

# SERVICE BULLETIN

**TITLE:** External load system - Installation of the purge drain protection

**SB Type:** Corrective measure

**APPLICABILITY**

Model:	AS350
Version:	B2, B3

Version	Criteria
B2	PRE MOD 0720162 and POST MOD OP3810
B3	Not equipped with Crash Resistant Fuel System (CRFS) and – PRE MOD 0720162 and – POST MOD OP2773 or – POST MOD OP3810

**COMPLIANCE: RECOMMENDED**

Airbus Helicopters recommends that you comply with this Service Bulletin.

**SUMMARY**

The purpose of this Service Bulletin is to install a protector tube on the rear lower cowling at the purge lever rotomolded tank.

**GENERAL EVALUATION**

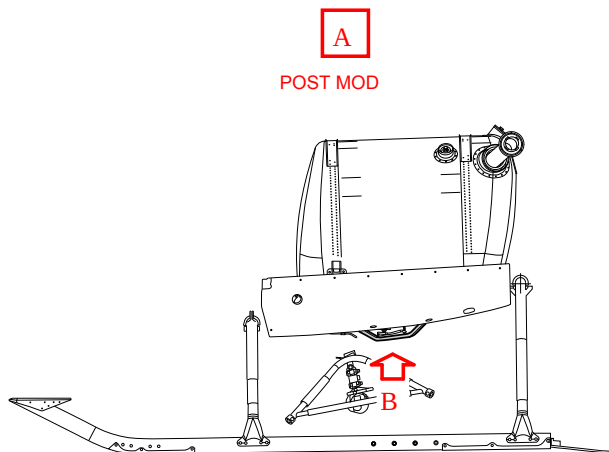
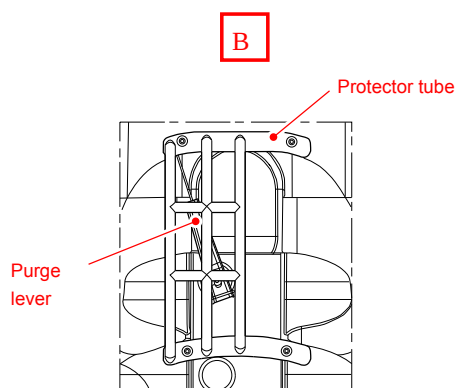
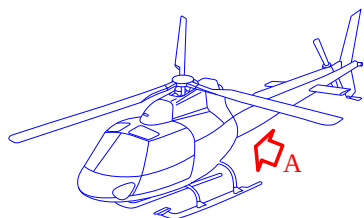
Evaluation table			
Perform once	YES	Accomplish recurring	NO

Export Control:

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



## PLANNING INFORMATION

### 1. REASON

It was highlighted that cargo swing could hit the rotomolded tank purge lever during flights.

Thus, Airbus Helicopters has designed a protector tube which prevents any damages to the purge lever.

Consequently, the purpose of this Service Bulletin is to install the protector tube on the rear lower cowling.

### 2. DESCRIPTION

This Service Bulletin provides instructions to:

- Modify the rear lower cowling, if necessary
- Install the protector tube on the rear lower cowling.

### 3. CONFIGURATION DEFINITION

Not applicable.

### 4. CONCURRENT REQUIREMENTS

Not applicable.

### 5. APPROVAL

The technical content of this document is approved under the prerogatives of the recognition of design capability ref. FRA21J-002-DGA for French Government helicopters.

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
1	Airframe technician	3h

### 6.2. Manpower for set-up and close-up

Number of Persons	Qualification	Estimated Man Hours
1	Airframe technician	1h

## 7. WEIGHT AND BALANCE

Weight (kg)	Longitudinal moment (m.kg) X	Lateral moment (m.kg) Y
+ 0,75	+ 2,60	- 0,02

## 8. ELECTRICAL LOAD DATA

Not applicable.

## 9. DOCUMENTATION AFFECTED

Aircraft Maintenance Manual (AMM)

## 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. 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

This Service Bulletin has no effect on mixability.

### 10.5. LIST OF NEW MATERIALS

Material Kit List					
Kit Designation		Kit Reference			
BLEED VALVE PROTECTOR KIT		350A07-2016-2071			
Kit Content					
Item	Designation	Reference	MFC	QTY	See Notes
01	Protector tube	350A84-0058-00	F0210	1	
02	Washer	350A21-1218-20	F0210	3	
03	Nut anchor self locking	52358CCM050E	F5442	4	(1)
NOTE(S)					
(1)	If already installed, items (3) and (4) will not be used to modify the rear lower cowling. Store them.				

