

# SERVICE BULLETIN

**TITLE:** Landing Gear - Replacement of the equipped skids

**SB Type:** Corrective measure

## APPLICABILITY

Model:	EC120
Version:	B

## COMPONENTS AFFECTED

Designation	Part Number
Landing Gear	C321A2601051 or C321A2602053

## COMPLIANCE: RECOMMENDED

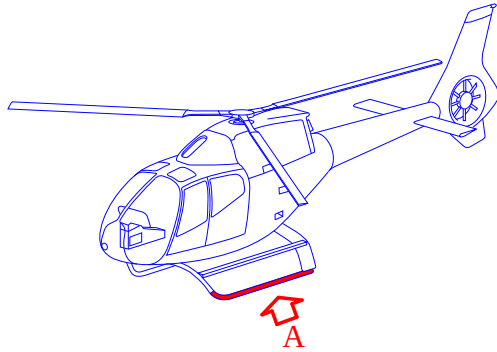
Airbus Helicopters recommends that you comply with this Service Bulletin.

## SUMMARY

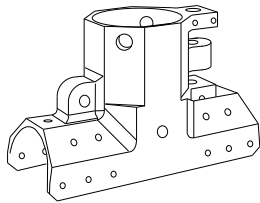
The purpose of this Service Bulletin is to replace the equipped skids. These new equipped skids include new reinforced crossbeam feet that improve strength and increase the number of landings allowed in autorotation.

## GENERAL EVALUATION

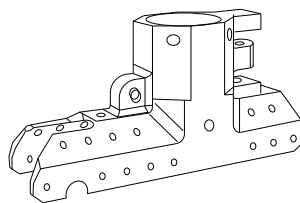
Evaluation table			
Perform once	YES	Accomplish recurring	NO



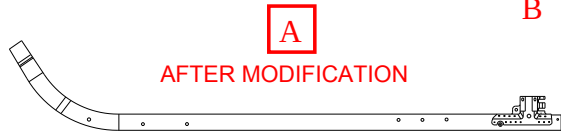
**B**  
BEFORE MODIFICATION



**C**  
AFTER MODIFICATION



**A**  
BEFORE MODIFICATION



**A**  
AFTER MODIFICATION



## PLANNING INFORMATION

### 1. REASON

The purpose of this Service Bulletin is to replace the equipped skids. The reason for this replacement is that, during autorotative landings, the crossbeam feet suffer from fatigue due to the stresses encountered.

Therefore, cases of cracks on landing gears had been detected.

These new equipped skids include new reinforced crossbeam feet that improve strength and increase the number of landings allowed in autorotation.

Compliance with this Service Bulletin enables operators to waive compliance with the instructions introduced through the Emergency Alert Service Bulletin EC120-05A022.

### 2. DESCRIPTION

This Service Bulletin provides the instructions to replace the equipped skids.

### 3. CONCURRENT REQUIREMENTS

Not applicable.

### 4. APPROVAL

The technical content of this document is approved under the authority of 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.

### 5. MANPOWER

#### NOTE

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

#### 5.1. Manpower for procedure

Number of Persons	Qualification	Estimated Man Hours
2	Airframe technicians	4h

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

Number of Persons	Qualification	Estimated Man Hours
2	Airframe technicians	4h

### 6. WEIGHT AND BALANCE

Weight	Longitudinal moment (m.kg) X	Lateral moment (m.kg) Y
+ 0.10 kg	+ 0.46 m.kg	0 m.kg

### 7. ELECTRICAL LOAD DATA

Not applicable.

### 8. DOCUMENTATION AFFECTED

- Aircraft Maintenance Manual (AMM)
- Illustrated Parts Catalog (IPC)
- Master Servicing Manual (MSM)

The changes to Instructions for Continued Airworthiness (ICA) which are required as a result of this SB will be incorporated in the next Normal Revision. Refer to DN.008.0026 until the information is available in the published technical documentation.

