
SERVICE BULLETIN

N° **139-694**

RECOMMENDED

DATE: February 28, 2024

REV. : /

TITLE

ATA 56 – WINDOW GASKET UPGRADE

REVISION LOG

First Issue

An appropriate entry should be made in the aircraft log book upon accomplishment.
If ownership of aircraft has changed, please, forward to new owner.

1. PLANNING INFORMATION

A. EFFECTIVITY

NOTE

Before returning to service, helicopters must:

- install new gaskets on both cockpit and cabin windows
- install new decals (internal/external) next to both cockpit and cabin windows

No other gasket/decals configuration is allowed.

For this reason:

- Helicopters equipped with cabin sliding doors must comply with Part I, Part III and Part IV of this Service Bulletin before Returning to Service
- Helicopters equipped with cabin hinged doors must comply with Part II, Part III and Part V of this Service Bulletin before Returning to Service

Part I

All AB139/AW139 helicopters equipped with cabin sliding doors NOT equipped with external handle 3G5630A01251.

Part II

All AB139/AW139 helicopters equipped with cabin hinged doors NOT equipped with external handle 3G5630A01251.

Part III

All AB139/AW139 helicopters NOT equipped with external handle 3G5630A01251.

NOTE

Part III and Part IV are applicable only to Helicopters installing internal and external markings with English wording.

In case a customized markings installation is desired (for example Markings with wording in languages different from English) please contact your Customer Support Area Manager requesting a quotation.

Part IV

All AB139/AW139 helicopters equipped with cabin sliding doors NOT equipped with external handle 3G5630A01251.

Part V

All AB139/AW139 helicopters equipped with cabin hinged doors NOT equipped with external handle 3G5630A01251.

B. COMPLIANCE

At first replacement of the emergency exits windows gaskets due to discard time.

C. CONCURRENT REQUIREMENTS

N.A.

D. REASON

This Service Bulletin is issued in order to provide the necessary instructions to introduce a new gasket installation 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 current design of gasket installation on the basic door (cockpit and cabin) is composed by two parts; the gasket and the filler. The new design is composed by three parts: the gasket, the filler and the retainer. Both the gasket and the retainer are respectively continuously bonded on the window and on the structure.

With the new gasket installation, the jettison force is independent from the bonding of the gasket and retainer as in the new installation the jettison force is related only to the friction of the contact between the retainer and the gasket.

Part I provides instructions to install the new gaskets in the cabin area for helicopters equipped with sliding doors.

Part II provides instructions to install the new gaskets in the cabin area for helicopters equipped with hinged doors.

Part III provides instructions to install the new gaskets in cockpit.

Part IV provides instructions to install the new internal/external markings (in English) for helicopters equipped with sliding doors.

Part V provides instructions to install the new internal/external markings (in English) for helicopters equipped with hinged doors.

The full gasket/decal upgrade must be embodied before returning the helicopter to Service. Please refer to Effectivity paragraph.

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: Thirty (30) MMH;

Part II: Twenty-four (24) MMH;

Part III: Ten (10) MMH;

Part IV: One (1) MMH;

Part V: One (1) MMH;

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

PART I

WEIGHT (Kg)	ARM (mm)	MOMENT (Kgmm)
		1.5
LONGITUDINAL BALANCE	4410	6615
LATERAL BALANCE	1	1.5

PART II

WEIGHT (Kg)	ARM (mm)	MOMENT (Kgmm)
		3.4
LONGITUDINAL BALANCE	4401	14963.4
LATERAL BALANCE	-1	-3.4

PART III

WEIGHT (Kg)	ARM (mm)	MOMENT (Kgmm)
		1.15
LONGITUDINAL BALANCE	2744	3155.6
LATERAL BALANCE	1060	1219

PART IV

N.A.

PART V

N.A.

I. REFERENCES

I.1 PUBLICATIONS

Following Data Modules refer to AMP:

<u>DATA MODULE</u>	<u>DESCRIPTION</u>	<u>PART</u>
DM01 39-A-00-20-00-00A-120A-A	Helicopter on ground for a safe maintenance.	All
DM02 39-A-11-00-01-00A-520A-A	Decal (polyester film) - Remove procedure	IV, V
DM03 39-A-11-00-01-00A-520B-A	Decal (vinyl film) - Remove procedure	IV, V
DM04 39-A-11-00-01-00A-720A-A	Decal - Install procedure	IV, V
DM05 39-A-56-21-01-00A-920A-A	Left cabin window - Replacement	I, II
DM06 39-A-56-21-02-00A-920A-A	Right cabin window - Replacement	I, II
DM07 39-B-56-31-01-00A-920A-K	Left cockpit door top window - Replacement	III

<u>DATA MODULE</u>	<u>DESCRIPTION</u>	<u>PART</u>
DM08 39-B-56-31-02-00A-920A-K	Right cockpit door top window - Replacement	III
DM09 39-A-56-32-01-00A-920A-A	Left cabin door window - Replacement	I, II
DM10 39-A-56-32-02-00A-920A-A	Right cabin door window - Replacement	I, II

I.2 ACRONYMS & ABBREVIATIONS

AMDI	Aircraft Material Data Information
AMP	Aircraft Maintenance Publication
AR	As Required
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	3G5600P00911		EMERGENCY EXIT WINDOW RETROMOD	REF	.	(1)	-
2	3G5600P01011		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(2)	-
3	3G5630A01251		Handle	6	..		139-694L1
4	3G5630A01351		Clip	6	..		139-694L1
5	3G5630A01951		Gasket	4	..		139-694L1
6	3G5630A02051		Retainer	4	..		139-694L1
7	3G5630A02151		Retainer	4	..		139-694L1
8	3G5630A02251		Retainer	8	..		139-694L1
9	3G5630A02351		Filler	8	..		139-694L1
10	3G5630A02451		Gasket	2	..		139-694L1
11	3G5630A02551		Retainer	2	..		139-694L1
12	3G5630A02651		Retainer	2	..		139-694L1
13	3G5630A02951		Filler	4	..		139-694L1
14	A487A003A		Strap Assembly	4	..		139-694L1
15	A487A005A		Strap Assembly	2	..		139-694L1
16	MS27980-13N		Stud	6	..		139-694L1

PART II

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
17	3G5600P01111		EMERGENCY EXIT WINDOW RETROMOD HINGED DOOR	REF	.	(3)	-
18	3G5630A01251		Handle	6	..		139-694L2
19	3G5630A01351		Clip	6	..		139-694L2
20	3G5630A01951		Gasket	2	..		139-694L2
21	3G5630A02051		Retainer	2	..		139-694L2
22	3G5630A02151		Retainer	2	..		139-694L2
23	3G5630A02251		Retainer	4	..		139-694L2
24	3G5630A02351		Filler	4	..		139-694L2
25	3G5630A02451		Gasket	4	..		139-694L2
26	3G5630A02551		Retainer	4	..		139-694L2
27	3G5630A02651		Retainer	4	..		139-694L2
28	3G5630A02951		Filler	8	..		139-694L2
29	A487A003A		Strap Assembly	4	..		139-694L2
30	A487A005A		Strap Assembly	2	..		139-694L2
31	MS27980-13N		Stud	4	..		139-694L2

PART III

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
32	3G5600P00211		EMERGENCY EXIT WINDOW RETROMOD	REF	.	(4)	-
33	3G5600P00311		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(5)	-
34	3G5600P00411		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(6)	-

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
35	3G5600P00511		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(7)	-
36	3G5600P00611		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(8)	-
37	3G5600P00711		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(9)	-
38	3G5600P00811		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(10)	-
39	3G5600P01011		EMERGENCY EXIT WINDOW RETROMOD	ALT REF	.	(11)	-
40	3G5630A01251		Handle	2	..		139-694L3
41	3G5630A01351		Clip	2	..		139-694L3
42	3G5630A01451		Gasket	2	..		139-694L3
43	3G5630A01551		Retainer	2	..		139-694L3
44	3G5630A01651		Retainer	2	..		139-694L3
45	3G5630A01751		Up forward retainer	2	..		139-694L3
46	3G5630A03251		Lower aft retainer	2	..		139-694L3
47	3G5630A01851		Filler	4	..		139-694L3
48	A436A06A2		Nut	2	..		139-694L3
49	A487A003A		Strap Assembly	2	..		139-694L3
50	A994A15T010D	AW017TY15T010D	Washer	4	..		139-694L3
51	MS27980-17B		Stud	2	..		139-694L3
52	MS35214-26		Screw	2	..		139-694L3
53	NAS1149D0363K		Washer	2	..		139-694L3

PART IV

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
54	A180A005E22		Decal	8	.	(12)	139-694L4
55	A180A009E22		Decal	6	.	(12)	139-694L4
56	A180A016E22		Decal	26	.	(12)	139-694L4
57	AW003DE005E33B		Decal	8	.	(12)	139-694L4

PART V

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
58	A180A005E22		Decal	8	.	(12)	139-694L5
59	A180A009E22		Decal	6	.	(12)	139-694L5
60	A180A016E22		Decal	22	.	(12)	139-694L5
61	AW003DE005E33B		Decal	8	.	(12)	139-694L5

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

A.2 CONSUMABLES

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

#	SPEC./LHD CODE NUMBER	DESCRIPTION	Q.TY	NOTE	PART
62	199-05-152 Type I, Class 2	Adhesive RTV 732 (C126)	AR	(1)	All

Refer also to AMDI for the consumable materials required to comply with the AMP DM 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
139-694L1	1		I
139-694L2	1		II
139-694L3	1		III
139-694L4	1	(12)	IV
139-694L5	1	(12)	V

NOTES

- (1) Applicable to SN-LN-ENH helicopters equipped with cabin sliding door assemblies P/N 3G5212A00336 (LH side) and P/N 3G5212A00435 (RH side) or similar (Ref. Figure 1).
- (2) Applicable to PLUS helicopters equipped with cabin sliding door assemblies P/N 3G5212A16232 (LH side) and P/N 3G5212A16332 (RH side) or similar (Ref. Figure 2).
- (3) Applicable to helicopters equipped with cabin hinged door assemblies LH and RH (Ref. Figure 7).
- (4) Applicable to helicopters equipped with storm window assy with privacy lock P/N 3G5606P00111 or similar (Ref. Figure 15).
- (5) Applicable to helicopters equipped with storm window assy with privacy lock P/N 3G5606P00112 or similar (Ref. Figure 16).
- (6) Applicable to helicopters equipped with window panel LH P/N 3G5206P06551 or similar and storm window assy RH P/N 3G5206P06631 or similar (Ref. Figure 17).
- (7) Applicable to SN helicopters equipped with window panel LH P/N 3G5211A01351 or similar and hinged storm window assy RH P/N 3G5211A00831 or similar (Ref. Figure 18).
- (8) Applicable to helicopters equipped with window panel LH P/N 3G5206P06551 or similar and storm window assy RH P/N 3G5206P06631 or similar (Ref. Figure 19).
- (9) Applicable to helicopters equipped with window panel P/N 3P5211A10152 or similar and storm window assy RH P/N 3P5211A48131 or similar (Ref. Figure 20).
- (10) Applicable to LN helicopters equipped with window panel LH P/N 3G5211A01351 or similar and hinged storm window assy RH P/N 3G5211A00831 or similar (Ref. Figure 21).
- (11) Applicable to PLUS helicopters equipped with window panel LH P/N 3G5211A01351 or similar and hinged storm window assy RH P/N 3G5211A00832 or similar (Ref. Figure 22).

(12) These items have English wording. In case a customized markings installation is desired (for example Markings with wording in languages different from English) please contact your Customer Support Area Manager requesting a quotation.

(13) Item to be procured as local supply.

B. SPECIAL TOOLS

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

C. INDUSTRY SUPPORT INFORMATION

This SB is commercially supported by LHD. Customer is requested to contact the Customer Support Account Manager for further details on the commercial policy.

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

For the emergency exit window retromod P/N 3G5600P00911 refer to Figure 1 and Figures 3 thru 6.

NOTE

For the emergency exit window retromod P/N 3G5600P01011 refer to Figure 2 and Figures 3 thru 6.

2. In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 1 or 2 and Figure 5 Detail B, from the left side wall assy, remove the existing window panel (retain for later reuse), extd rubber window seal P/N A417AG002WB, n°2 extd rubber fillers P/N A417AF001WB, strap assembly P/N A487A005A and stud P/N MS27980-13N.

3. In accordance with the applicable steps of AMP DM 39-A-56-32-01-00A-920A-A and with reference to Figures 1 or 2 and Figure 3 Detail A, from the left cabin sliding door assy, remove n°2 existing passenger door windows (retain for later reuse), n°2 extd rubber window seals P/N A417AG002WB2412, n°4 extd rubber fillers P/N A417AF001WB2412, n°2 strap assemblies P/N A487A003A and n°2 studs P/N MS27980-13N.
4. In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 1 or 2 and Figure 5 Detail B, from the right side wall assy, remove the existing window panel (retain for later reuse), extd rubber window seal P/N A417AG002WB, n°2 extd rubber filler P/N A417AF001WB, strap assembly P/N A487A005A and stud P/N MS27980-13N.
5. In accordance with the applicable steps of AMP DM 39-A-56-32-02-00A-920A-A and with reference to Figures 1 or 2 and Figure 3 Detail A, from the right cabin sliding door assy, remove n°2 existing passenger door windows (retain for later reuse), n°2 extd rubber window seals P/N A417AG002WB2412, n°4 extd rubber fillers P/N A417AF001WB2412, n°2 strap assemblies P/N A487A003A and n°2 studs P/N MS27980-13N.

NOTE

- Sanding of the gasket, filler and retainer (rubber parts) is not permitted.
 - During the installation phase, it is not allowed to stretch the gasket, the filler and the retainer.
 - To ensure a correct bonding / adhesion between the transparent and the gasket and between the retainer and the door panel, make sure that during the adhesive application phase there is a squeeze-out of the adhesive itself. The bonding process must be performed using a tool or gun or syringe.
 - After 30 minutes, remove squeeze out adhesive on internal and external side.
6. With reference to Figures 1 thru 6, perform the installation of the new cabin window gaskets as described in the following procedure:
 - 6.1 In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 1 or 2 and Figures 5 and 6, install the following components on the left side wall assy:
 - the window panel removed at step 2;
 - the retainer P/N 3G5630A02551;
 - the retainer P/N 3G5630A02651;

- the gasket P/N 3G5630A02451;
 - n°2 fillers P/N 3G5630A02951;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A005A;
 - the stud P/N MS27980-13N.
- 6.2 In accordance with the applicable steps of AMP DM 39-A-56-32-01-00A-920A-A and with reference to Figures 1 or 2 and Figures 3 and 4, install the following components on the left cabin sliding door assy:
- n°2 passenger door windows removed at step 3;
 - n°2 retainers P/N 3G5630A02051;
 - n°2 retainers P/N 3G5630A02151;
 - n°4 retainers P/N 3G5630A02251;
 - n°2 gaskets P/N 3G5630A01951;
 - n°4 fillers P/N 3G5630A02351;
 - n°2 handles P/N 3G5630A01251;
 - n°2 clips P/N 3G5630A01351;
 - n°2 strap assemblies P/N A487A003A;
 - n°2 studs P/N MS27980-13N.
- 6.3 In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 1 or 2 and Figures 5 and 6, install the following components on the right side wall assy:
- the window panel removed at step 4;
 - the retainer P/N 3G5630A02551;
 - the retainer P/N 3G5630A02651;
 - the gasket P/N 3G5630A02451;
 - n°2 fillers P/N 3G5630A02951;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A005A;
 - the stud P/N MS27980-13N.
- 6.4 In accordance with the applicable steps of AMP DM 39-A-56-32-02-00A-920A-A and with reference to Figures 1 or 2 and Figures 3 and 4, install the following components on the right cabin sliding door assy:
- n°2 passenger door windows removed at step 5;
 - n°2 retainers P/N 3G5630A02051;

- n°2 retainers P/N 3G5630A02151;
- n°4 retainers P/N 3G5630A02251;
- n°2 gaskets P/N 3G5630A01951;
- n°4 fillers P/N 3G5630A02351;
- n°2 handles P/N 3G5630A01251;
- n°2 clips P/N 3G5630A01351;
- n°2 strap assemblies P/N A487A003A;
- n°2 studs P/N MS27980-13N.

