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SERVICE BULLETIN

N° **189-332**

**OPTIONAL**

DATE: May 3, 2024

REV. : /

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**TITLE**

**ATA 56 - WINDOW GASKET UPGRADE**

**REVISION LOG**

First Issue

# 1. PLANNING INFORMATION

## A. EFFECTIVITY

All AW189 helicopters equipped with “Internal Emergency Exit Handles” P/N 8G9500L00151 and “External Emergency Exit Handles” P/N 8G9500L00251 on all cabin and cockpit emergency exits.

## B. COMPLIANCE

At Customer's option.

## C. CONCURRENT REQUIREMENTS

N.A.

## D. REASON

This Service Bulletin is issued in order to provide the necessary instructions on how to perform the installation of new gasket on the basic jettisonable emergency exit of the helicopter.

LHD issued this SB for the following reason:

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

## E. DESCRIPTION

The gasket installation of the emergency exits is composed by a gasket bonded only to the transparent on both sides (internal and external) and a filler on each side (internal and external).

The improved design introduces a rubber retainer between the gasket and the structure which are respectively continuously bonded to the window and to the structure.

The new gasket installation leads the emergency exit jettison force independent from the bonding process between gasket and fuselage.

In addition, this Service Bulletin introduces new internal and external pull tabs which hold the filler and the handle.

The compliance with this Service Bulletin will extend the discard time from 2 years (DT56-01 and DT56-02) to 4 years inspection (DT56-03 and DT56-4).

## 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 twenty-eight (28) MMH are deemed necessary. MMH are based on hands-on time and can change with helicopter configuration, personnel and facilities available. MMH are not comprehensive of the overall hours necessary to get access to work areas and to remove all the equipment that interferes with the application of the prescribed instructions.

## H. WEIGHT AND BALANCE

For helicopters equipped with sliding doors configuration the following entry in Chart A must be added:

<b>WEIGHT (kg)</b>	<b>ARM (mm)</b>	<b>MOMENT (kg-mm)</b>
		4.46
<b>LONGITUDINAL BALANCE</b>	4195.6	18712.37
<b>LATERAL BALANCE</b>	0	0

For helicopters equipped with hinged doors configuration the following entry in Chart A must be added:

<b>WEIGHT (kg)</b>	<b>ARM (mm)</b>	<b>MOMENT (kg-mm)</b>
		3.95
<b>LONGITUDINAL BALANCE</b>	4140.9	16356.5
<b>LATERAL BALANCE</b>	0	0

## I. REFERENCES

### I.1 PUBLICATIONS

Following Data Modules refer to AMP:

<u>DATA MODULE</u>	<u>DESCRIPTION</u>	<u>PART</u>
DM01 89-A-00-20-00-00A-120A-A	Helicopter on ground for a safe maintenance	-
DM02 89-A-06-41-00-00A-010A-A	Access doors and panels - General Data	-
DM03 89-A-56-31-01-00A-920A-A	Left cockpit door window - Replacement	-
DM04 89-A-56-31-02-00A-920A-A	Right cockpit door window - Replacement	-
DM05 89-A-56-32-01-00A-920A-A	Left cabin door window - Replacement	-
DM06 89-A-56-32-02-00A-920A-A	Right cabin door window - Replacement	-
DM07 89-A-56-33-01-00A-920A-A	Left hinged cabin door window - Replacement	-
DM08 89-A-56-33-02-00A-920A-A	Right hinged cabin door window - Replacement	-
DM09 89-A-56-33-03-00A-920A-A	Left central cabin window - Replacement	-
DM10 89-A-56-33-04-00A-920A-A	Right central cabin window - Replacement	-
DM11 89-A-56-21-01-00A-920A-A	Left forward cabin window - Replacement	-
DM12 89-A-56-21-02-00A-920A-A	Right forward cabin window - Replacement	-
DM13 89-A-56-21-03-00A-920A-A	Left aft cabin window - Replacement	-
DM14 89-A-56-21-04-00A-920A-A	Right aft cabin window - Replacement	-

### I.2 ACRONYMS & ABBREVIATIONS

AMD	Aircraft Material Data Information
AMP	Aircraft Maintenance Publication
AR	As Required
ATA	Air Transport Association
DM	Data Module
DOA	Design Organization Approval
EASA	European Aviation Safety Agency
IPD	Illustrated Parts 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

## **J. PUBLICATIONS AFFECTED**

N.A.

## **K. SOFTWARE ACCOMPLISHMENT SUMMARY**

N.A.

