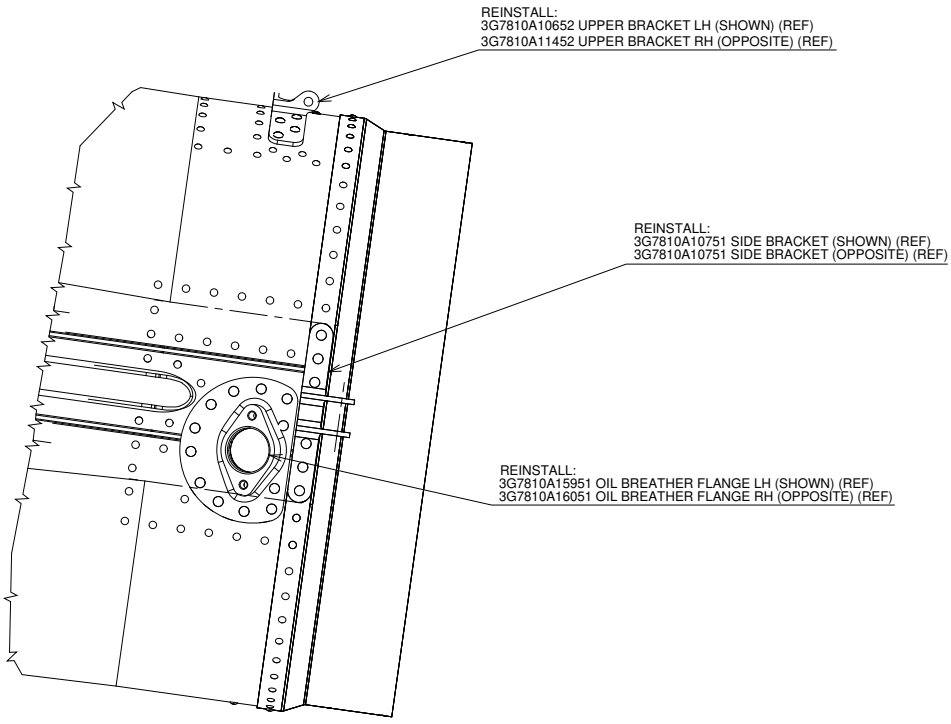
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 5



VIEW E

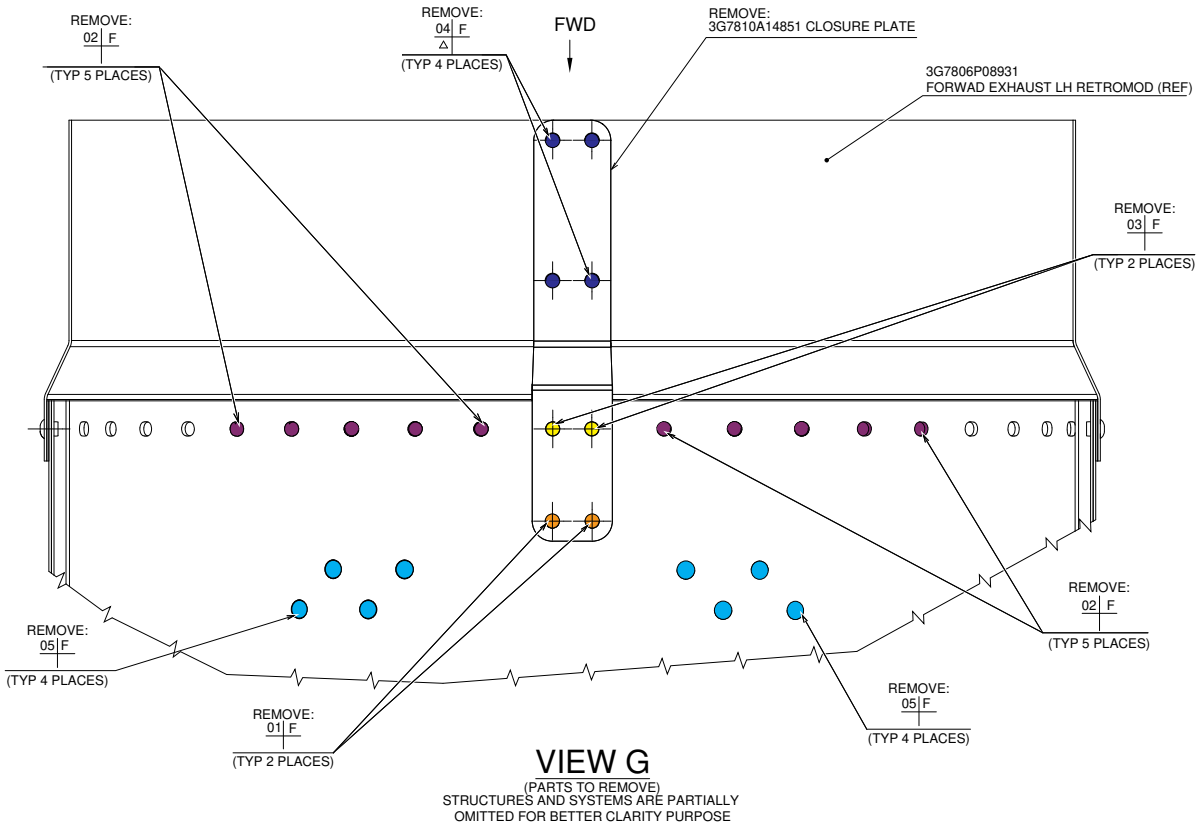
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



VIEW F

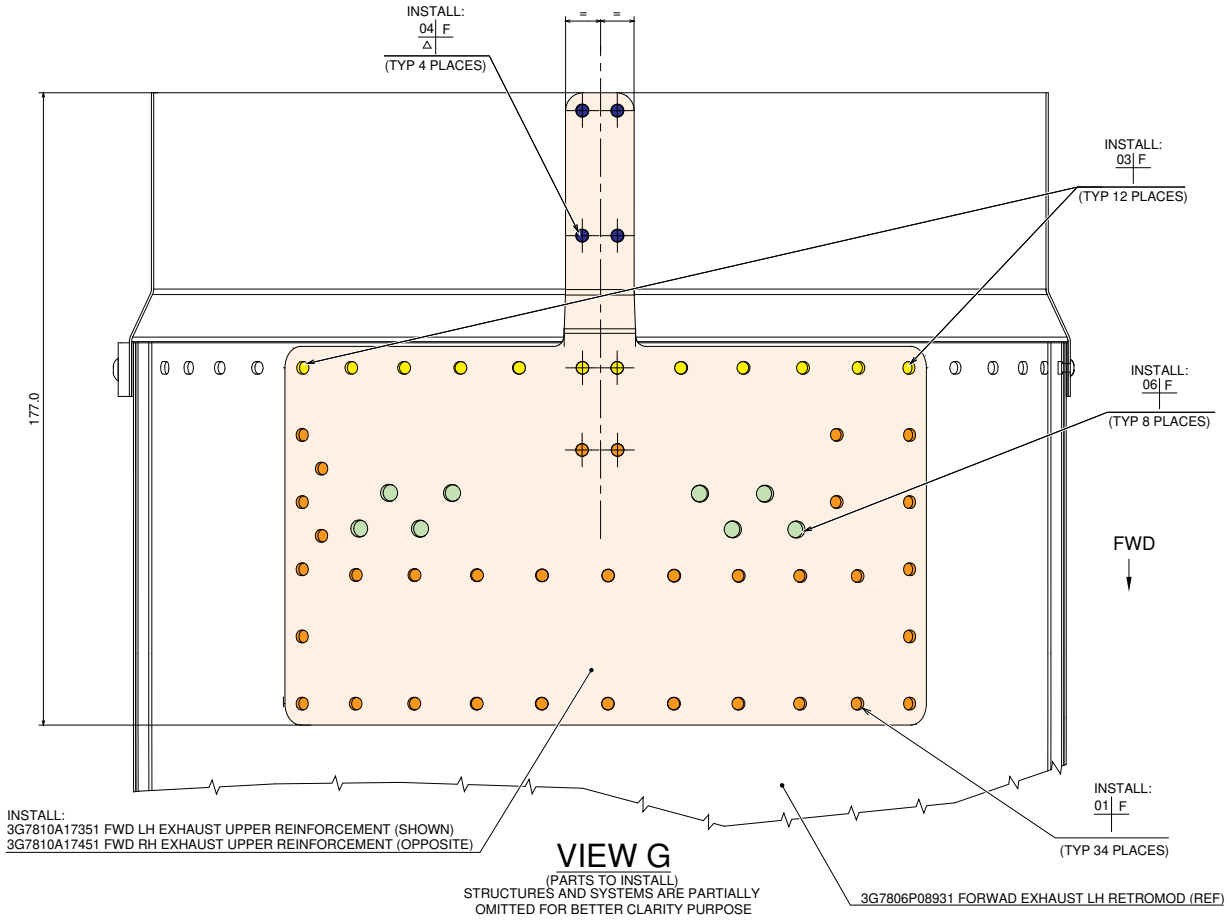
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 6



