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AgustaWestland Products

SERVICE BULLETIN

OPTIONAL

N° 139-729

DATE: September 1, 2023

REV.: /

TITLE

ATA 28 – FUEL PORT MODIFICATION

REVISION LOG

First Issue

1. PLANNING INFORMATION

A. EFFECTIVITY

AW139 helicopters from S/N 41801 to S/N 41804.

B. COMPLIANCE

At Customer's option.

C. CONCURRENT REQUIREMENTS

N.A.

D. REASON

This Service Bulletin is issued in order to:

- Part I, provide the necessary instruction on how to remove the kit close circuit refuelling receiver (CCRR) P/N 4G2820F00111;
- Part II, perform the fuel tank CCRR ISO45 structural retromod P/N 3G5338P00811 (applicable to helicopters from S/N 41801 to S/N 41803), the structural provision for CCRR ISO45 P/N 3G5310A17011 (applicable to helicopter S/N 41804) and the cover plug fuel tank CCRR ISO45 installation P/N 3G5338A26711.

LH issued this SB for the following reason:

Helicopter Reliability/Maintainability	
Product Improvement	
Obsolescence	
Customization	✓
Product/Capability Enhancement	

E. DESCRIPTION

Part I of this Service Bulletin provides all necessary instruction to remove the kit CCRR P/N 4G2820F00111 by restoring the basic gravity fuel port. This consists in installing the basic tank filler cap P/N 3G2810V00431 and the basic tank filler adapter P/N 503522-1.

Part II of this Service Bulletin provides all necessary instruction to perform the fuel tank CCRR ISO45 structural retromod P/N 3G5338P00811, the structural provision for

CCRR ISO45 P/N 3G5310A17011 and to install the cover plug fuel tank CCRR ISO45 installation P/N 3G5338A26711.

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 three (3) MMH;

Part II: approximately forty (40) MMH.

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

H. WEIGHT AND BALANCE

PART I

WEIGHT (kg)	-0.812	
	ARM (mm)	**MOMENT (kgmm)**
LONGITUDINAL BALANCE	6082	-4938.584
LATERAL BALANCE	963	-781.956

PART II

WEIGHT (kg)	1.3	
	ARM (mm)	**MOMENT (kgmm)**
LONGITUDINAL BALANCE	6083	7907.9
LATERAL BALANCE	1033	-1342.8

I. REFERENCES

I.1 PUBLICATIONS

Following Data Modules refer to AMP:

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.	II
DM03	39-A-20-10-01-00A-259A-A	Ground connections - Other procedure to protect surfaces	II
DM04	39-A-20-30-00-00A-010A-A	Standard practices - Fuel system - General data	I
DM05	39-A-28-11-03-00A-720A-A	Number 2 tank filler cap – Install procedure	I
DM06	39-A-28-11-03-00B-520A-K	Number 2 tank filler cap - Remove procedure	I
DM07	39-A-28-11-04-00A-720A-A	Number 2 tank filler ring - Install procedure	I
DM08	39-A-28-11-04-00B-520A-K	Number 2 tank filler ring - Remove procedure	I
DM09	39-A-28-11-19-00A-720A-A	Number 2 tank filler adapter - Install procedure	I
DM10	39-A-28-11-19-00B-520A-K	Number 2 tank refuelling receiver - Remove procedure	I

I.2 ACRONYMS & ABBREVIATIONS

AMDI	Aircraft Material Data Information
AMP	Aircraft Maintenance Publication
AR	As Required
CCRR	Close Circuit Refueling Receiver
DM	Data Module
DOA	Design Organization Approval
EASA	European Aviation Safety Agency
IPD	Illustrated Part Data
ITEP	Illustrated tool and equipment publication
LH	Left Hand
LHD	Leonardo Helicopters Division
MMH	Maintenance Man Hours
N.A.	Not Applicable
P/N	Part Number

RH	Right Hand
SB	Service Bulletin
S/N	Serial Number

I.3 ANNEX

N.A.

J. PUBLICATIONS AFFECTED

N.A.

K. SOFTWARE ACCOMPLISHMENT SUMMARY

N.A.

2. MATERIAL INFORMATION

A. REQUIRED MATERIALS

A.1 PARTS

PART I

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
1	3G2810V00431		Tank filler cap	1	.		139-729L1
2	503522-1		Tank filler adapter	1	.		139-729L1
3	AN525-416R8		Screw	2	.		139-729L1
4	MS29513-156		O-ring	1	.		139-729L1
5	MS29513-164		O-ring	1	.		139-729L1

PART II

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
6	**3G5338P00811**		**FUEL TANK CCRR ISO45 STRUCTURAL RETROMOD**	**REF**	**.**	**(1)**	**-**
7	3G2810A01251		Anticlocking ring	1	..		139-729L2
8	3G5310A17151		Flange	1	..		139-729L2
9	A601A3B14		Bonding cable assy	1	..		139-729L2
10	A605A01		Grounding connector	1	..		139-729L2
11	MS20426AD4-5-5		Rivet	16	..		139-729L2
12	MS20426AD4-6		Rivet	0.1 kg	..		139-729L2
13	MS21042L08		Nut	4	..		139-729L2
14	MS35206-246		Screw	4	..		139-729L2
15	NAS1149DN832H		Washer	10	..		139-729L2
16	**3G5310A17011**		**STRUCTURAL PROVISION FOR CCRR ISO45**	**REF**	**.**	**(2)**	**-**
17	3G2810A01251		Anticlocking ring	1	..		139-729L3
18	3G5310A17151		Flange	1	..		139-729L3
19	3G5310A17251		Reinforcement	1	..		139-729L3
20	3G5338A27051		Collar shim	1	..		139-729L3
21	A601A3B14		Bonding cable assy	1	..		139-729L3
22	A605A01		Grounding connector	1	..		139-729L3
23	MS20426AD4-5-5		Rivet	16	..		139-729L3
24	MS20426AD4-6		Rivet	0.1 kg	..		139-729L3
25	MS21042L08		Nut	4	..		139-729L3
26	MS35206-246		Screw	4	..		139-729L3
27	NAS1149DN832H		Washer	10	..		139-729L3
28	**3G5338A26711**		**COVER PLUG FUEL TANK CCRR INSTALLATION**	**REF**	**.**		**-**
29	3G5338A26851		Locking ring	1	..		139-729L2 139-729L3
30	3G5338A26931		Cover assy	1	..		139-729L2 139-729L3
31	AN525-10R6		Screw	6	..		139-729L2 139-729L3
32	MS29513-262		O-ring	1	..		139-729L2 139-729L3

Refer also to IPD for the spares materials required to comply with the AMP DMs referenced in the accomplishment instructions.

A.2 CONSUMABLES

#	SPEC./LHD CODE NUMBER	DESCRIPTION	Q.TY	NOTE	PART
33	MMM-A-132 Type 1, Class 3 199-05-002 Type II, Class 2	Adhesive EA934NA (C057)	AR	(3)	II
34	MMM-A-132, Type 2, Class II 199-05-002, Type I, Class 2	Adhesive EA9309.3NA (C021)	AR	(3)	II
35	AWMS05-001 Type 1, Class C, Grade 1	Sealant MC-780 C (C465)	AR	(3)	II
36	AWMS05-001 Type 1, Class B, Grade 2	Sealant MC-780 B (C465)	AR	(3)	II
37	AWTR033	Fiberglass fabric 20749 1200 (C931)	AR	(3)	II
38	199-50-002 Type II	Hardener B5173	AR	(3)	II
39	Commercial	Epoxy resin Araldit LY5138-2	AR	(3)	II
40	Commercial	Sealant Thixoflex Gray TG8498-50 (C347)	AR	(3)	II
41	Commercial	Fiberglass 20644 1200 (THK 0,23 mm)	AR	(3)	II
42	199-05-002 Type II, Class 3	Adhesive EA 956 AERO (C193)	AR	(3)	II

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

A.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
139-729L1	1		I
139-729L2	1	(1)	II
139-729L3	1	(2)	

NOTES

(1) Applicable to helicopters from S/N 41801 to S/N 41803.

(2) Applicable to helicopter S/N 41804.

(3) Item to procured as local supply.

B. SPECIAL TOOLS

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

C. INDUSTRY SUPPORT INFORMATION

Customization.

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) During the installation of bonding braids or components requiring grounding, clean the surface structure in order to obtain a good ground contact.

e) Let adhesive cure at room temperature for at least 24 hours unless otherwise specified.

f) Exposed thread surface and nut must be protected using a layer of tectyl according to MIL-C-16173 grade I.

g) All lengths are in mm.

PART I

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.

NOTE

Make sure to use fuel-system standard practices during the following procedures. Refer to AMP DM 39-A-20-30-00-00A-010A-A.

2. With reference to Figure 1, perform the removal of kit close circuit refuelling receiver P/N 4G2820F00111 as described in the following procedure:

   2.1 In accordance with AMP DM 39-A-28-11-03-00B-520A-K and with reference to Figure 1 View A, remove the tank filler cap (part of close circuit refuelling receiver P/N 750000-15) and n°2 screws P/N AN525-416R10.

   2.2 In accordance with AMP DM 39-A-28-11-04-00B-520A-K and with reference to

Figure 1 View A, remove the tank filler ring P/N 504333 and n°10 screws P/N AN525-416R8. Retain the tank filler ring and the screws for later reuse.

2.3 In accordance with AMP DM 39-A-28-11-19-00B-520A-K and with reference to Figure 1 View A, remove the tank refuelling receiver (part of close circuit refuelling receiver P/N 750000-15), the O-ring P/N MS29513-156 and the O-ring P/N MS29513-164. Discard the O-rings.

2.4 With reference to Figure 1 View A, remove and discard the stencil P/N AW001DSP015EQ or the decal P/N AW003DBHP025E00Q or the decal P/N AW003DBHP025E01Q.

2.5 With reference to Figure 1 View A, remove and discard the stencil P/N AW001DSD040EQ or the decal P/N AW003DBHD080E00Q or the decal P/N AW003DBHD080E01Q.

3. In accordance with AMP DM 39-A-28-11-19-00A-720A-A and with reference to Figures 2 View B, install the tank filler adapter P/N 503522-1, the O-ring P/N MS29513-156 and the O-ring P/N MS29513-164.
4. In accordance with AMP DM 39-A-28-11-04-00A-720A-A and with reference to Figures 2 View B, re-install the tank filler ring P/N 504333 by means of n°12 screws P/N AN525-416R8.
5. In accordance with AMP DM 39-A-28-11-03-00A-720A-A and with reference to Figures 2 View B, install the tank filler cap P/N 3G2810V00431.
6. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
7. Return the helicopter to flight configuration and record for compliance with this Service Bulletin on the helicopter logbook.
8. Gain access to My Communications section on Leonardo WebPortal and compile the “Service Bulletin Application Communication”.

   As an alternative, send the attached compliance form to the following mail box:

   engineering.support.lhd@leonardo.com

   and (for North, Central and South America) also to:

   AWPC.Engineering.Support@leonardocompany.us

PART II

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.

NOTE

The following Step 2 is applicable to helicopters from S/N 41801 to S/N 41803.

2. In accordance with AMP DM 39-A-06-41-00-00A-010A-A and with reference to Figures 3 thru 8, remove all external panels, internal panels and internal liners as required to gain access to the area affected by the installation and perform the fuel tank CCRR ISO45 structural retromod P/N 3G5338P00811 as described in the following procedure:

   2.1 With reference to Figure 5, remove the following components and related fixing hardware:

   - the cover plate P/N 3P5338A19351;
   - the adaptor plate P/N 3P5310P4051;
   - the upper plate P/N 3G5310P04054;
   - the lower plate P/N 3G5310P04053;
   - the additional shim P/N 3G5310P04057;
   - the shim P/N 3G5310P04052.