NOTE

Helicopters equipped with cabin sliding doors must comply with Part I, Part III and Part IV of this Service Bulletin before Returning to Service

7. Perform Part III and Part IV of this Service Bulletin.
8. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
9. Return the helicopter to flight configuration and record for compliance with Part I of this Service Bulletin on the helicopter logbook.
10. 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.
2. In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 7 and 8 Detail A, from the left side wall assy, remove the existing window panel (retain for later reuse), extd rubber window seal P/N A417AG002WB, n°2 extd rubber fillers P/N A417AF001WB, strap assembly P/N A487A005A and stud P/N MS27980-13N.
3. In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 7 and 11 Detail G, from the left fixed door assy, remove the existing window panel (retain for later reuse), window seal profile P/N 3P5330A19852, n°2 window seal wedge P/N 3P5330A19952, strap assembly P/N A487A003A and stud P/N MS27980-13N.
4. In accordance with the applicable steps of AMP DM 39-A-56-32-01-00A-920A-A and with reference to Figures 7 and 11 Detail G, from the left cabin hinged door assy (retain for later reuse), remove existing passenger door window, extd rubber window seal P/N A417AG002WB2412, n°2 extd rubber fillers P/N A417AF001WB2412, strap assembly P/N A487A003A and stud P/N MS27980-13N.
5. In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 7 and 8 Detail A, from the right side wall assy, remove the existing window panel (retain for later reuse), extd rubber window seal P/N A417AG002WB, n°2 extd rubber fillers P/N A417AF001WB, strap assembly P/N A487A005A and stud P/N MS27980-13N.
6. In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 7 and 11 Detail G, from the right fixed door assy, remove the existing window panel (retain for later reuse), window seal profile P/N 3P5330A19852, n°2 window seal wedge P/N 3P5330A19952, strap assembly P/N A487A003A and stud P/N MS27980-13N.
7. In accordance with the applicable steps of AMP DM 39-A-56-32-02-00A-920A-A and with reference to Figures 7 and 11 Detail G, from the right cabin hinged door assy, remove existing passenger door window (retain for later reuse), extd rubber window seal P/N A417AG002WB2412, n°2 extd rubber fillers P/N A417AF001WB2412, strap assembly P/N A487A003A and stud P/N MS27980-13N.

NOTE

- Sanding of the gasket, filler and retainer (rubber parts) is not permitted.
- During the installation phase, it is not allowed to stretch the gasket, the filler and the retainer.
- To ensure a correct bonding / adhesion between the transparent and the gasket and between the retainer and the door panel, make sure that during the adhesive application phase there is a squeeze-out of the adhesive itself. The bonding process must be performed using a tool or gun or syringe.
- After 30 minutes, remove squeeze out adhesive on internal and external side.

8. With reference to Figures 7 thru 14, perform the installation of the new cabin window gaskets as described in the following procedure:

8.1 In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 8 thru 10, install the following components on the left side wall assy:

- the window panel removed at step 2;
- the retainer P/N 3G5630A02551;
- the retainer P/N 3G5630A02651;
- the gasket P/N 3G5630A02451;
- n°2 fillers P/N 3G5630A02951;
- the handle P/N 3G5630A01251;
- the clip P/N 3G5630A01351;
- the strap assembly P/N A487A005A;
- the stud P/N MS27980-13N.

8.2 In accordance with the applicable steps of AMP DM 39-A-56-21-01-00A-920A-A and with reference to Figures 11 thru 14, install the following components on the left fixed door assy:

- the window panel removed at step 3;
- the retainer P/N 3G5630A02551;
- the retainer P/N 3G5630A02651;
- the gasket P/N 3G5630A02451;
- n°2 fillers P/N 3G5630A02951;
- the handle P/N 3G5630A01251;

- the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A003A;
 - the stud P/N MS27980-13N.
- 8.3 In accordance with the applicable steps of AMP DM 39-A-56-32-01-00A-920A-A and with reference to Figures 11 thru 14, install the following components on the left cabin hinged door assy:
- the passenger door windows removed at step 4;
 - the retainer P/N 3G5630A02051;
 - the retainer P/N 3G5630A02151;
 - n°2 retainers P/N 3G5630A02251;
 - the gasket P/N 3G5630A01951;
 - n°2 fillers P/N 3G5630A02351;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A003A;
 - the stud P/N MS27980-13N.
- 8.4 In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 8 thru 10, install the following components on the right side wall assy:
- the window panel removed at step 5;
 - the retainer P/N 3G5630A02551;
 - the retainer P/N 3G5630A02651;
 - the gasket P/N 3G5630A02451;
 - n°2 fillers P/N 3G5630A02951;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A005A;
 - the stud P/N MS27980-13N.
- 8.5 In accordance with the applicable steps of AMP DM 39-A-56-21-02-00A-920A-A and with reference to Figures 11 thru 14, install the following components on the right fixed door assy:
- the window panel removed at step 6;
 - the retainer P/N 3G5630A02551;
 - the retainer P/N 3G5630A02651;
 - the gasket P/N 3G5630A02451;
 - n°2 fillers P/N 3G5630A02951;

- the handle P/N 3G5630A01251;
- the clip P/N 3G5630A01351;
- the strap assembly P/N A487A003A;
- the stud P/N MS27980-13N.

8.6 In accordance with the applicable steps of AMP DM 39-A-56-32-02-00A-920A-A and with reference to Figures 11 thru 14, install the following components on the right cabin hinged door assy:

- the passenger door windows removed at step 7;
- the retainer P/N 3G5630A02051;
- the retainer P/N 3G5630A02151;
- n°2 retainers P/N 3G5630A02251;
- the gasket P/N 3G5630A01951;
- n°2 fillers P/N 3G5630A02351;
- the handle P/N 3G5630A01251;
- the clip P/N 3G5630A01351;
- the strap assembly P/N A487A003A;
- the stud P/N MS27980-13N.

NOTE

Helicopters equipped with cabin hinged doors must comply with Part II, Part III and Part V of this Service Bulletin before Returning to Service

9. Perform Part III and Part V of this Service Bulletin.
10. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
11. Return the helicopter to flight configuration and record for compliance with Part II of this Service Bulletin on the helicopter logbook.
12. 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 III

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.

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NOTE

For the emergency exit window retromod P/N 3G5600P00211 refer to Figure 15 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00311 refer to Figure 16 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00411 refer to Figure 17 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00511 refer to Figure 18 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00611 refer to Figure 19 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00711 refer to Figure 20 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P00811 refer to Figure 21 and Figures 23 thru 27.

NOTE

For the emergency exit window retromod P/N 3G5600P01011 refer to Figure 22 and Figures 23 thru 27.

2. In accordance with the applicable steps of AMP DM 39-B-56-31-01-00A-920A-K and with reference to Figures 15 or 16 or 17 or 18 or 19 or 20 or 21 or 22, remove the following components from the left cockpit door:

- existing window panel LH (retain for later reuse);
 - the seal P/N 999-1700-48-101G;
 - the filler P/N 999-1700-49-101G;
 - the strap assembly P/N A487A003A;
 - the washer P/N NAS1149D0363K;
 - the stud P/N MS27980-17B;
 - if present the screw P/N MS35214-26, the strap P/N 3G5610A04751, the nut P/N A436A06A2 and n°2 washers P/N A994A15T010D.
3. In accordance with the applicable steps of AMP DM 39-B-56-31-02-00A-920A-K and with reference to Figures 15 or 16 or 17 or 18 or 19 or 20 or 21 or 22, remove the following components from the right cockpit door:
- existing window panel RH (retain for later reuse);
 - the seal P/N 999-1700-48-101G;
 - the filler P/N 999-1700-49-101G;
 - the strap assembly P/N A487A003A;
 - the washer P/N NAS1149D0363K;
 - the stud P/N MS27980-17B;
 - if present the screw P/N MS35214-26, the strap P/N 3G5610A04751, the nut P/N A436A06A2 and n°2 washers P/N A994A15T010D.

NOTE

- Sanding of the gasket, filler and retainer (rubber parts) is not permitted.
 - During the installation phase, it is not allowed to stretch the gasket, the filler and the retainer.
 - To ensure a correct bonding / adhesion between the transparent and the gasket and between the retainer and the door panel, make sure that during the adhesive application phase there is a squeeze-out of the adhesive itself. The bonding process must be performed using a tool or gun or syringe.
 - After 30 minutes, remove squeeze out adhesive on internal and external side.
4. With reference to Figures 15 or 16 or 17 or 18 or 19 or 20 or 21 or 22 and Figures 23 thru 27, perform the installation of the new cockpit door window gaskets as described in the following procedure:

- 4.1 In accordance with the applicable steps of AMP DM 39-B-56-31-01-00A-920A-K, install the following components on the left cockpit door:
- the window panel LH removed at step 2;
 - the retainer P/N 3G5630A01551;
 - the retainer P/N 3G5630A01651;
 - the retainer P/N 3G5630A01751;
 - the retainer P/N 3G5630A03251;
 - the gasket P/N 3G5630A01451;
 - n°2 fillers P/N 3G5630A01851;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A003A;
 - the washer P/N NAS1149D0363K;
 - the stud P/N MS27980-17B;
 - if necessary, the screw P/N MS35214-26, the nut P/N A436A06A2 and n°2 washers P/N A994A15T010D.
- 4.2 In accordance with the applicable steps of AMP DM 39-A-56-32-02-00A-920A-A, install the following components on the right cockpit door:
- the window panel RH removed at step 2;
 - the retainer P/N 3G5630A01551;
 - the retainer P/N 3G5630A01651;
 - the retainer P/N 3G5630A01751;
 - the retainer P/N 3G5630A03251;
 - the gasket P/N 3G5630A01451;
 - n°2 fillers P/N 3G5630A01851;
 - the handle P/N 3G5630A01251;
 - the clip P/N 3G5630A01351;
 - the strap assembly P/N A487A003A;
 - the washer P/N NAS1149D0363K;
 - the stud P/N MS27980-17B;
 - if necessary, the screw P/N MS35214-26, the nut P/N A436A06A2 and n°2 washers P/N A994A15T010D.

NOTE

The following Step 5 is applicable only to helicopters equipped with cabin sliding doors.

NOTE

Helicopters equipped with cabin sliding doors must comply with Part I, Part III and Part IV of this Service Bulletin before Returning to Service

5. Perform Part I and Part IV of this Service Bulletin.

NOTE

The following Step 6 is applicable only to helicopters equipped with cabin Hinged doors.

NOTE

Helicopters equipped with cabin hinged doors must comply with Part II, Part III and Part V of this Service Bulletin before Returning to Service

6. Perform Part II and Part V of this Service Bulletin.
7. In accordance with weight and balance changes, update the Chart A (see Rotorcraft Flight Manual, Part II, section 6).
8. Return the helicopter to flight configuration and record for compliance with Part II of this Service Bulletin on the helicopter logbook.
9. 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 IV

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.
2. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-520B-A and with reference to Figure 28, remove the following decals from the left inner side of the helicopter:
 - n°13 decals P/N A181A001E1 or equivalent;
 - n°3 decals P/N A180A009E2 or equivalent;
 - n°3 decals P/N A180A005E2 or equivalent;
 - the decal P/N A180A010E2 or equivalent.

3. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-520A-A and with reference to Figure 30, remove the following decals from the left outer side of the helicopter:
 - n°3 decals P/N 999-2701-45-509 or equivalent;
 - the decal P/N 212-072-636-109 or equivalent.
4. Repeat step 2 and 3 for the right side of the helicopter.
5. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-720A-A and with reference to Figure 29, install the following decals to the left inner side of the helicopter:
 - n°7 decals P/N A180A016E22;
 - n°3 decals P/N A180A009E22;
 - n°4 decals P/N A180A005E22;
6. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-720A-A and with reference to Figures 30 and 31, install the following decals to the left outer side of the helicopter:
 - n°6 decals P/N A180A016E22;
 - n°4 decal P/N AW003DE005E33B.
7. Repeat step 5 and 6 for the right side of the helicopter.

NOTE

Helicopters equipped with cabin sliding doors must comply with Part I, Part III and Part IV of this Service Bulletin before Returning to Service

8. Perform Part I and Part III of this Service Bulletin.
9. Return the helicopter to flight configuration and record for compliance with Part IV of this Service Bulletin on the helicopter logbook.
10. 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 V

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.

2. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-520B-A and with reference to Figure 32, remove the following decals from the left inner side of the helicopter:
 - n°13 decals P/N A181A001E1 or equivalent;
 - n°3 decals P/N A180A009E2 or equivalent;
 - n°3 decals P/N A180A005E2 or equivalent;
 - the decal P/N A180A010E2 or equivalent.
3. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-520A-A and with reference to Figure 34, remove the following decals from the left outer side of the helicopter:
 - n°3 decals P/N 999-2701-45-509 or equivalent;
 - the decal P/N 212-072-636-109 or equivalent.
4. Repeat step 2 and 3 for the right side of the helicopter.
5. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-720A-A and with reference to Figure 33, install the following decals on the left inner side of the helicopter:
 - n°6 decals P/N A180A016E22;
 - n°3 decals P/N A180A009E22;
 - n°4 decals P/N A180A005E22;
6. In accordance with the applicable steps of AMP DM 39-A-11-00-01-00A-720A-A and with reference to Figure 34, install the following decals on the left outer side of the helicopter:
 - n°5 decals P/N A180A016E22;
 - n°4 decal P/N AW003DE005E33B.
7. Repeat step 5 and 6 for the right side of the helicopter.

NOTE

Helicopters equipped with cabin hinged doors must comply with Part II, Part III and Part V of this Service Bulletin before Returning to Service