### 9. MATERIAL INFORMATION

#### 9.1. 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.

#### 9.2. Availability

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

#### 9.3. 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.

#### 9.4. Mixability

No mixed solutions or combinations of parts from before modification solution and after modification solution are permitted.

#### 9.5. LIST OF NEW MATERIALS

Spare Sets List				
Set Designation		Set Reference		
SKID REINFORCEMENT KIT		C321A080330071		
Set Content				
Item	Designation	Reference	MFC	QTY
3	Blind rivet	ASNA0363T0603	F0210	24
4	Screw	DHS411-101.3082	F0210	2
5	Washer	23119AG100LE	F0210	2
6	Nut	ASNA0045BC100L	F0210	2
7	Cotter pin	EN2367-18028	F0210	2

Individual Spares List				
Item	Designation	Reference	MFC	QTY
1	Equipped right skid	C321A2502106	F0210	1
2	Equipped left skid	C321A2503106	F0210	1
8	Plate indication	ECS2033.M10	F0210	1

Consumables, Materials and Expendables			
Designation	Reference	MFC	QTY
Varnish	CM372	F0210	0.2 Kg
Sealing compound	CM6268	F0210	0.5 L
Anti-corrosion agent	CM518	F0210	0.5 L
Sealing compound	CM6056	F0210	0.5 L
Primer	CM487	F0210	0.5 L
Primer	CM488	F0210	0.5 L
Paint	CM490	F0210	0.5 L

Special Tools				
Item	Designation	Reference	MFC	QTY
None				

### 9.6. LIST OF EXISTING PARTS

INTERCHANGEABLE PARTS			
Old Reference	Designation	New Reference	Interch
C321A2502101 C321A2502102 C321A2502105	Equipped right skid	C321A2502106	two way
C321A2503101 C321A2503102 C321A2503105	Equipped left skid	C321A2503106	two way

REMOVED SPARE PARTS		
Old Reference	Designation	See Notes
C321A2502101 C321A2502102 C321A2502105	Equipped right skid	
NOTE(S)		
(1) DHS.411-101.3082 and DHS.411-101.3080 are not in the same configuration.		

REMOVED SPARE PARTS			
Old Reference	Designation	See Notes	
C321A2503101 C321A2503102 C321A2503105	Equipped left skid		
DHS.411-101.3082 DHS.411-101.3080	Screw	(1)	
ASNA0027SB0604	Blind rivet		
NOTE(S)			
(1) DHS.411-101.3082 and DHS.411-101.3080 are not in the same configuration.			
RE-IDENTIFIED PARTS TABLE			
Old Reference	Designation	New Reference	See Notes
C321A2601051	Landing Gear	C321A2601051 + SB EC120-32-11-0001	(2)
C321A2602053	Landing Gear	C321A2602053 + SB EC120-32-11-0001	(1) (2)
NOTE(S)			
(1) C321A2602053 + SB EC120-32-11-0001 for Landing Gear are equivalent to C321A2602054.			
(2) The references given in the list above are usually identified with two alphabetic characters at the end, for example "AA".			

## 10.ACCOMPLISHMENT INSTRUCTION

Comply with the accomplishment procedure 32-11-0001, 933

## 11. ADDITIONAL INFORMATION

Not applicable.