## 2. MATERIAL INFORMATION

### A. REQUIRED MATERIALS

#### A.1 PARTS

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
<b>1</b>	<b>8G5600P00311</b>		<b>JETTISON HANDLE RETROMOD GLAZNG SEALS</b>	<b>REF</b>	.		-
2	8G5620A00351		Corner retainer	12	..	(1)	189-332L1 189-332L2
3	8G5620A07051		Window gasket	6	..	(2)(3)	189-332L1 189-332L2
4	8G5620A07551		Upper retainer	6	..	(2)(3)	189-332L1 189-332L2
5	8G5620A08751		Window gasket	2	..	(3)	189-332L1 189-332L2
6	8G5620A11751		Upper retainer	2	..	(3)	189-332L1 189-332L2
7	8G5620A12151		Retainer	2	..		189-332L1 189-332L2
8	8G5620A12251		Lower retainer	2	..	(3)	189-332L1 189-332L2
9	8G5620A12351		Filler	4	..	(3)	189-332L1 189-332L2
10	8G5620A13051		Window gasket	2	..	(2)(3)	189-332L1 189-332L2
11	8G5620A13151		Upper retainer	2	..	(2)(3)	189-332L1 189-332L2
12	8G5620A13251		Lower corner retainer	2	..	(2)	189-332L1 189-332L2
13	8G5620A13451		Filler	4	..	(1)(3)	189-332L1 189-332L2
14	8G5620A13551		Filler	12	..	(1)(3)	189-332L1 189-332L2
15	8G5620A13651		Lower retainer	6	..	(2)(3)	189-332L1 189-332L2
16	8G5620A13751		Retainer	2	..		189-332L1 189-332L2
<b>17</b>	<b>8G9500A00731</b>		<b>Handle assy window jettison</b>	<b>REF</b>	..		-
18	8G9520A00251		Clip window jettison	20	...		189-332L1 189-332L2
<b>19</b>	<b>8G9500A03051</b>		<b>Pull tab handle window jettison</b>	<b>REF</b>	...		-
20	3G5630A01251		Pull tab handle window jettison	20	....	(4)	189-332L1 189-332L2

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

## CONSUMABLES

The following consumable materials, or equivalent, are necessary to accomplish this Service Bulletin:

#	SPEC./LHD CODE NUMBER	DESCRIPTION	Q.TY	NOTE	PART
21	199-05-152 TY I, CL 2	Rubber adhesive RTV 732 (C126)	AR	(5)	-

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

### A.2 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
189-332L1	1	(6)	-
189-332L2	1	(7)	-

### NOTES

- (1) In case of helicopter with hinged door configuration, this item has to be ordered in qty 8 to allow the retromod installation.
- (2) In case of helicopter with hinged door configuration, this item has to be ordered in qty 4 to allow the retromod installation.
- (3) The following seals are provided oversized and shall be trimmed on installation to ensure no gaps are present between seal joints.
- (4) P/N 3G5630A01251 must be remarked in P/N 8G9500A03051 before its installation.  
Please Refer to Accomplishment Instructions paragraph.
- (5) Item to procured as local supply.
- (6) Logistic Part Number to be supplied for helicopter with sliding door configuration.
- (7) Logistic Part Number to be supplied for helicopter with hinged door configuration.

## B. SPECIAL TOOLS

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

## C. INDUSTRY SUPPORT INFORMATION

Product improvement.

### **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) Let adhesive cure at room temperature for at least 24 hours unless otherwise specified.
  - c) Seals are provided oversized and shall be trimmed on installation to ensure no gaps are present between seal joints.
  - d) All lengths are in mm.
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1. In accordance with AMP DM 89-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 89-A-06-41-00-00A-010A-A and with reference to Figures 1 thru 6, if necessary remove all external panels, internal panels and internal liners as required to gain access to the area affected by the installation and perform the jettison handle retromod Glazing seals P/N 8G5600P00311 as described in the following procedure:
    - 2.1 In accordance with the applicable steps of AMP DM 89-A-56-31-01-00A-920A-A and with reference to Figure 1 "Was Solution" and Section L-L, remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, the two fillers and the window gasket from the co-pilot door window.
    - 2.2 In accordance with the applicable steps of AMP DM 89-A-56-21-03-00A-920A-A and with reference to Figure 1 "Was Solution" and Section L-L, , remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, two fillers and the window gasket from the left passenger cabin window.
    - 2.3 In accordance with the applicable steps of AMP DMs 89-A-56-31-02-00A-920A-A and 89-A-56-21-04-00A-920A-A, repeat steps 2.1 and 2.2 for the pilot door window and the right passenger cabin window.



**NOTE**

Perform steps 2.4 and 2.5 for helicopters equipped with cabin sliding doors.

- 2.4 In accordance with the applicable steps of AMP DM 89-A-56-32-01-00A-920A-A and with reference to Figure 1 “Was Solution” and Section L-L, remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, two fillers and the window gasket from the LH passenger door windows.
- 2.5 In accordance with the applicable steps of AMP DM 89-A-56-32-02-00A-920A-A, repeat step 2.4 for the RH passenger door windows.

**NOTE**

Perform steps 2.6 thru 2.8 for helicopters equipped with hinged cabin doors.