8. Perform Part II and Part III of this Service Bulletin.
9. 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

3G5630A00911
EMERGENCY EXIT RETRO-MOD
ENANCHED

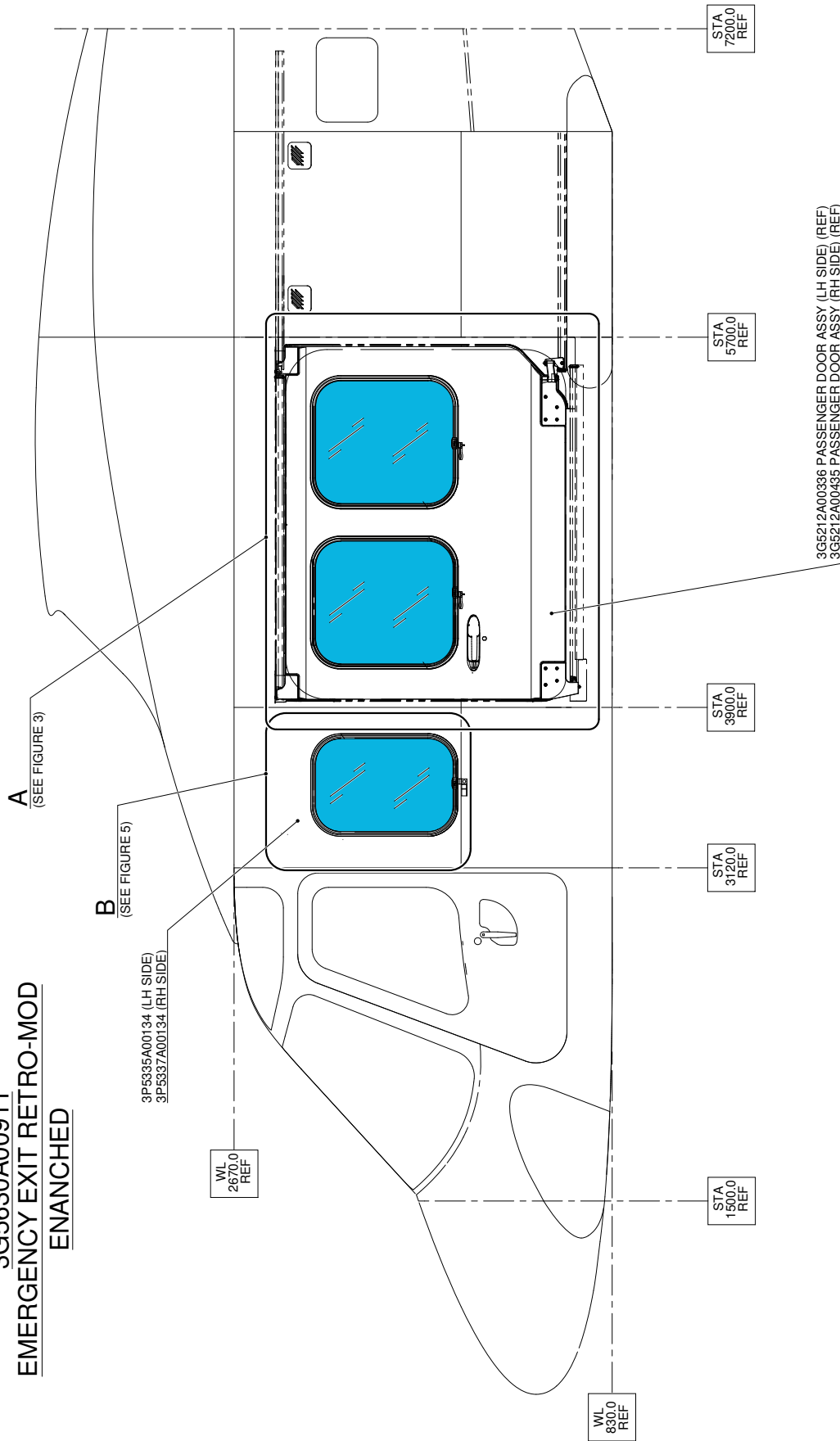


Figure 1

3G5600P01011
EMERGENCY EXIT RETRO-MOD
WINDOW FOR PLUS

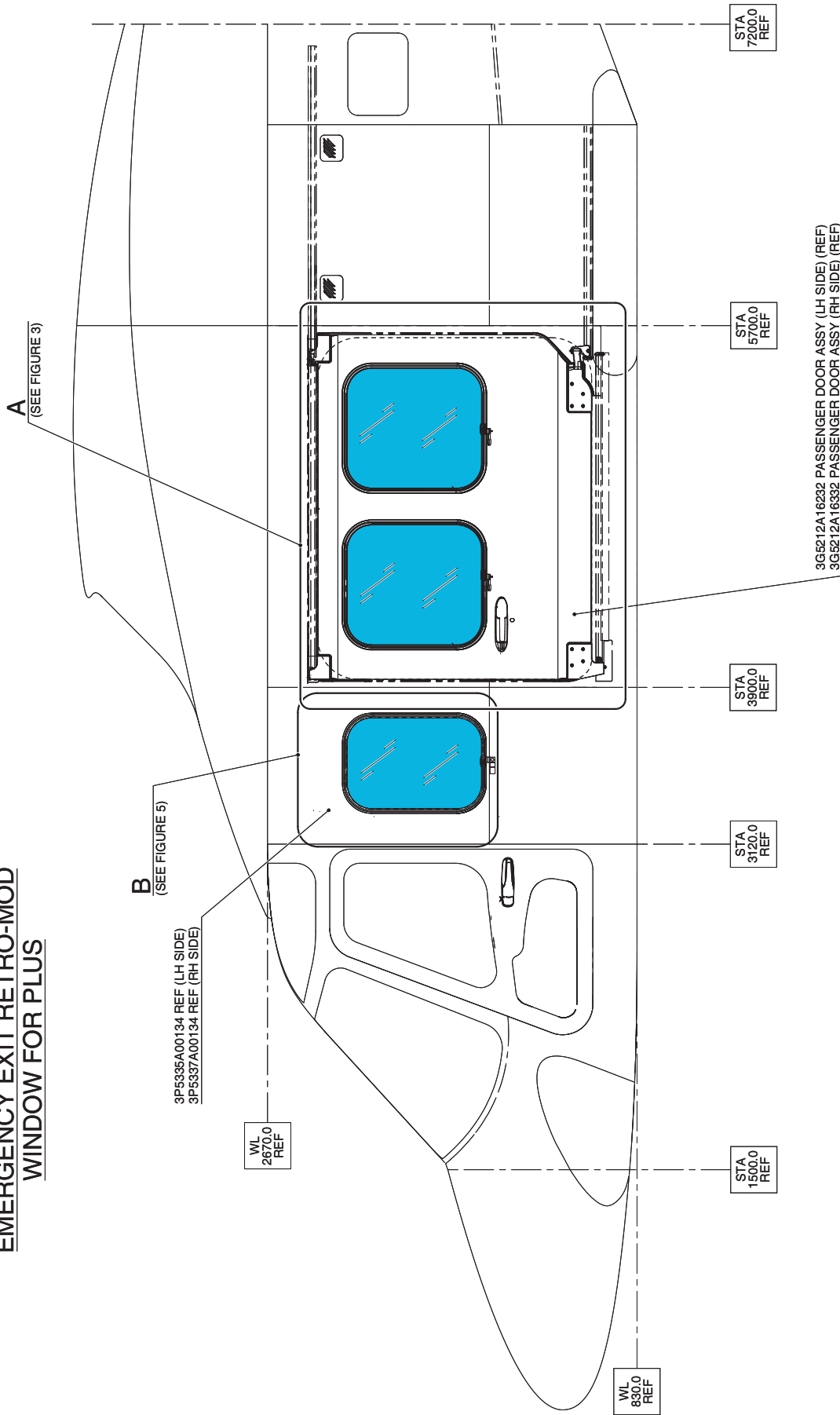


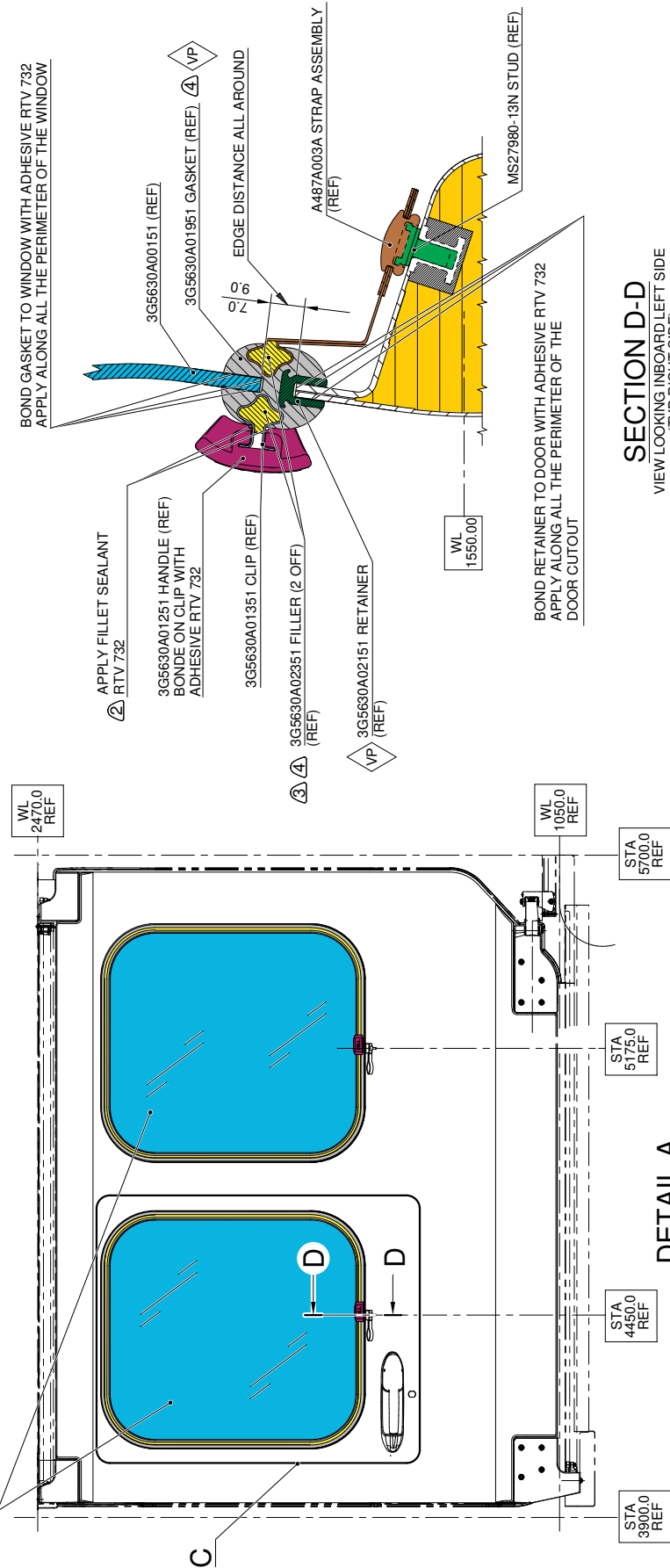
Figure 2

S.B. N°139-694 RECOMMENDED
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REVISION: /

NOTES:

- REMOVE:**
- ① 3G5630A00151 PASSENGER DOOR WINDOW (2 OFF)
 - A417AG002WB2412 EXT.D. RUBBER WINDOW SEAL (2 OFF)
 - A417AF001WB2412EXTD. RUBBER FILLER (4 OFF)
 - A487A003A STRAP ASSEMBLY (2 OFF)
 - MS27980-13N STUD (2 OFF)
- INSTALL:**
- ① 3G5630A00151 PASSENGER DOOR WINDOW (2 OFF) (REF)
 - 3G5630A01951 GASKET (2 OFF)
 - 3G5630A02351 FILLER (4 OFF)
 - 3G5630A02151 RETAINER (2 OFF)
 - 3G5630A02051 RETAINER (2 OFF)
 - 3G5630A02251 RETAINER (4 OFF)
 - A487A003A STRAP ASSEMBLY (2 OFF)
 - MS27980-13N STUD (2 OFF)
 - 3G5630A01251 HANDLE (2 OFF)
 - 3G5630A01351 CLIP (2 OFF)

- ① THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.
- ② APPLY THE FILLET SEALANT ONLY AFTER INSTALLING THE CLIP P/N 3G5630A01351 AND FILLER (P/N 3G5630A02351 AND P/N 3G5630A02951) IN THE GASKET SEAT. THE FILLET SEALANT MUST BE AS LONG AS THE CLIP TO PREVENT THE SQUEEZE OUT GOING ON FILLER INSIDE THE GASKET SEAT.
- ③ ON INTERNAL FUSELAGE SIDE INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW.
- ④ ON EXTERNAL FUSELAGE SIDE:
 - INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW;
 - CHECK IF THERE IS SQUEEZE OUT OF ADHESIVE ALL AROUND THE GASKET, IF NOT, LIFT THE SEAL EDGE AND FILL AGAIN.



SECTION D-D

VIEW LOOKING INBOARD LEFT SIDE
(TYP RIGHT SIDE)
(TYP 2 PLACES)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

DETAIL A

VIEW LOOKING INBOARD LEFT SIDE
(TYP RIGHT SIDE)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 3

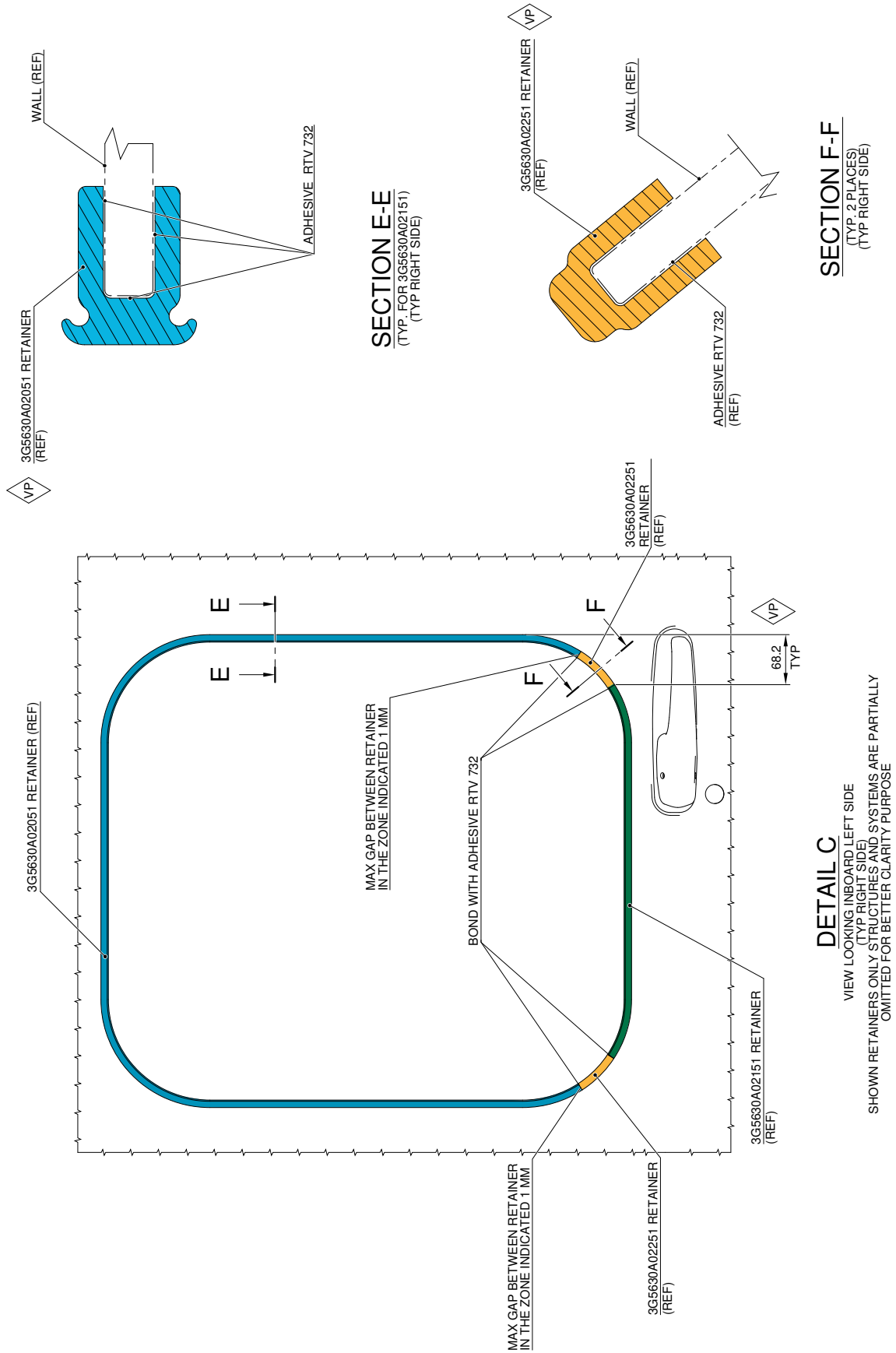
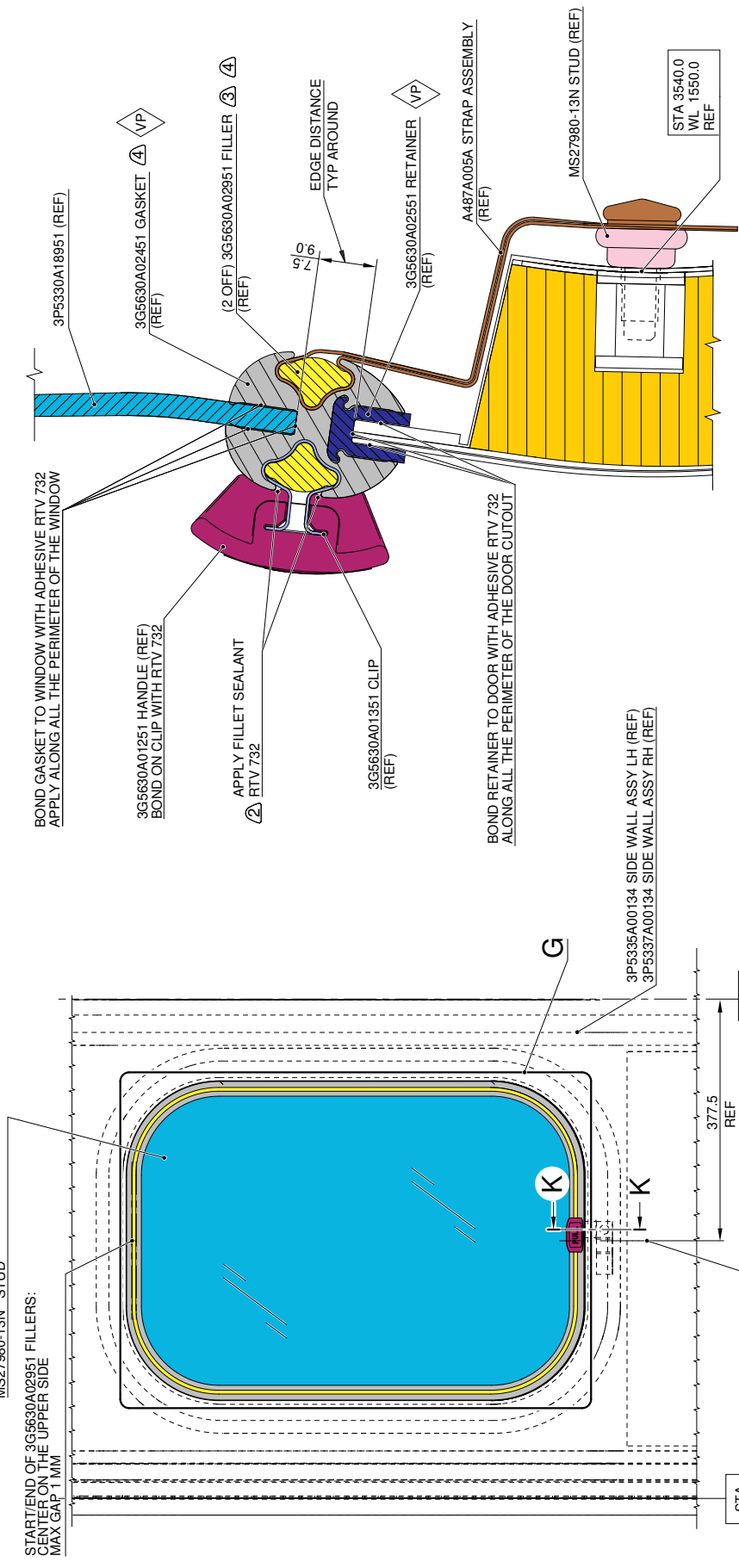