Material Kit List					
Kit Designation		Kit Reference			
BLEED VALVE PROTECTOR KIT		350A07-2016-2071			
Kit Content					
Item	Designation	Reference	MFC	QTY	See Notes
04	Blind rivet	NAS1399CW3A2	80205	8	(1)
05	Six lobe recess screw	ECS2365TK05S14X	F0210	3	
06	Bonding braid	993503-095	F0210	1	
07	Washer	23112AG050LE	F0111	3	
08	Bolt	22125BC050015L	F0111	1	
09	Self locking nut	ASN52320BH050N	F5442	1	
10	Bolt	22125BC050016L	F0111	1	
11	Bonding braid	993503-005	F0210	1	
NOTE(S)					
(1)	If already installed, items (3) and (4) will not be used to modify the rear lower cowling. Store them.				

Individual Spares List				
Item	Designation	Reference	MFC	QTY
None				

Consumables, Materials and Expendables			
Designation	Reference	MFC	QTY
Alodine	CM316	F0210	0.1 L
P05 Primer	CM487	F0210	0.1 Kg
P20 Primer	CM488	F0210	0.1 Kg

Special Tools				
Item	Designation	Reference	MFC	QTY
None				

#### 10.6. LIST OF EXISTING PARTS

RE-IDENTIFIED PARTS TABLE		
Old Reference	Designation	New Reference
350A21-0026-00A1 350A21-0026-07A1 350A21-0026-09A1 350A21-0026-09A2 350A21-0026-09A3 350A21-0026-1701 350A21-0026-1702	Rear lower cowling	350A21-0026-00A1 + SB 25-91-0001
		350A21-0026-07A1 + SB 25-91-0001
		350A21-0026-09A1 + SB 25-91-0001
		350A21-0026-09A2 + SB 25-91-0001
		350A21-0026-09A3 + SB 25-91-0001
		350A21-0026-1701 + SB 25-91-0001
		350A21-0026-1702 + SB 25-91-0001

#### 11. ACCOMPLISHMENT INSTRUCTION

Comply with the accomplishment procedure [25-91-0001, 933](#).

#### 12. ADDITIONAL INFORMATION

Not applicable.

End of section

## ACCOMPLISHMENT PROCEDURE 25-91-0001, 933

### 1. APPLICABILITY

Model:	AS350
Version:	B2, B3

### 2. GENERAL INFORMATION

Acronym/Abbreviation List

AMM - AIRCRAFT MAINTENANCE MANUAL

CRFS - CRASH RESISTANT FUEL SYSTEM

FOD - FOREIGN OBJECT DAMAGE

### 3. PRELIMINARY REQUIREMENTS

#### 3.1. Applicable Documents

- Installation of rivets - retrofitting and repair - Riveting [MTC 20-02-04-402](#)
- General riveting acceptance requirements - Riveting [MTC 20-02-04-601](#)
- Assembly by screws and nuts - Joining [MTC 20-02-05-404](#)
- Electrical bonding: General - Electrical bonding [MTC 20-02-07-101](#)
- Electrical bonding procedure - Electrical bonding [MTC 20-02-07-401](#)
- Bonding procedure applied on metal structure - Electrical bonding [MTC 20-02-07-402](#)
- GENERAL REPAIR INSTRUCTIONS Unriveting principle - General repair instructions [MTC 20-03-01-102](#)
- Preparation of surfaces before painting - Surface treatment before painting [MTC 20-04-04-401](#)
- Touch-up of the Alodine 1200 protection (Bonderite M-Cr 1200) - Surface treatment before painting [MTC 20-04-04-403](#)
- Application of Primer EPOXY P05-P20 - Paint and primer application procedure [MTC 20-04-05-402](#)
- Application of polyurethane finish paint (1500-M) - Paint and primer application procedure [MTC 20-04-05-422](#)
- Application of paint FE 08.2 - Paint and primer application procedure [MTC 20-04-05-433](#)
- Park the helicopter in a hangar [MTC 20-07-01-201](#)



- Appearance checks on an aircraft after inspection or repair - Technical instructions [MTC 20-07-03-408](#)
- Monitoring of parts in operation - marking - service life customization - General rules applicable to aircraft [MTC 20-08-05-103](#)
- Removal / Installation - Lower cowling - Cowlings [AMM 53-51-00, 4-2](#)

### 3.2. Set up

- Park the helicopter in a hangar. Refer to Work Card [MTC 20-07-01-201](#)
- Disconnect all the electrical power supplies.
- Remove and/or open all applicable cowlings, panels, doors and other items of equipment to get access to the different work areas.

