

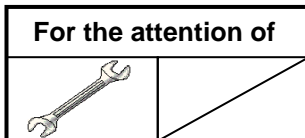
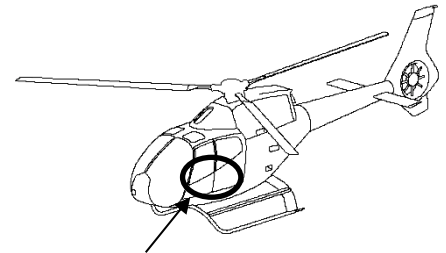
No. EC120-53-019

Civil version(s): B

SERVICE BULLETIN

CORRECTIVE MEASURE

**DOORS - Panel of communication
Improvement on the attachment and sealing of the panel of
communication cabin-cargo**



Revision No.	Date of issue
Revision 0	2023-05-12

Summary:

The purpose of this Service Bulletin is to improve the attachment and sealing of the panel of communication cabin-cargo by replacement of the clip attachments, include two new fixations "quick fastener" type and add seals.

Compliance:

Airbus Helicopters recommends that you comply with this Service Bulletin.

No. EC120-53-019**1. PLANNING INFORMATION****CAUTION**

MAKE SURE THAT THE MODIFICATIONS RELATED TO THIS SERVICE BULLETIN AGREE WITH THE HELICOPTER CONFIGURATION AT THIS TIME. IF THE MODIFICATIONS DO NOT AGREE WITH THE HELICOPTER CONFIGURATION:

- PREPARE THE NECESSARY ADAPTATION WORK.
- GET THE APPROVAL BY THE APPLICABLE LOCAL AIR TRANSPORT AUTHORITIES.
- COMPLY WITH THE AIRWORTHINESS REQUIREMENTS.

THIS SERVICE BULLETIN IS WRITTEN FOR THE INITIAL HELICOPTER CONFIGURATION SPECIFIED IN THE INDIVIDUAL INSPECTION LOG BOOK. IT INCLUDES ONLY THE POST-DELIVERY CONFIGURATION CHANGES THAT ARE KNOWN AND APPROVED BY AIRBUS HELICOPTERS.

1.A. EFFECTIVITY**1.A.1. Helicopters/installed equipment or parts**

Helicopters EC120 version B equipped with panel of communication cabin-cargo MP/N C523S3101052.

NOTE 1

You can identify the modification status of the helicopter in the Section of modifications embodied in the helicopter in the Individual Inspection Log Book.

1.A.2. Non-installed equipment or parts

Panel of communication cabin cargo MP/N C523S3101052.

1.B. ASSOCIATED REQUIREMENTS

Not applicable.

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1.C. REASON

During a flight operation, a helicopter without rear seats and the RH sliding door opened lost the panel of communication cabin-cargo. With the addition of new fixations, the attachments of the panel of communication cabin-cargo will be solved. See SIN No. 2148-S-52 for more information.

The purpose of this Service Bulletin is to improve the attachment and sealing of the panel of communication cabin-cargo by replacement of the clip attachments, include two new fixations "quick fastener" type and add seals.

Airbus Helicopters is also adding seals on this panel of communication cabin-cargo to improve sealing in order to prevent the spread of engine gas odors in the cabin during specific flight operations.

1.D. DESCRIPTION

This Service Bulletin includes the work steps that follow:

- Remove the panel of communication cabin-cargo
- Modify the panel of communication cabin-cargo
- Modify the cabin of the helicopter
- Install the improved panel of communication cabin-cargo.

1.E. COMPLIANCE

1.E.1. Compliance at H/C manufacturer level

Not applicable.

1.E.2. Compliance in service

Helicopters/installed equipment or parts:

It is the operator who does the work on the helicopter.

Airbus Helicopters recommends that you comply with paragraph [3.B.](#) during one of the next maintenance inspections aligned with your operational availabilities / constraints.

Non-installed equipment or parts:

Before you install the panel of communication identified in paragraph [1.A.2.](#), do a check of the stock and do the modification when applicable as given in paragraph [3.B.2.b.](#)

1.F. 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.