Figure 4

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- REMOVE:**
- 3P5330A18951 WINDOW PANEL
 - A417AG002WB EXTD. RUBBER WINDOW SEAL
 - A417AF001WB EXTD. RUBBER FILLER (2 OFF)
 - A487A005A STRAP ASSEMBLY
 - MS27980-13N STUD
- INSTALL:**
- 3P5330A18951 WINDOW PANEL (REF)
 - 3G5630A02551 RETAINER
 - 3G5630A02651 GASKET
 - 3G5630A02451 FILLER (2 OFF)
 - 3G5630A01251 HANDLE
 - 3G5630A01351 CLIP
 - A487A005A STRAP ASSEMBLY
 - MS27980-13N STUD
- NOTES:**
- ① THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.
 - ② APPLY THE FILLET SEALANT ONLY AFTER INSTALLING THE CLIP P/N 3G5630A01351 AND FILLER (P/N 3G5630A02351 AND P/N 3G5630A02951) IN THE GASKET SEAT. THE FILLET SEALANT MUST BE AS LONG AS THE CLIP TO PREVENT THE SQUEEZE OUT GOING ON FILLER INSIDE THE GASKET SEAT.
 - ③ ON INTERNAL FUSELAGE SIDE INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW.
 - ④ ON EXTERNAL FUSELAGE SIDE:
 - INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW;
 - CHECK IF THERE IS SQUEEZE OUT OF ADHESIVE ALL AROUND THE GASKET, IF NOT, LIFT THE SEAL EDGE AND FILL AGAIN.



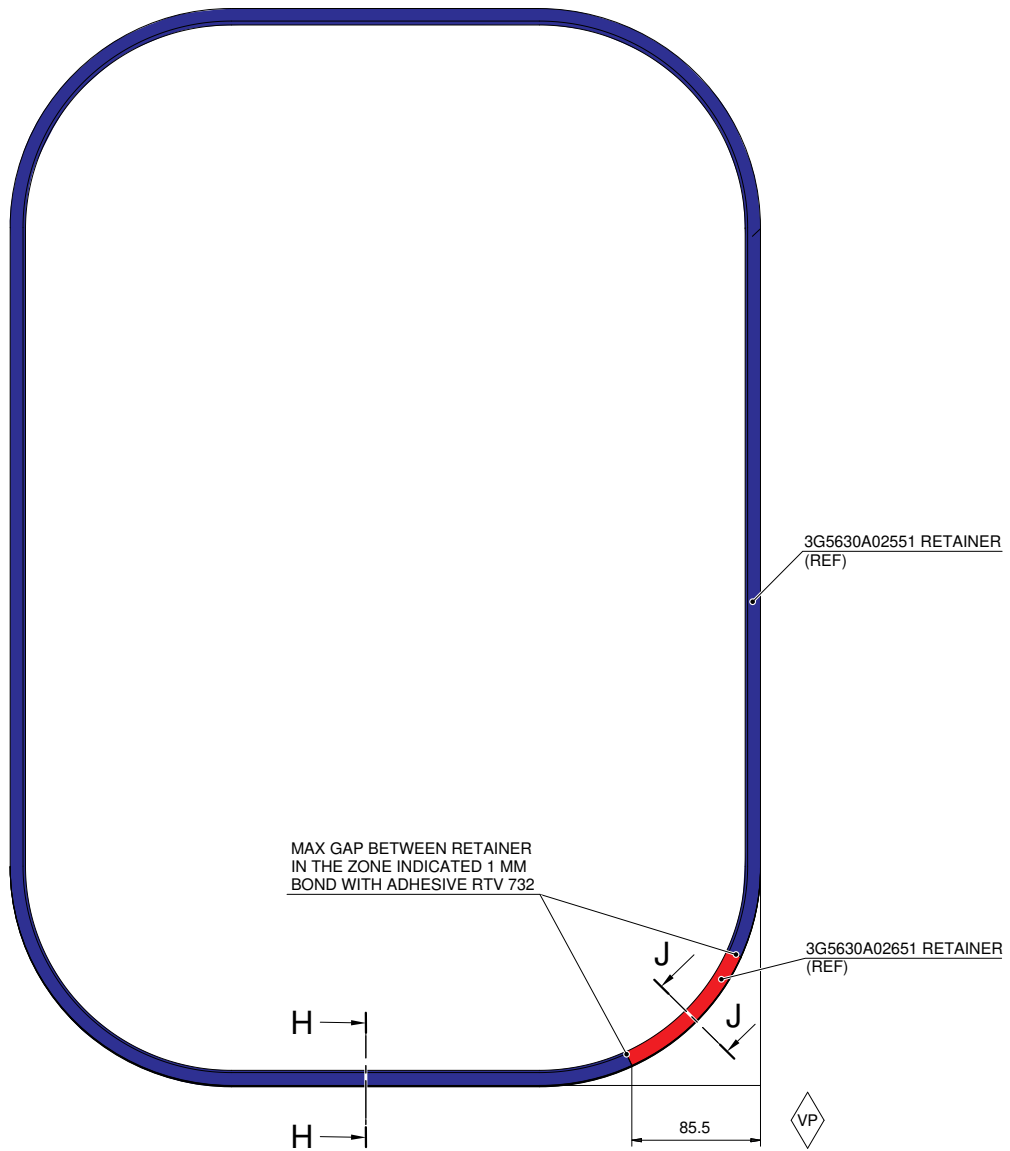
SECTION K-K
(TYP RIGHT SIDE)

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

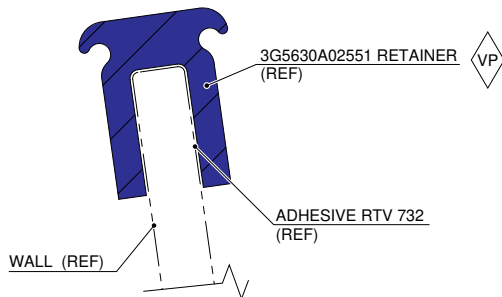
DETAIL B
(TYP RIGHT SIDE)

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

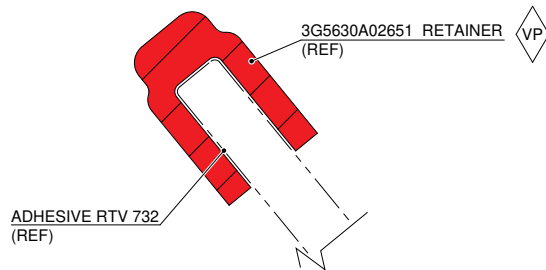
Figure 5



DETAIL G
(TYP RIGHT SIDE)
SHOWN RETAINERS ONLY
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



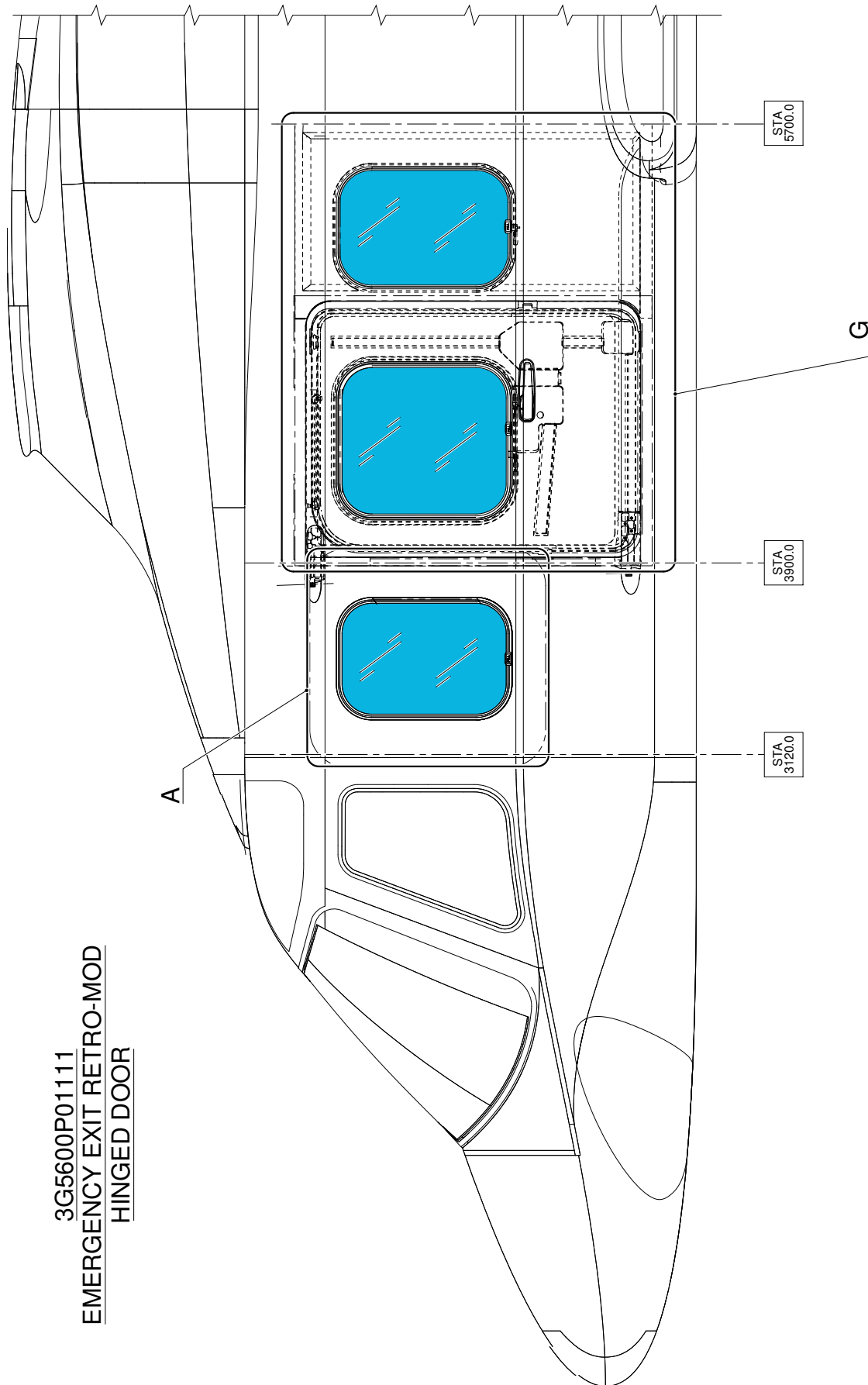
SECTION H-H
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SECTION J-J
STRUCTURES AND SYSTEMS ARE PARTIALLY
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Figure 6

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3G5600P01111
EMERGENCY EXIT RETRO-MOD
HINGED DOOR

Figure 7

NOTE:

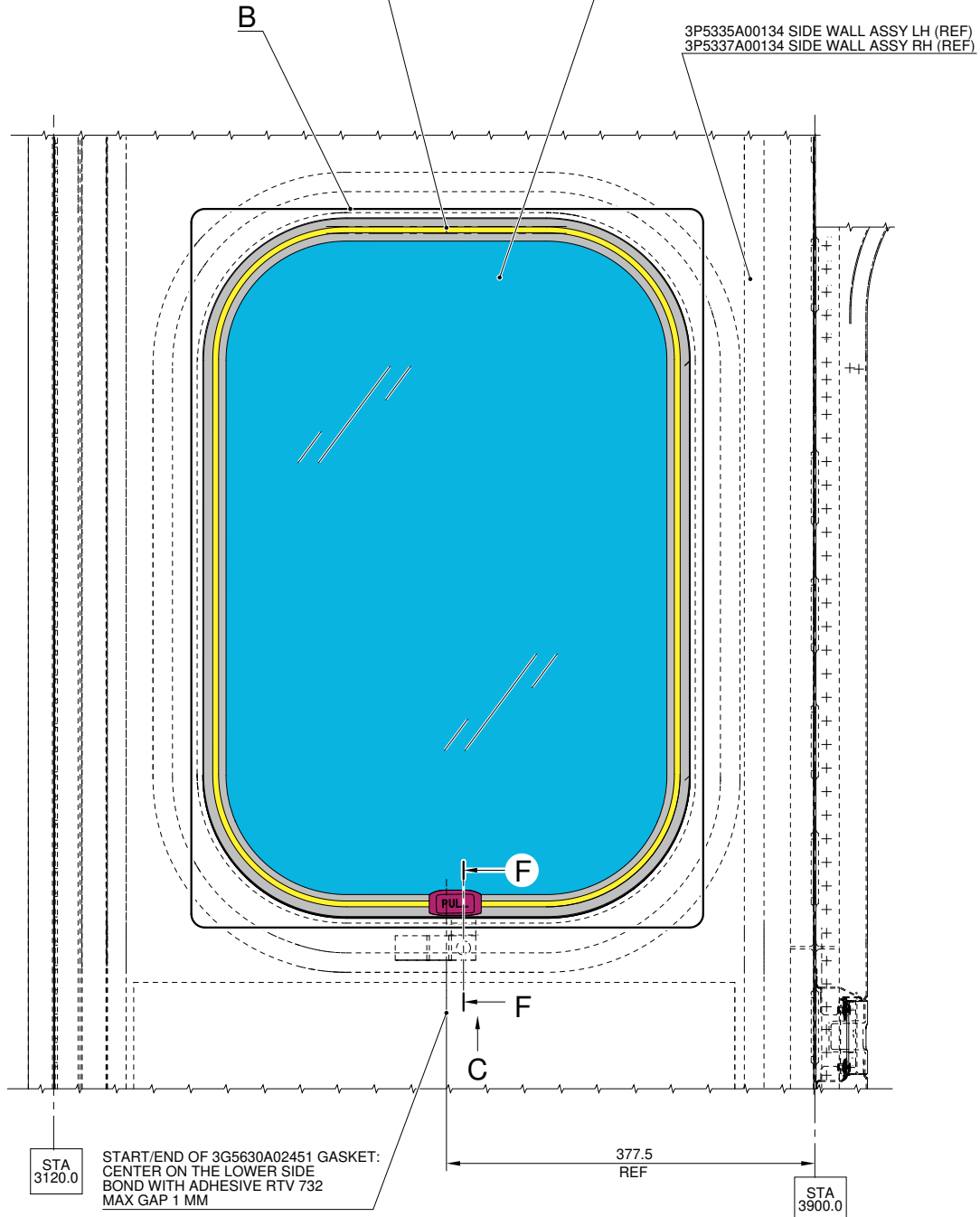
⚠ THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.