   2.1 With reference to Figure 4 Detail A, install the anticlocking ring P/N 3G2810A01251 by means of n°12 rivets P/N MS20426AD4-6 on the flange P/N°3G5310A17151.

   2.2 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 4 Section C-C, if necessary prepare the indicated contact surfaces to assure the correct electrical bonding.

   2.3 With reference to Figure 4, install the flange P/N 3G5310A17151 by means of n°16 rivets P/N MS20426AD4-5-5 on the panel P/N 3P5338A01532. Use conductive sealant S1184 all around.

   2.4 With reference to Figure 8, remove the aft plate P/N 3G5310P04056 and the FWD plate P/N 3G5310P04055 and related fixing hardware from the FWD lower panel assy P/N 3P5340A01431.

   2.5 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 6 Section E-E, prepare the indicated contact surfaces on the external skin P/N 3P5340A34951 to assure the correct electrical bonding.

NOTE

Apply a layer of sealant MC-780 C (C465) on all faying surfaces. Apply a fillet all around the mating surfaces boundary using sealant MC-780 B (C465).

2.6 With reference to Figure 6 Section E-E, install grounding connector P/N A605A01 by means of n°2 screws P/N MS35206-246, n°4 washers P/N NAS1149DN832H and n°2 nuts P/N MS21042L08.

2.7 With reference to Figure 7 Section H-H, remove existing rivets and drill a hole Ø 5.0÷5.2 on the profile STA 7200 P/N 3P5340A12951.

2.8 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 7 Section H-H, prepare the indicated surfaces on the profile STA 7200 to assure the correct electrical bonding

2.9 With reference to Figure 6 Section G-G and Figure 7 Section H-H, install the bonding cable assy P/N A601A3B14 by means of n°2 screws P/N MS35206-246, n°6 washers P/N NAS1149DN832H and n°2 nuts P/N MS21042L08.

NOTE

The following Step 3 is applicable to helicopter S/N 41804.

3. In accordance with AMP DM 39-A-06-41-00-00A-010A-A and with reference to Figures 9 thru 15, remove all external panels, internal panels and internal liners as required to gain access to the area affected by the installation and perform the structural provision for CCRR ISO45 P/N 3G5310A17011 as described in the following procedure:

3.1 With reference to Figure 10 Section B-B and Figure 15 Section P-P, perform the indicated cut-out Ø 248.0 through the panel P/N 3P5338A01532.

NOTE

Carefully rework where indicated and remove honeycomb core in localised areas ensuring no damage to external skin (Ref. Figure 15).

3.2 With reference to Figure 15 Section P-P and Section R-R, remove honeycomb core Ø 298.0 from the internal side of the panel P/N 3P5338A01532 in correspondence of the previously performed cut-out.

3.3 With reference to Figure 15 Section P-P and Section R-R, trim honeycomb core and internal skin of the panel P/N 3P5338A01532.

3.4 With reference to Figure 15 Schematic View, seal honeycomb edge by means of adhesive EA934NA (C057).

3.5 With reference to Figure 15 Schematic View, apply on the cut out edges a ply of

fiberglass 20644 1200 by means of adhesive EA 956 AERO (C193).

3.6 With reference to Figure 10 Section B-B, install the reinforcement P/N°3G5310A17251 by means of adhesive EA9309.3NA (C021).

3.7 With reference to Figure 15 Section P-P and Section R-R, install collar shim P/N°3G5338A27051 as required.

3.8 With reference to Figure 10 Detail A, install the anticlocking ring P/N 3G2810A01251 by means of n°12 rivets P/N°MS20426AD4-6 on the flange P/N°3G5310A17151.

3.9 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 10 Section B-B, prepare the indicated contact surfaces to assure the correct electrical bonding.

3.10 With reference to Figure 10 Detail A and Section B-B, install the flange P/N 3G5310A17151 by means of n°16 rivets P/N° MS20426AD4-5-5 on the panel P/N 3P5338A01532. Use conductive sealant S1184 all around.

NOTE

Carefully rework where indicated and remove honeycomb core in localised areas ensuring no damage to external skin (Ref. Figure 13).

3.11 With reference to Figure 11 Detail D and Figure 13, remove honeycomb core Ø 50.0 from the internal side of the FWD lower panel assy P/N 3P5340A01431 as indicated.

3.12 With reference to Figure 13 Schematic Section M-M, seal honeycomb edge by means of adhesive EA934NA (C057).

3.13 Prepare a mixture of 23 parts by weight of hardener B5173 with 100 parts by weight of epoxy resin Araldit LY5138-2.

3.14 With reference to Figure 13 Schematic Section M-M, perform the indicated reparation by means of n°3 plies of fiberglass fabric 20749 1200 (C931) soaked with the previously prepared compound.

3.15 With reference to Figure 13 Detail L, perform the indicated cut-out Ø 16.0 through the panel.

3.16 With reference to Figure 13 Detail L, drill n°3 holes Ø 4.5 through the panel.

3.17 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 11 Section E-E, prepare the indicated contact surfaces on the external skin P/N 3P5340A34951 to assure the correct electrical bonding.

NOTE

Apply a layer of sealant MC-780 C (C465) on all faying surfaces. Apply a fillet all around the mating surfaces boundary using sealant MC-780 B (C465).

3.18 With reference to Figure 11 Section E-E, install grounding connector P/N A605A01 by means of n°2 screws P/N MS35206-246, n°4 washers P/N NAS1149DN832H and n°2 nuts P/N MS21042L08.

3.19 With reference to Figure 12 Section H-H, remove existing rivets and drill a hole Ø 5.0÷5.2 on the profile STA 7200 P/N 3P5340A12951.

3.20 In accordance with AMP DM 39-A-20-10-01-00A-259A-A and with reference to Figure 12 Section H-H, prepare the indicated surfaces on the profile STA 7200 to assure the correct electrical bonding

3.21 With reference to Figure 11 Section G-G and Figure 12 Section H-H, install the bonding cable assy P/N A601A3B14 by means of n°2 screws P/N MS35206-246, n°6 washers P/N NAS1149DN832H and n°2 nuts P/N MS21042L08.

4. With reference to Figure 16, perform the cover plug fuel tank CCRR ISO45 installation P/N 3G5338A26711 as described in the following procedure:

NOTE

Use sealant thixoflex Gray TG8498-50 (C347).

4.1 With reference to Figure 16, install the cover assy P/N 3G5338A26931, the locking ring P/N 3G5338A26851 and the O-ring P/N MS29513-262 by means of n°6 screws P/N AN525-10R6.

5. In accordance with AMP DM 39-A-06-41-00-00A-010A-A, re-install all external panels, internal panels and internal liners previously removed.
6. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
7. Return the helicopter to flight configuration and record for compliance with this Service Bulletin on the helicopter logbook.
8. Gain access to My Communications section on Leonardo WebPortal and compile the “Service Bulletin Application Communication”.

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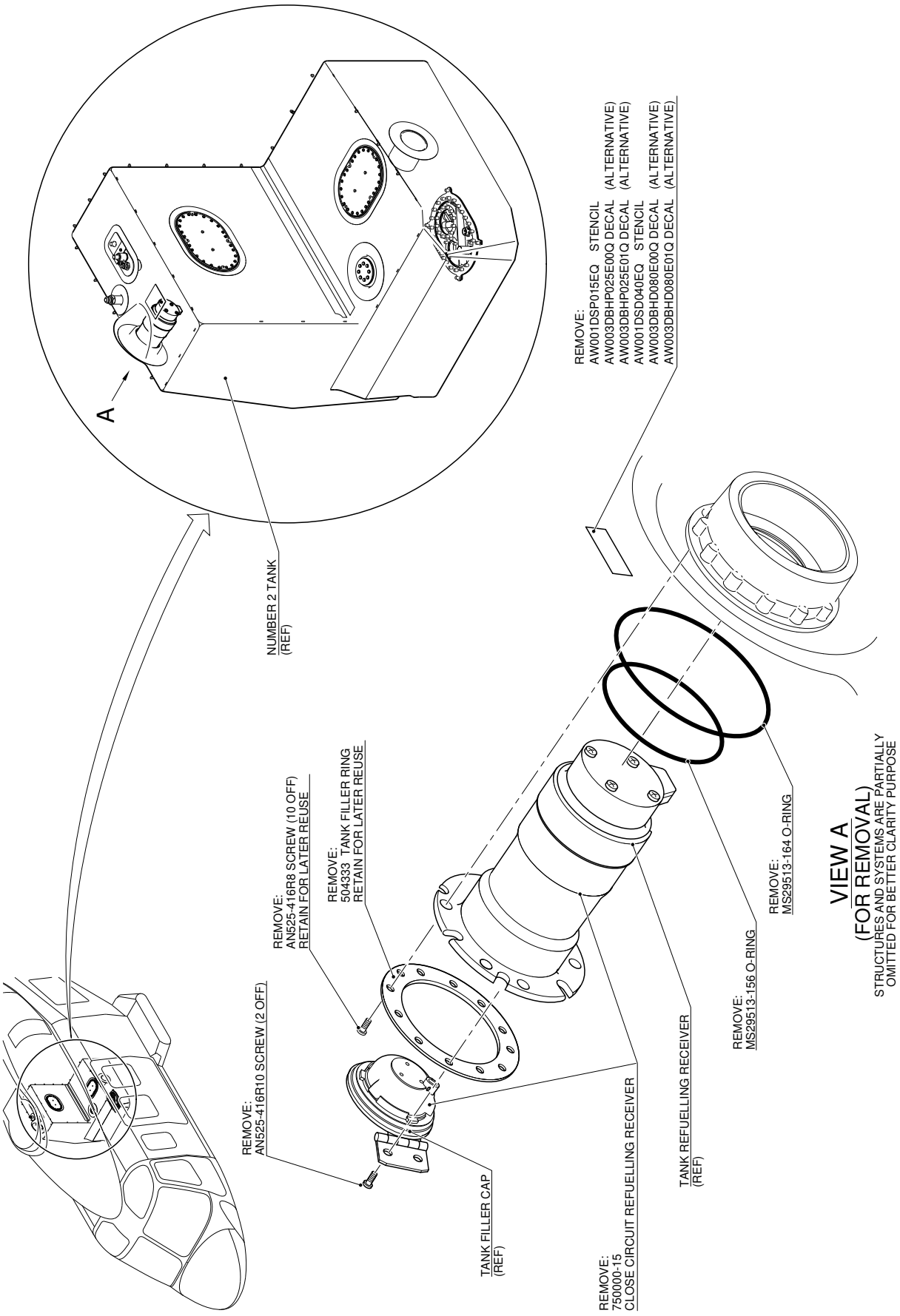

A
NUMBER 2 TANK
(REF)
REMOVE:
AW001DSP015EQ STENCIL
AW003DBHP025E00Q DECAL (ALTERNATIVE)
AW003DBHP025E01Q DECAL (ALTERNATIVE)
AW001DSD040EQ STENCIL
AW003DBHD080E00Q DECAL (ALTERNATIVE)
AW003DBHD080E01Q DECAL (ALTERNATIVE)
REMOVE:
AN525-416R8 SCREW (10 OFF)
RETAIN FOR LATER REUSE
REMOVE:
504333 TANK FILLER RING
RETAIN FOR LATER REUSE
REMOVE:
AN525-416R10 SCREW (2 OFF)
TANK FILLER CAP
(REF)
REMOVE:
750000-15
CLOSE CIRCUIT REFUELLING RECEIVER
TANK REFUELLING RECEIVER
(REF)
REMOVE:
MS29513-156 O-RING
REMOVE:
MS29513-164 O-RING
VIEW A
(FOR REMOVAL)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 1