- 2.6 In accordance with the applicable steps of AMP DM 89-A-56-33-01-00A-920A-A and with reference to Figure 1 “Was Solution” and Section L-L, remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, two fillers and the window gasket from the left hinged door window.
- 2.7 In accordance with the applicable steps of AMP DM 89-A-56-33-03-00A-920A-A and with reference to Figure 1 “Was Solution” and Section L-L, remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, two fillers and the window gasket from the left fixed cabin door window.
- 2.8 In accordance with the applicable steps of AMP DMs 89-A-56-33-02-00A-920A-A and 89-A-56-33-04-00A-920A-A repeat steps 2.6 and 2.7 for the right hinged door window and the right fixed cabin door window.

**NOTE**

Perform steps 2.9 and 2.10 if the helicopter is not equipped with bubble windows (P/N 8G5620F00111 and/or P/N 8G5620F00112) or sliding windows (P/N 8G5620F00211 and/or P/N 8G5620F00311).

- 2.9 In accordance with the applicable steps of AMP DM 89-A-56-21-01-00A-920A-A and with reference to Figure 1 “Was Solution” and Section L-L, remove the internal and external emergency exit handles P/N 8G9500L00151 and P/N 8G9500L00251, two fillers and the window gasket from the left passenger cabin window.

- 2.10 In accordance with the applicable steps of AMP DM 89-A-56-21-02-00A-920A-A repeat step 2.9 for the window on the RH side.
- 2.11 In accordance with the applicable steps of AMP DM 89-A-56-31-01-00A-920A-A and with reference to Figure 2 and Figure 6 Section J-J, bond the upper retainer P/N 8G5620A11751, the retainer P/N 8G5620A12151, the retainer P/N 8G5620A13751 and the lower retainer P/N 8G5620A12251 on the co-pilot door panel assy P/N 8G5211A01232 by means of adhesive RTV 732 (C126).
- 2.12 In accordance with the applicable steps of AMP DM 89-A-56-31-01-00A-920A-A and with reference to Figure 2 and Figure 6 Section J-J, install and bond the new window gasket P/N 8G5620A08751 to the co-pilot transparency P/N 4F5211A01351 and the retainers previously installed by means of adhesive RTV 732 (C126).
- 2.13 Remark n°20 P/N 3G5630A01251 pull tab handle window jettison as P/N 8G9500A03051 pull tab handle window jettison.

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.14 In accordance with the applicable steps of AMP DM 89-A-56-31-01-00A-920A-A and with reference to Figure 2 and Figure 6 Section J-J and Detail K, install the two handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the two fillers P/N 8G5620A12351 then install the two fillers P/N 8G5620A12351 in the internal groove of the window gasket P/N 8G5620A08751 by means of adhesive RTV 732 (C126).
- 2.15 In accordance with the applicable steps of AMP DM 89-A-56-21-03-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J, bond the upper retainer P/N 8G5620A13151 and the lower corner retainer P/N 8G5620A13251 on the side wall panel P/N 8G5335A15831 by means of adhesive RTV 732 (C126).
- 2.16 In accordance with the applicable steps of AMP DM 89-A-56-21-03-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J, install and bond the new window gasket P/N 8G5620A13051 to the LH aft passenger cabin transparency P/N 8G5620A00451 and the retainers previously installed by means of adhesive RTV 732 (C126).

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.17 In accordance with the applicable steps of AMP DM 89-A-56-21-03-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J and Detail K, install the two handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the two fillers P/N 8G5620A13451 then install the two fillers P/N 8G5620A13451 in the internal groove of the window gasket P/N 8G5620A13051 by means of adhesive RTV 732 (C126).
- 2.18 In accordance with the applicable steps of AMP DMs 89-A-56-31-02-00A-920A-A and 89-A-56-21-04-00A-920A-A, repeat steps from 2.11 to 2.17 for the pilot transparency P/N 4F5211A15851 and the RH aft passenger cabin transparency P/N 8G5620A00551.

**NOTE**

Perform steps 2.19 and 2.22 for helicopters equipped with cabin sliding doors.

- 2.19 In accordance with the applicable steps of AMP DM 89-A-56-32-01-00A-920A-A and with reference to Figure 3 and Figure 6 Section J-J, bond n°2 upper retainers P/N 8G5620A07551, n°2 lower retainers P/N 8G5620A13651 and n°4 corner retainers P/N 8G5620A00351 on the passenger door panel P/N 8G5212A17431 by means of adhesive RTV 732 (C126).
- 2.20 In accordance with the applicable steps of AMP DM 89-A-56-32-01-00A-920A-A and with reference to Figure 3 and Figure 6 Section J-J, install and bond n°2 new window gaskets P/N 8G5620A07051 to the two LH FWD passenger door transparencies P/N 4F5630A00151 and P/N 4F5630A00351 and the retainers previously installed by means of adhesive RTV 732 (C126).