REMOVE:
 ① 3P5330A18951 WINDOW PANEL
 A417AG002WB EXT. RUBBER WINDOW SEAL
 A417AF001WB EXT. RUBBER FILLER (2 OFF)
 A487A005A STRAP ASSEMBLY
 MS27980-13N STUD

INSTALL:
 ① 3P5330A18951 WINDOW PANEL (REF)
 3G5630A02551 RETAINER
 3G5630A02651 RETAINER
 3G5630A02451 GASKET
 3G5630A02951 FILLER (2 OFF)
 3G5630A01251 HANDLE
 3G5630A01351 CLIP
 A487A005A STRAP ASSEMBLY
 MS27980-13N STUD

START/END OF 3G5630A02951 FILLERS:
 CENTER ON THE UPPER SIDE
 MAX GAP 1 MM

3P5335A00134 SIDE WALL ASSY LH (REF)
 3P5337A00134 SIDE WALL ASSY RH (REF)



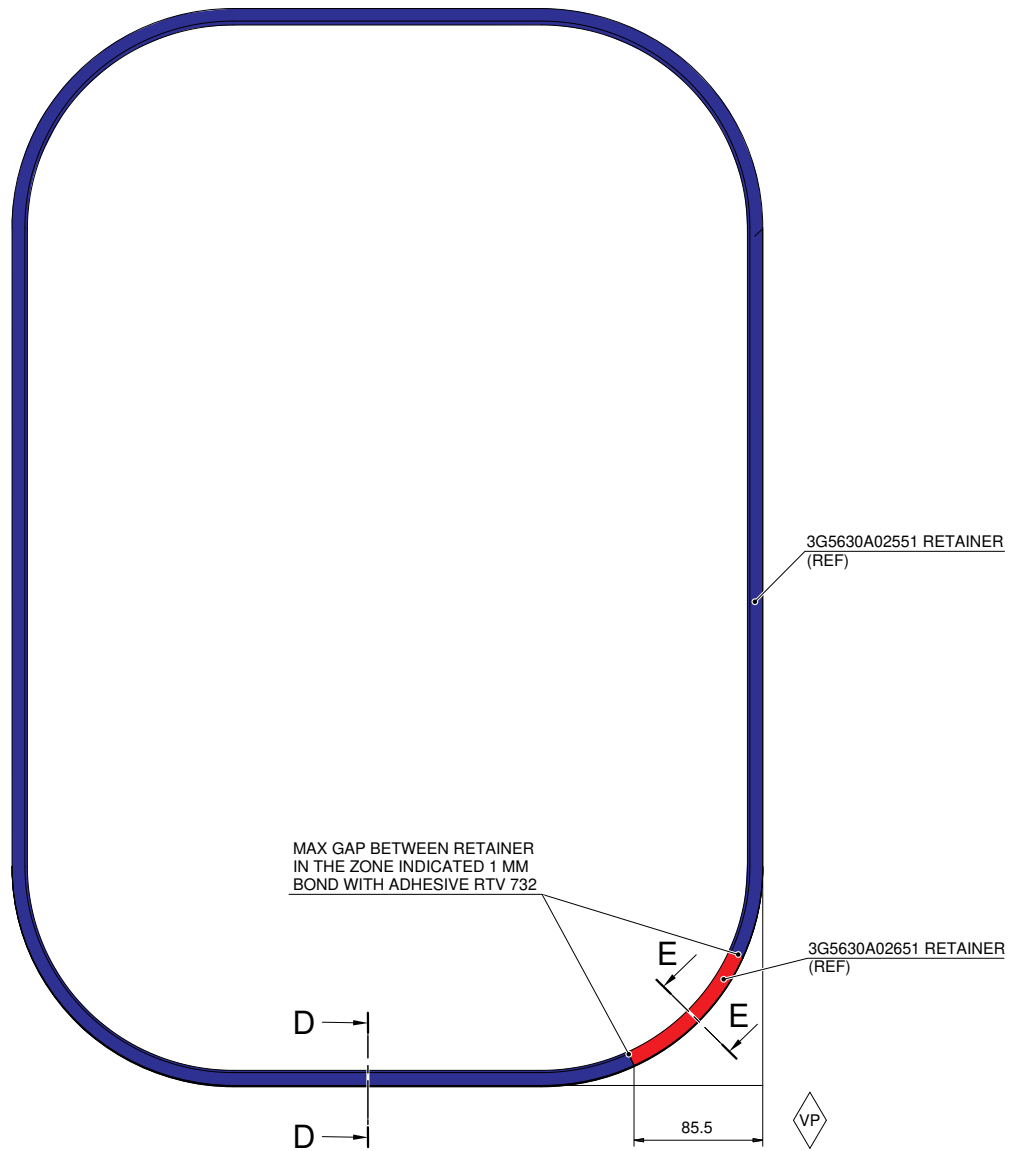
STA 3120.0 START/END OF 3G5630A02451 GASKET:
 CENTER ON THE LOWER SIDE
 BOND WITH ADHESIVE RTV 732
 MAX GAP 1 MM

DETAIL A

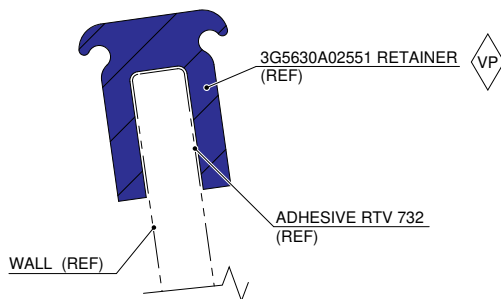
(TYP RIGHT SIDE)
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Figure 8

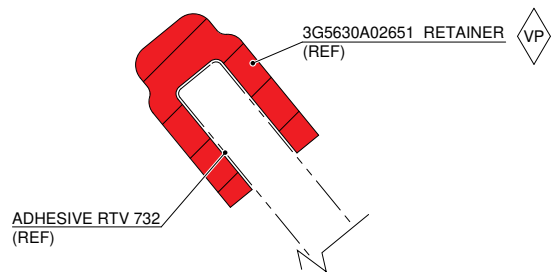
S.B. N°139-694 RECOMMENDED
 DATE: February 28, 2024
 REVISION: /



DETAIL B
(TYP RIGHT SIDE)
SHOWN RETAINERS ONLY
STRUCTURES AND SYSTEMS ARE PARTIALLY
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SECTION D-D
STRUCTURES AND SYSTEMS ARE PARTIALLY
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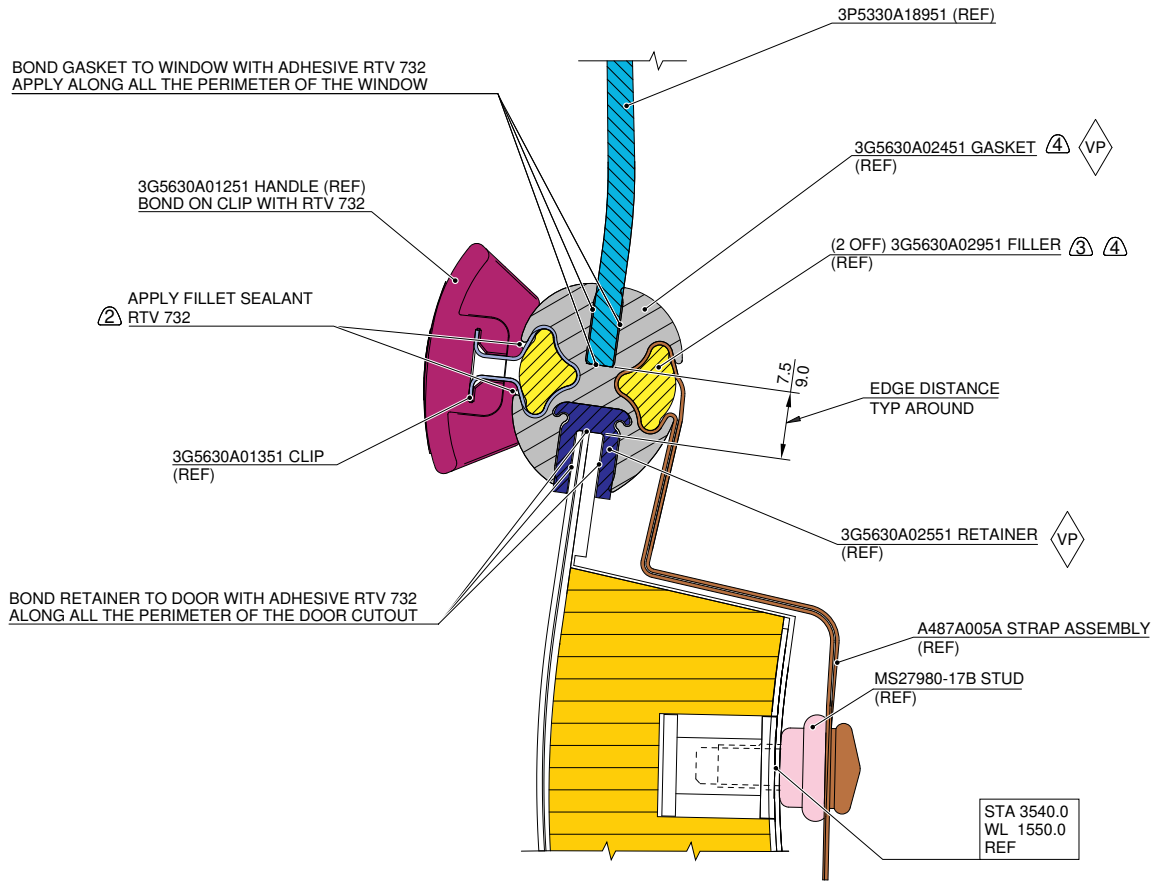


SECTION E-E
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 9

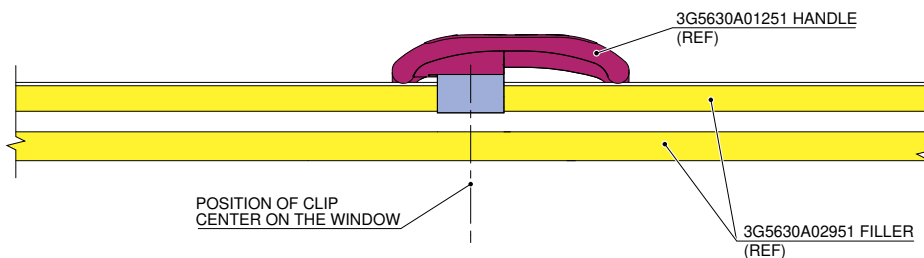
NOTES:

- ② APPLY THE FILLET SEALANT ONLY AFTER INSTALLING THE CLIP P/N 3G5630A01351 AND FILLER (P/N 3G5630A02351 AND P/N 3G5630A02951) IN THE GASKET SEAT. THE FILLET SEALANT MUST BE AS LONG AS THE CLIP TO PREVENT THE SQUEEZE OUT GOING ON FILLER INSIDE THE GASKET SEAT.
- ③ ON INTERNAL FUSELAGE SIDE INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW.
- ④ ON EXTERNAL FUSELAGE SIDE:
 - INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW;
 - CHECK IF THERE IS SQUEEZE OUT OF ADHESIVE ALL AROUND THE GASKET,IF NOT, LIFT THE SEAL EDGE AND FILL AGAIN.



SECTION F-F

STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



VIEW C

(TYP RIGHT SIDE)
SHOWN PULL TABS AND FILLERS ONLY
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 10

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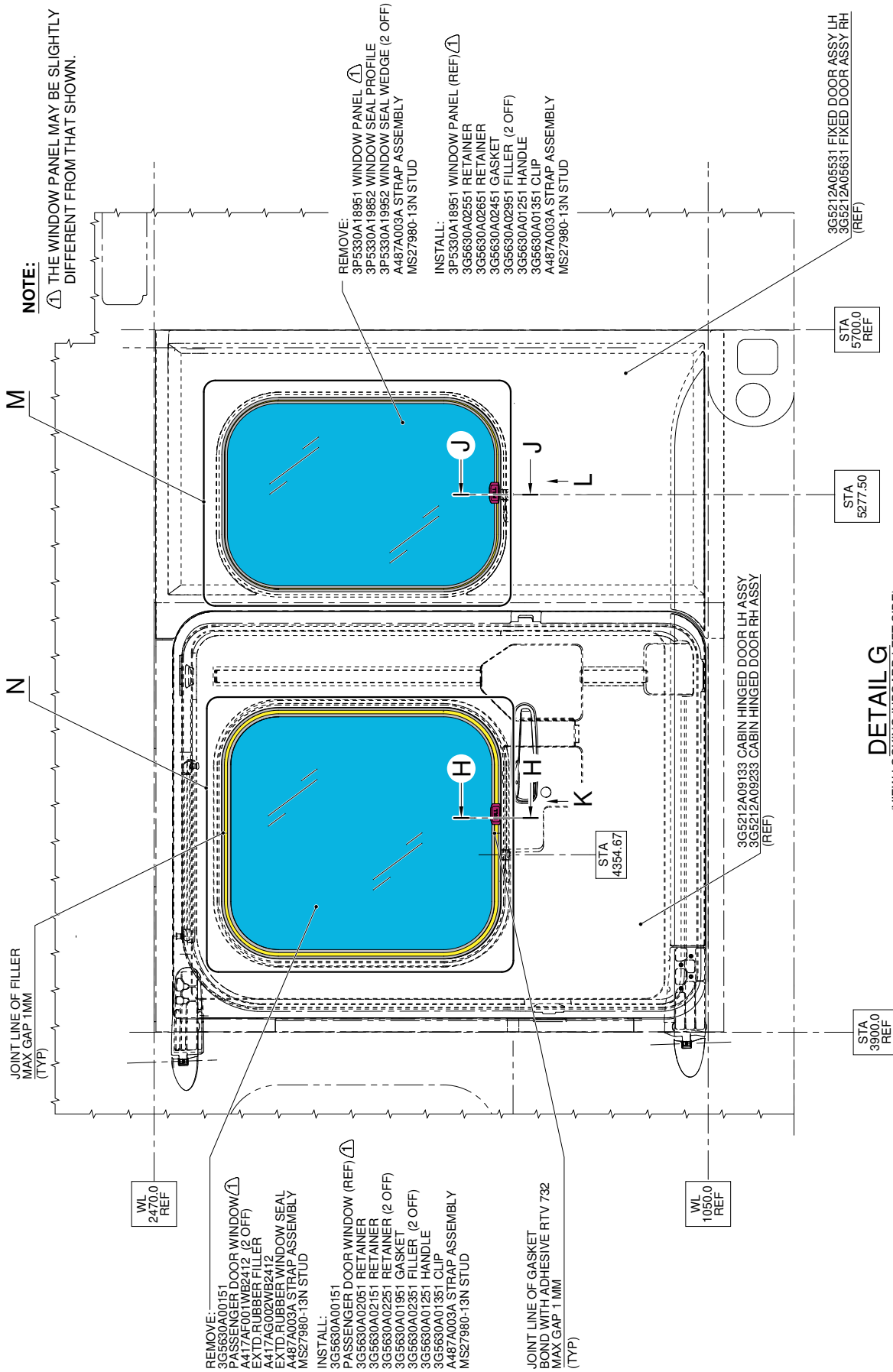
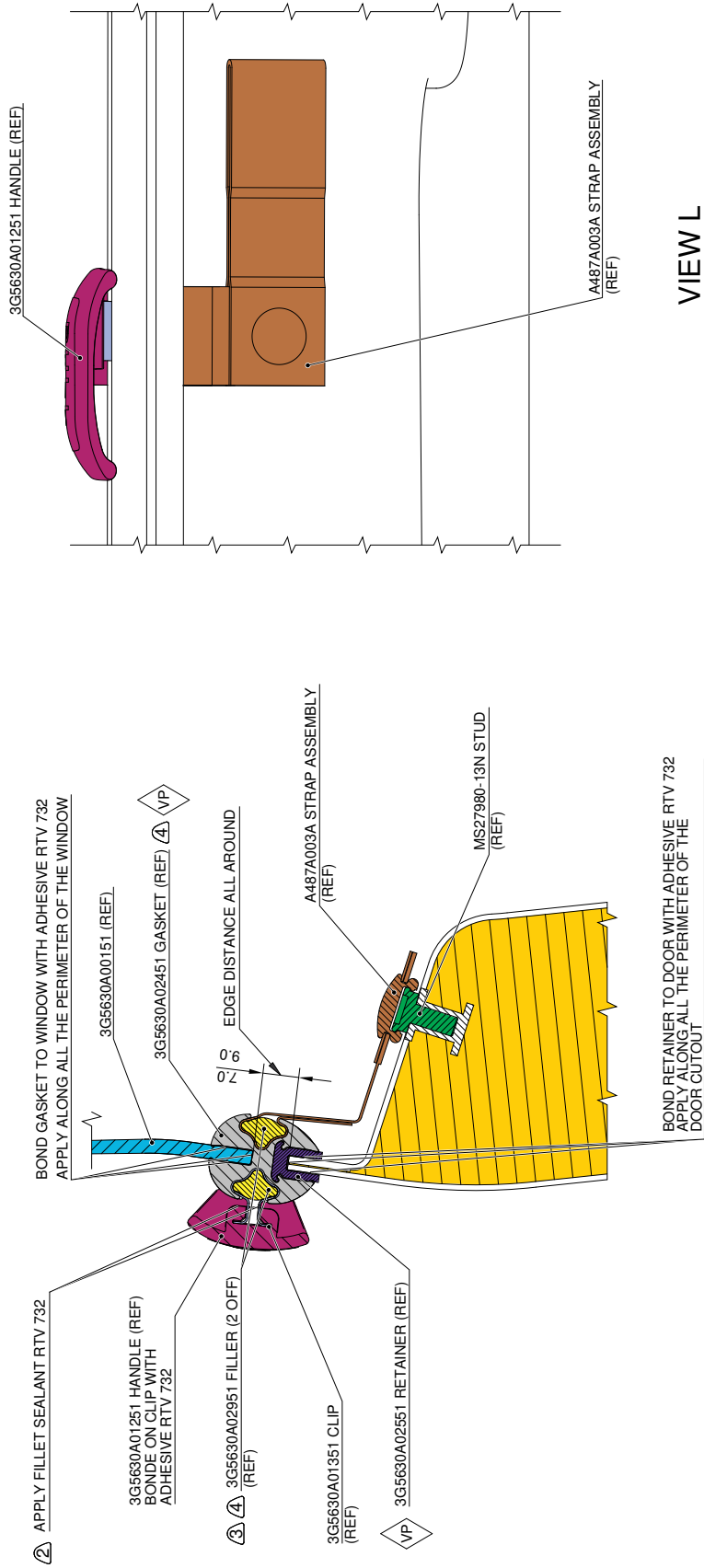


Figure 11

NOTE:

- ② APPLY THE FILLET SEALANT ONLY AFTER INSTALLING THE CLIP P/N 3G5630A01351 AND FILLER (P/N 3G5630A02351 AND P/N 3G5630A02951) IN THE GASKET SEAT. THE FILLET SEALANT MUST BE AS LONG AS THE CLIP TO PREVENT THE SQUEEZE OUT GOING ON FILLER INSIDE THE GASKET SEAT.
- ③ ON INTERNAL FUSELAGE SIDE INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW.
- ④ ON EXTERNAL FUSELAGE SIDE:
 - INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW;
 - CHECK IF THERE IS SQUEEZE OUT OF ADHESIVE ALL AROUND THE GASKET, IF NOT, LIFT THE SEAL EDGE AND FILL AGAIN.