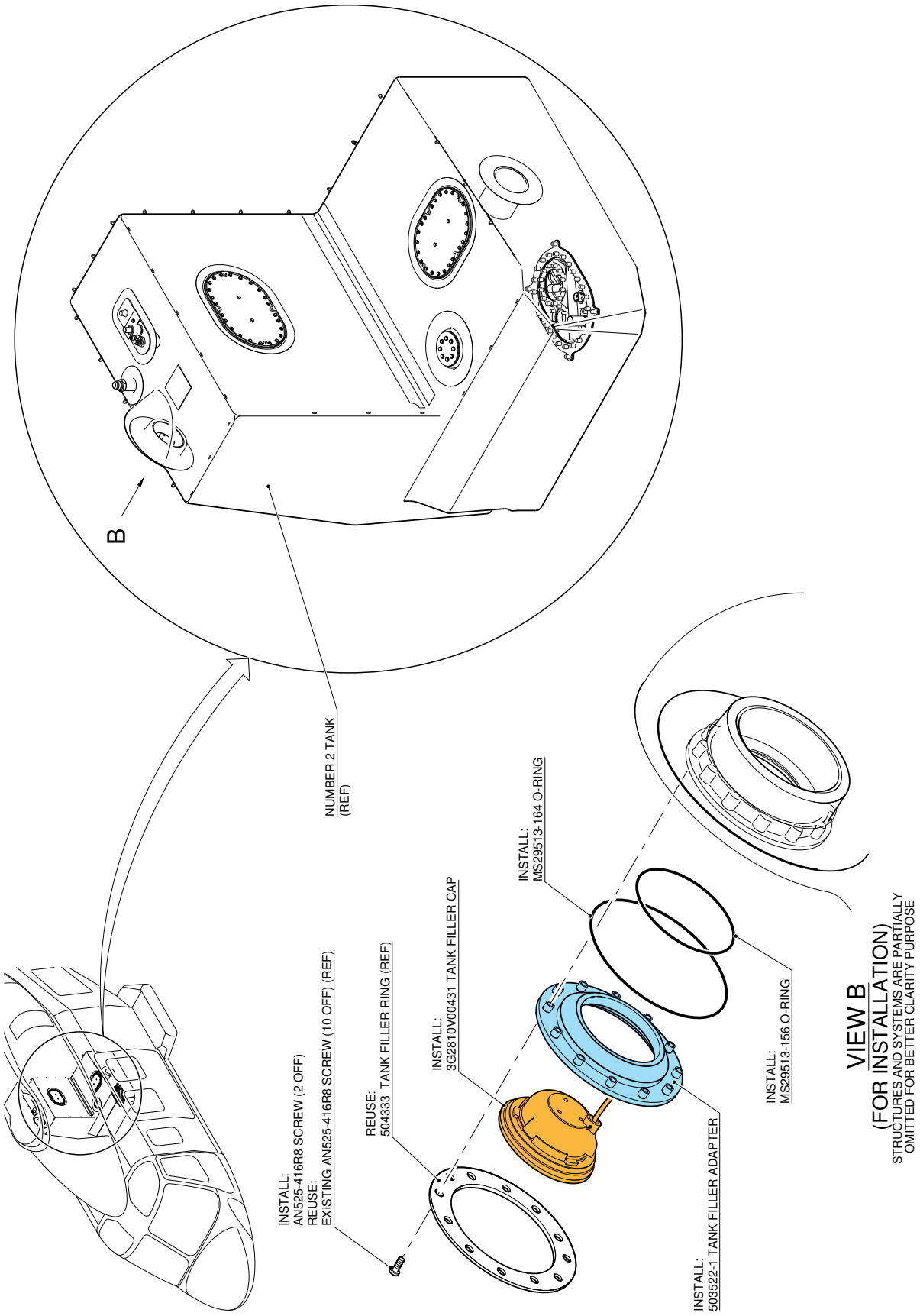

B
NUMBER 2 TANK
(REF)
INSTALL:
AN525-416R8 SCREW (2 OFF)
REUSE:
EXISTING AN525-416R8 SCREW (10 OFF) (REF)
REUSE:
504333 TANK FILLER RING (REF)
INSTALL:
3G2810V00431 TANK FILLER CAP
INSTALL:
MS29513-164 O-RING
INSTALL:
503522-1 TANK FILLER ADAPTER
INSTALL:
MS29513-156 O-RING
VIEW B
(FOR INSTALLATION)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 2

3G5338P00811
FUEL TANK CCRR ISO45
STRUCTURAL RETRO-MOD
(APPLICABLE TO HELICOPTERS FROM S/N 41801 TO S/N 41803)

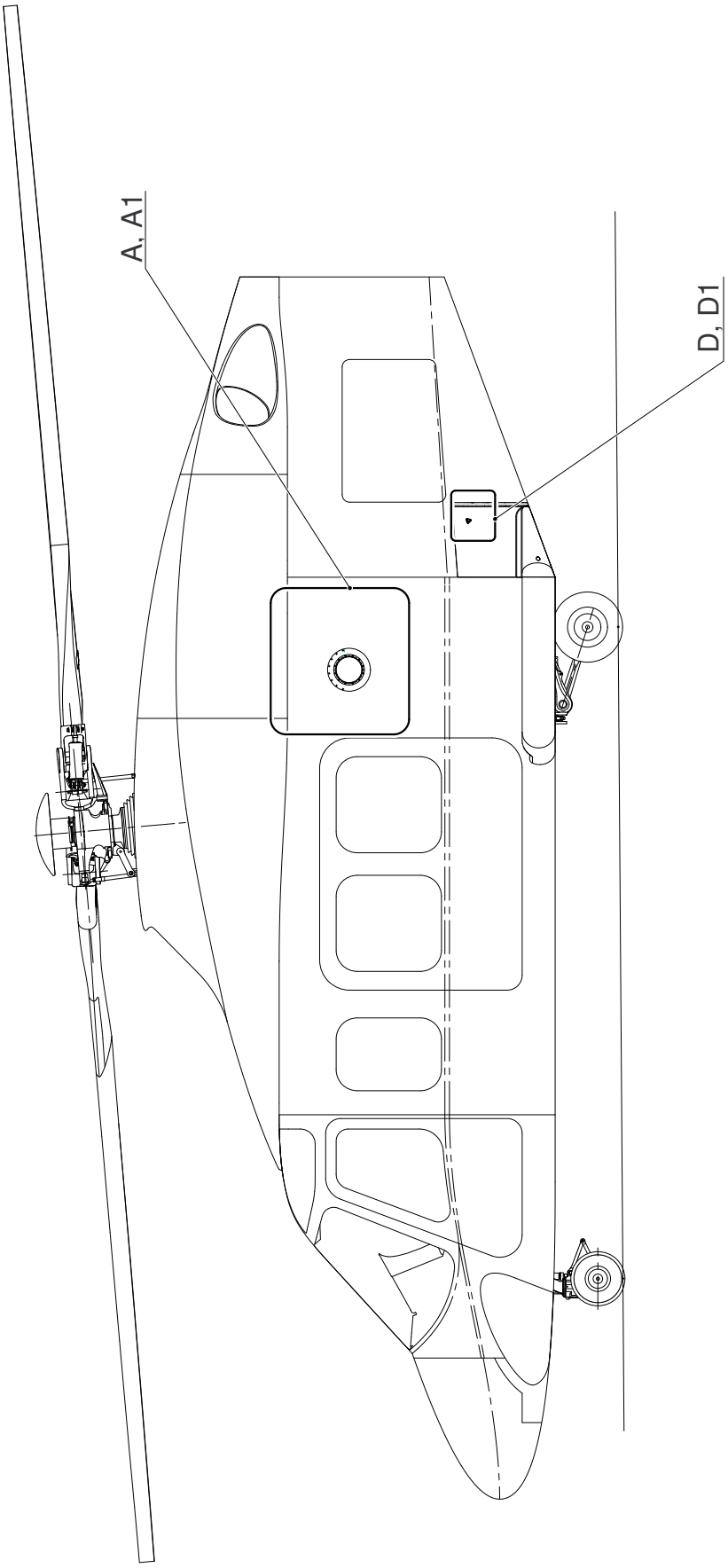
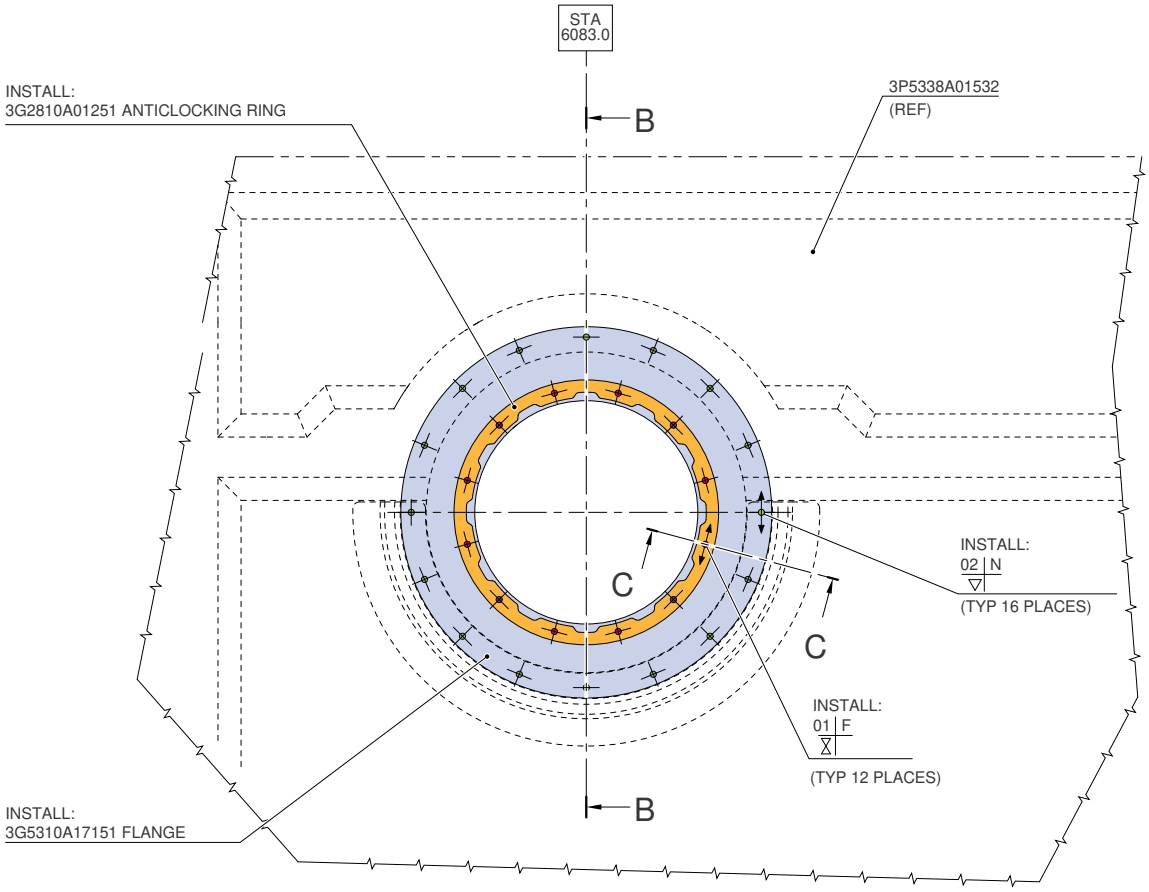