End of section



## Replacement of the equipped skids 32-11-0001, 933

### 1. APPLICABILITY

Model:	EC120
Version:	B
Component affected:	C321A2601051 or C321A2602053

### 2. GENERAL INFOS

AMM - AIRCRAFT MAINTENANCE MANUAL

FOD - FOREIGN OBJECT DAMAGE

IPC - ILLUSTRATED PARTS CATALOG

MSM - MASTER SERVICNG MANUAL

### 3. PRELIMINARY REQUIREMENTS

#### 3.1. Applicable Documents

- Installation of rivets - pitch and edge distance - Riveting [MTC 20-02-04-401](#)
- General riveting acceptance requirements - Riveting [MTC 20-02-04-601](#)
- Assembly by screws and nuts - Joining [MTC 20-02-05-404](#)
- Safeying assemblies: General- Safeying and locking assemblies [MTC 20-02-06-101](#)
- Electrical bonding: General - Electrical bonding [MTC 20-02-07-101](#)
- Use of AERODUR 43022 varnish - Electrical bonding [MTC 20-02-07-403](#)
- Installation of blind bolts ASN-A 0026 - ASN-A 0027 and 0363 - General rivet replacement principles [MTC 20-03-02-405](#)
- Use of Abrasion-Resistant Topcoat 23 T 3 - Paint and primer application procedure [MTC 20-04-05-447](#)
- Use of THIXOFLEX and SLG products - General sealing procedures [MTC 20-05-01-401](#)
- General rules for bonding with adhesives - Bonding with adhesives [MTC 20-06-01-101](#)
- 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 - Landing Gear [AMM 32-12-00, 4-1](#)
- Assembly / Disassembly - Landing Gear [AMM 32-12-00, 4-2](#)
- Repair - Landing Gear [AMM 32-12-00, 8-1](#)

### 3.2. Set up

- Park the helicopter in a hangar [MTC 20-07-01-201](#)
- Install the applicable access equipment.
- Disconnect all the electrical power supplies.
- Removal / Installation - Landing Gear [AMM 32-12-00, 4-1](#)

### 3.3. Special tools

None

### 3.4. Materials

Designation	Reference	MFC	QTY
Varnish	CM0372	F0210	0.2 Kg
Sealing compound	CM6268	F0210	0.5 L
Anti-corrosion agent	CM518	F0210	0.5 L
Sealing compound	CM6056	F0210	0.5 L
Primer	CM487	F0210	0.5 L
Primer	CM488	F0210	0.5 L
Paint	CM490	F0210	0.5 L

### 3.5. Spares

Designation	Reference	MFC	QTY
Equipped right skid	C321A2502106	F0210	1
Equipped left skid	C321A2503106	F0210	1
Blind rivet	ASNA0363T0603	F0210	24
Screw	DHS411-101.3082	F0210	2
Washer	23119AG100LE	F0210	2
Nut	ASNA0045BC100L	F0210	2
Cotter pin	EN2367-18028	F0210	2
Plate indication	ECS2033.M10	F0210	1

### 3.6. Safety conditions



## 4. PROCEDURE

4.1. Replacement of the equipped skids.

4.1.1. Disassemble the Landing Gear. Refer to Assembly / Disassembly - Landing Gear [AMM 32-12-00, 4-2.](#)

4.1.2. Remove and keep all the parts around the Equipped left skid and the Equipped right skid. Refer to Repair - Landing Gear [AMM 32-12-00, 8-1.](#)

4.1.3. Put the skids into storage.

4.1.4. Install all the necessary parts on the Equipped left skid and the Equipped right skid. Refer to Repair - Landing Gear [AMM 32-12-00, 8-1.](#)