VIEW G

(PARTS TO REMOVE)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



VIEW G

(PARTS TO INSTALL)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 7

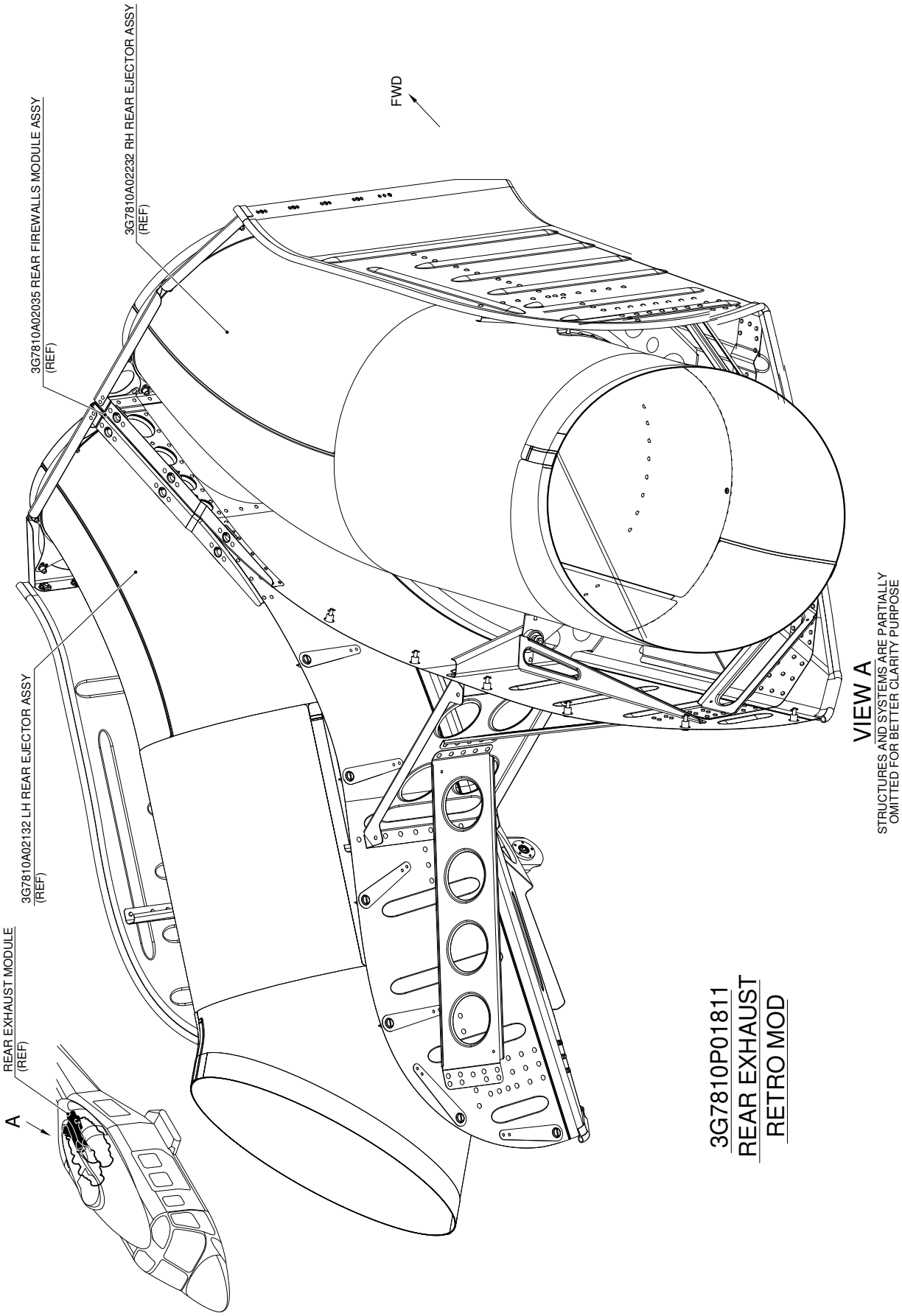

FWD
3G7810A02232 RH REAR EJECTOR ASSY
(REF)
3G7810A02035 REAR FIREWALLS MODULE ASSY
(REF)
3G7810A02132 LH REAR EJECTOR ASSY
(REF)
REAR EXHAUST MODULE
(REF)
A
VIEW A
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
3G7810P01811
REAR EXHAUST
RETRO MOD