### 3.3. Special Tools

None

### 3.4. Consumables, Materials and Expendables

Designation	Reference	MFC	QTY
Alodine	CM316	F0210	0.1 L
P05 Primer	CM487	F0210	0.1 kg
P20 Primer	CM488	F0210	0.1 kg

### 3.5. Spares

Designation	Reference	MFC	QTY
Protector tube	350A84-0058-00	F0210	1
Washer	350A21-1218-20	F0210	3
Nut anchor self locking	52358CCM050E	F5442	4
Blind rivet	NAS1399CW3A2	80205	8
Six lobe recess screw	ECS2365TK05S14X	F0210	3
Bonding braid	993503-095	F0210	1
Washer	23112AG050LE	F0111	3

Designation	Reference	MFC	QTY
Bolt	22125BC050015L	F0111	1
Self locking nut	ASN52320BH050N	F5442	3
Bolt	22125BC050016L	F0111	1
Bonding braid	993503-005	F0210	1

### 3.6. Safety conditions



## 4. PROCEDURE

- 4.1. Modification of the rear lower cowling ([Figure 1](#)) (If necessary)
  - 4.1.1. Remove the rear lower cowling. Refer to [AMM 53-51-00. 4-2.](#)
  - 4.1.2. Identify the position of the holes (E) on the rear lower cowling. Refer to the dimensions (DETAIL B).

### NOTE

You can use the Protector tube 350A84-0058-00 (1) to position the holes (E).

- 4.1.3. Drill the holes (E) to 6.5 mm diameter.
- 4.1.4. Install the Nut anchor self locking 52358CCM050E (3) with the Blind rivet NAS1399CW3A2 (4) on the inner part of the rear lower cowling (DETAIL C).
- 4.1.5. Identify again the rear lower cowling with indelible ink. Refer to Work Card [MTC 20-08-05-103](#) and paragraph 9.6.

Former Reference	Designation	New Reference
350A21-0026-00A1 350A21-0026-07A1 350A21-0026-09A1 350A21-0026-09A2 350A21-0026-09A3 350A21-0026-1701 350A21-0026-1702	Rear lower cowling	Former reference + SB-AS350-25-91-0001