Figure 3



DETAIL A

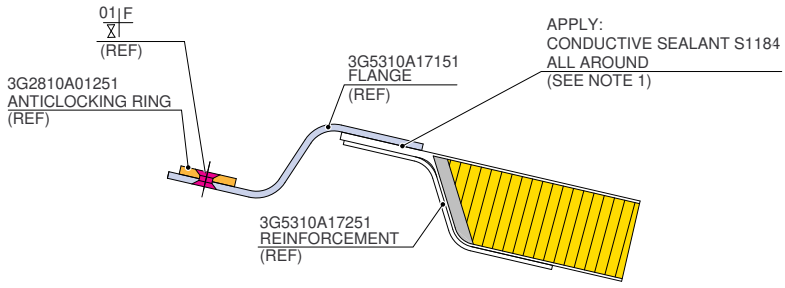
(FOR INSTALLATION)

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

NOTES:

1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING

RIVET REFERENCE TABLE	
REF. N°	RIVET P/N
01 ●	MS20426AD4-6
02 ●	MS20426AD4-5-5
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
⧖	COUNTERSINK (100° ONLY) IS ON BOTH SIDES



SECTION C-C

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 4

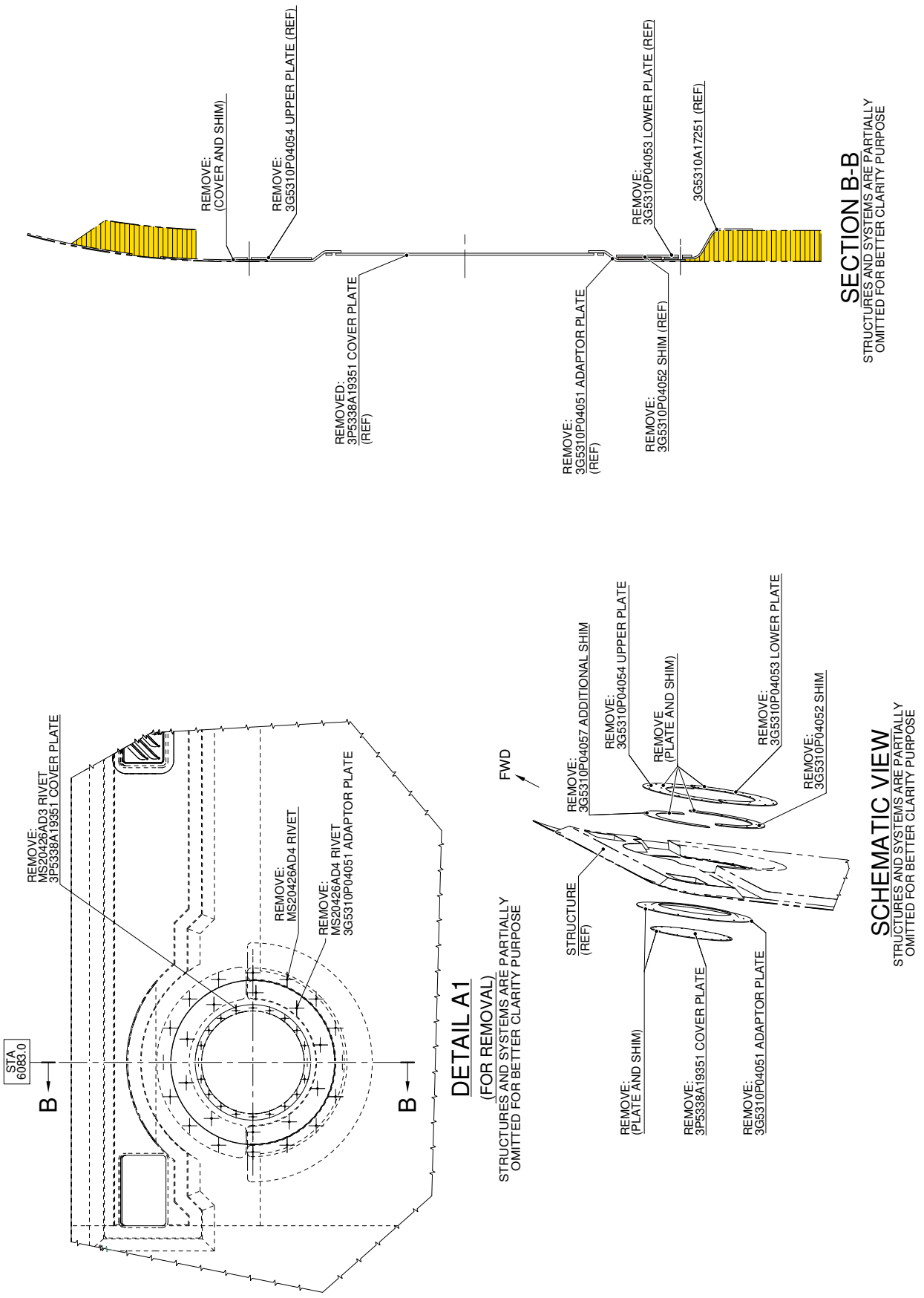

SECTION B-B
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
REMOVE: (COVER AND SHIM)
REMOVE: 3G5310P04054 UPPER PLATE (REF)
REMOVED: 3P5338A19351 COVER PLATE (REF)
REMOVE: 3G5310P04051 ADAPTOR PLATE (REF)
REMOVE: 3G5310P04052 SHIM (REF)
REMOVE: 3G5310P04053 LOWER PLATE (REF)
3G5310A17251 (REF)
DETAIL A1
(FOR REMOVAL)
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
STA 6083.0
B
B
REMOVE: MS20426AD3 RIVET 3P5338A19351 COVER PLATE
REMOVE: MS20426AD4 RIVET
REMOVE: MS20426AD4 RIVET 3G5310P04051 ADAPTOR PLATE
SCHEMATIC VIEW
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
FWD
REMOVE: 3G5310P04057 ADDITIONAL SHIM
REMOVE: 3G5310P04054 UPPER PLATE
REMOVE (PLATE AND SHIM)
REMOVE: 3G5310P04053 LOWER PLATE
REMOVE: 3G5310P04052 SHIM
STRUCTURE (REF)
REMOVE: (PLATE AND SHIM)
REMOVE: 3P5338A19351 COVER PLATE
REMOVE: 3G5310P04051 ADAPTOR PLATE

Figure 5

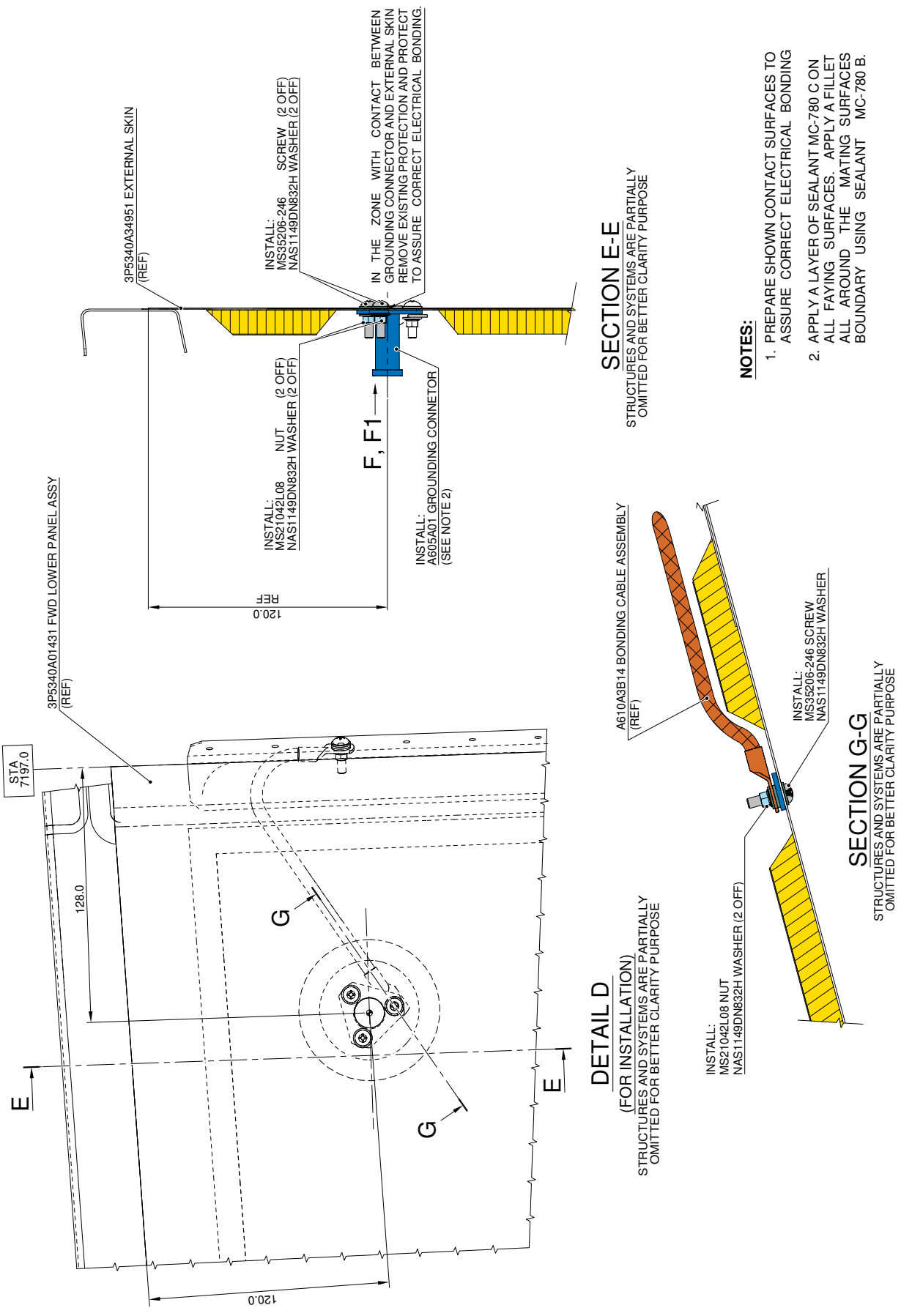
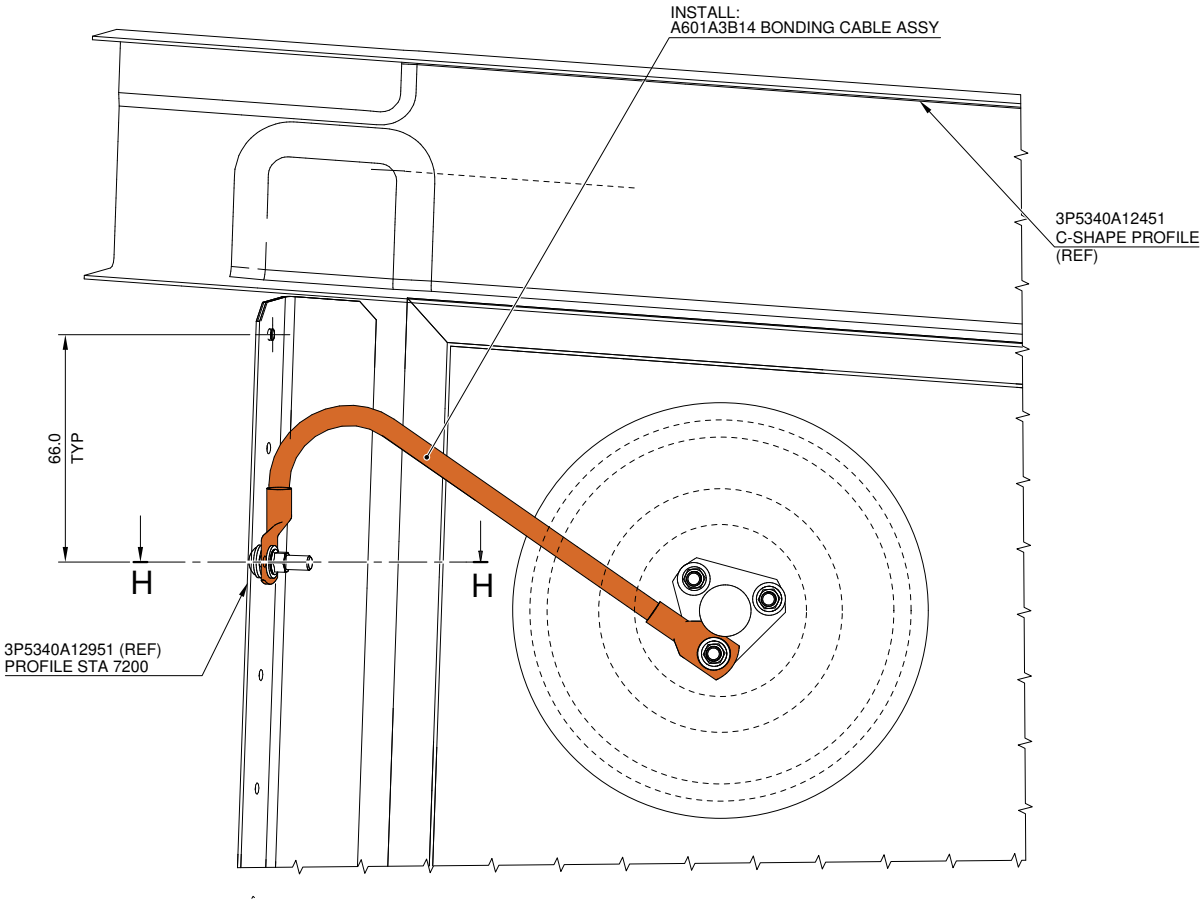