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.21 In accordance with the applicable steps of AMP DM 89-A-56-32-01-00A-920A-A and with reference to Figure 3 and Figure 6 Section J-J and Detail K, install the four handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the four fillers P/N 8G5620A13551 then install the four fillers P/N 8G5620A13551 in the internal groove of the window gasket P/N 8G5620A07051 by means of adhesive RTV 732 (C126).
- 2.22 In accordance with the applicable steps of AMP DM 89-A-56-32-02-00A-920A-A, repeat steps from 2.19 to 2.21 for the RH FWD passenger door transparencies P/N 4F5630A00251 and P/N 4F5630A00451.

**NOTE**

Perform steps 2.23 thru 2.29 for helicopters equipped with hinged cabin doors.

- 2.23 In accordance with the applicable steps of AMP DM 89-A-56-33-01-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, bond the upper retainer P/N 8G5620A07551, the lower retainer P/N 8G5620A13651 and n°2 corner retainers P/N 8G5620A00351 on the hinged door panel P/N 8G5212A00531 by means of adhesive RTV 732 (C126).
- 2.24 In accordance with the applicable steps of AMP DM 89-A-56-33-01-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, install and bond the new window gasket P/N 8G5620A07051 to the LH hinged door transparency P/N 4F5630A00151 and the retainers previously installed by means of adhesive RTV 732 (C126).

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.25 In accordance with the applicable steps of AMP DM 89-A-56-33-01-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, install the two handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the two fillers P/N 8G5620A13551 then install the two fillers P/N 8G5620A13551 in the internal groove of the window gasket

- P/N 8G5620A07051 by means of adhesive RTV 732 (C126).
- 2.26 In accordance with the applicable steps of AMP DM 89-A-56-33-03-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, bond the upper retainer P/N 8G5620A13151 and the lower corner retainer P/N 8G5620A13251 on the fixed door panel P/N 8G5212A01131 by means of adhesive RTV 732 (C126).
- 2.27 In accordance with the applicable steps of AMP DM 89-A-56-33-03-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, install and bond the new window gasket P/N 8G5620A13051 to the LH fixed door transparency P/N 8G5620A00451 and the retainers previously installed by means of adhesive RTV 732 (C126).

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.28 In accordance with the applicable steps of AMP DM 89-A-56-33-03-00A-920A-A and with reference to Figure 5 and Figure 6 Section J-J, install the two handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the two fillers P/N 8G5620A13451 then install the two fillers P/N 8G5620A13451 in the internal groove of the window gasket P/N 8G5620A13051 by means of adhesive RTV 732 (C126).
- 2.29 In accordance with the applicable steps of AMP DMs 89-A-56-33-02-00A-920A-A and 89-A-56-33-04-00A-920A-A, repeat steps from 2.23 to 2.28 for the right hinged door window P/N 4F5630A00251 and the right fixed cabin door window P/N 8G5620A00551.

**NOTE**

Perform steps 2.30 thru 2.33 if the helicopter is not equipped with bubble windows (P/N 8G5620F00111 and/or P/N 8G5620F00112) or sliding windows (P/N 8G5620F00211 and/or P/N 8G5620F00311).

- 2.30 In accordance with the applicable steps of AMP DM 89-A-56-21-01-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J, bond the upper retainer P/N 8G5620A07551, the lower retainer P/N 8G5620A13651 and n°2 corner retainers P/N 8G5620A00351 on the side wall panel P/N 8G5335A15831 by means of adhesive RTV 732 (C126).

- 2.31 In accordance with the applicable steps of AMP DM 89-A-56-21-01-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J, install and bond the new window gasket P/N 8G5620A07051 to the LH FWD passenger cabin transparency P/N 4F5630A00551 and the retainers previously installed by means of adhesive RTV 732 (C126).

**NOTE**

Carefully slide filler through the clip of the handle assy before inserting both filler and handle in the channel of the gasket.

- 2.32 In accordance with the applicable steps of AMP DM 89-A-56-21-01-00A-920A-A and with reference to Figure 4 and Figure 6 Section J-J, install the two handles assy window jettison P/N 8G9500A00731 (pull tab P/N 8G9500A03051 + clip P/N 8G9520A00251) in position on the two fillers P/N 8G5620A13551 then install the two fillers P/N 8G5620A13551 in the internal groove of the window gasket P/N 8G5620A07051 by means of adhesive RTV 732 (C126).
- 2.33 In accordance with the applicable steps of AMP DM 89-A-56-21-02-00A-920A-A, repeat steps from 2.30 to 2.32 for the RH FWD passenger cabin transparency P/N 4F5630A00651.
3. In accordance with AMP DM 89-A-06-41-00-00A-010A-A, re-install all external panels, internal panels and internal liners previously removed.
4. Return the helicopter to flight configuration and record for compliance with this Service Bulletin on the helicopter logbook.
5. Gain access to My Communications section on Leonardo WebPortal and compile the "Service Bulletin Application Communication".