VIEW L

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

SECTION J-J

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 13

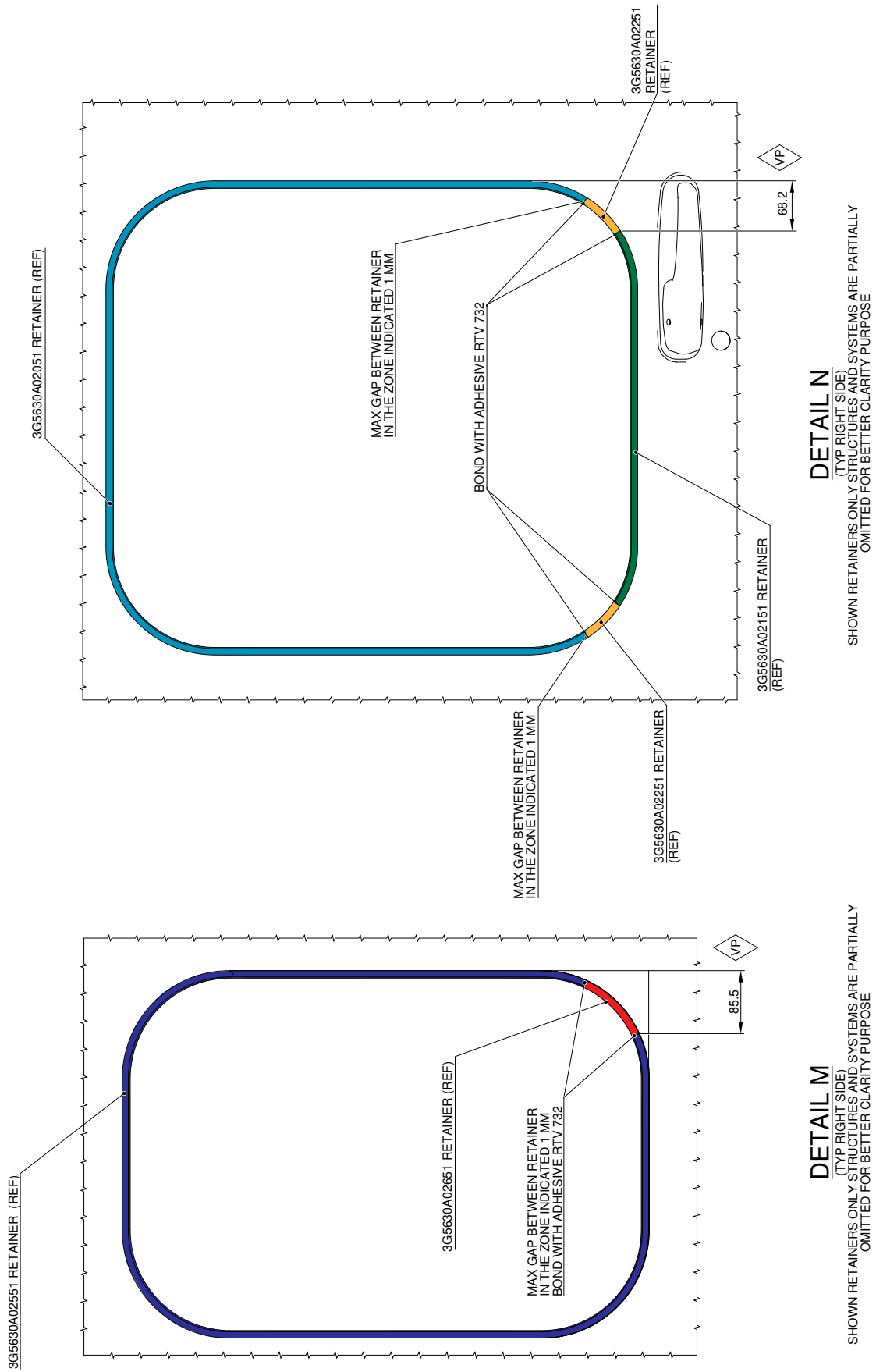


Figure 14

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

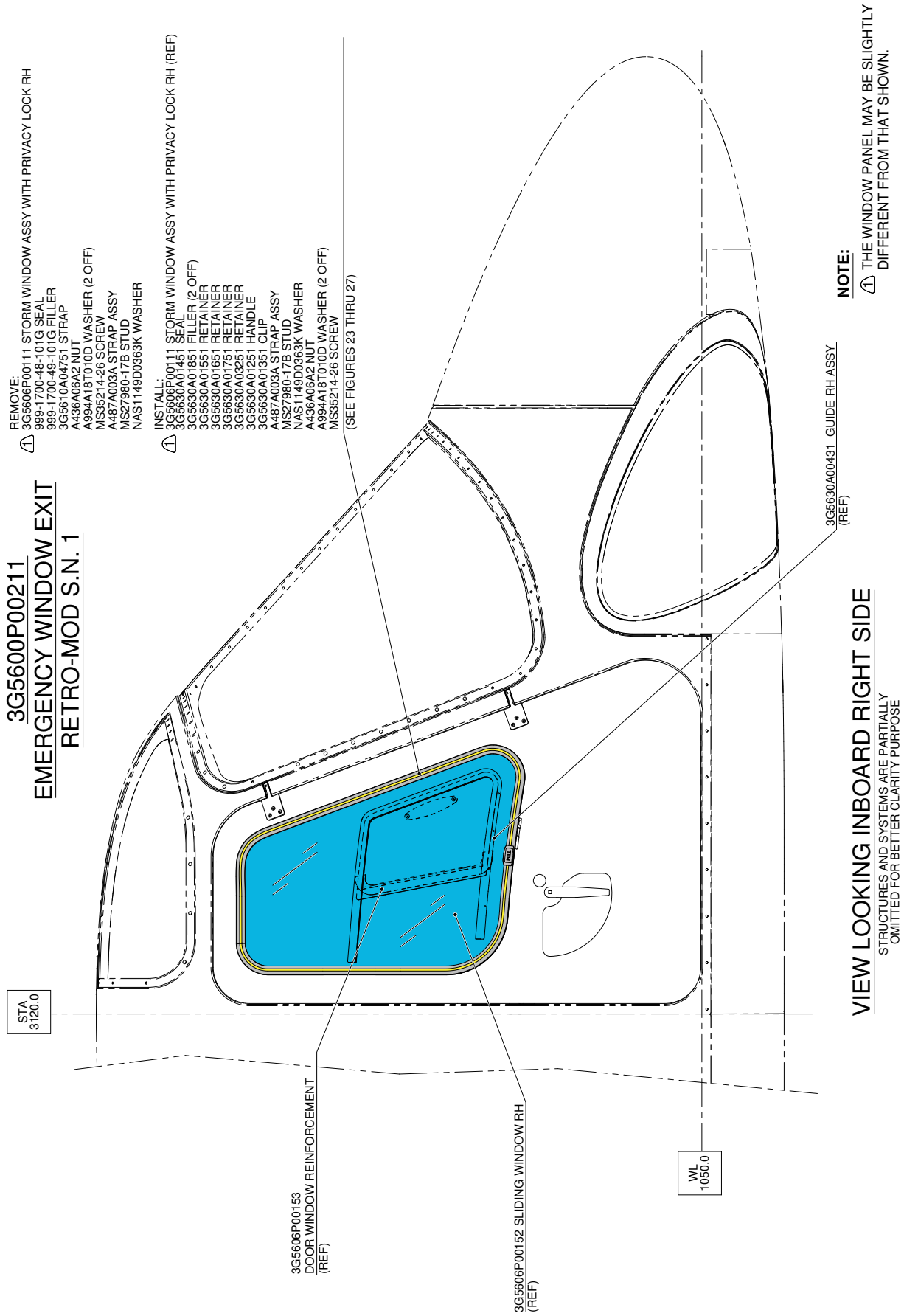


Figure 15

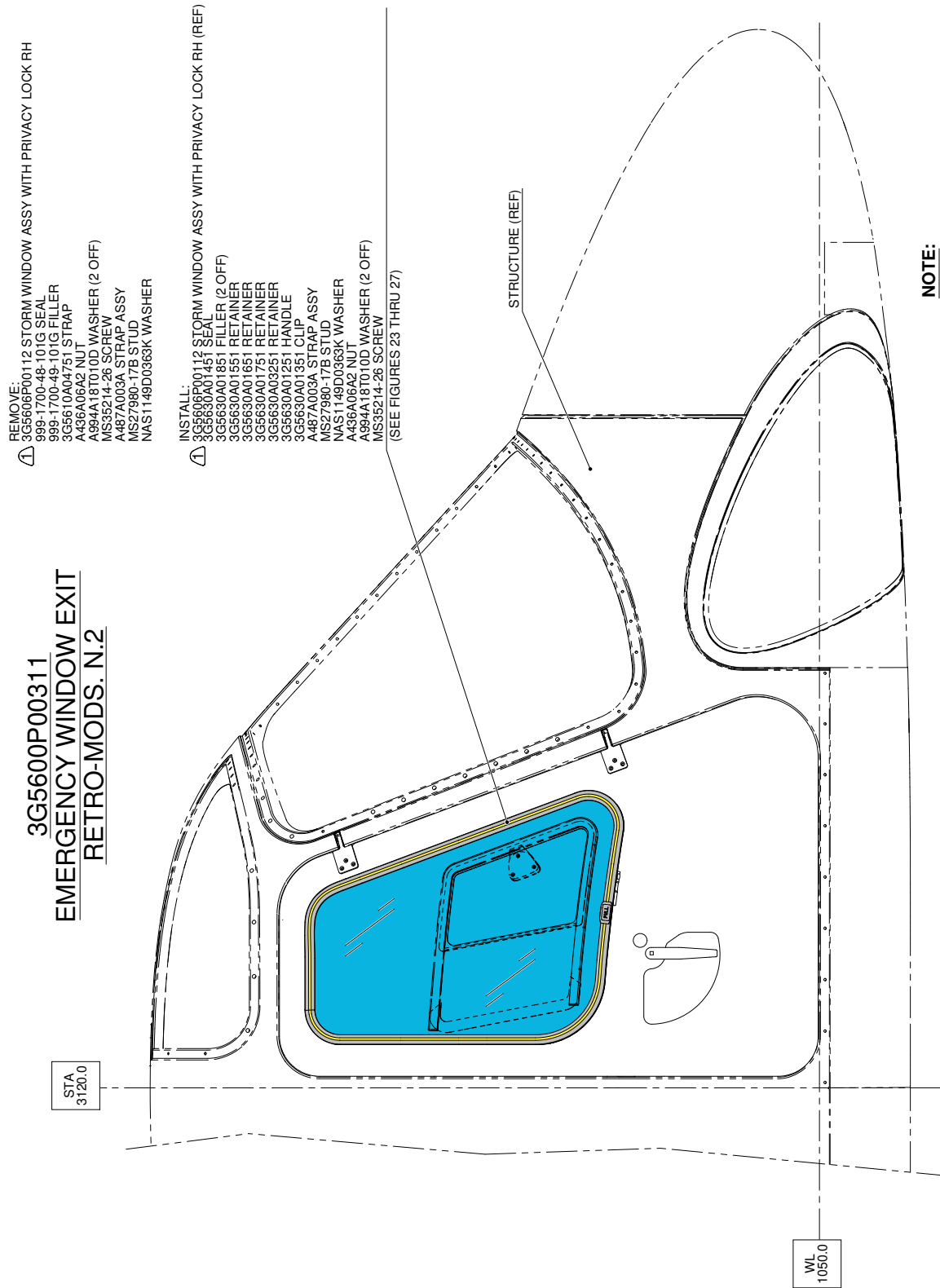




Figure 16


S.B. N°139-694 RECOMMENDED
 DATE: February 28, 2024
 REVISION: /


3G5600P00411
EMERGENCY WINDOW EXIT
RETRO-MOD S.N.3

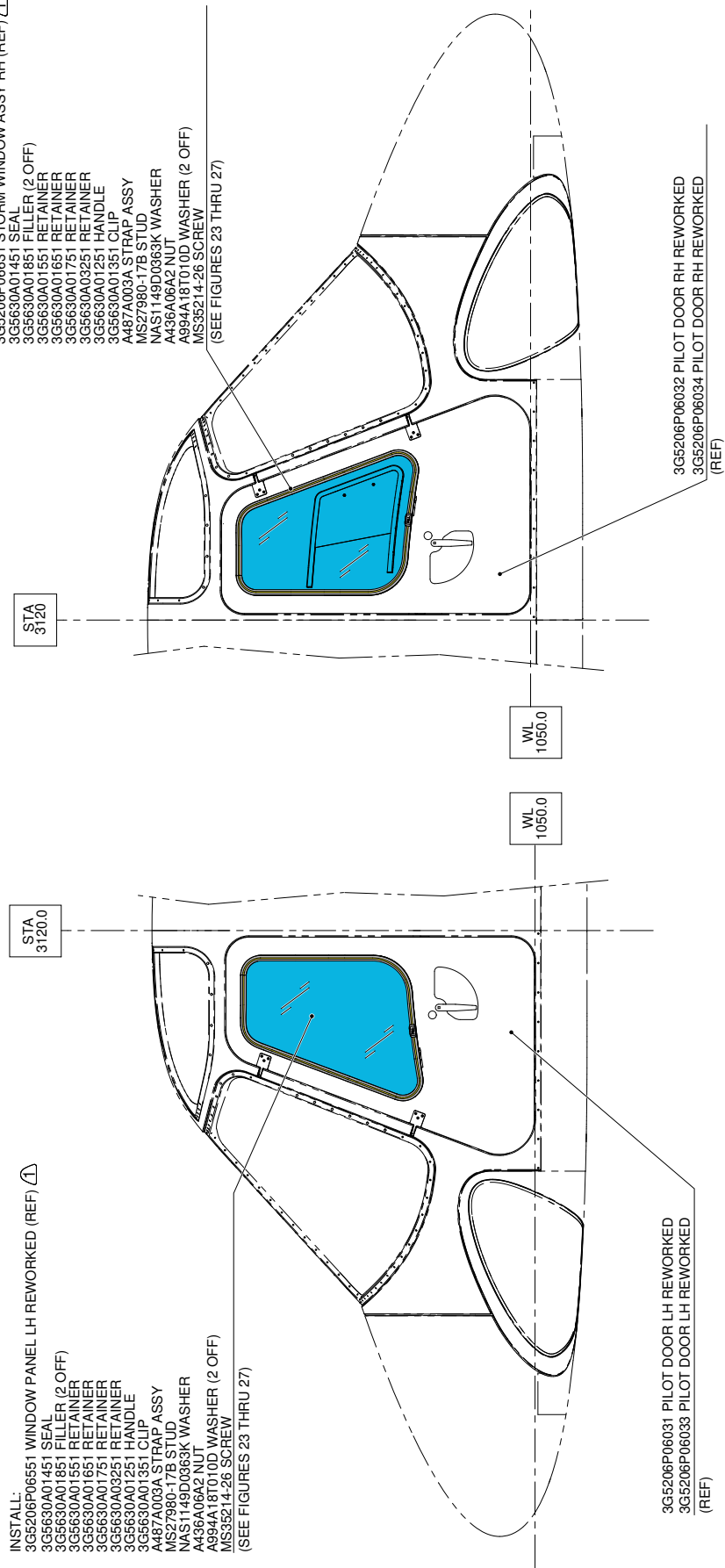
REMOVE:
3G5206P06631 STORM WINDOW ASSY RH (REF) 
989-1700-48-101G SEAL
989-1700-49-101G FILLER
3G5610A04751 STRAP
A436A06A2 NUT
A994A18T010D WASHER (2 OFF)
MS35214-26 SCREW
A487A003A STRAP ASSY
MSZ7980-17B STUD
NAS1149D0363K WASHER

INSTALL:
3G5206P06631 STORM WINDOW ASSY RH (REF) 
3G5630A01451 SEAL
3G5630A01851 FILLER (2 OFF)
3G5630A01551 RETAINER
3G5630A01651 RETAINER
3G5630A01751 RETAINER
3G5630A03251 RETAINER
3G5630A01251 HANDLE
3G5630A01351 CLIP
A487A003A STRAP ASSY
MSZ7980-17B STUD
NAS1149D0363K WASHER
A436A06A2 NUT
A994A18T010D WASHER (2 OFF)
MS35214-26 SCREW
(SEE FIGURES 23 THRU 27)

NOTE:
 THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.