Figure 8

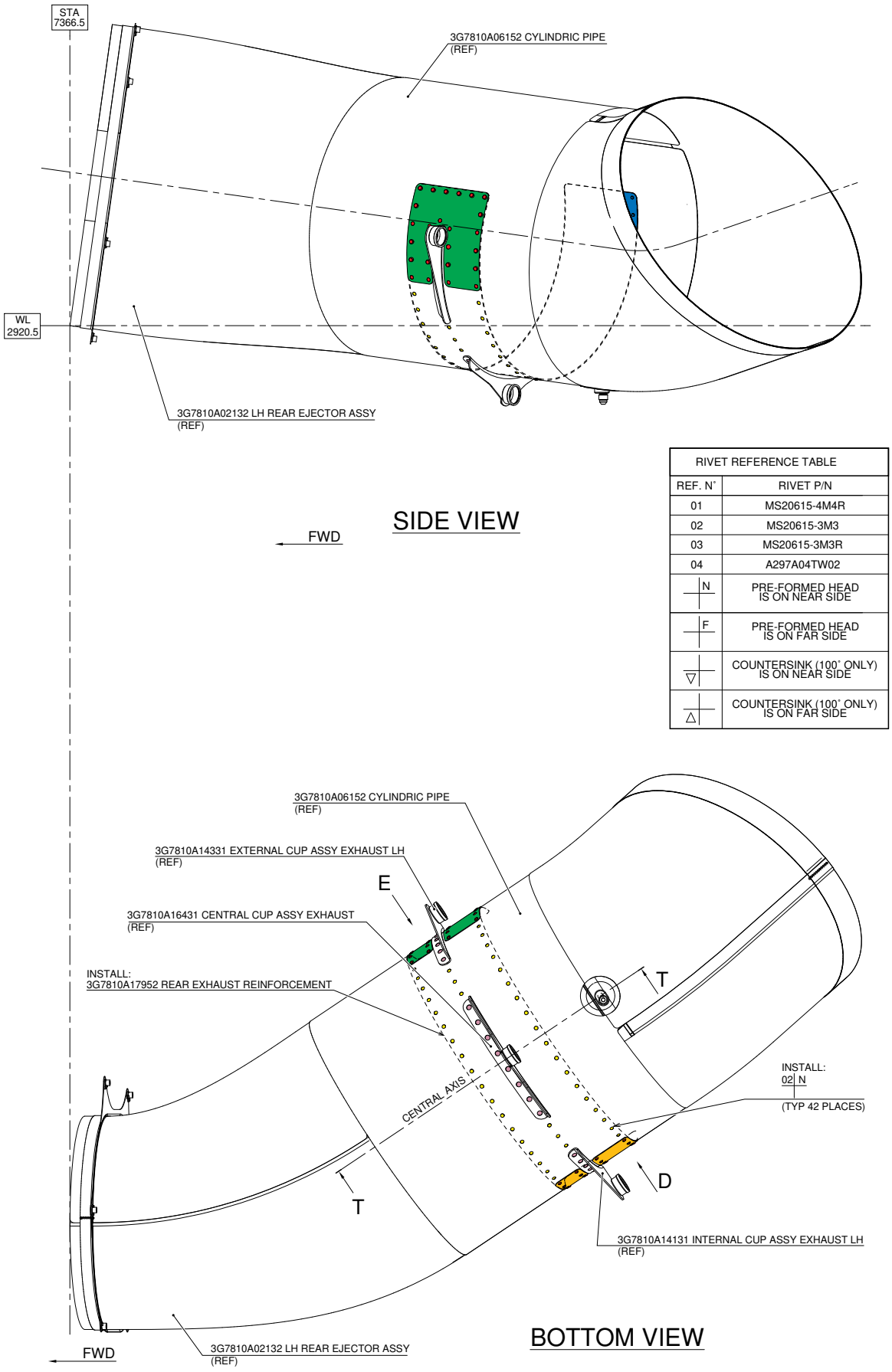

STA 7366.5
3G7810A06152 CYLINDRIC PIPE (REF)
WL 2920.5
3G7810A02132 LH REAR EJECTOR ASSY (REF)
SIDE VIEW
FWD
RIVET REFERENCE TABLE
REF. N° | RIVET P/N
01 | MS20615-4M4R
02 | MS20615-3M3
03 | MS20615-3M3R
04 | A297A04TW02
N | PRE-FORMED HEAD IS ON NEAR SIDE
F | PRE-FORMED HEAD IS ON FAR SIDE
COUNTERSINK (100° ONLY) IS ON NEAR SIDE
COUNTERSINK (100° ONLY) IS ON FAR SIDE
3G7810A06152 CYLINDRIC PIPE (REF)
3G7810A14331 EXTERNAL CUP ASSY EXHAUST LH (REF)
E
3G7810A16431 CENTRAL CUP ASSY EXHAUST (REF)
INSTALL: 3G7810A17952 REAR EXHAUST REINFORCEMENT
T
INSTALL: 02 N (TYP 42 PLACES)
CENTRAL AXIS
T
D
3G7810A14131 INTERNAL CUP ASSY EXHAUST LH (REF)
FWD
3G7810A02132 LH REAR EJECTOR ASSY (REF)
BOTTOM VIEW