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1.G. MANPOWER



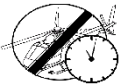
Airbus Helicopters recommends that the personnel who will do this Service Bulletin have this qualification:

Qualification:
1 Airframe Technician.



The man-hours are an estimate given for information only and for a standard helicopter configuration.

Estimated man-hours:
6 hours for Airframe Technician.



The helicopter downtime is an estimate given for information only and for a standard helicopter configuration.

The estimate of the helicopter downtime is 1 day.

1.H. WEIGHT AND BALANCE



Weight: + 0.148 kg

Longitudinal Moment: + 0.54 m.kg

After you complete the work, record the new weights and moments in your applicable document.

1.I. POWER CONSUMPTION

Not applicable.

1.J. SOFTWARE UPGRADES/UPDATES

Not applicable.

1.K. REFERENCES

These documents are necessary to comply with this Service Bulletin:

Aircraft Maintenance Manual (AMM):

AMM: 20-10-00,3-15: Bonding with adhesives - Airframe

AMM: 20-10-00,3-33: General riveting acceptance requirements - Airframe

AMM: 20-20-00,3-1: Standard Practices - Structure

AMM: 20-20-00,4-2: Installation of rivets - Pitch and edge distance - Airframe

AMM: 53-00-00,3-1: General safety instructions - Fuselage

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Standard Practices Manual (MTC):

MTC: 20-02-04-402: Installation of rivets - retrofitting and repair - Riveting
MTC: 20-03-02-401: Installation of normal rivets - General rivet replacement principles
MTC: 20-04-01-102: Use of cleaning products on individual parts and on aircraft - Cleaning
MTC: 20-04-01-402: Cleaning of removed individual parts with liquid solvents - Cleaning
MTC: 20-04-01-403: Cleaning helicopters - Cleaning
MTC: 20-04-02-401: Chemical stripping of organic surface finishes - Stripping
MTC: 20-04-04-401: Preparation of surfaces before painting - Surface treatment before painting
MTC: 20-04-05-402: Application of Primer EPOXY P05-P20 - Paint and primer application procedure
MTC: 20-06-01-101: General rules for bonding with adhesives - Bonding with adhesives
MTC: 20-06-01-310: Application of BOSTIK 1400 cement - Bonding with adhesives
MTC: 20-07-02-201: Helicopter parked in a repair shop - Safety instructions
MTC: 20-08-05-103: Monitoring of parts in operation - marking - service life customization - General rules applicable to aircraft

Information Notice (IN):

IN: 3481-I-00: The Marketplace: an AirbusWorld eOrdering service
IN: 3686-I-00: Publishing of complementary Instructions for Continued Airworthiness through Delivery Notes
IN: 3785-I-00: Introduction of the digital Service Bulletin reporting SB Insight

Safety Information Notice (SIN):

SIN: 2148-S-52: Cabin/Cargo Communication Panel - Loss of a panel in flight

1.L. OTHER AFFECTED PUBLICATIONS



The changes to Instructions for Continued Airworthiness (ICA) which are required as a result of this Service Bulletin will be incorporated in the next Normal Revision. Refer to DN.008.0010 until the information is available in the published technical documentation.

NOTE 2

You can find more information about Delivery Notes in Information Notice IN 3686-I-00.

1.M. PART INTERCHANGEABILITY OR MIXABILITY

Interchangeability:

PRE MOD and POST MOD components are not interchangeable.

Mixability:

You must not use PRE MOD and POST MOD components together.

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2. EQUIPMENT OR PARTS INFORMATION

2.A. EQUIPMENT OR PARTS: PRICE - AVAILABILITY - PROCUREMENT

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.

Availability

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

Procurement

Send an order for the necessary quantities to the Airbus Helicopters Network Sales and Customer Relations Department:

Airbus Helicopters
Etablissement de Marignane
Direction Ventes et Relations Client
13725 MARIIGNANE CEDEX
FRANCE

In the purchase order, write the information that follows:

- The mode of transport
- The destination
- The serial numbers of the helicopters to change.