REMOVE:
3G5206P06551 WINDOW PANEL LH REWORKED 
989-1700-48-101G SEAL
989-1700-49-101G FILLER
3G5610A04751 STRAP
A436A06A2 NUT
A994A18T010D WASHER (2 OFF)
MS35214-26 SCREW
A487A003A STRAP ASSY
MSZ7980-17B STUD
NAS1149D0363K WASHER

INSTALL:
3G5206P06551 WINDOW PANEL LH REWORKED (REF) 
3G5630A01451 SEAL
3G5630A01851 FILLER (2 OFF)
3G5630A01551 RETAINER
3G5630A01651 RETAINER
3G5630A01751 RETAINER
3G5630A03251 RETAINER
3G5630A01251 HANDLE
3G5630A01351 CLIP
A487A003A STRAP ASSY
MSZ7980-17B STUD
NAS1149D0363K WASHER
A436A06A2 NUT
A994A18T010D WASHER (2 OFF)
MS35214-26 SCREW
(SEE FIGURES 23 THRU 27)



VIEW LEFT SIDE
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

VIEW RIGHT SIDE
STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

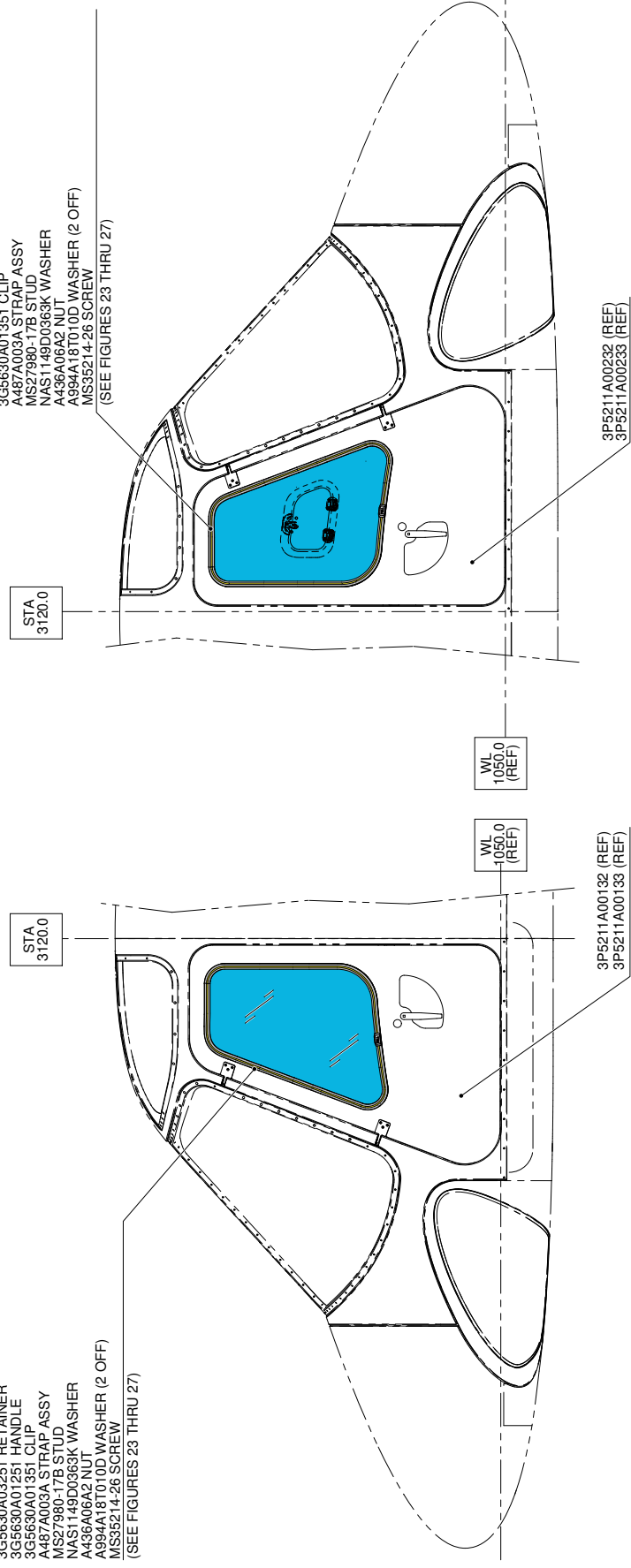
Figure 17

- REMOVE:**
 3G5211A00831 HINGED STORM WINDOW ASSY RH (REF) ⚠
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
- INSTALL:**
 3G5211A00831 HINGED STORM WINDOW ASSY RH (REF) ⚠
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 RETAINER
 3G5630A01351 HANDLE
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)

3G5600P00511
EMERGENCY WINDOW EXIT
RETRO-M0D S.N.4

NOTE:
 ⚠ THE WINDOW PANEL MAY BE SLIGHTLY
 DIFFERENT FROM THAT SHOWN.

- REMOVE:**
 3G5211A01351 WINDOW PANEL LH REWORKED ⚠
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
- INSTALL:**
 3G5211A01351 WINDOW PANEL LH REWORKED (REF) ⚠
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 RETAINER
 3G5630A01351 HANDLE
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)



VIEW LOOKING INBOARD RIGHT SIDE
 STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

VIEW LOOKING INBOARD LEFT SIDE
 STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

Figure 18

3G5600P00611
EMERGENCY EXIT RETRO-MOD

L.N. 1

- REMOVE:**
- 3G5206P06551 WINDOW PANEL LH REWORKED (REF)
 - 999-1700-48-101G SEAL
 - 999-1700-49-101G FILLER
 - 3G5610A04751 STRAP
 - A436A06A2 NUT
 - A994A18T010D WASHER (2 OFF)
 - MS35214-26 SCREW
 - A487A003A STRAP ASSY
 - MS27980-17B STUD
 - NAS1149D0363K WASHER

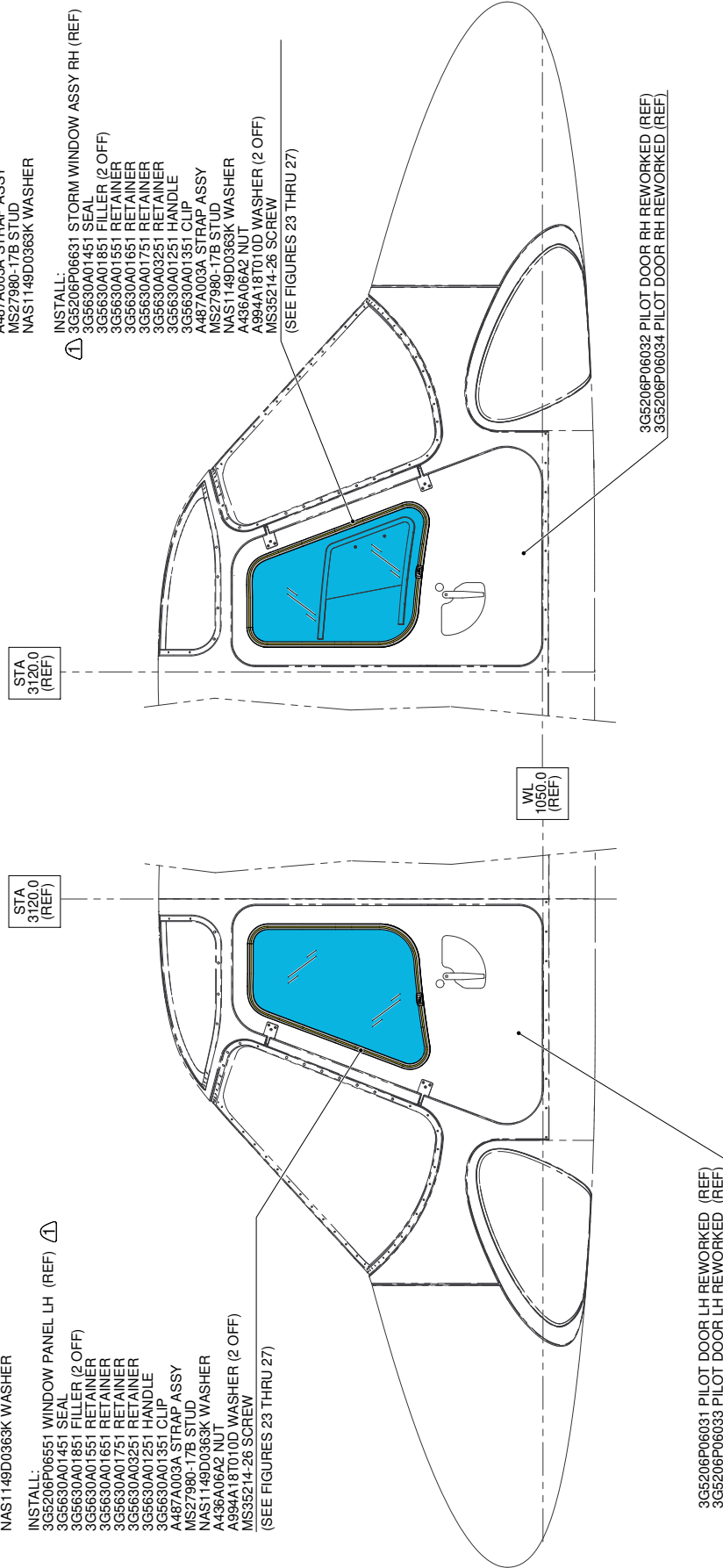
- INSTALL:**
- 3G5206P06551 WINDOW PANEL LH (REF) (A)
 - 3G5630A01451 SEAL
 - 3G5630A01851 FILLER (2 OFF)
 - 3G5630A01551 RETAINER
 - 3G5630A01651 RETAINER
 - 3G5630A01751 RETAINER
 - 3G5630A03251 RETAINER
 - 3G5630A01251 HANDLE
 - 3G5630A01351 CLIP
 - A487A003A STRAP ASSY
 - MS27980-17B STUD
 - NAS1149D0363K WASHER
 - A436A06A2 NUT
 - A994A18T010D WASHER (2 OFF)
 - MS35214-26 SCREW
- (SEE FIGURES 23 THRU 27)

NOTE:

- (A) THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.

- REMOVE:**
- (A) 3G5206P06631 STORM WINDOW ASSY RH
 - 999-1700-48-101G SEAL
 - 999-1700-49-101G FILLER
 - 3G5610A04751 STRAP
 - A436A06A2 NUT
 - A994A18T010D WASHER (2 OFF)
 - MS35214-26 SCREW
 - A487A003A STRAP ASSY
 - MS27980-17B STUD
 - NAS1149D0363K WASHER

- INSTALL:**
- (A) 3G5206P06631 STORM WINDOW ASSY RH (REF)
 - 3G5630A01451 SEAL
 - 3G5630A01851 FILLER (2 OFF)
 - 3G5630A01551 RETAINER
 - 3G5630A01651 RETAINER
 - 3G5630A01751 RETAINER
 - 3G5630A03251 RETAINER
 - 3G5630A01251 HANDLE
 - 3G5630A01351 CLIP
 - A487A003A STRAP ASSY
 - MS27980-17B STUD
 - NAS1149D0363K WASHER
 - A436A06A2 NUT
 - A994A18T010D WASHER (2 OFF)
 - MS35214-26 SCREW
- (SEE FIGURES 23 THRU 27)



VIEW LOOKING INBOARD LEFT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

VIEW LOOKING INBOARD RIGHT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 19

3G5600P00711
EMERGENCY EXIT RETRO-MOD
L.N 2

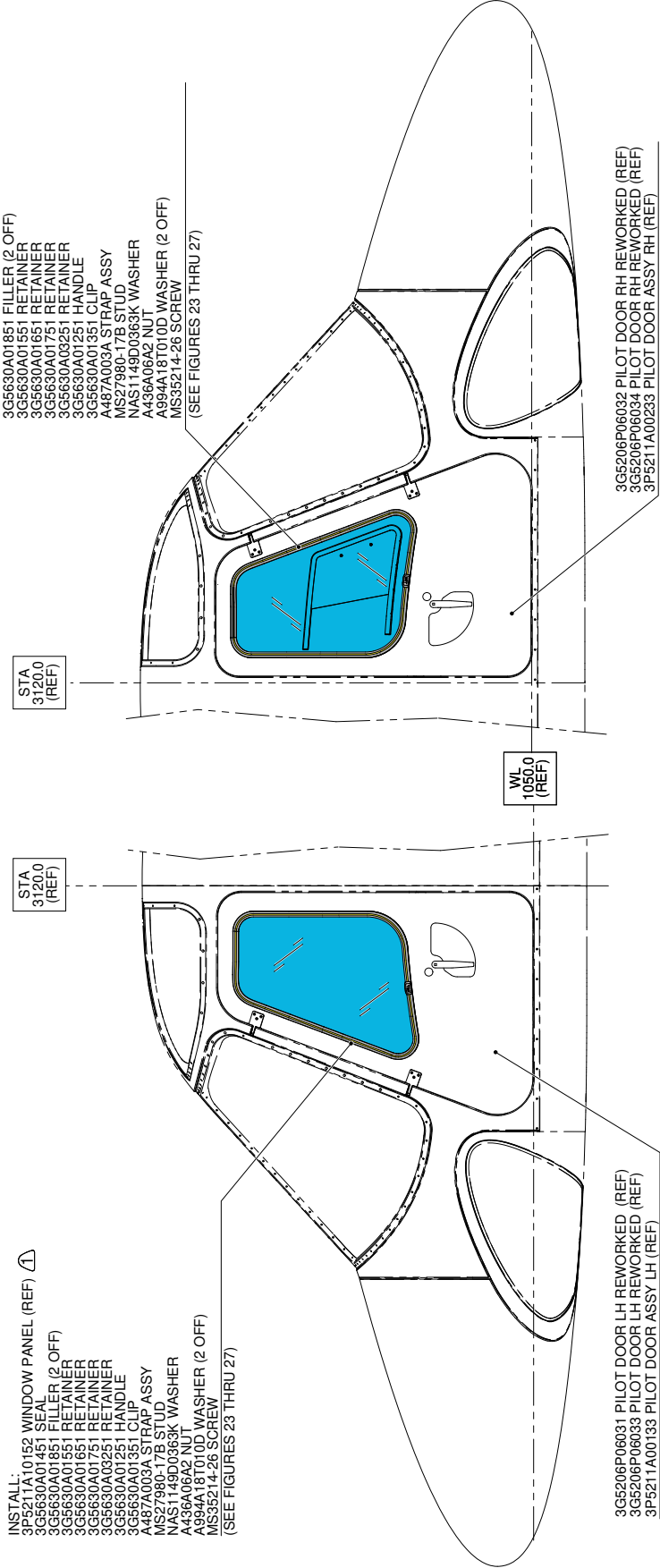
REMOVE:
 3P5211A48131 STORM WINDOW ASSY RH
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

NOTE:
 ⚠ THE WINDOW PANEL MAY BE SLIGHTLY
 DIFFERENT FROM THAT SHOWN.