4.1.5. Assemble the Landing Gear ([Figure 1](#)).

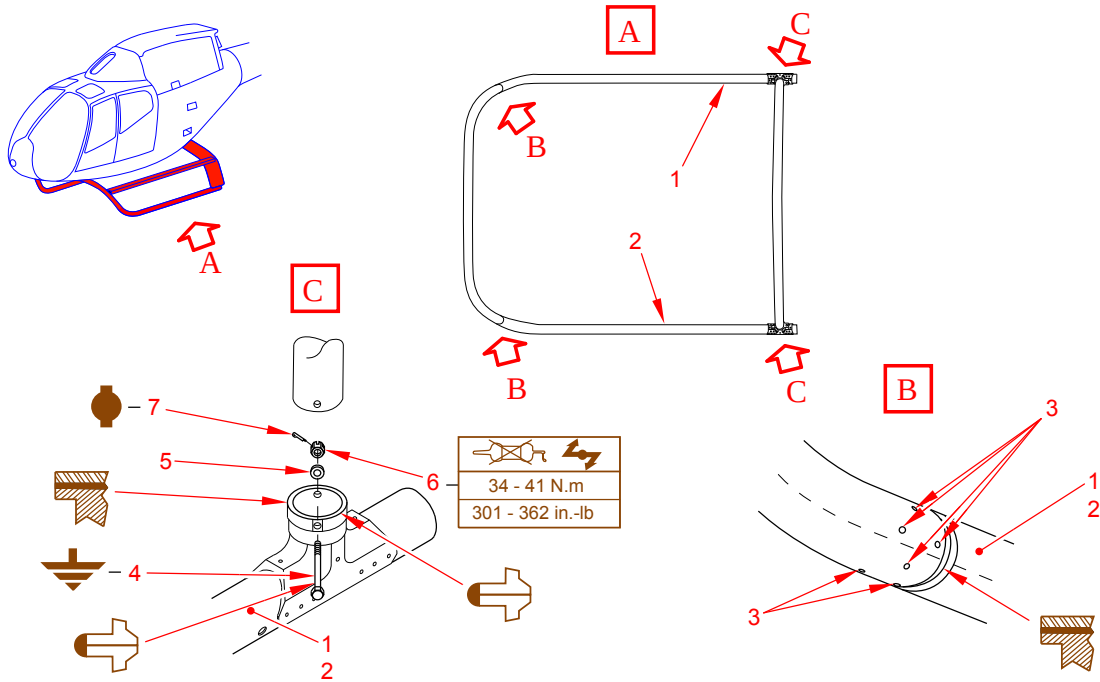
4.1.5.1. Drill the holes in the Equipped right skid C321A2502106 (1) and Equipped left skid C321A2503106 (2) in accordance with the front crossbeam. Refer to Installation of blind bolts ASN-A 0026 - ASN-A 0027 and 0363 - General rivet replacement principles [MTC 20-03-02-405](#)

4.1.5.2. Engage the Equipped right skid C321A2502106 (1) and the Equipped left skid C321A2503106 (2) in the front crossbeam.

4.1.5.3. Apply the Primer CM487 on the twelve Blind rivet ASNA0363T0603 (3).

4.1.5.4. Install the Equipped right skid C321A2502106 (1) and Equipped left skid C321A2503106 (2) in the front crossbeam with the twelve Blind rivet ASNA0363T0603 (3).

- 4.1.5.5. Apply a bead of Sealing compound CM6056 between Equipped right skid C321A2502106 (1) and Equipped left skid C321A2503106 (2) and the front crossbeam.
- 4.1.5.6. Do the paint touch-ups on the sealing compound and the Blind rivet ASNA0363T0603 (3) with Primer CM488 and Paint CM490.
- 4.1.5.7. Engage the rear crossbeam in the Equipped right skid C321A2502106 (1) and the Equipped left skid C321A2503106 (2).
- 4.1.5.8. Do the electrical bonding on the Screw DHS411-101.3082 (4), the Washer 23119AG100LE (5) and the Nut ASNA0045BC100L (6).
- 4.1.5.9. Apply Anti-corrosion agent CM518 on the smooth part of the Screw DHS411-101.3082 (4).
- 4.1.5.10. Install the Screw DHS411-101.3082 (4), the Washer 23119AG100LE (5) and the Nut ASNA0045BC100L (6).
- 4.1.5.11. Torque the Nut ASNA0045BC100L (6) to the indicated value.
- 4.1.5.12. Safety the Nut ASNA0045BC100L (6) with the Cotter pin EN2367-18028 (7).
- 4.1.5.13. Apply a bead of the Sealing compound CM6056 between the rear crossbeam and the Equipped right skid C321A2502106 (1) and Equipped left skid C321A2503106 (2).