3P5340A34951 EXTERNAL SKIN (REF)
INSTALL: MS35206-246 SCREW (2 OFF) NAS1149DN832H WASHER (2 OFF)
IN THE ZONE WITH CONTACT BETWEEN GROUNDING CONNECTOR AND EXTERNAL SKIN REMOVE EXISTING PROTECTION AND PROTECT TO ASSURE CORRECT ELECTRICAL BONDING.
INSTALL: MS21042L08 NUT (2 OFF) NAS1149DN832H WASHER (2 OFF)
F, F1
INSTALL: A605A01 GROUNDING CONNETOR (SEE NOTE 2)
120.0 REF
SECTION E-E
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
NOTES:
1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING
2. APPLY A LAYER OF SEALANT MC-780 C ON ALL FAYING SURFACES. APPLY A FILLET ALL AROUND THE MATING SURFACES BOUNDARY USING SEALANT MC-780 B.
3P5340A01431 FWD LOWER PANEL ASSY (REF)
STA 7197.0
128.0
G
G
E
E
120.0
DETAIL D
(FOR INSTALLATION)
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
A610A3B14 BONDING CABLE ASSEMBLY (REF)
INSTALL: MS35206-246 SCREW NAS1149DN832H WASHER
INSTALL: MS21042L08 NUT NAS1149DN832H WASHER (2 OFF)
SECTION G-G
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 6

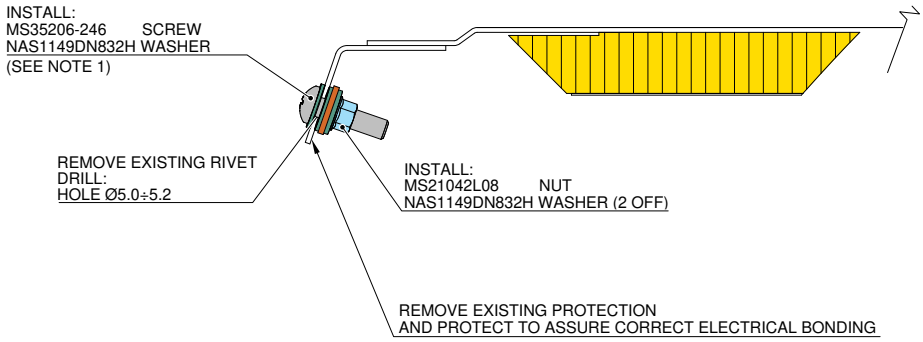


VIEW F

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

NOTE:

1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING



SECTION H-H

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 7

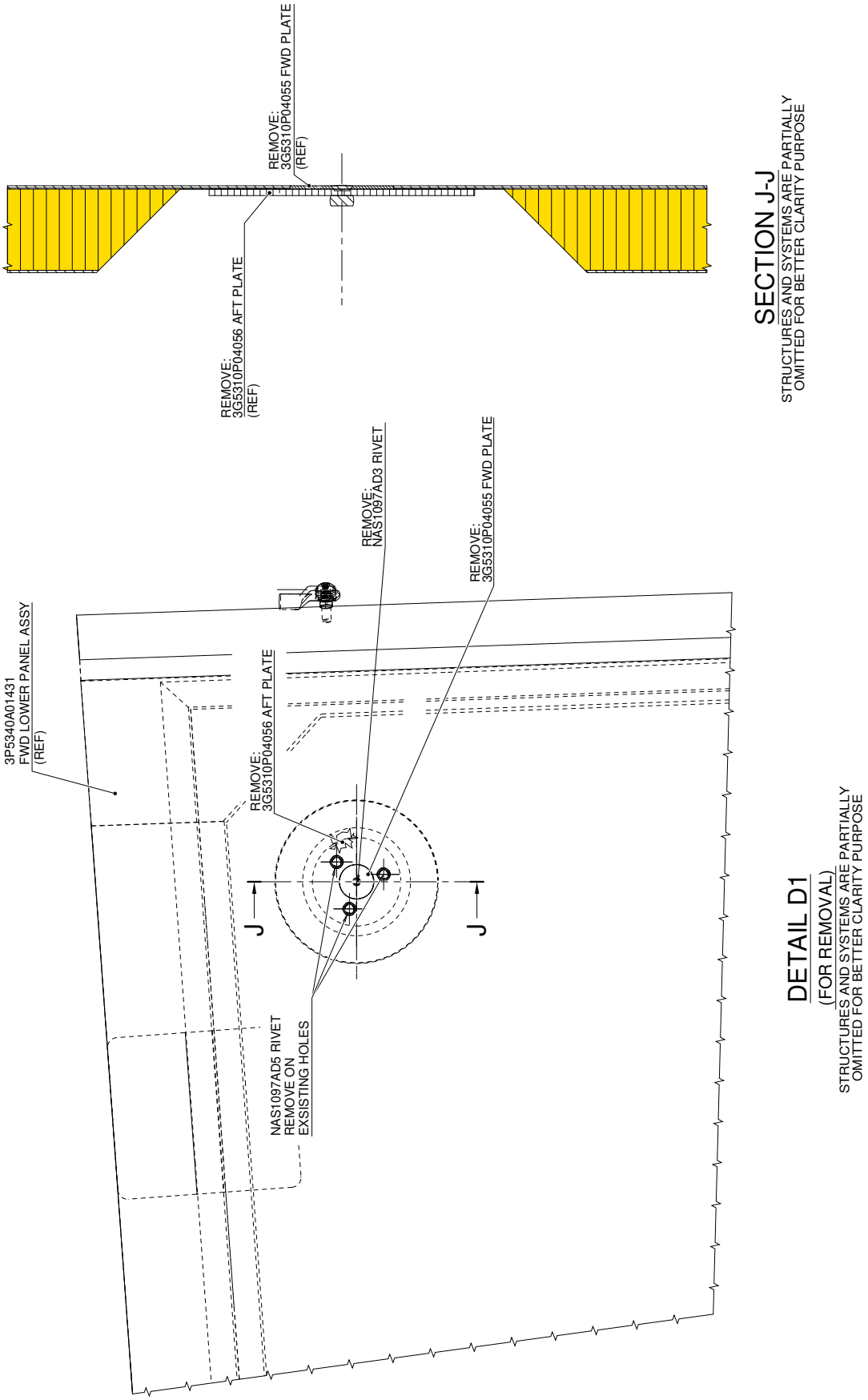

REMOVE:
3G5310P04055 FWD PLATE
(REF)
REMOVE:
3G5310P04056 AFT PLATE
(REF)
SECTION J-J
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE
REMOVE:
NAS1097AD3 RIVET
REMOVE:
3G5310P04055 FWD PLATE
3P5340A01431
FWD LOWER PANEL ASSY
(REF)
REMOVE:
3G5310P04056 AFT PLATE
J
J
NAS1097AD5 RIVET
REMOVE ON
EXSISTING HOLES
DETAIL D1
(FOR REMOVAL)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 8

3G5310A17011
STRUCTURAL PROVISION
FOR CCRR ISO45
(APPLICABLE TO HELICOPTER S/N 41804)