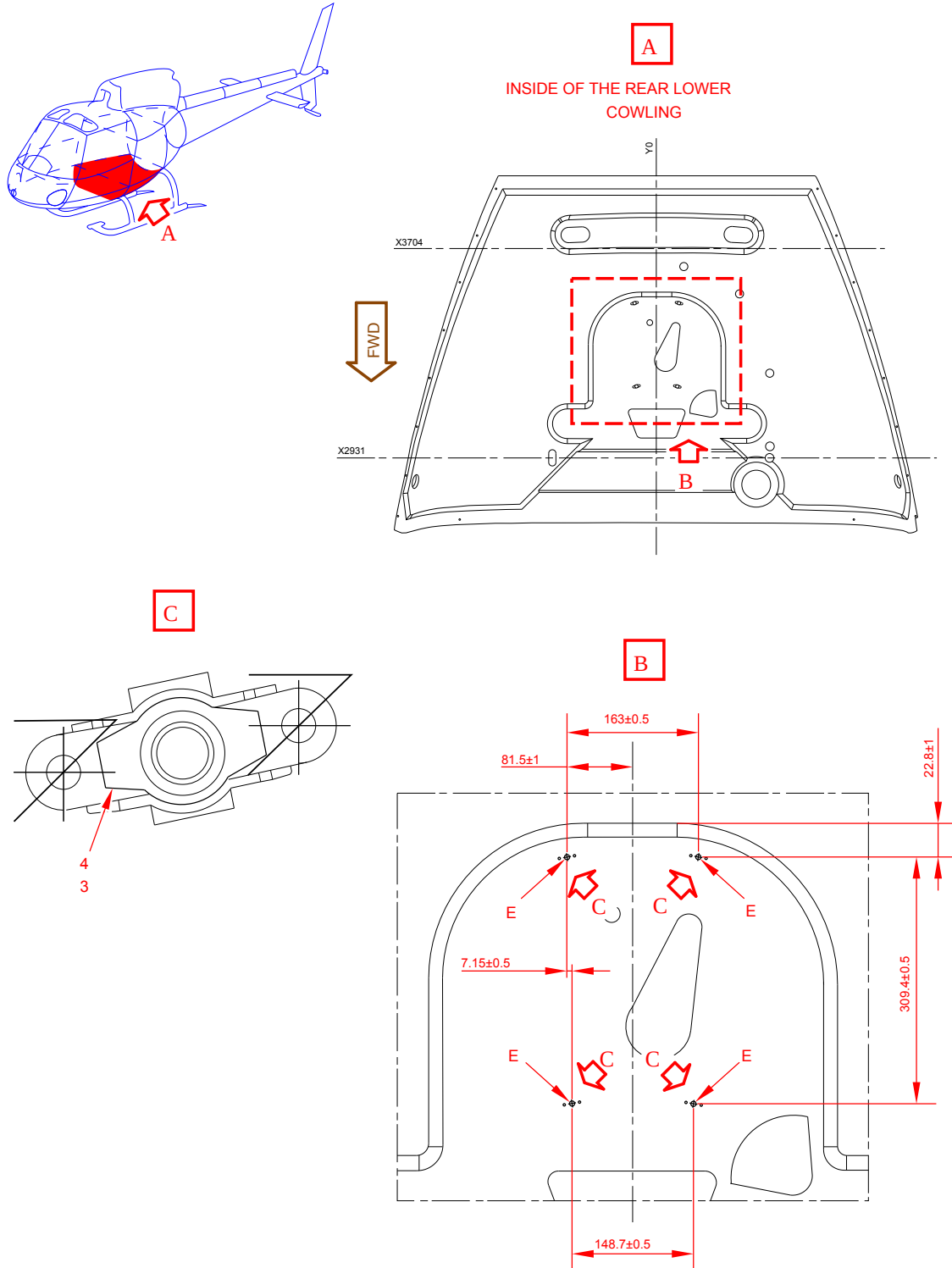
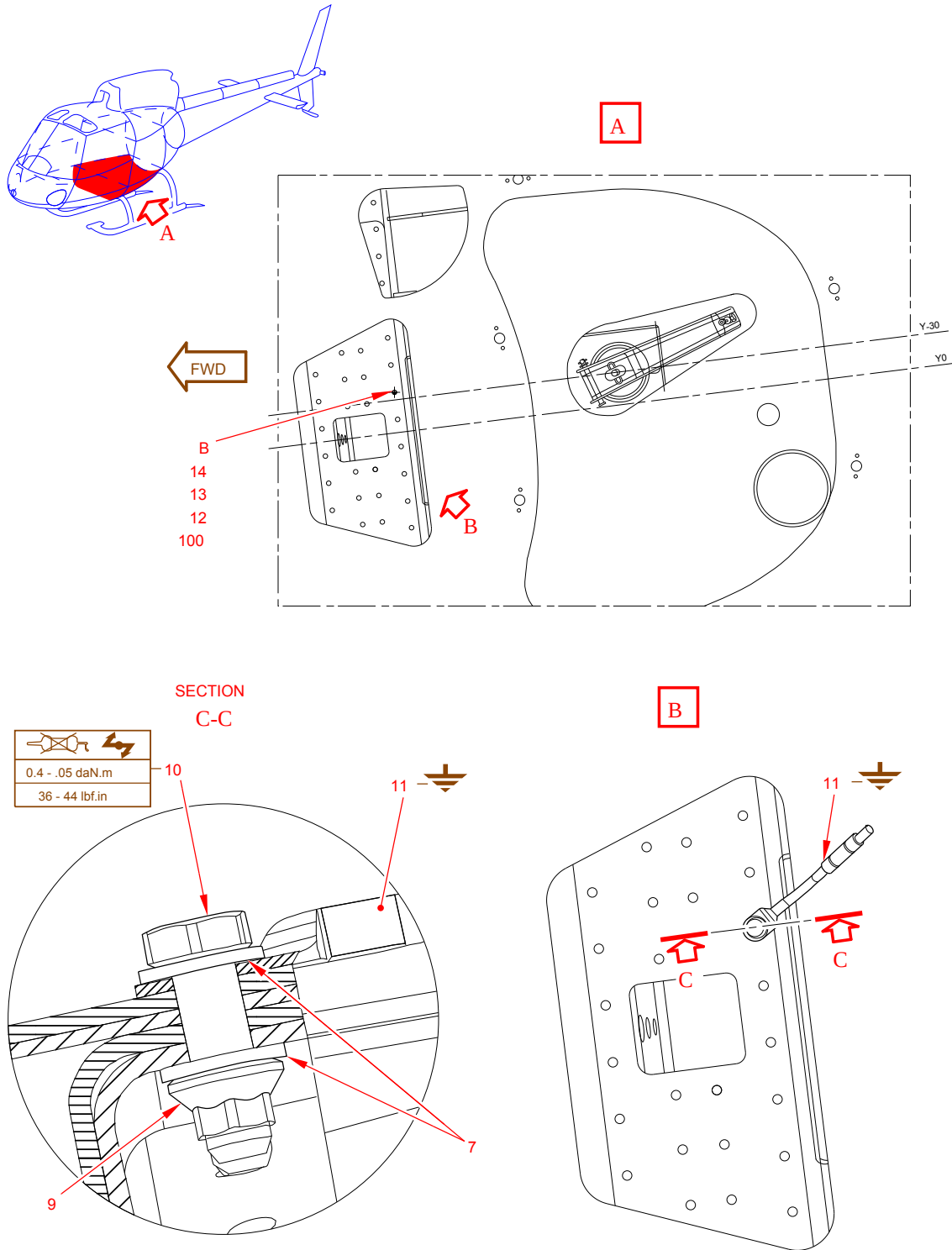