Figure 9

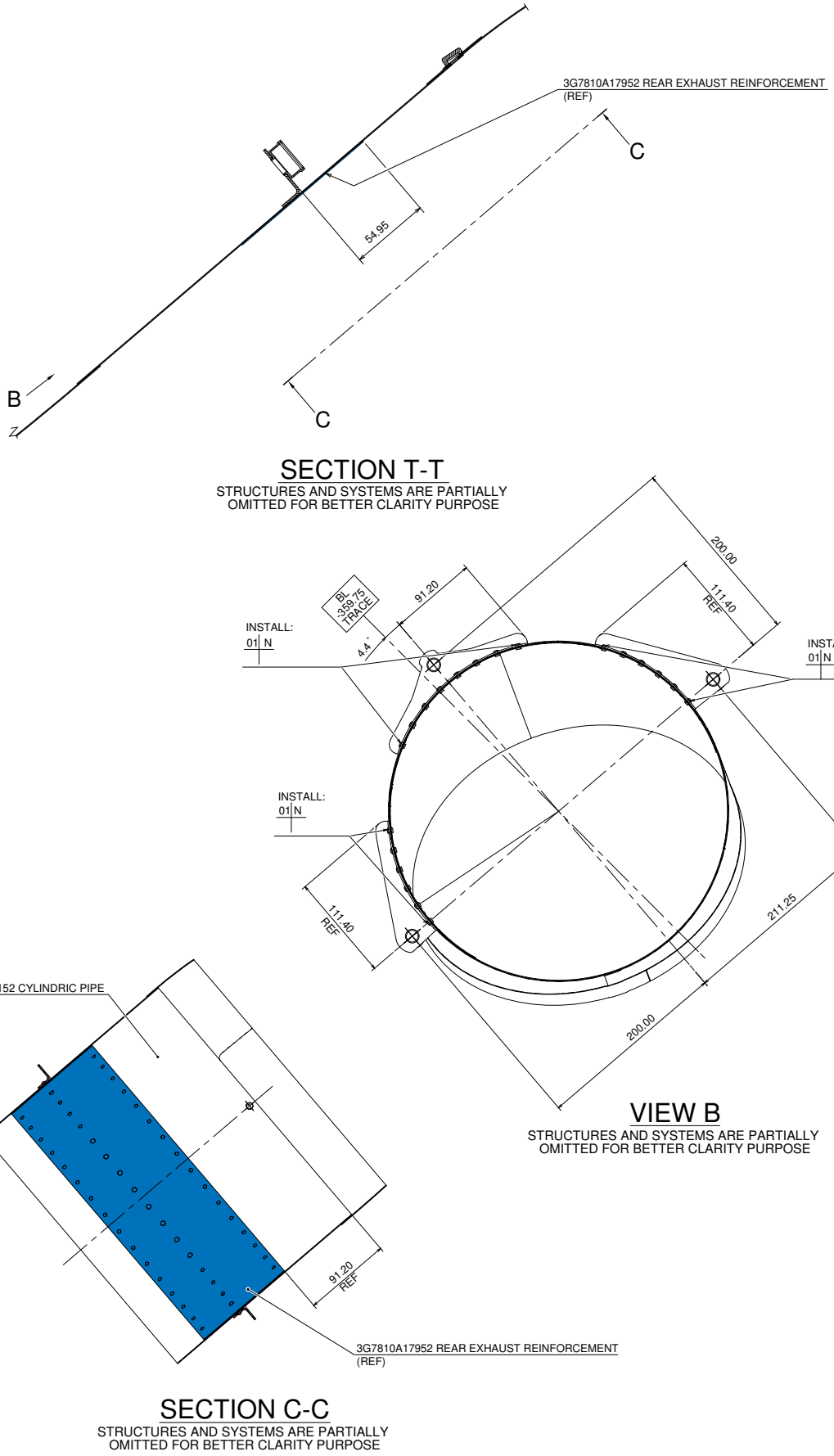
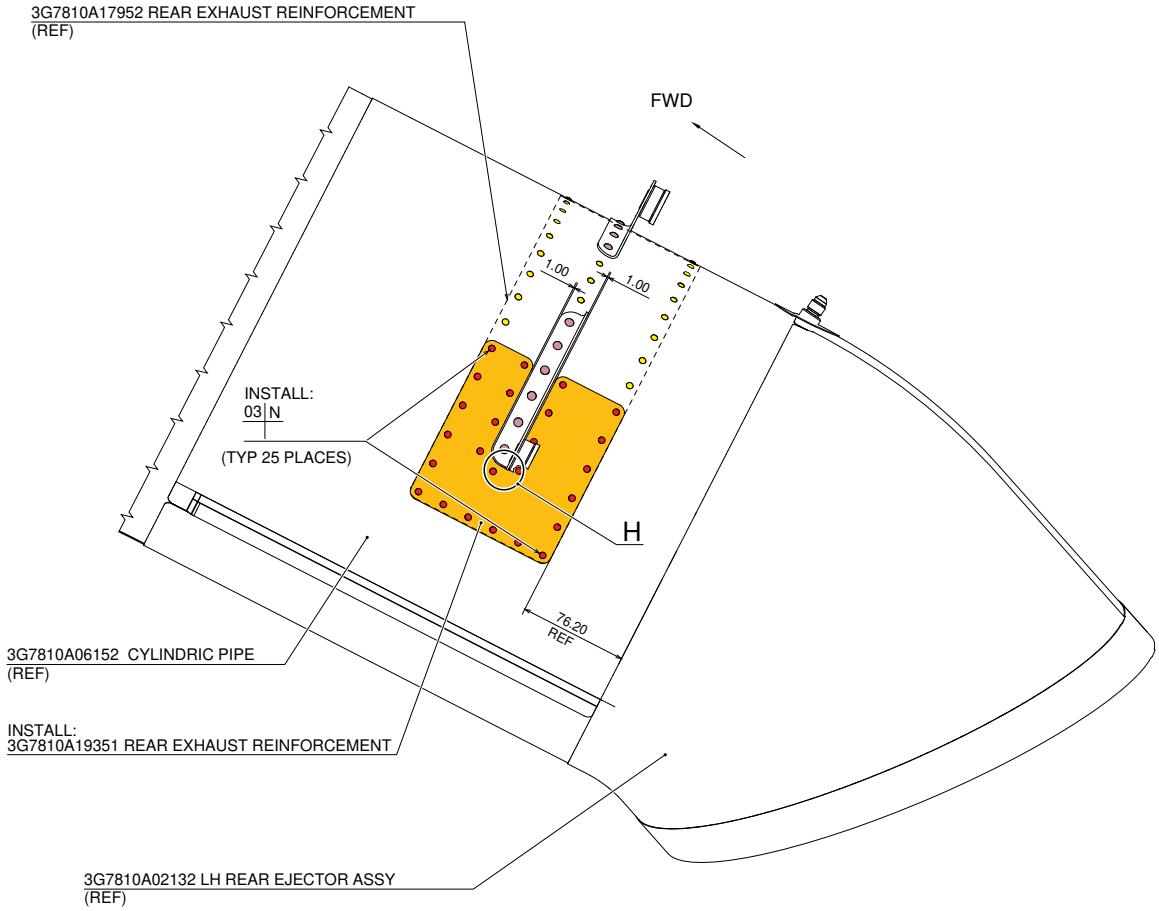
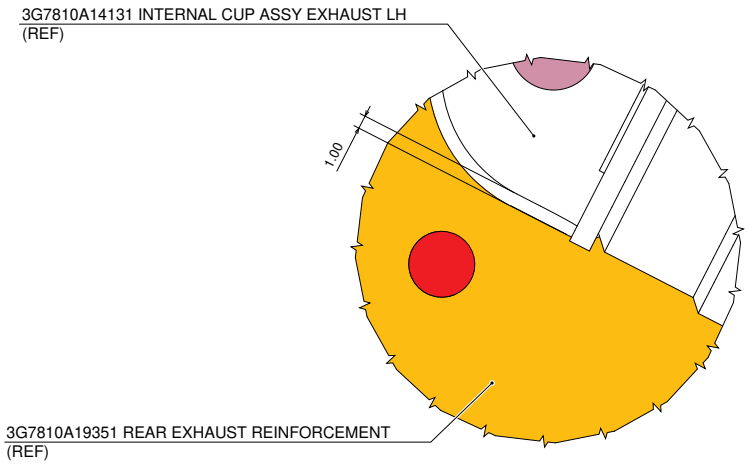

3G7810A17952 REAR EXHAUST REINFORCEMENT
(REF)
C
54.95
B
Z
C
SECTION T-T
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
200.00
111.40
REF
91.20
BL
-359.75
TRACE
4.4°
INSTALL:
01 N
INSTALL:
01 N
INSTALL:
01 N
111.40
REF
211.25
200.00
VIEW B
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
3G7810A06152 CYLINDRIC PIPE
(REF)
91.20
REF
3G7810A17952 REAR EXHAUST REINFORCEMENT
(REF)
SECTION C-C
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 10



VIEW D

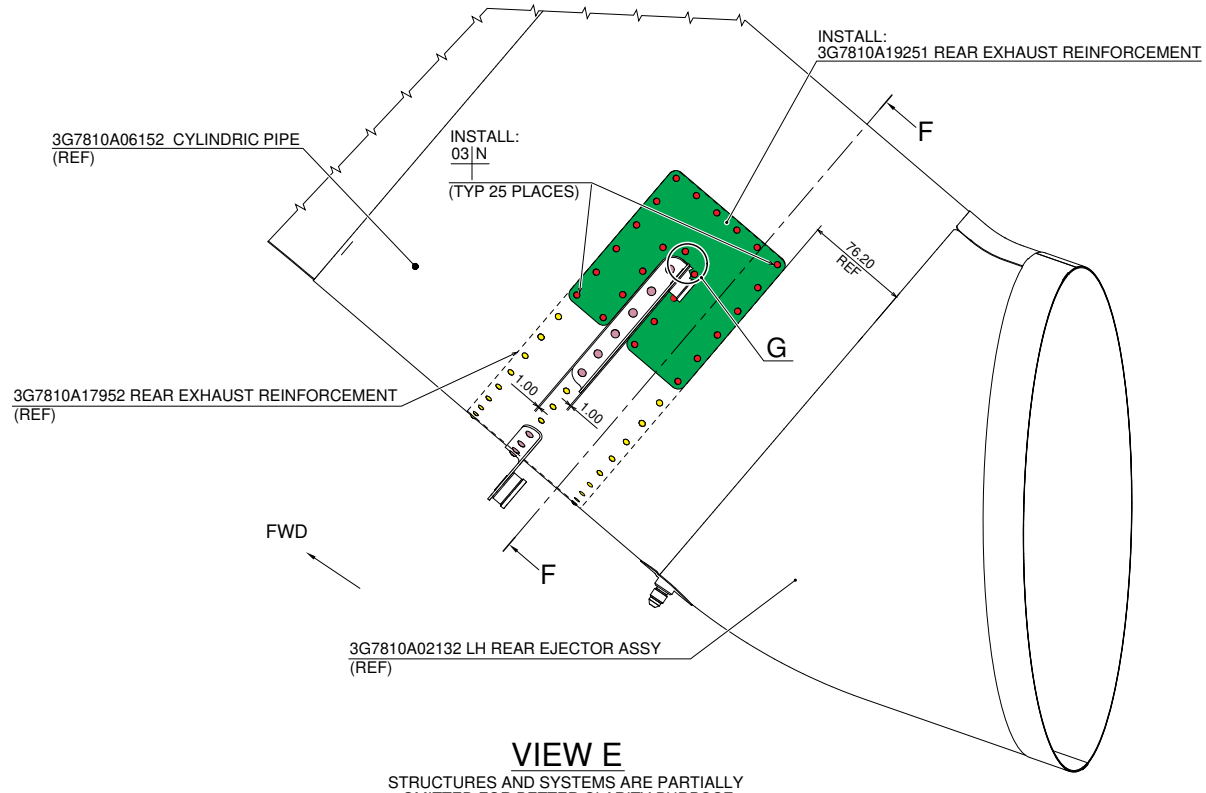
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