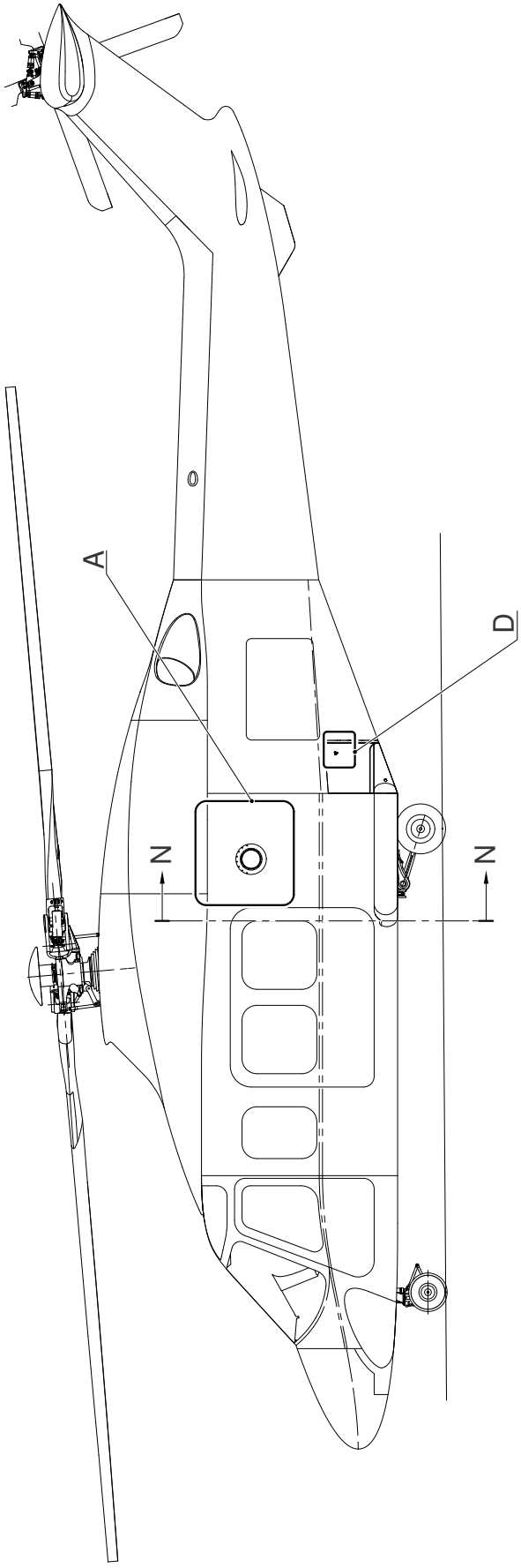


Figure 9

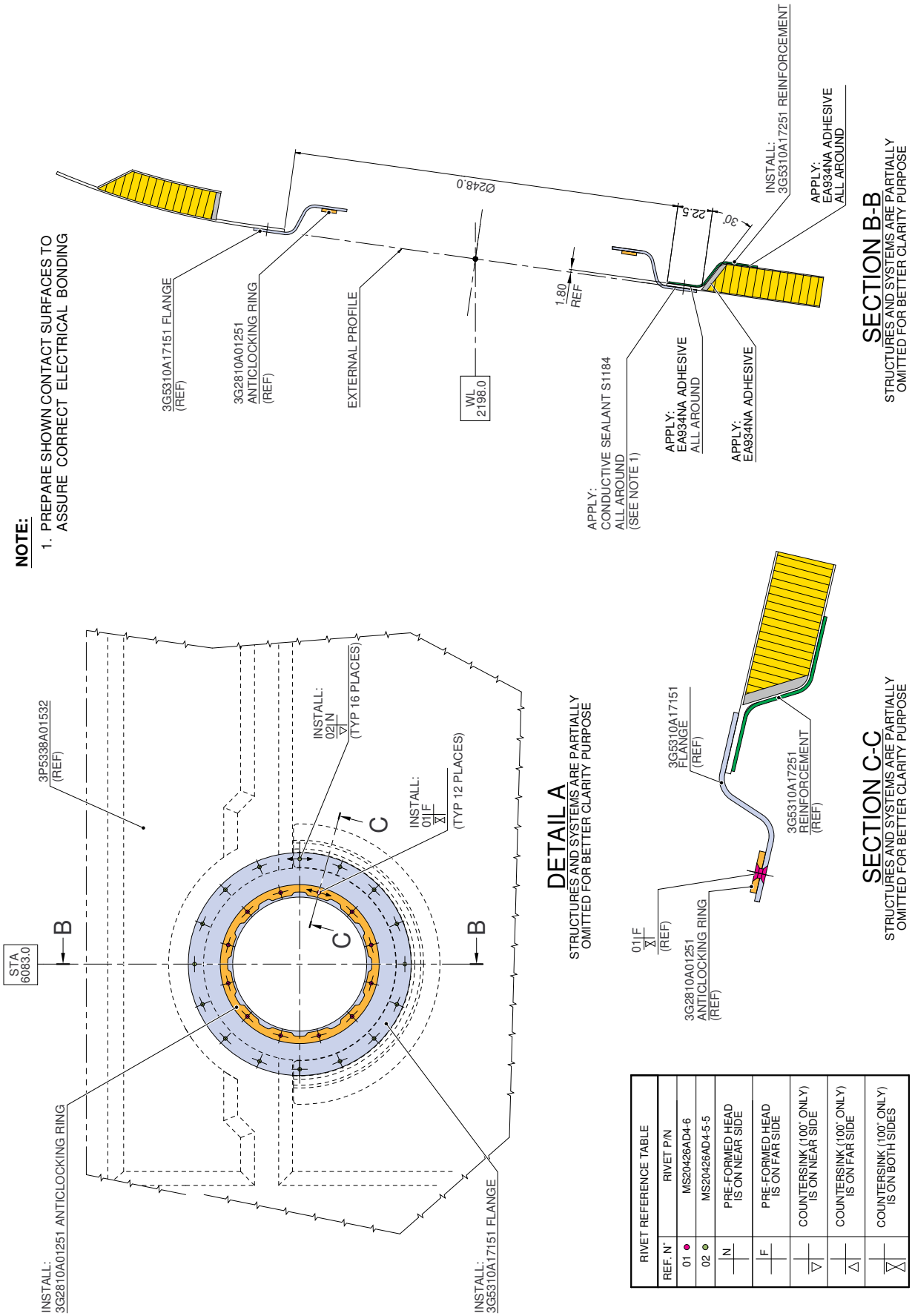

NOTE:
1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING
3G5310A17151 FLANGE (REF)
3G2810A01251 ANTICLOCKING RING (REF)
EXTERNAL PROFILE
WL 2198.0
1.80 REF
Ø248.0
22.5
30°
APPLY: CONDUCTIVE SEALANT S1184 ALL AROUND (SEE NOTE 1)
APPLY: EA934NA ADHESIVE ALL AROUND
APPLY: EA934NA ADHESIVE
INSTALL: 3G5310A17251 REINFORCEMENT
APPLY: EA934NA ADHESIVE ALL AROUND
SECTION B-B
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
3P5338A01532 (REF)
STA 6083.0
B
C
INSTALL: 02|N (TYP 16 PLACES)
INSTALL: 01|F (TYP 12 PLACES)
INSTALL: 3G2810A01251 ANTICLOCKING RING
INSTALL: 3G5310A17151 FLANGE
DETAIL A
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
3G5310A17151 FLANGE (REF)
3G5310A17251 REINFORCEMENT (REF)
01|F (REF)
3G2810A01251 ANTICLOCKING RING (REF)
SECTION C-C
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
RIVET REFERENCE TABLE
REF. N°
RIVET P/N
01 MS20426AD4-6
02 MS20426AD4-5-5
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
COUNTERSINK (100° ONLY) IS ON BOTH SIDES

Figure 10

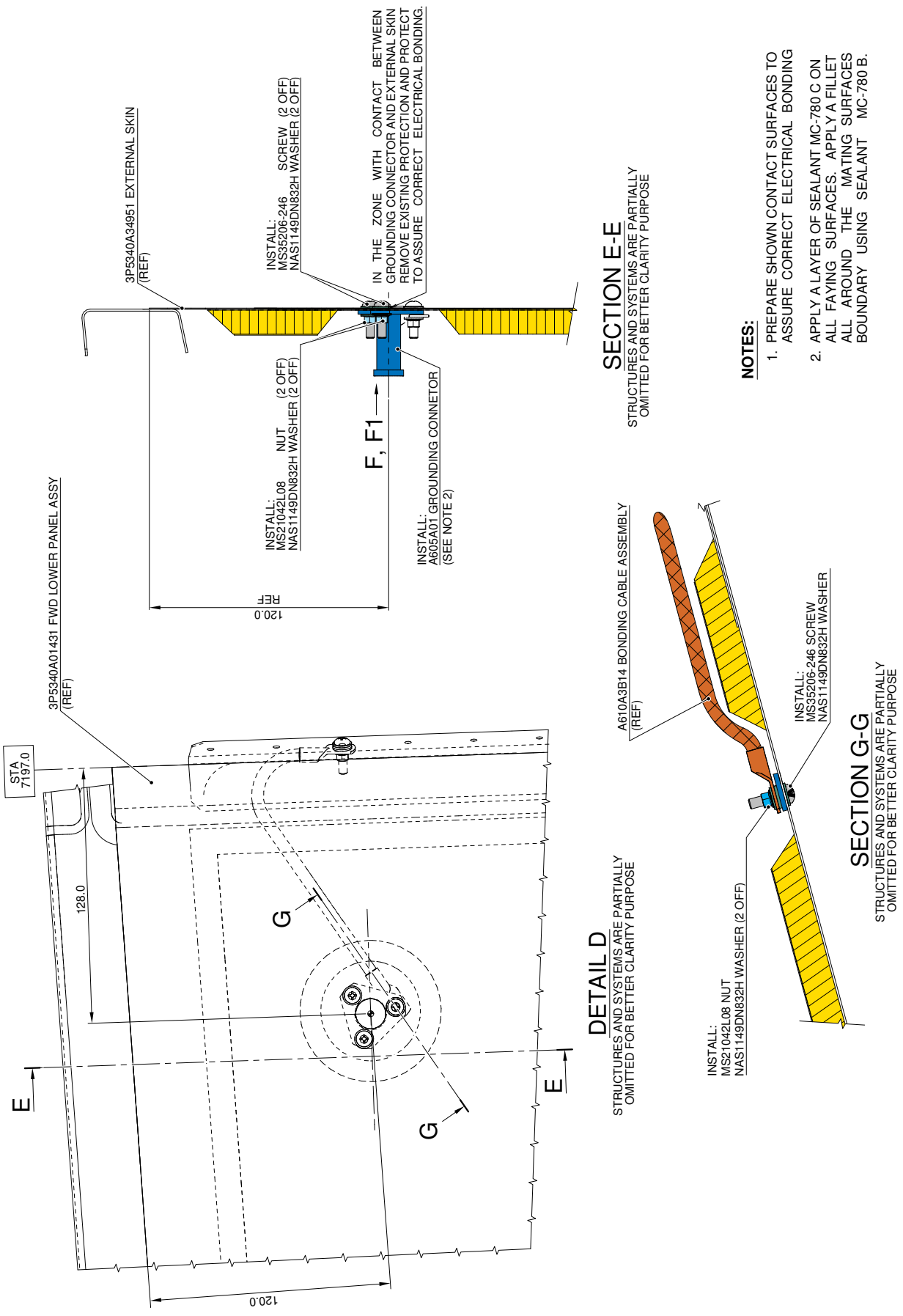
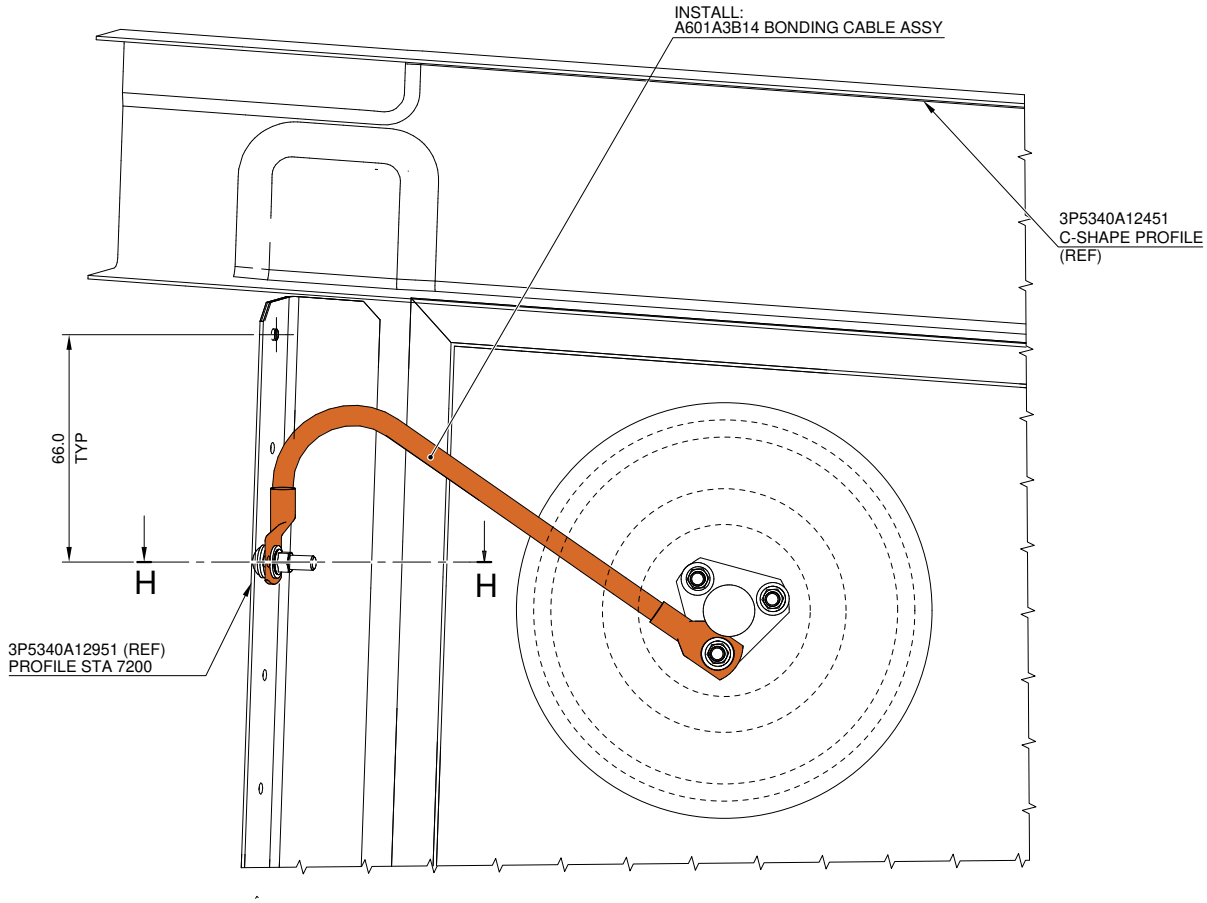