2.B. LOGISTIC INFORMATION

Not applicable.

2.C. EQUIPMENT OR PARTS REQUIRED PER HELICOPTER/COMPONENT

Kits to be ordered for one helicopter or one assembly:

Key word	Qty	New P/N	Item	Former P/N	→	Instruction
<u>Improvement panel of communication kit including:</u>		<u>C120A080180071</u>				
Upper joint	1	C523A1052201	1			
Lateral joint	2	C523A1052202	2			
Lower joint	1	C523A1052203	3			
Quick fastener socket	2	NSA55134-202	5			
Rivet	4	21217DC2408J	6			
Quick fastener	2	NSA55193-103	8			

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Key word	Qty	New P/N	Item	Former P/N	→	Instruction
<u>Improvement panel of communication kit including (cont.):</u>						
		<u>C120A080180071</u>				
Washer retaining	2	NSA55144-002	9			
Clip	11	133159G	10			

Consumables to be ordered separately:

Refer to Work Cards and Tasks indicated in this Service Bulletin and the list below:

Key Word	Qty	P/N	CM	Item
Adhesive	0.3 KG	DHS171-141.20	6014	4
Touch-up pen	0.2 L	ECS2338.10	316	7
Basic resin for primer	0.2 L	DHS186-111.30	460	11

You can send an order for the consumables from the AirbusWorld Marketplace through e-ordering (IN 3481-I-00).

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

Special tools:

Refer to the Work Cards and Tasks indicated in this Service Bulletin.

2.D. EQUIPMENT OR PARTS TO BE RETURNED

Not applicable.

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3. ACCOMPLISHMENT INSTRUCTIONS

3.A. GENERAL

- Comply with the instructions for bonding with adhesives. Refer to Task 20-10-00,3-15 (AMM).
- Comply with the instructions on the general riveting acceptance requirements. Refer to Task 20-10-00,3-33 (AMM).
- Comply with the general instructions on standard practices. Refer to Task 20-20-00,3-1 (AMM).
- Comply with the instructions for the installation of rivets. Refer to Task 20-20-00,4-2 (AMM).
- Comply with the general instructions for safety. Refer to Task 53-00-00,3-1 (AMM).
- Comply with the general instructions for installation of rivets. Refer to Work Card 20-02-04-402 (MTC).
- Comply with the instructions for the use of cleaning products on individual parts and on aircraft. Refer to Work Card 20-04-01-102 (MTC).
- Comply with the instructions for cleaning of removed individual parts with liquid solvents. Refer to Work Card 20-04-01-402 (MTC).
- Comply with the instructions for cleaning helicopters. Refer to Work Card 20-04-01-403 (MTC).
- Comply with the instructions for the chemical stripping of organic surface finishes. Refer to Work Card 20-04-02-401 (MTC).
- Comply with the general instructions for bonding with adhesives. Refer to Work Card 20-06-01-101 (MTC).
- Comply with the instructions of BOSTIK 1400 cement. Refer to Work Card 20-06-01-310 (MTC).
- Comply with the general instructions to park a helicopter. Refer to Work Card 20-07-02-201 (MTC).

3.B. WORK STEPS



CAUTION

MAKE SURE THAT YOU PREVENT ALL POSSIBLE FOREIGN OBJECT DAMAGE (FOD). REFER TO SAFETY PROMOTION NOTICE (SPN) No. 3703-P-00.

3.B.1. Preliminary steps

- Park the helicopter in a maintenance hangar.
- Install the appropriate access equipment.
- Remove and/or open all the cowlings, panels, doors, and all the equipment items to get access to the different work areas.

3.B.2. Procedure

NOTE 1

Cutouts and drillings: Work Card 20-04-04-401 (MTC) gives information on deburring and protection.

3.B.2.a. Removal of the panel of communication cabin-cargo ([Figure 1](#))

- Remove the panel of communication cabin-cargo (a) and the clips (b) from the cabin bulkhead (c) (Detail A - PRE MOD).
- Discard the clips (b).