DETAIL H

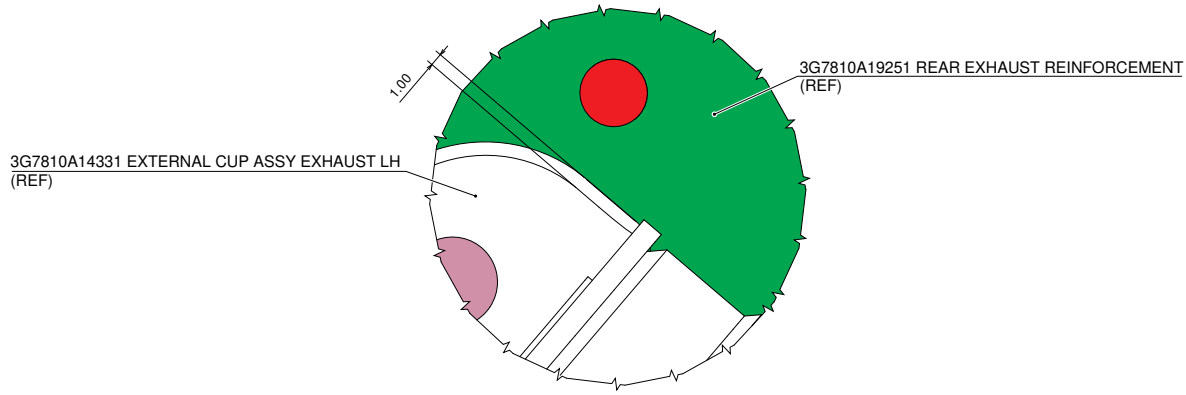
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 11