Figure 1

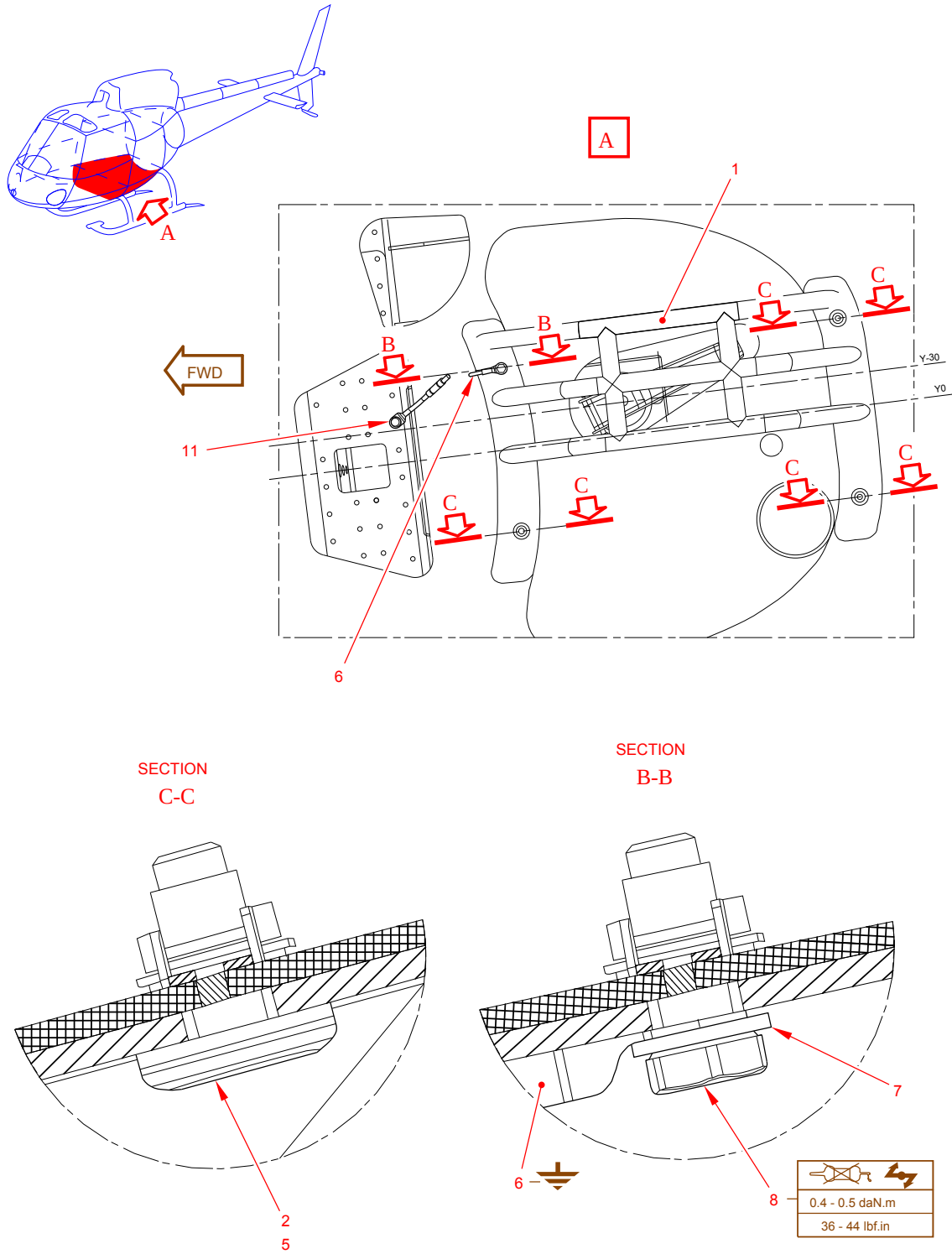
- 4.2. Installation of the protector tube on the rear lower cowling ([Figure 2](#)) ([Figure 3](#))
  - 4.2.1. Remove the rivet (100) from the cradle ([Figure 2](#)) (DETAIL A).
  - 4.2.2. Counterdrill the hole (B) to 5.2 mm diameter on the cradle.
  - 4.2.3. On the hole (B), apply:
    - Alodine (CM0316)
    - P05 Primer (CM0487)
    - P20 Primer (CM0488).
  - 4.2.4. Do the electrical bonding code 61 of the Bonding braid 993503-005 (11) (DETAIL B and SECTION C-C). Refer to [MTC 20-02-07-401](#).
  - 4.2.5. Install the Bonding braid 993503-005 (11) on the cradle (SECTION C-C) with:
    - The Bolt 22125BC050016L (10)
    - The Washer 23112AG050LE (7)
    - The Self locking nut ASN52320BH050N (9).