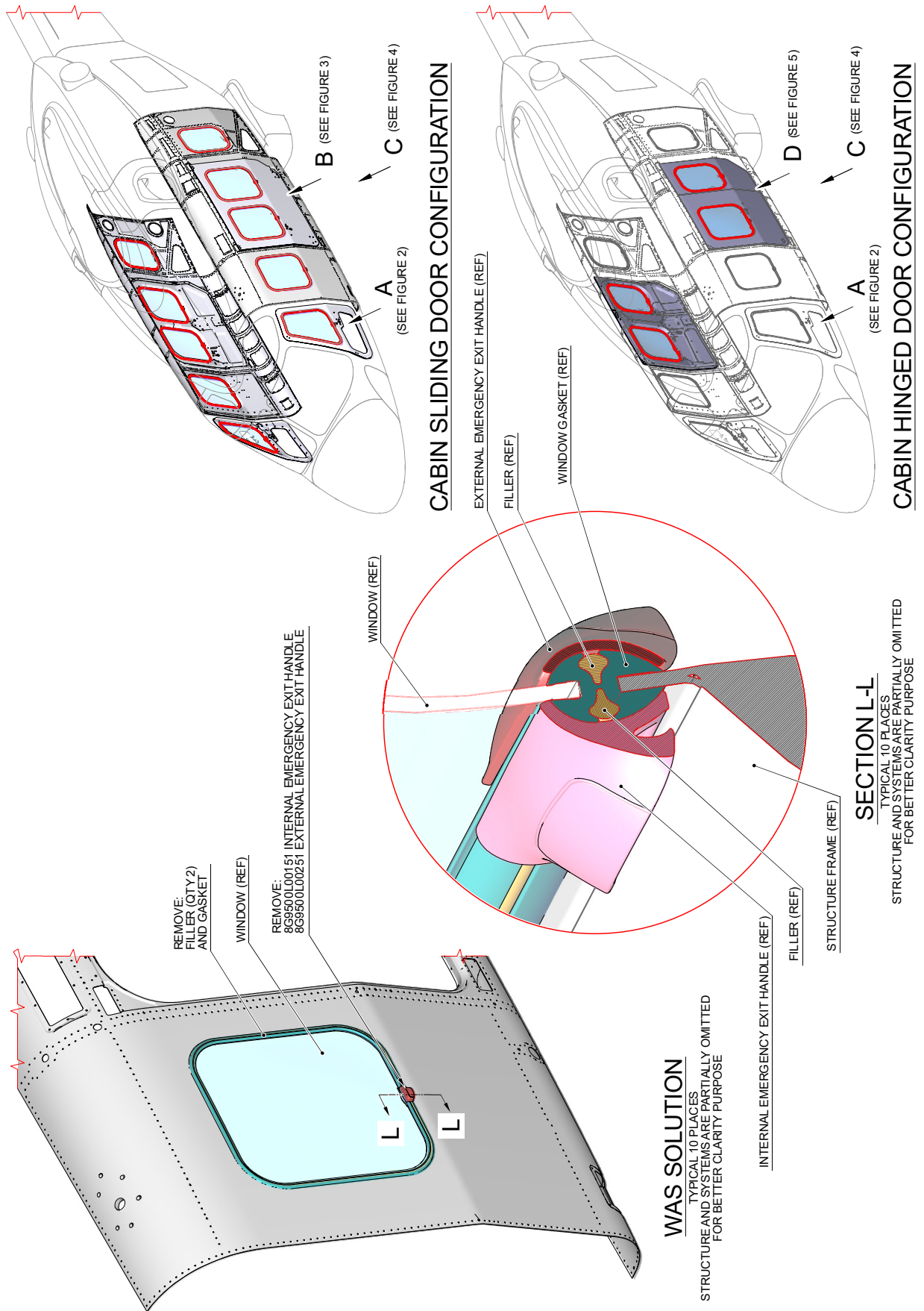
As an alternative, send the attached compliance form to the following mail box:

[engineering.support.lhd@leonardo.com](mailto:engineering.support.lhd@leonardo.com)