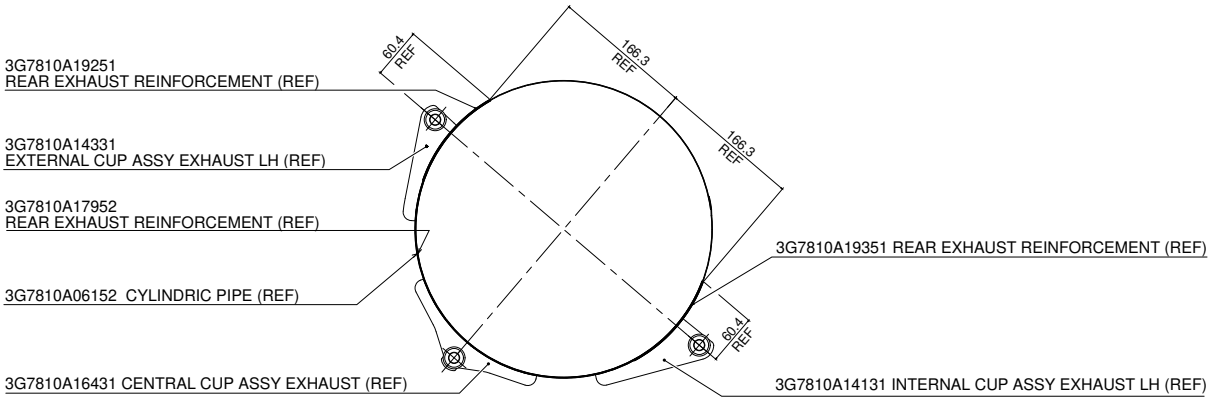
VIEW E

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



DETAIL G

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



SECTION F-F

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 12

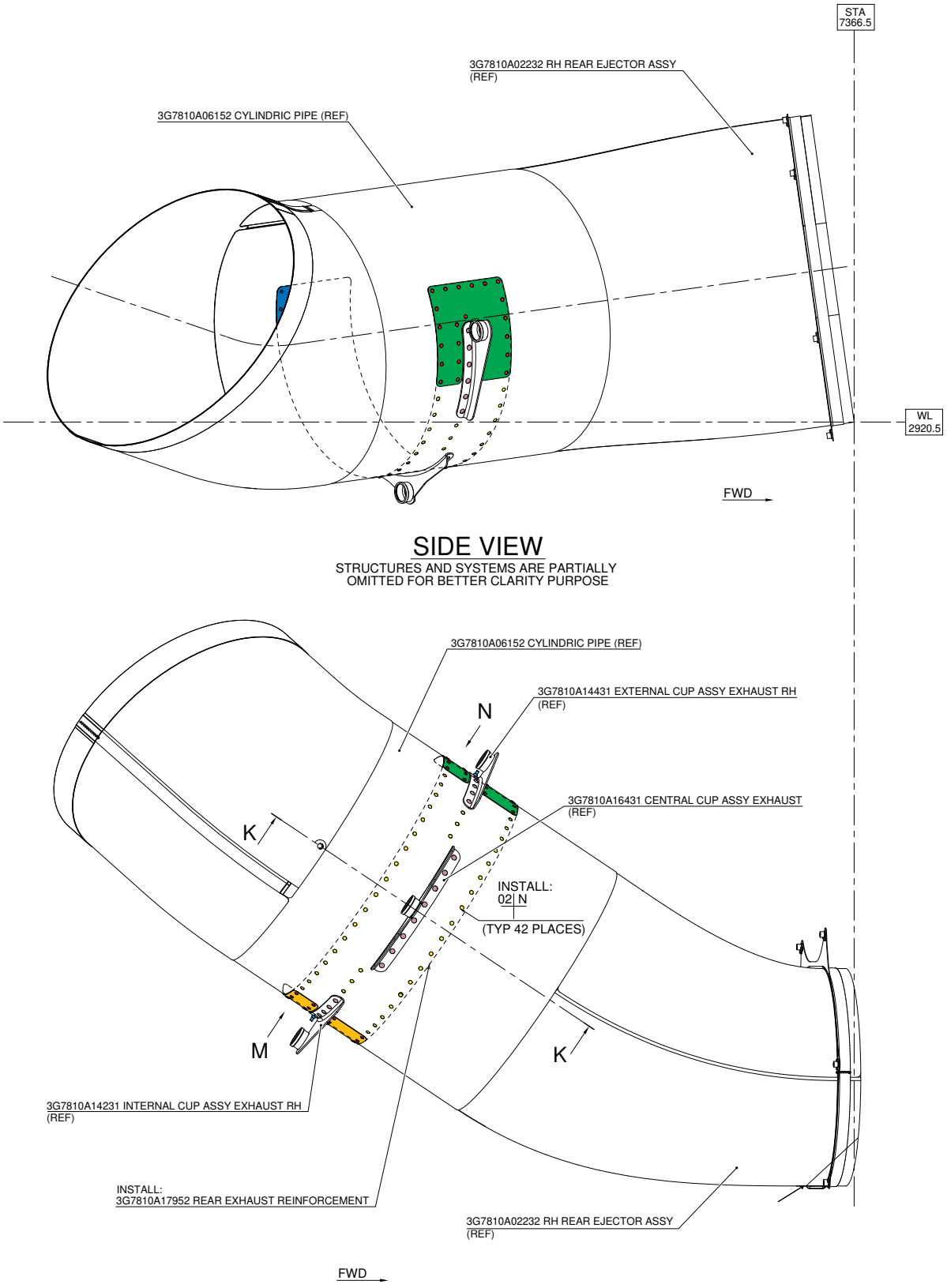

STA
7366.5
3G7810A02232 RH REAR EJECTOR ASSY
(REF)
3G7810A06152 CYLINDRIC PIPE (REF)
WL
2920.5
FWD
SIDE VIEW
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
3G7810A06152 CYLINDRIC PIPE (REF)
3G7810A14431 EXTERNAL CUP ASSY EXHAUST RH
(REF)
N
3G7810A16431 CENTRAL CUP ASSY EXHAUST
(REF)
K
INSTALL:
02 N
(TYP 42 PLACES)
M
K
3G7810A14231 INTERNAL CUP ASSY EXHAUST RH
(REF)
INSTALL:
3G7810A17952 REAR EXHAUST REINFORCEMENT
3G7810A02232 RH REAR EJECTOR ASSY
(REF)
FWD
BOTTOM VIEW
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 13

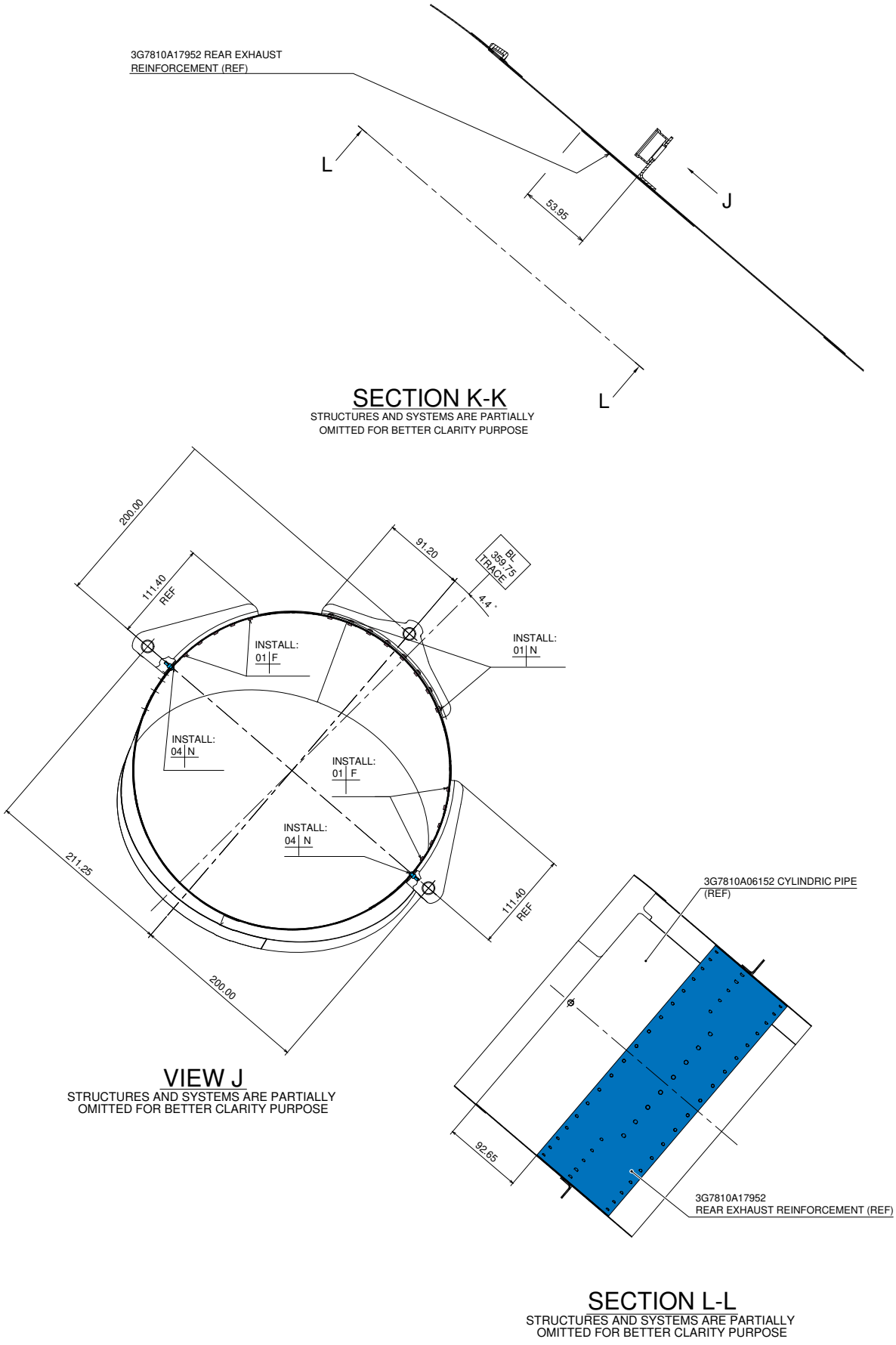
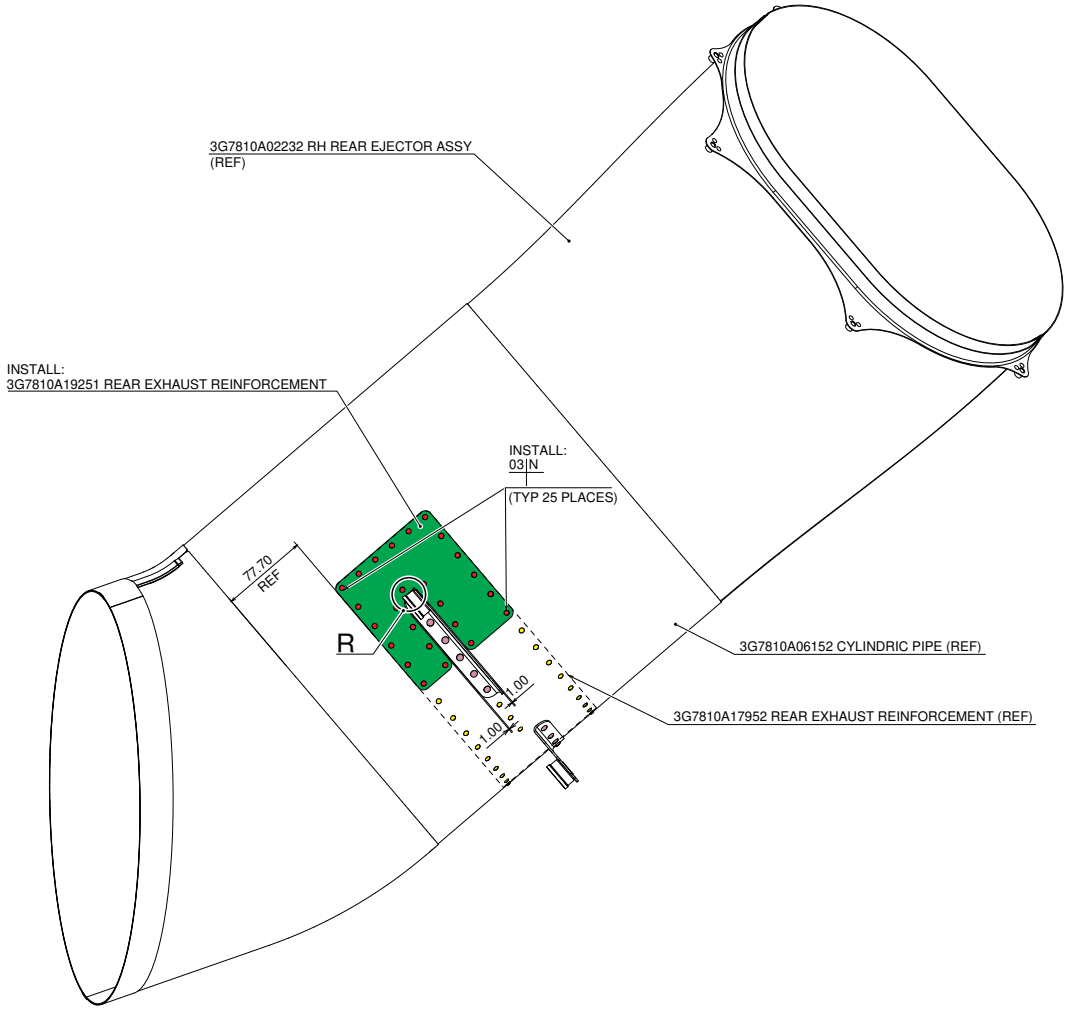
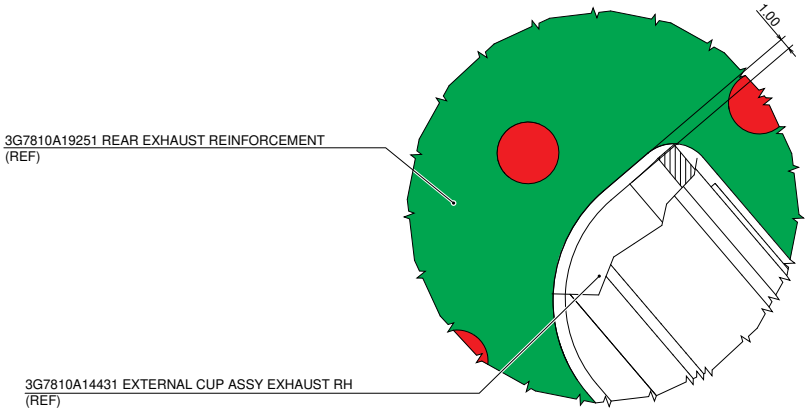