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3.B.2.b. Modification of the panel of communication cabin-cargo ([Figure 1](#), [Figure 2](#))

On the panel of communication cabin-cargo (a) ([Figure 1](#), Detail A - POST MOD):

- Put in position:
 - . The upper joint (1)
 - . The lateral joints (2)
 - . The lower joint (3).
- To avoid collision with the optional folding litter MP/N C255A3201051 (if installed), cut the lateral joints (2).
- In accordance with the joints (Detail B), identify with marks, strip and clean:
 - . The area (A)
 - . The areas (B)
 - . The area (C).
- Use the adhesive (4) to install:
 - . The upper joint (1) (Figure 2, SECTION A-A)
 - . The lateral joints (2) (SECTION B-B)
 - . The lower joint (3) (SECTION C-C).
- Let the adhesive (4) dry.
- Install the quick fastener (8) and washer retaining (9).

3.B.2.c. Modification of the cabin bulkhead ([Figure 3](#))

- Increase the existing boreholes on the cabin bulkhead (c) with a drill bit diameter 12.7 mm ([Figure 3](#) - Detail B).
- Clean the work areas.
- Put in position the quick fastener sockets (5) on the cabin bulkhead (c) ([Figure 3](#) - Detail C).
- Counter drill the 4 rivet holes from the quick fastener sockets (5) to the cabin bulkhead (c) with a drill bit diameter 2.5 mm.
- Remove the quick fastener sockets (5) from the cabin bulkhead (c).
- Clean the work areas.
- Apply touch-up pen (7) (not shown) on the boreholes.
- Apply Basic resin for primer (11) (not shown). Refer to Work Card 20-04-05-402 (MTC).
- Install the quick fastener sockets (5) to the cabin bulkhead (c) with 4 countersunk rivets (6). Refer to Work Card 20-03-02-401 (MTC).

3.B.2.d. Installation of the panel of communication cabin-cargo ([Figure 1](#), [Figure 2](#))

Install the panel of communication cabin-cargo (a) on the cabin bulkhead (c) with the clips (10).

3.B.3. Final steps

- Clean and apply the close-up procedures to the work areas and the helicopter.
- Install or close all cowlings, panels, doors, and items of equipment that you removed and/or opened during the preliminary steps (refer to paragraph [3.B.1.](#)).
- Remove the access equipment.
- Set the helicopter to flight condition.

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3.C. RECORD OF COMPLIANCE

Compliance with this document:

Record the full compliance with this Service Bulletin, with the revision number, in the helicopter documents.

Record the full compliance with this Service Bulletin (see IN 3785-I-00 for instructions):
QR code or hypertext link



NOTE 2

The recording of compliance with Service Bulletins in the SB Insight tool does not replace the recording in the helicopter documents.

[SB EC120 53-019](#)

Identification of modifications on equipment or parts:

Identify the panel of communication cabin-cargo. Refer to the table below and to the Work Card 20-08-05-103 (MTC).

Key word	Old P/N	New P/N	MOD	Marking type
Panel of communication cabin-cargo	C523S3101052	C523S3101052 + Service Bulletin No. 53-019	Service Bulletin No. 53-019	Indelible ink