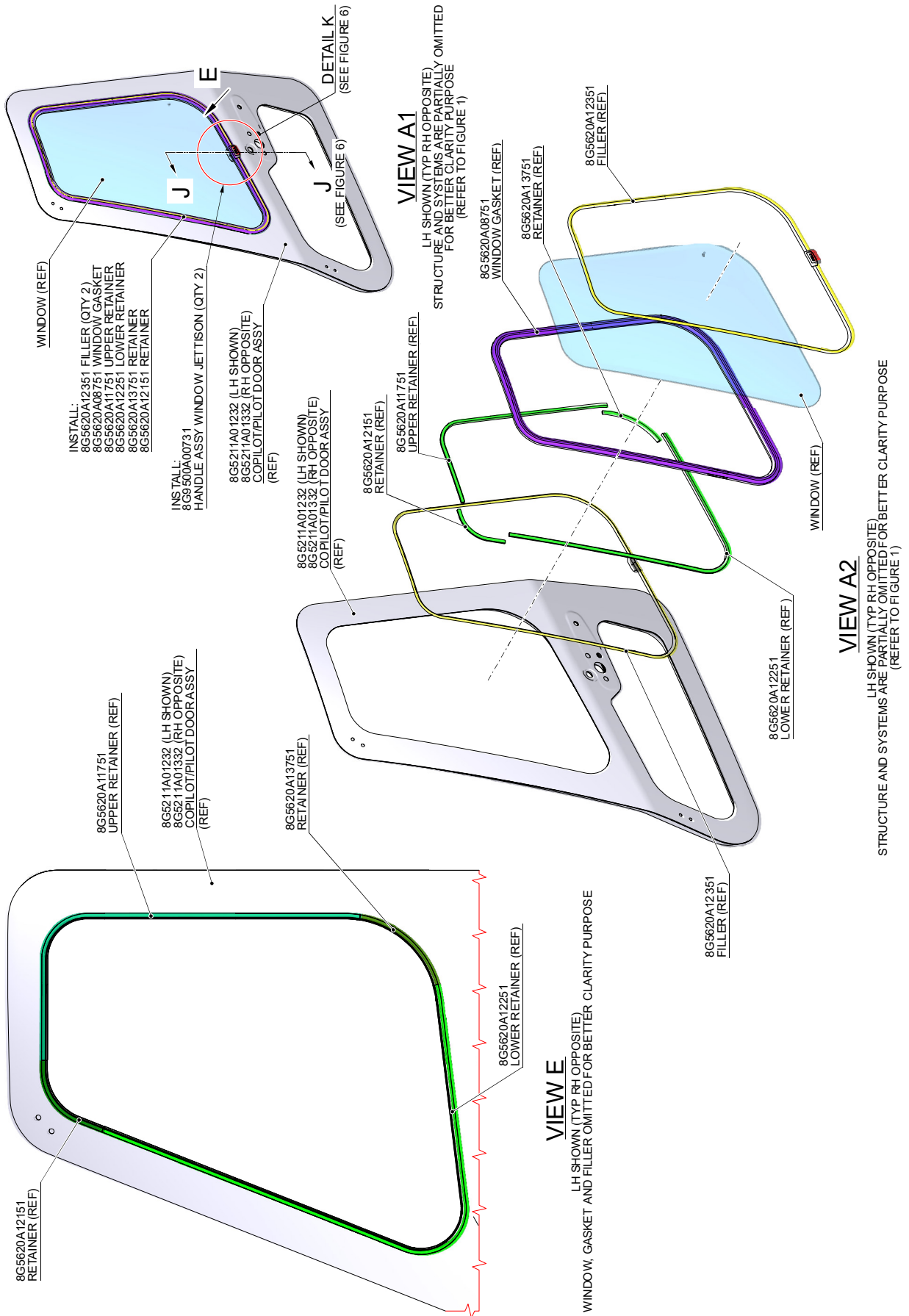
and (for North, Central and South America) also to:

[AWPC.Engineering.Support@leonardocompany.us](mailto:AWPC.Engineering.Support@leonardocompany.us)