**Figure 2**

- 4.2.6. Install the Protector tube 350A84-0058-00 (1) ([Figure 3](#)) (DETAIL A and SECTION C-C) with:
- The Washer 350A21-1218-20 (2)
  - The Six lobe recess screw ECS2365TK05S14X (5).
- 4.2.7. Do the electrical bonding code 61 of the Bonding braid 993503-095 (6) (SECTION B-B). Refer to [MTC 20-02-07-401](#).
- 4.2.8. Install the Bonding braid 993503-095 (6) with:
- The Bolt 22125BC050015L (8)
  - The Washer 23112AG050LE (7).
- 4.2.9. Tighten the Six lobe recess screw ECS2365TK05S14X (5) to standard torque (SECTION C-C).
- 4.2.10. Tighten to the specified torque (SECTION B-B):
- The Bolt 22125BC050015L (8) ([Figure 3](#)) (SECTION B-B)
  - The Bolt 22125BC050016L (10) ([Figure 2](#)) (SECTION C-C).
- 4.2.11. Install the rear lower cowling. Refer to Task [AMM 53-51-00, 4-2](#).
- 4.2.12. Connect the Bonding braid 993503-005 (11) and the Bonding braid 993503-095 (6) ([Figure 3](#)) (DETAIL A).





**Figure 3**

## 5. CLOSE UP

- 5.1. Do a check of the appearance of the helicopter. Refer to Work Card [MTC 20-07-03-408](#)
- 5.2. Install or close all cowlings, panels, doors and items of equipment that you removed and/or opened during the preliminary steps (paragraph 3.2 of this Service Bulletin).
- 5.3. Connect all the electrical power supplies.
- 5.4. Record the new weight and moment in your applicable document.
- 5.5. Record compliance with this Service Bulletin in the helicopter documents.
- 5.6. Record the modification 0720162 in the helicopter documents.
- 5.7. Record compliance with this Service Bulletin (see IN 3785-I-00 for instructions):  
QR code or hypertext link



[AS350-25-91-0001](#)

End of Service Bulletin