3G7810A17952 REAR EXHAUST
REINFORCEMENT (REF)
L
53.95
J
L
SECTION K-K
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
200.00
111.40
REF
91.20
BL
359.75
TRACE
4.4°
INSTALL:
01 F
INSTALL:
01 N
INSTALL:
04 N
INSTALL:
01 F
INSTALL:
04 N
211.25
200.00
111.40
REF
VIEW J
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
3G7810A06152 CYLINDRIC PIPE
(REF)
92.65
3G7810A17952
REAR EXHAUST REINFORCEMENT (REF)
SECTION L-L
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 14



VIEW N

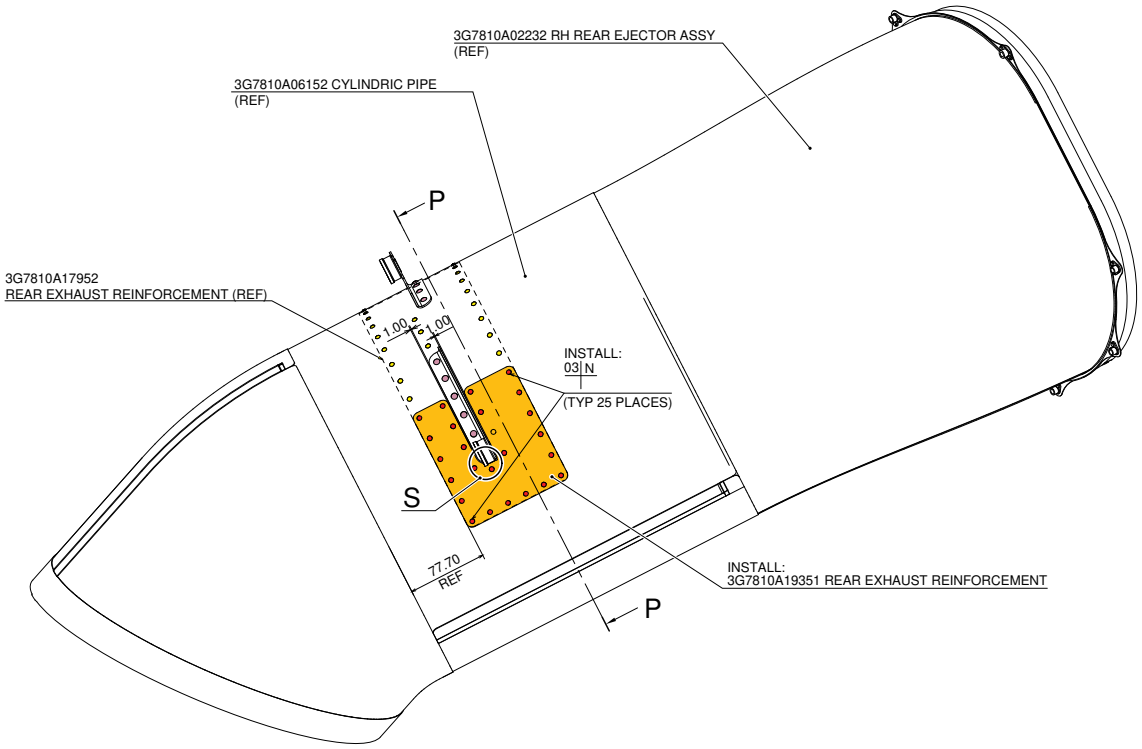
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



DETAIL R

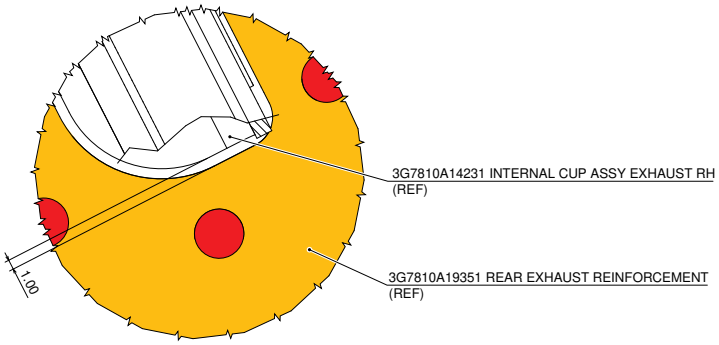
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 15