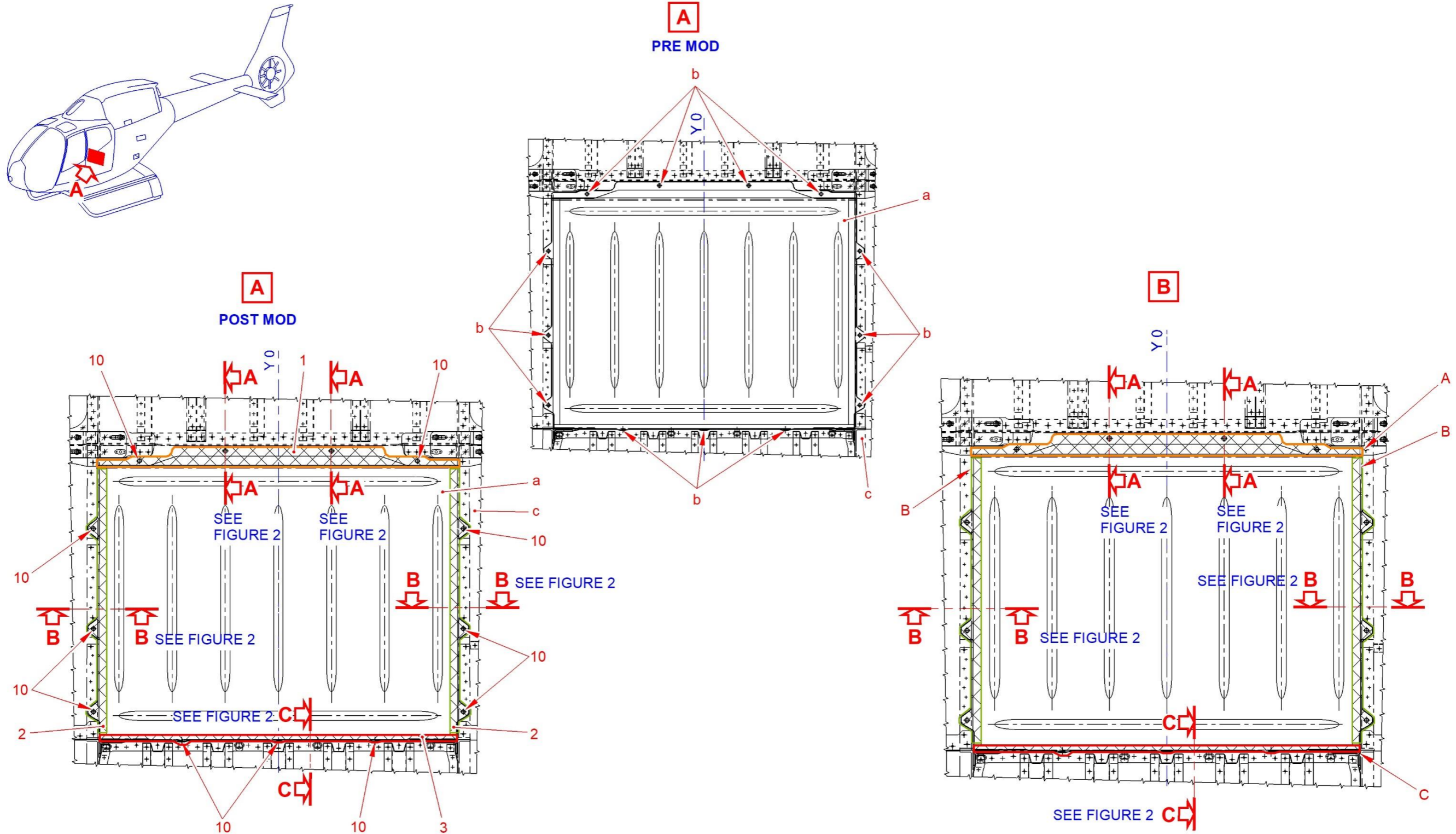
3.D. OPERATING AND MAINTENANCE INSTRUCTIONS

Operation instructions:

Not applicable.

Maintenance instructions:

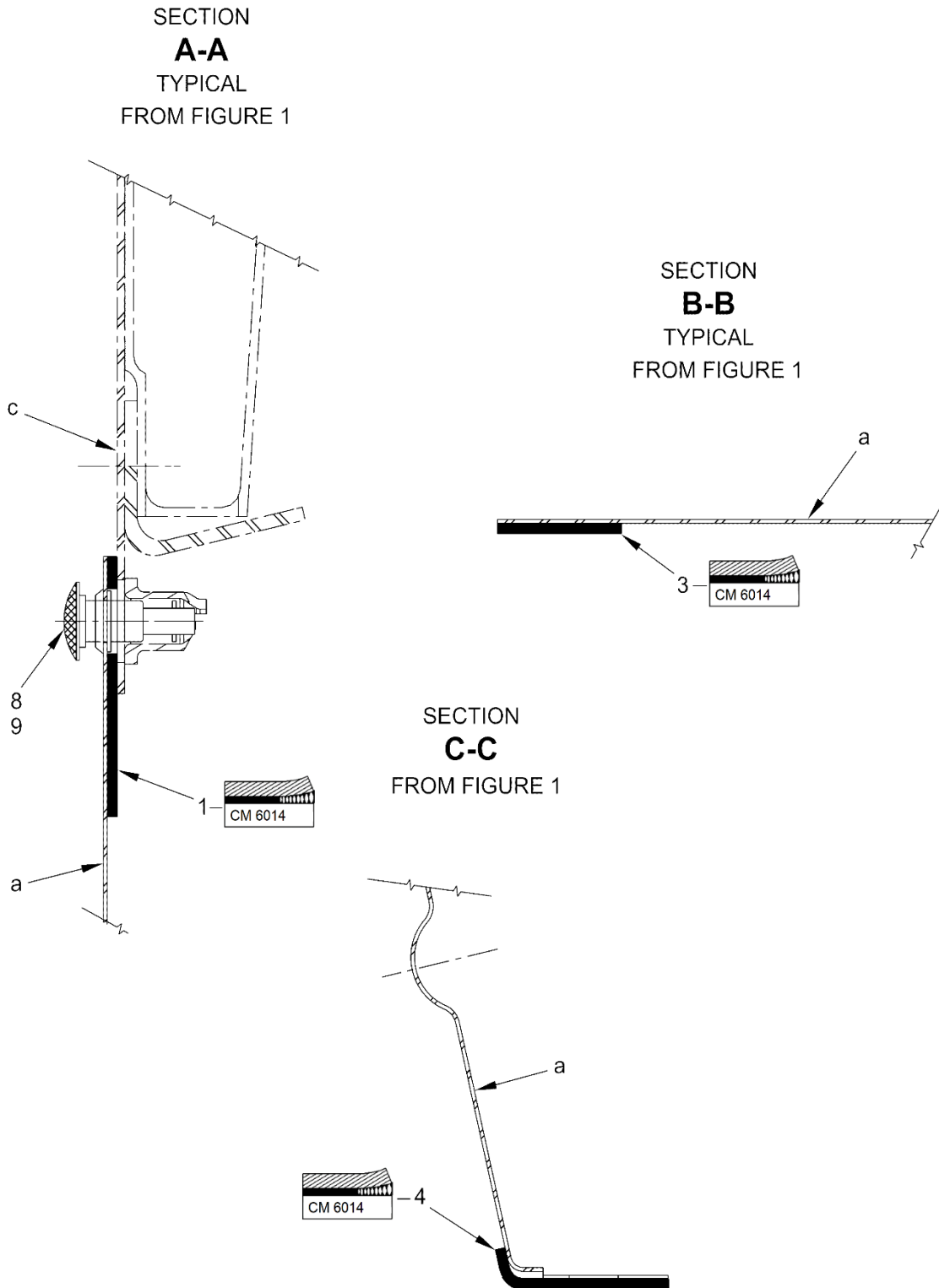
Refer to the applicable technical publication.



Back to paragraphs [3.B.2.a.](#), [3.B.2.b.](#) and [3.B.2.d.](#)