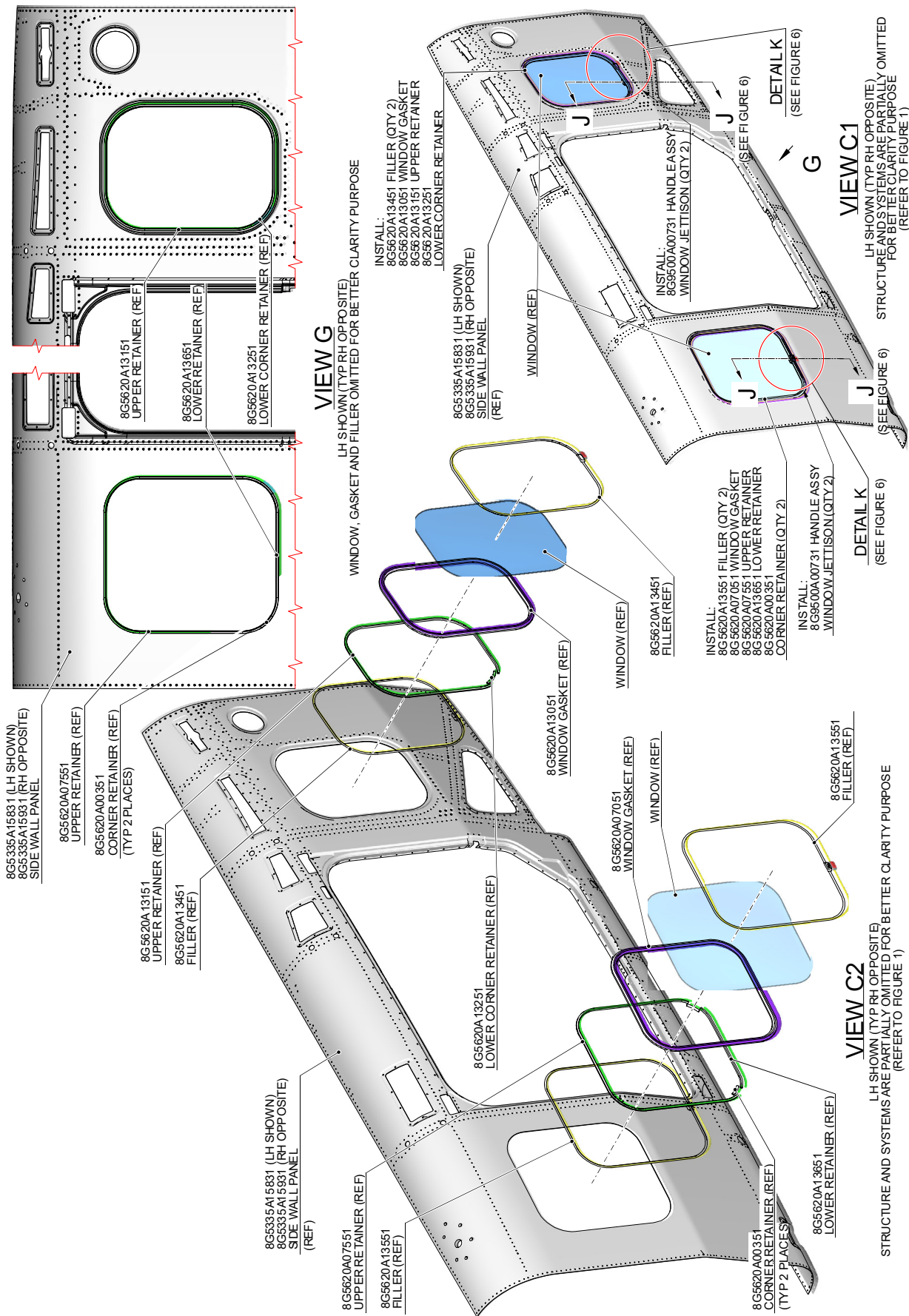
**Figure 1**



**Figure 2**







**Figure 4**

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