3P5340A34951 EXTERNAL SKIN (REF)
INSTALL: MS35206-246 SCREW (2 OFF) NAS1149DN832H WASHER (2 OFF)
IN THE ZONE WITH CONTACT BETWEEN GROUNDING CONNECTOR AND EXTERNAL SKIN REMOVE EXISTING PROTECTION AND PROTECT TO ASSURE CORRECT ELECTRICAL BONDING.
INSTALL: MS21042L08 NUT (2 OFF) NAS1149DN832H WASHER (2 OFF)
INSTALL: A605A01 GROUNDING CONNETOR (SEE NOTE 2)
F, F1
120.0 REF
SECTION E-E
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
NOTES:
1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING
2. APPLY A LAYER OF SEALANT MC-780 C ON ALL FAYING SURFACES. APPLY A FILLET ALL AROUND THE MATING SURFACES BOUNDARY USING SEALANT MC-780 B.
3P5340A01431 FWD LOWER PANEL ASSY (REF)
STA 7197.0
128.0
G
E
120.0
DETAIL D
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
A610A3B14 BONDING CABLE ASSEMBLY (REF)
INSTALL: MS35206-246 SCREW NAS1149DN832H WASHER
INSTALL: MS21042L08 NUT NAS1149DN832H WASHER (2 OFF)
SECTION G-G
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 11

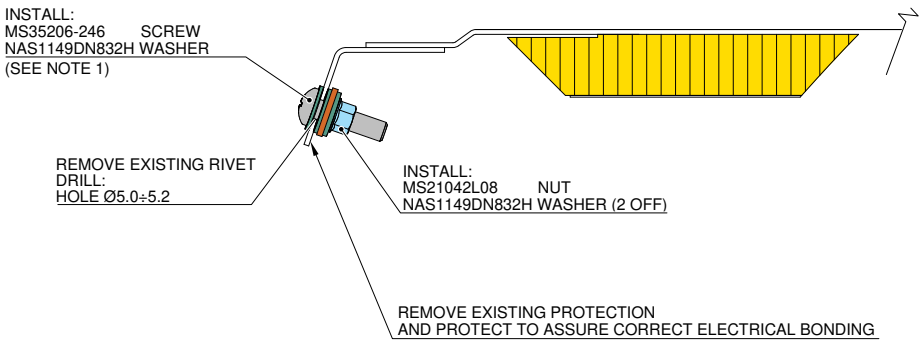


VIEW F

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

NOTE:

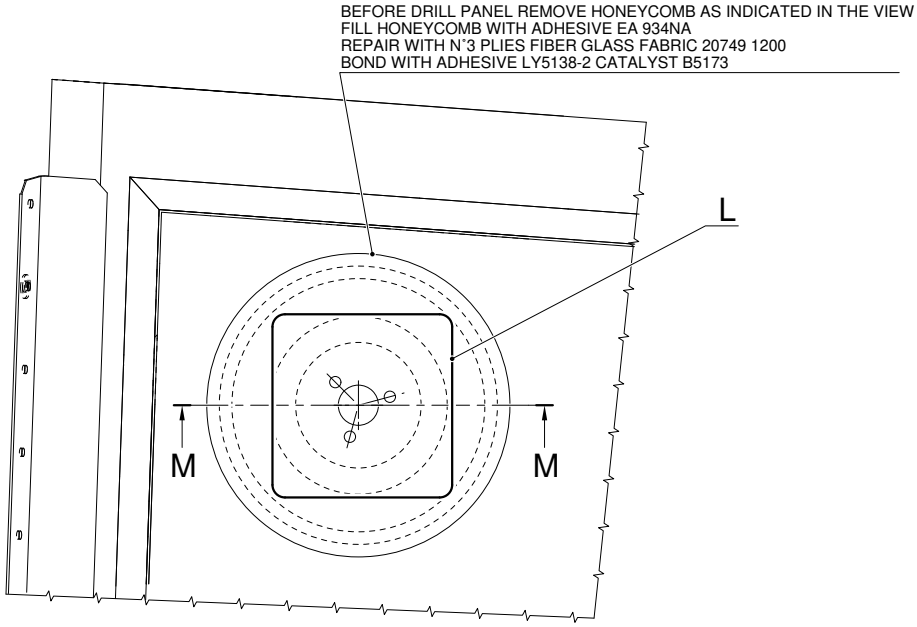
1. PREPARE SHOWN CONTACT SURFACES TO ASSURE CORRECT ELECTRICAL BONDING



SECTION H-H

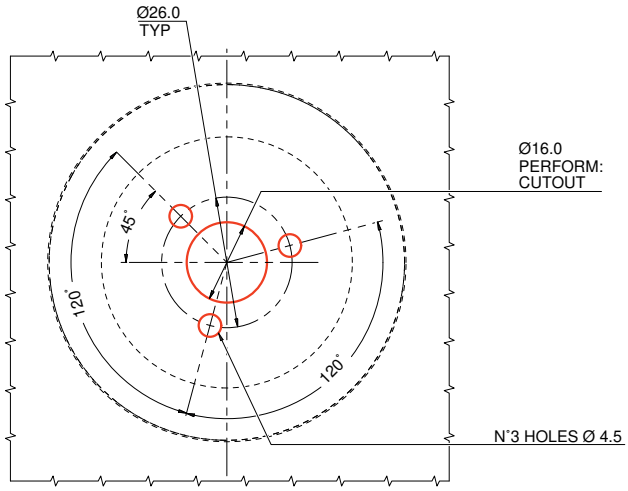
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 12