**Figure 1**

4.1.6. Marking of the Landing Gear ([Figure 2](#)).

4.1.6.1. Do the marking on the Plate indication ECS2033.M10 (8). Refer to Monitoring of parts in operation - marking - service life customization - General rules applicable to aircraft [MTC 20-08-05-103](#) and the table below:

Former Reference	Designation	New Reference
C321A2601051	Landing Gear	C321A2601051 + SB 32-11-0001
C321A2602053	Landing Gear	C321A2602053 + SB 32-11-0001

**NOTE**

C321A2602053 + SB EC120-32-11-0001 for Landing Gear are equivalent to C321A2602054.

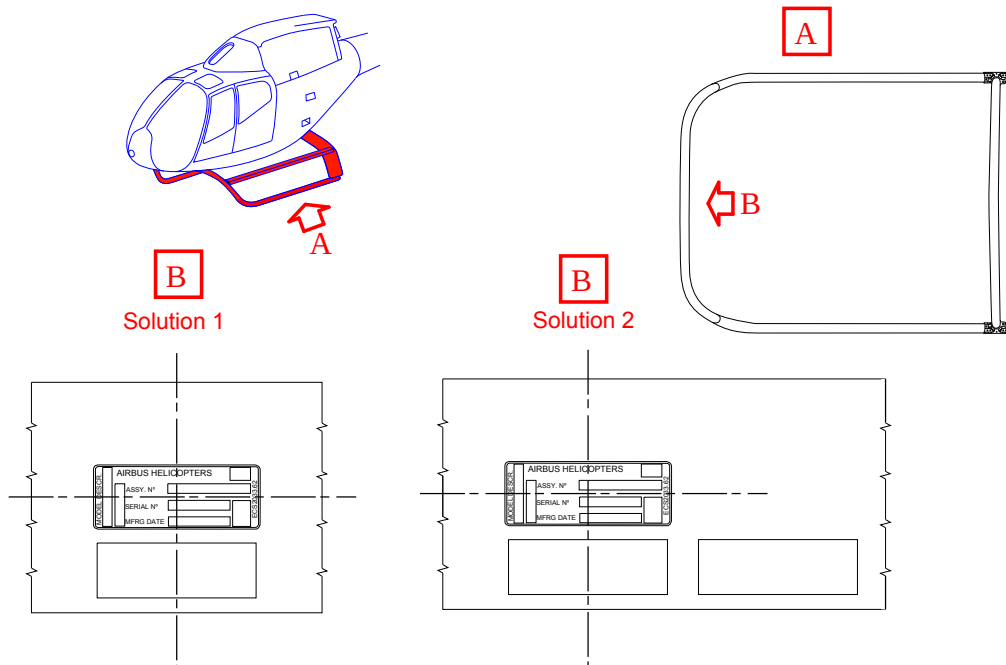
**NOTE**

The references given in the list above are usually identified with two alphabetic characters at the end, for example "AA".

4.1.6.2. Prepare the surface of the front crossbeam for bonding. Refer to General rules for bonding with adhesives - Bonding with adhesives [MTC 20-06-01-101](#).

4.1.6.3. Bond the Plate indication ECS2033.M10 (8) as near possible to the existing one.





**Figure 2**

- 4.1.6.4. Apply a layer of Varnish CM0372 to the Plate indication ECS2033.M10 (8). Refer to the principle of Use of AERODUR 43022 varnish - Electrical bonding [MTC 20-02-07-403](#)

## 5. CLOSE UP

- 5.1. Removal / Installation - Landing Gear [AMM 32-12-00, 4-1](#)
- 5.2. Appearance checks on an aircraft after inspection or repair - Technical instructions [MTC 20-07-03-408](#)
- 5.3. Connect all the electrical power supplies.
- 5.4. After you complete the work, record the new weights and moments in your applicable documents.
- 5.5. Record compliance with this Service Bulletin in the helicopter document.
- 5.6. Record compliance with this Service Bulletin to Airbus Helicopters by flashing the QR code below or by clicking on the hypertext link.



[EC120-32-11-0001](#)

End of service bulletin