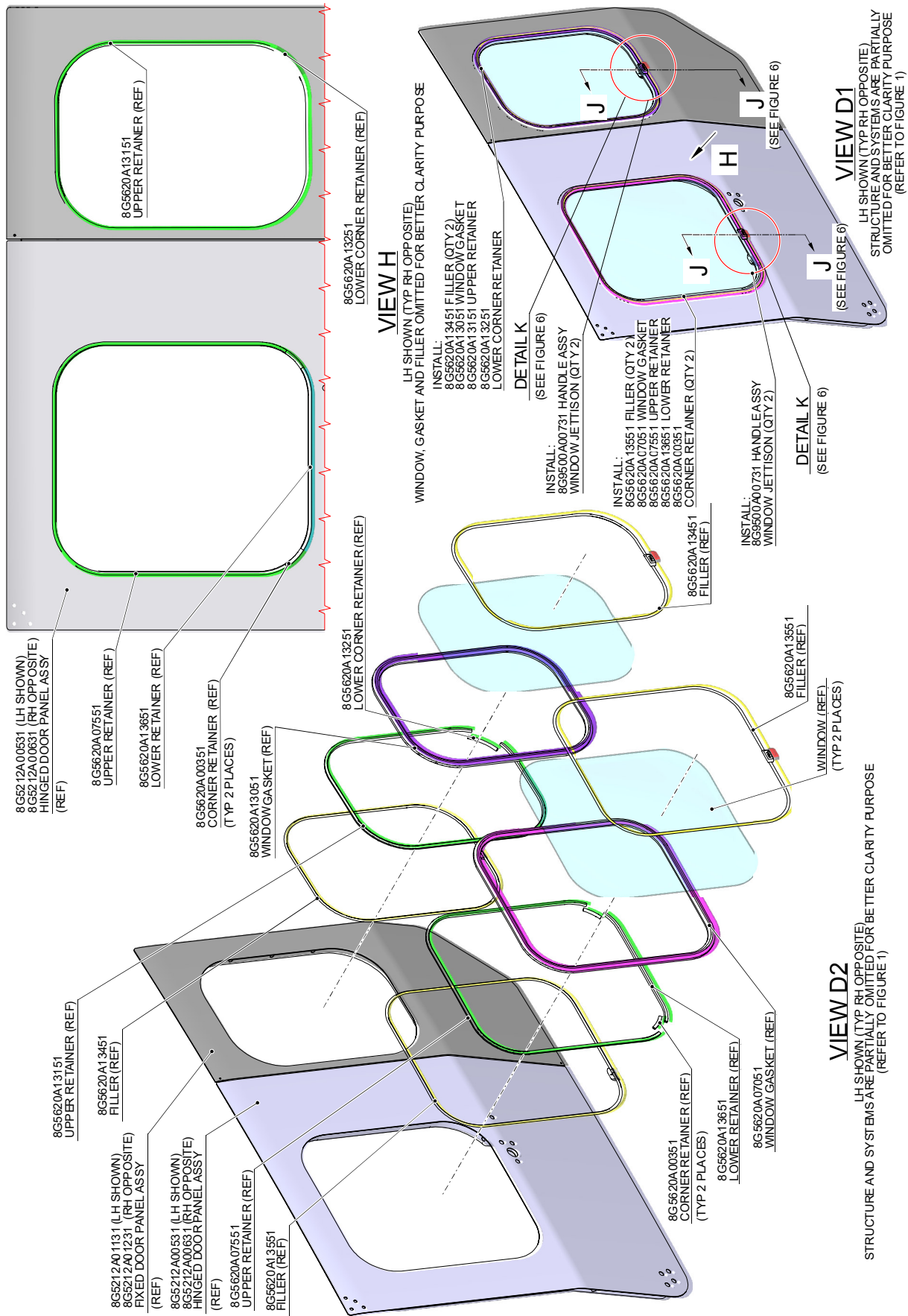
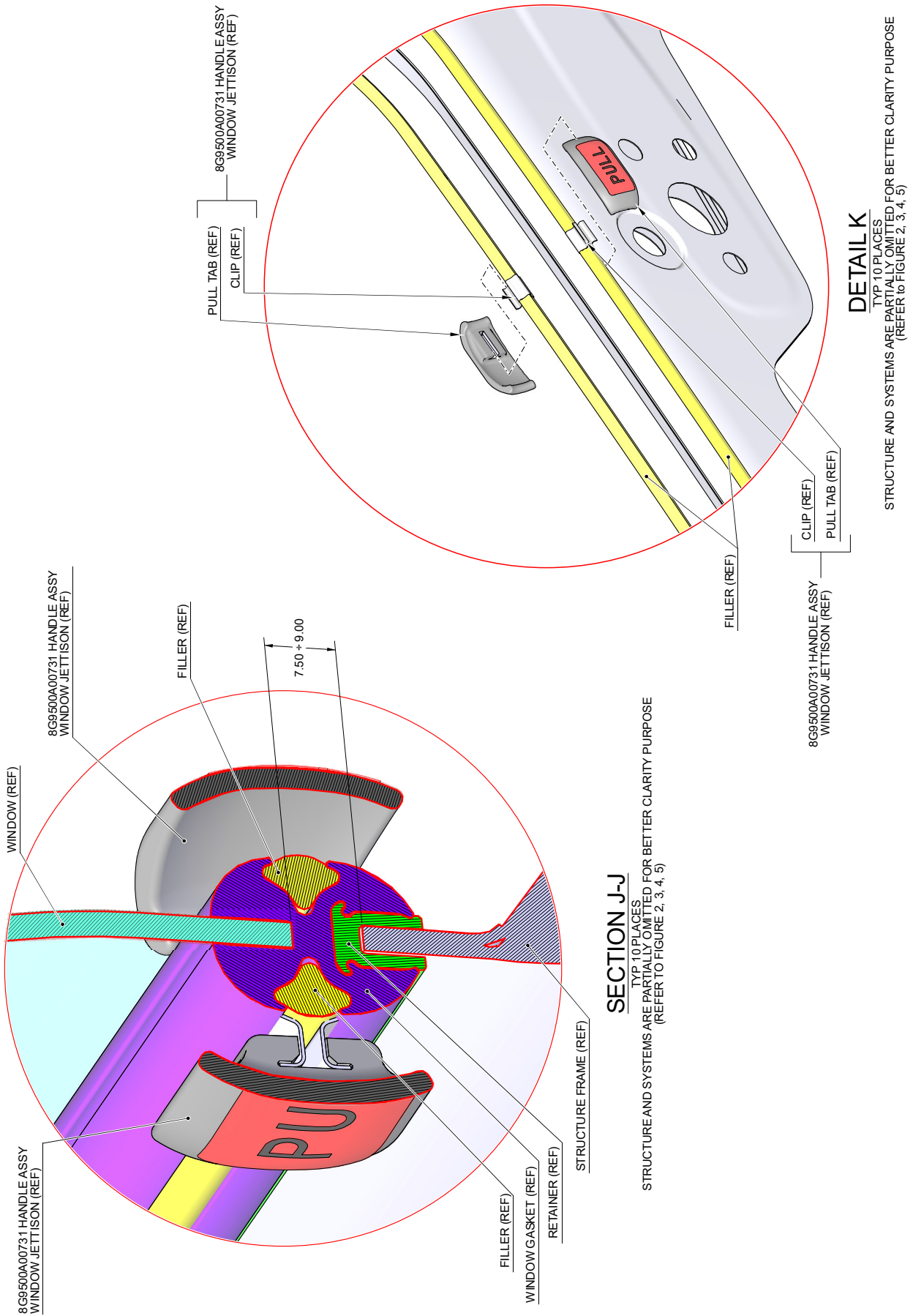


Figure 5



**Figure 6**