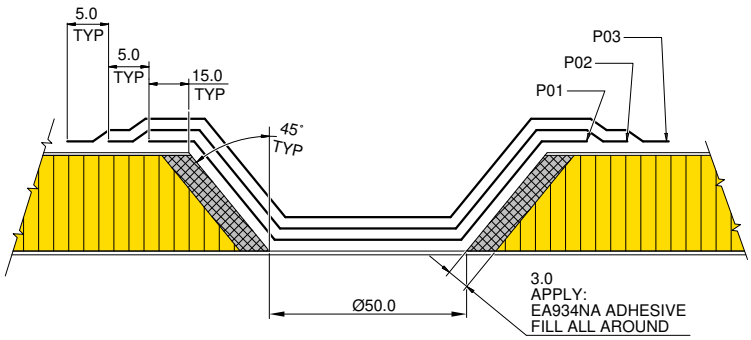
VIEW F1

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



DETAIL L

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



SCHEMATIC SECTION M-M

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 13

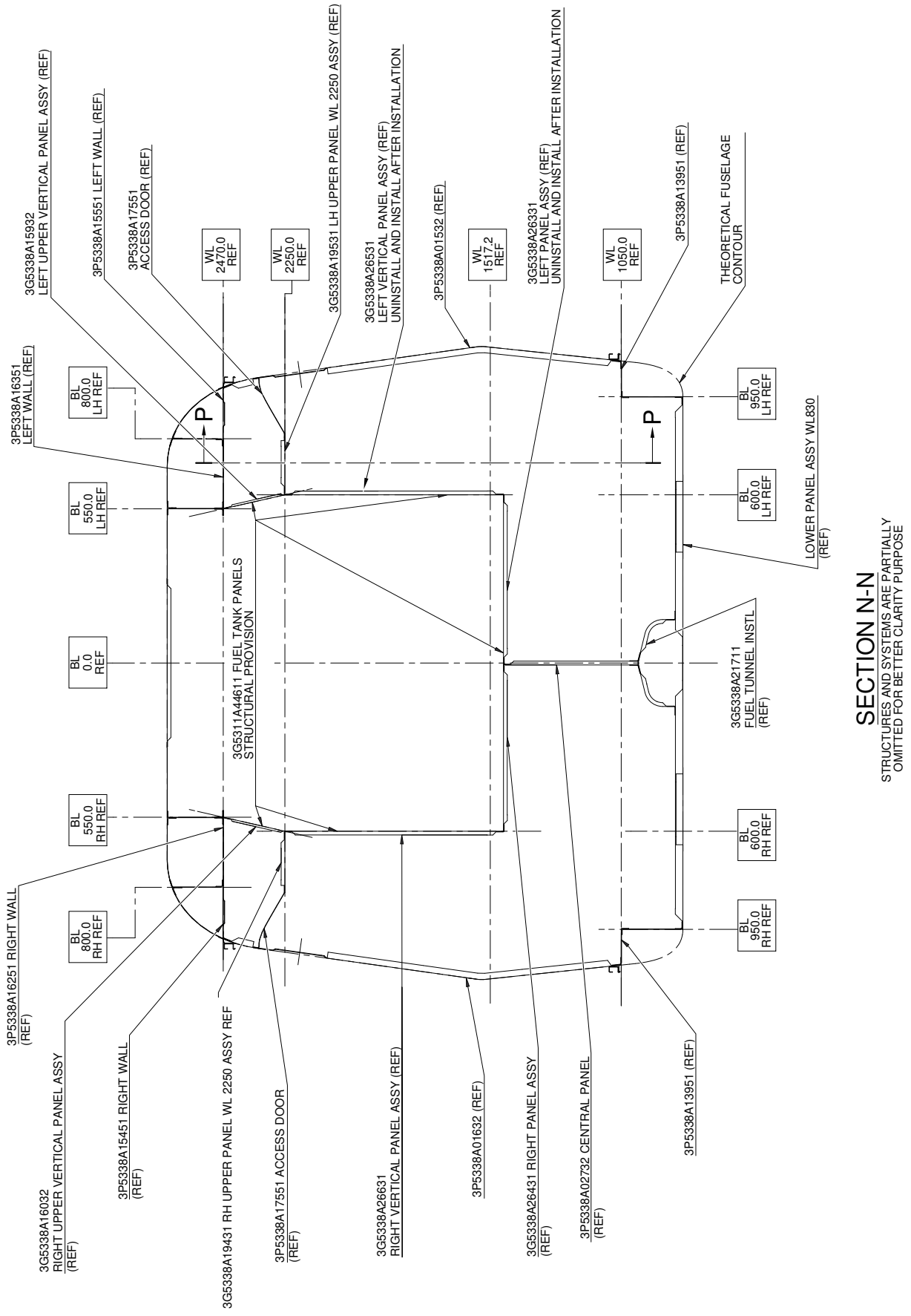
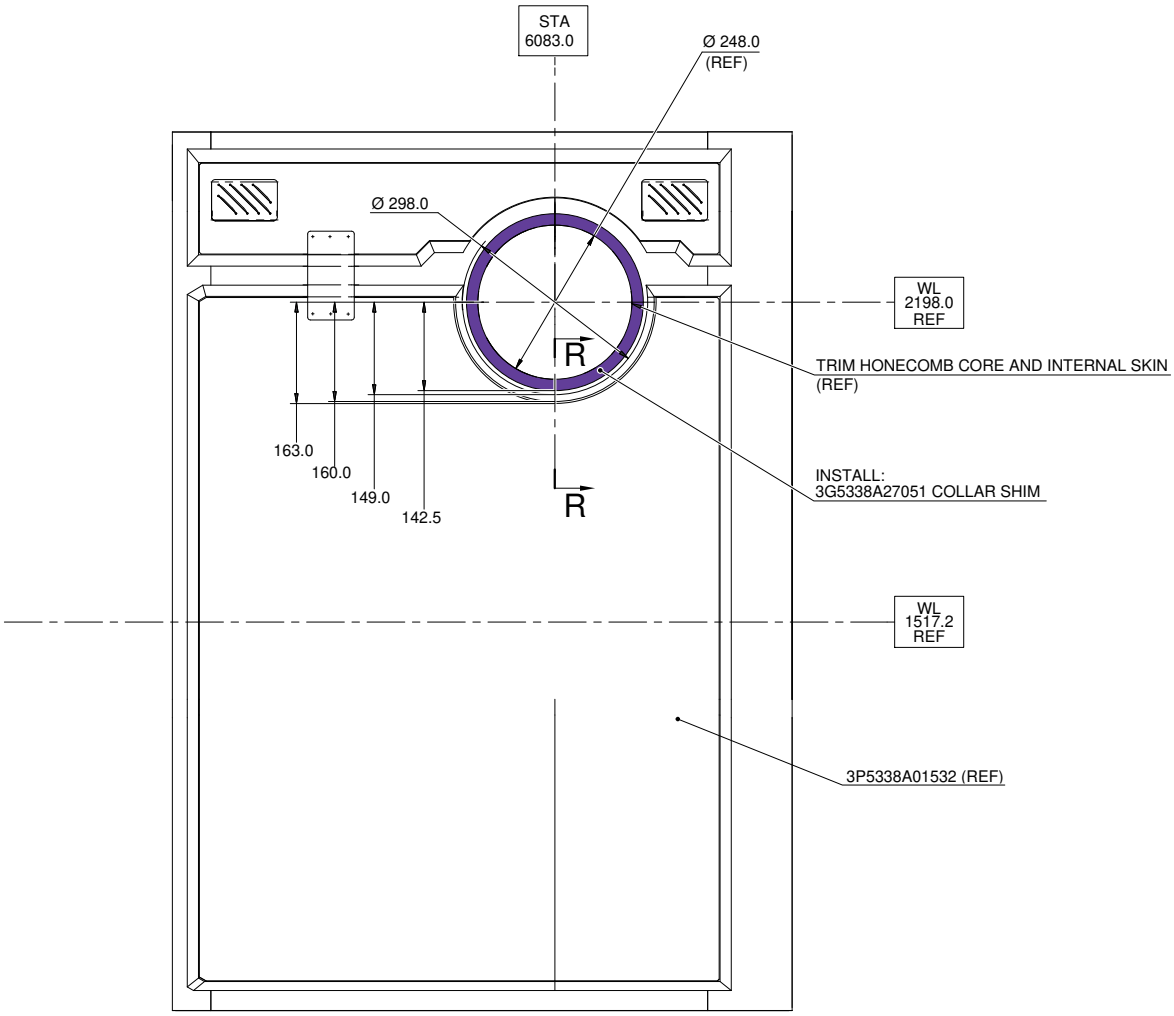
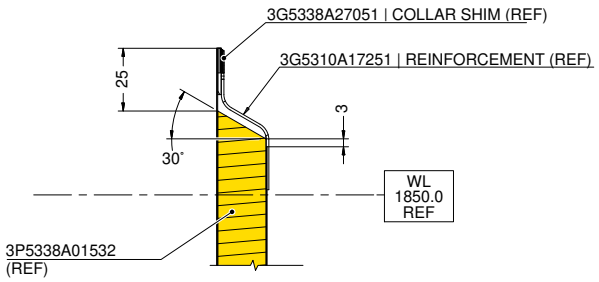

SECTION N-N
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
3G5338A15932 LEFT UPPER VERTICAL PANEL ASSY (REF)
3P5338A15551 LEFT WALL (REF)
3P5338A17551 ACCESS DOOR (REF)
WL 2470.0 REF
WL 2250.0 REF
3G5338A19531 LH UPPER PANEL WL 2250 ASSY (REF)
3G5338A26531 LEFT VERTICAL PANEL ASSY (REF) UNINSTALL AND INSTALL AFTER INSTALLATION
3P5338A01532 (REF)
WL 1517.2 REF
3G5338A26331 LEFT PANEL ASSY (REF) UNINSTALL AND INSTALL AFTER INSTALLATION
WL 1050.0 REF
3P5338A13951 (REF)
THEORETICAL FUSELAGE CONTOUR
3P5338A16351 LEFT WALL (REF)
BL 800.0 LH REF
BL 550.0 LH REF
BL 0.0 REF
BL 550.0 RH REF
BL 800.0 RH REF
BL 950.0 LH REF
BL 600.0 LH REF
BL 600.0 RH REF
BL 950.0 RH REF
P
P
3G5311A44611 FUEL TANK PANELS STRUCTURAL PROVISION
LOWER PANEL ASSY WL830 (REF)
3G5338A21711 FUEL TUNNEL INSTL (REF)
3P5338A16251 RIGHT WALL (REF)
3G5338A16032 RIGHT UPPER VERTICAL PANEL ASSY (REF)
3P5338A15451 RIGHT WALL (REF)
3G5338A19431 RH UPPER PANEL WL 2250 ASSY REF
3P5338A17551 ACCESS DOOR (REF)
3G5338A26631 RIGHT VERTICAL PANEL ASSY (REF)
3P5338A01632 (REF)
3G5338A26431 RIGHT PANEL ASSY (REF)
3P5338A02732 CENTRAL PANEL (REF)
3P5338A13951 (REF)

Figure 14



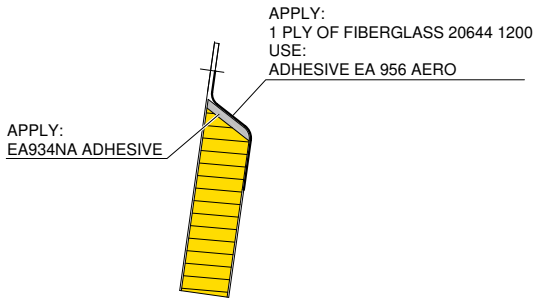
SECTION P-P

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



SECTION R-R

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



SCHEMATIC VIEW

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 15

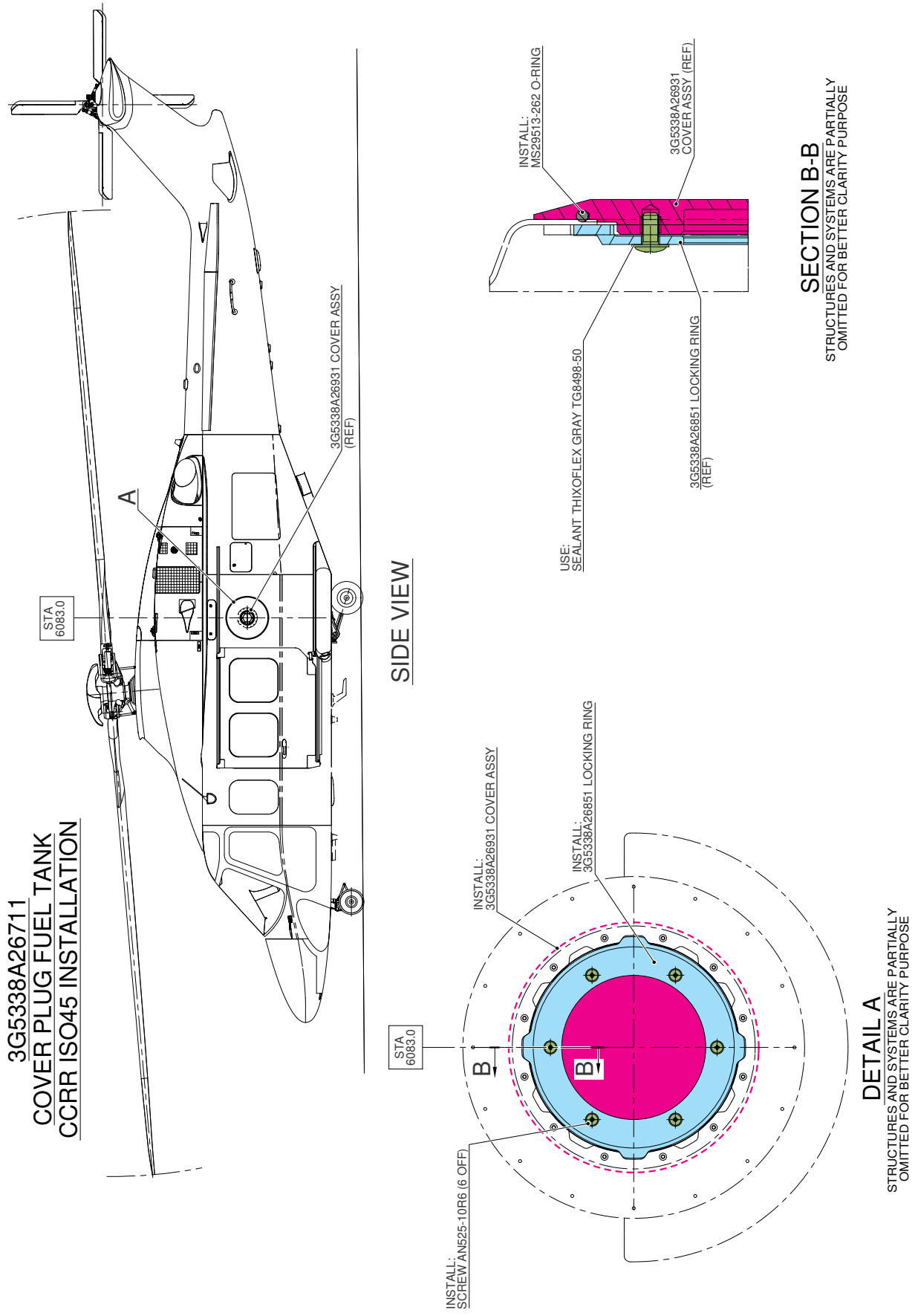

3G5338A26711
COVER PLUG FUEL TANK
CCRR ISO45 INSTALLATION
SIDE VIEW
STA 6083.0
A
D
3G5338A26931 COVER ASSY (REF)
SECTION B-B
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
INSTALL: MS29513-262 O-RING
3G5338A26931 COVER ASSY (REF)
USE: SEALANT THIXOFLEX GRAY TG8498-50
3G5338A26851 LOCKING RING (REF)
DETAIL A
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE
INSTALL: 3G5338A26931 COVER ASSY
INSTALL: 3G5338A26851 LOCKING RING
STA 6083.0
B
B
INSTALL: SCREW AN525-10R6 (6 OFF)

Figure 16

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.