Figure 1

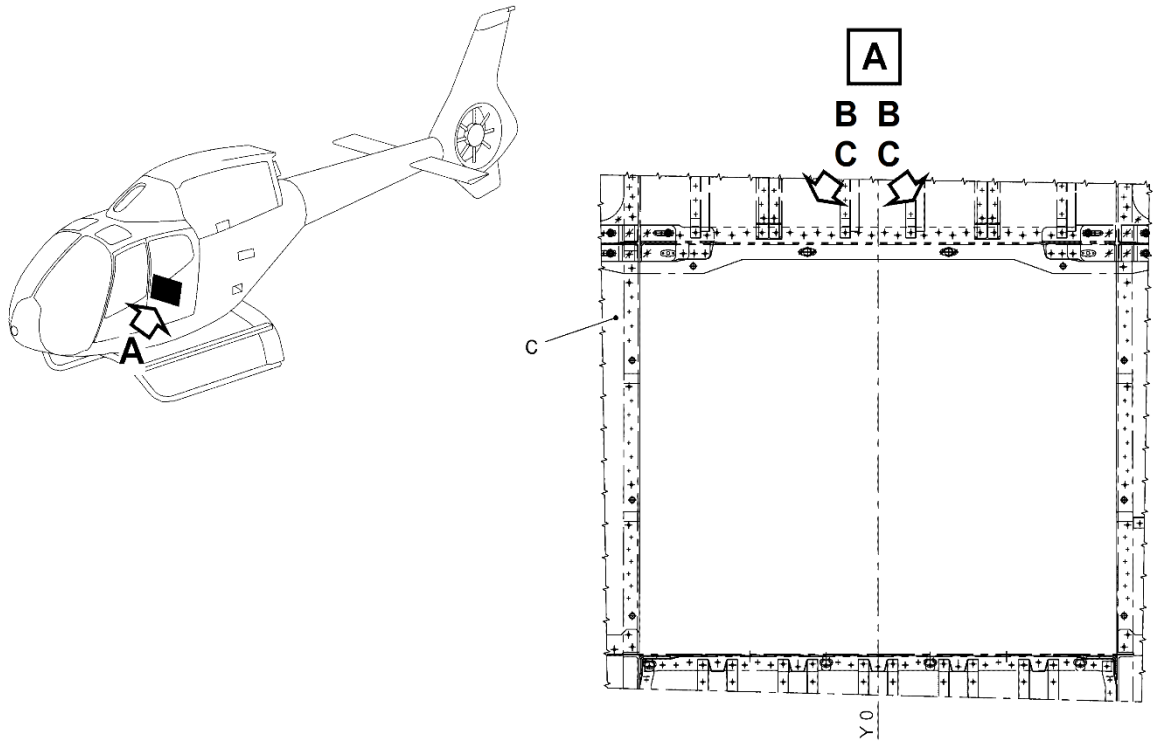
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Back to paragraphs [3.B.2.b.](#) and [3.B.2.d.](#)

Figure 2

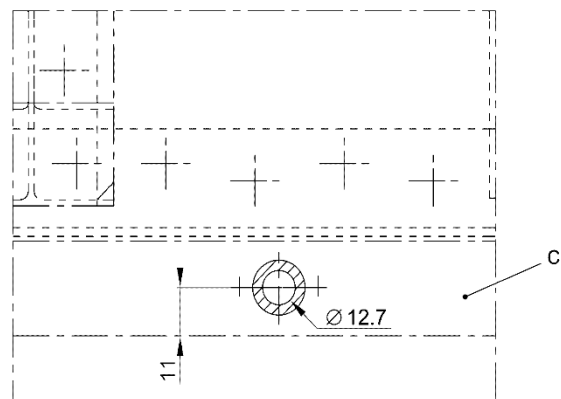
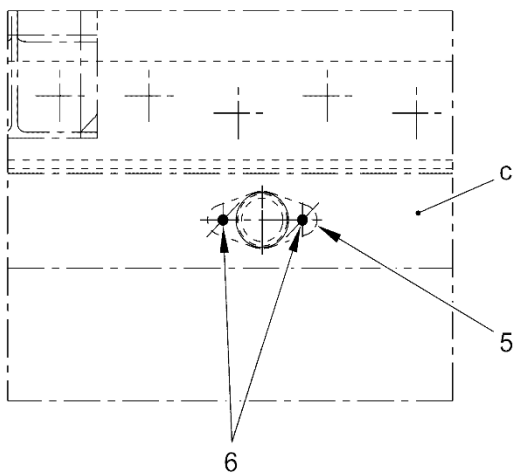
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C

B

ONLY BULKHEAD SHOWN



Back to paragraph [3.B.2.c.](#)

Figure 3