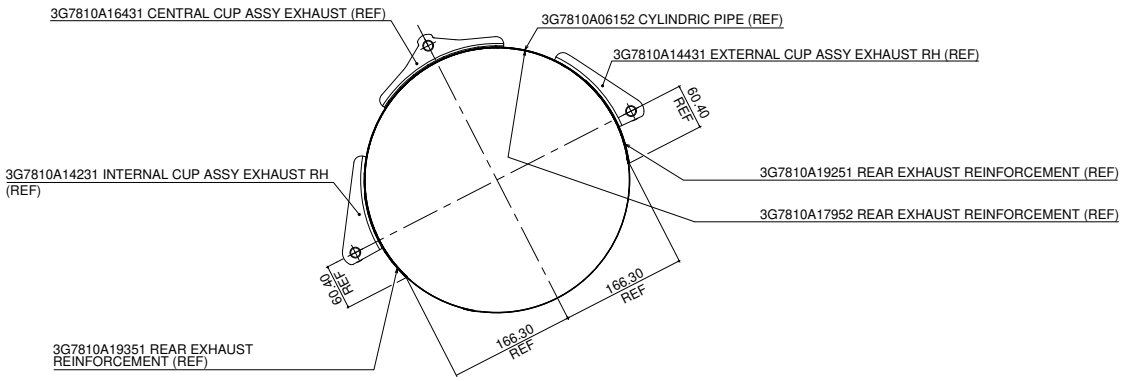
VIEW M

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



DETAIL S

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



SECTION P-P

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 16

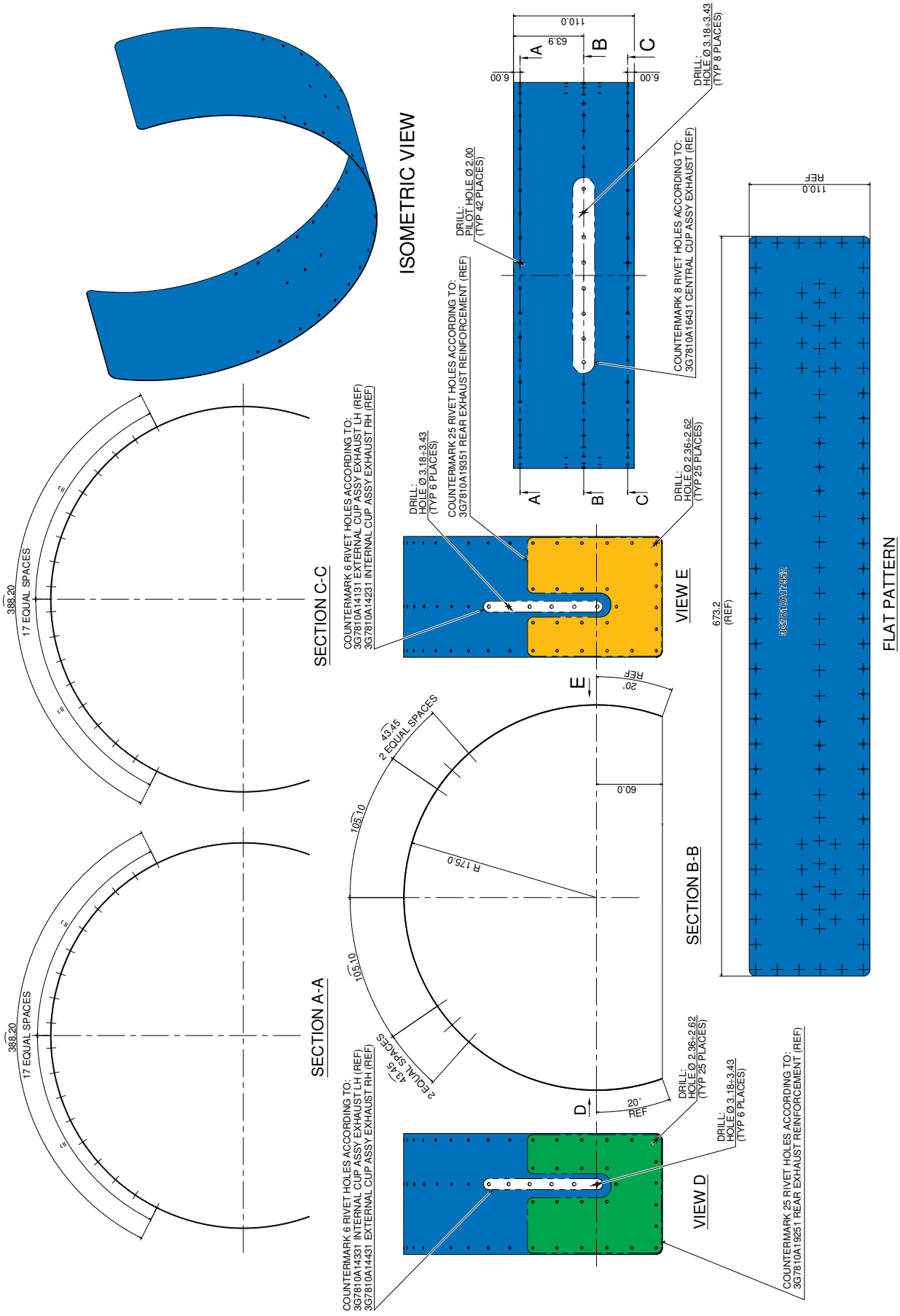

ISOMETRIC VIEW
SECTION C-C
SECTION A-A
SECTION B-B
VIEW E
VIEW D
FLAT PATTERN
388.20
17 EQUAL SPACES
43.45
2 EQUAL SPACES
105.10
R 175.0
60.0
110.0
63.9
6.00
DRILL:
HOLE Ø 3.18÷3.43
(TYP 8 PLACES)
DRILL:
PILOT HOLE Ø 2.00
(TYP 42 PLACES)
COUNTERMARK 8 RIVET HOLES ACCORDING TO:
3G7810A16431 CENTRAL CUP ASSY EXHAUST (REF)
COUNTERMARK 6 RIVET HOLES ACCORDING TO:
3G7810A14131 EXTERNAL CUP ASSY EXHAUST LH (REF)
3G7810A14231 INTERNAL CUP ASSY EXHAUST RH (REF)
COUNTERMARK 25 RIVET HOLES ACCORDING TO:
3G7810A19351 REAR EXHAUST REINFORCEMENT (REF)
DRILL:
HOLE Ø 2.36÷2.62
(TYP 25 PLACES)
673.2
(REF)
3G7810A17952
COUNTERMARK 6 RIVET HOLES ACCORDING TO:
3G7810A14331 INTERNAL CUP ASSY EXHAUST LH (REF)
3G7810A14431 EXTERNAL CUP ASSY EXHAUST RH (REF)
COUNTERMARK 25 RIVET HOLES ACCORDING TO:
3G7810A19251 REAR EXHAUST REINFORCEMENT (REF)

Figure 17

LEONARDO
HELICOPTERS

AgustaWestland Products

Please send to the following address: **LEONARDO S.p.A.** **CUSTOMER SUPPORT & SERVICES - ITALY** **PRODUCT SUPPORT ENGINEERING & LICENSES DEPT.** Via Giovanni Agusta, 520 21017 Cascina Costa di Samarate (VA) - ITALY Tel.: +39 0331 225036 Fax: +39 0331 225988	**SERVICE BULLETIN COMPLIANCE FORM**	Date:
	Number:	
	Revision:	

Customer Name and Address:	Telephone:
	Fax:
	B.T. Compliance Date:

Helicopter Model	S/N	Total Number	Total Hours	T.S.O.

Remarks:

Information:

We request your cooperation in filling this form, in order to keep out statistical data relevant to aircraft configuration up-to-date. The form should be filled in all its parts and sent to the above address or you can communicate the application also via Technical Bulletin Application Communication Section placed in Leonardo AW Customer Portal - MyCommunications Area. We thank you beforehand for the information given.