INSTALL:
 3P5211A48131 STORM WINDOW ASSY RH (REF)
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 RETAINER
 3G5630A01251 HANDLE
 3G5630A01351 CLIP
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)

REMOVE:
 3P5211A10152 WINDOW PANEL ⚠
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

INSTALL:
 3P5211A10152 WINDOW PANEL (REF) ⚠
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 RETAINER
 3G5630A01251 HANDLE
 3G5630A01351 CLIP
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)



3G5206P06032 PILOT DOOR RH REWORKED (REF)
 3G5206P06034 PILOT DOOR RH REWORKED (REF)
 3P5211A00233 PILOT DOOR ASSY RH (REF)

3G5206P06031 PILOT DOOR LH REWORKED (REF)
 3G5206P06033 PILOT DOOR LH REWORKED (REF)
 3P5211A00133 PILOT DOOR ASSY LH (REF)

VIEW LOOKING INBOARD RIGHT SIDE
 STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

VIEW LOOKING INBOARD LEFT SIDE
 STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

Figure 20

3G5600P00811
EMERGENCY EXIT RETRO-MOD
L.N. 3

REMOVE:
 3G5211A01351 WINDOW PANEL LH (REF) (1)
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

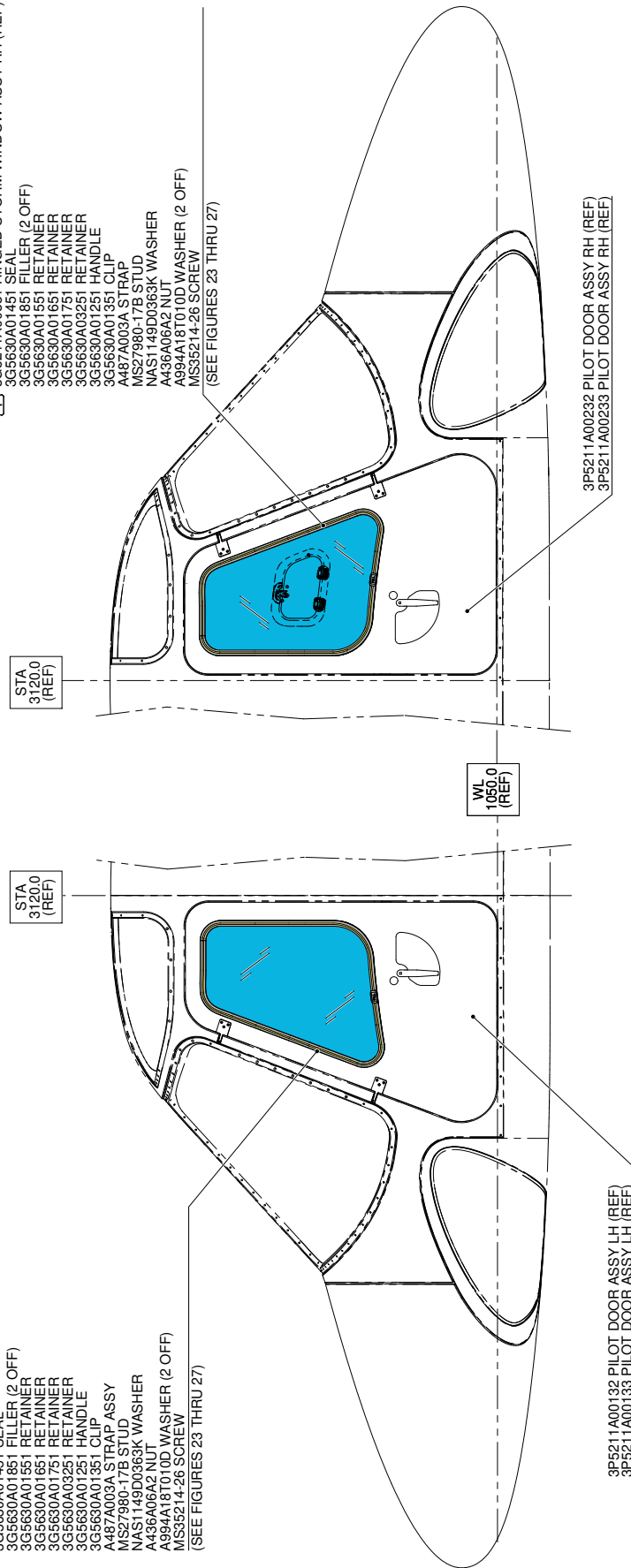
NOTE:

(1) THE WINDOW PANEL MAY BE SLIGHTLY
 DIFFERENT FROM THAT SHOWN.

REMOVE:
 3G5211A00831 HINGED STORM WINDOW ASSY RH
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

INSTALL:
 3G5211A01351 WINDOW PANEL LH (REF) (1)
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01651 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 HANDLE
 3G5630A01351 CLIP
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)

INSTALL:
 3G5211A00831 HINGED STORM WINDOW ASSY RH (REF)
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01651 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 HANDLE
 3G5630A01351 CLIP
 A487A003A STRAP
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)



VIEW LOOKING INBOARD LEFT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

VIEW LOOKING INBOARD RIGHT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY
 OMITTED FOR BETTER CLARITY PURPOSE

Figure 21

3G5600P01011 EMERGENCY EXIT RETRO-MOD WINDOW FOR PLUS

REMOVE:
 3G5211A01351 WINDOW PANEL LH (REF) ⚠
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

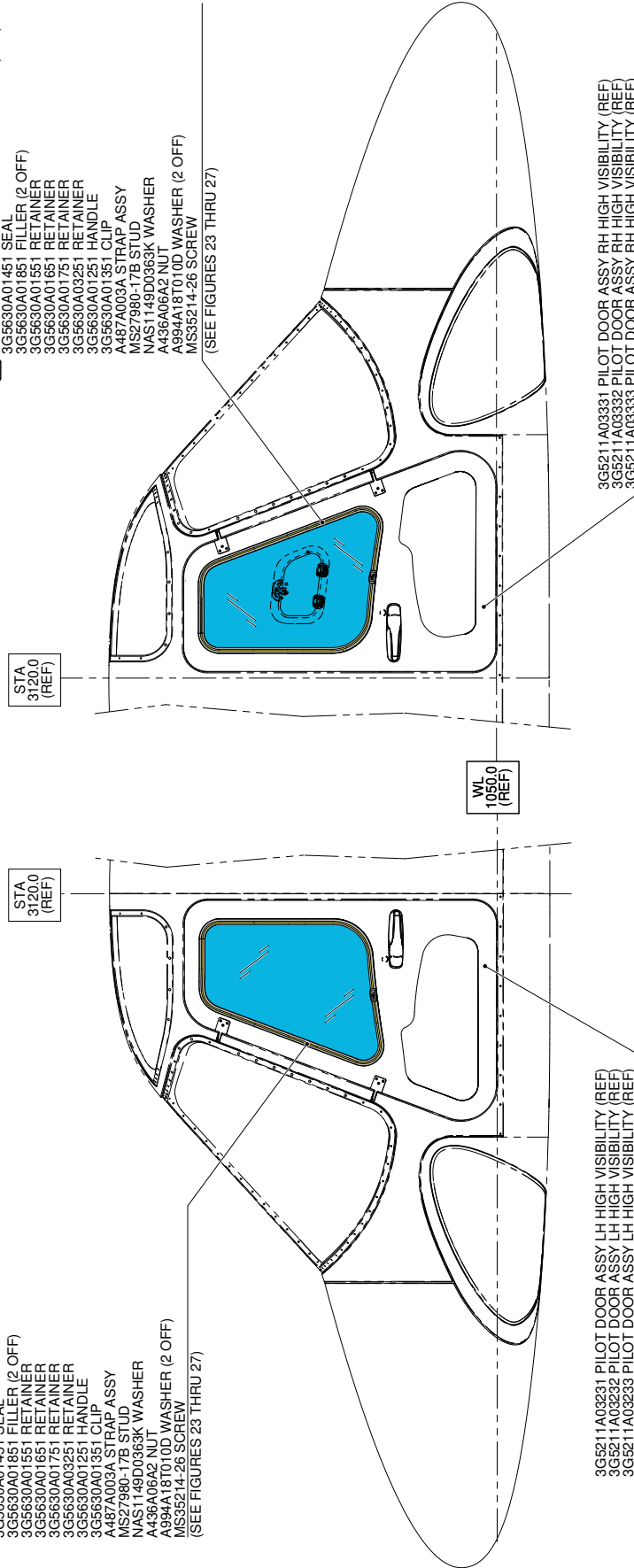
NOTE:

⚠ THE WINDOW PANEL MAY BE SLIGHTLY DIFFERENT FROM THAT SHOWN.

REMOVE:
 3G5211A00832 STORM WINDOW ASSY RH
 999-1700-48-101G SEAL
 999-1700-49-101G FILLER
 3G5610A04751 STRAP
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER

INSTALL:
 3G5211A01351 WINDOW PANEL LH (REF) ⚠
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01651 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 HANDLE
 3G5630A01251 CLIP
 3G5630A01351 CLIP
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)

INSTALL:
 3G5211A00832 STORM WINDOW ASSY RH (REF) ⚠
 3G5630A01451 SEAL
 3G5630A01851 FILLER (2 OFF)
 3G5630A01551 RETAINER
 3G5630A01651 RETAINER
 3G5630A01751 RETAINER
 3G5630A03251 HANDLE
 3G5630A01251 CLIP
 3G5630A01351 CLIP
 A487A003A STRAP ASSY
 MS27980-17B STUD
 NAS1149D0363K WASHER
 A436A06A2 NUT
 A994A18T010D WASHER (2 OFF)
 MS35214-26 SCREW
 (SEE FIGURES 23 THRU 27)



VIEW LOOKING INBOARD LEFT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

VIEW LOOKING INBOARD RIGHT SIDE

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 22

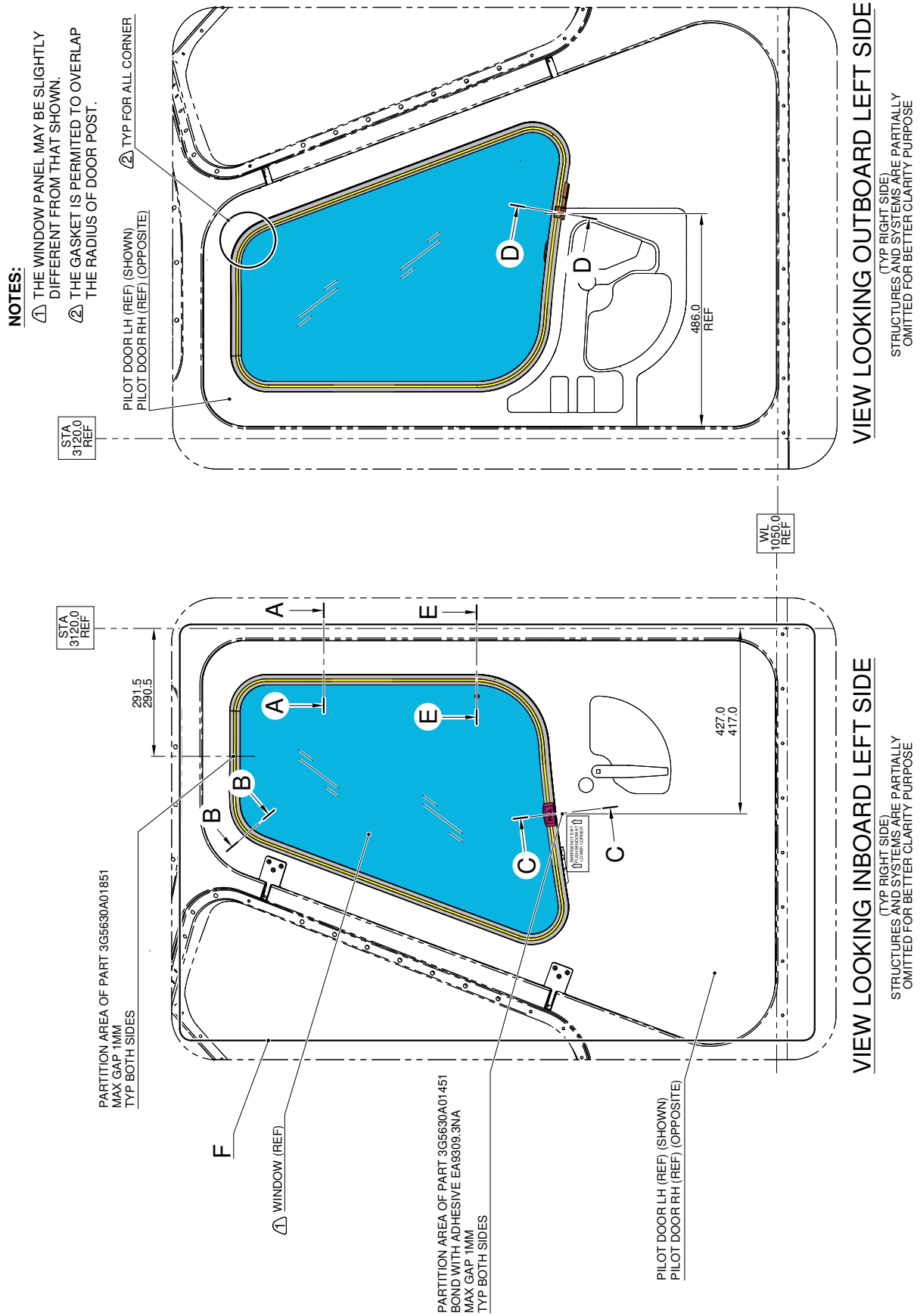
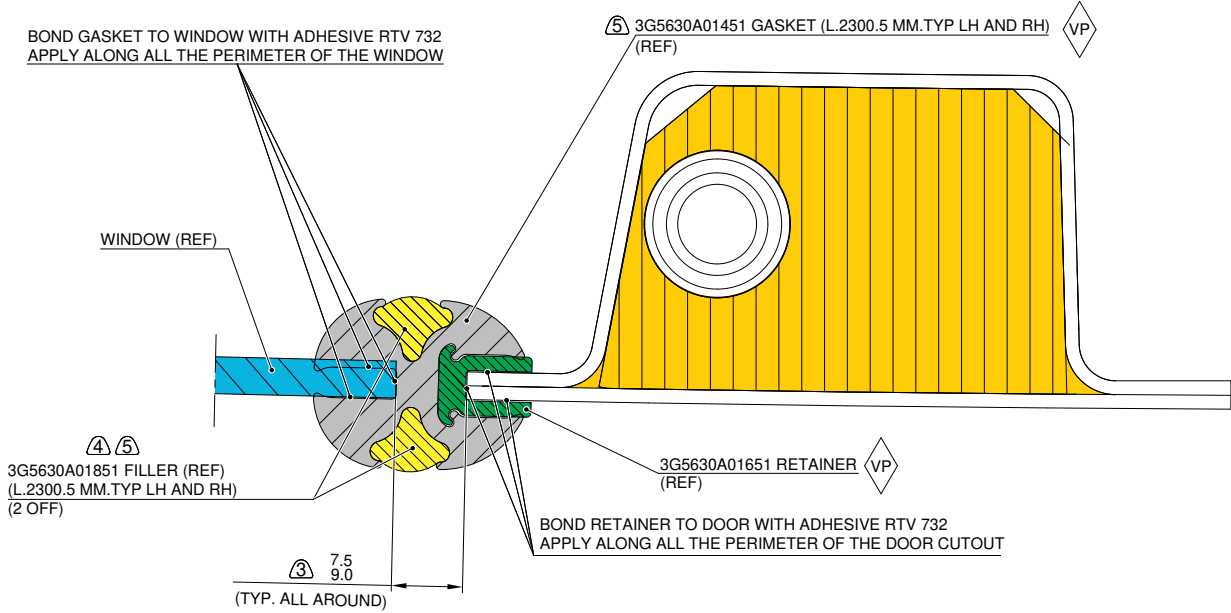


Figure 23

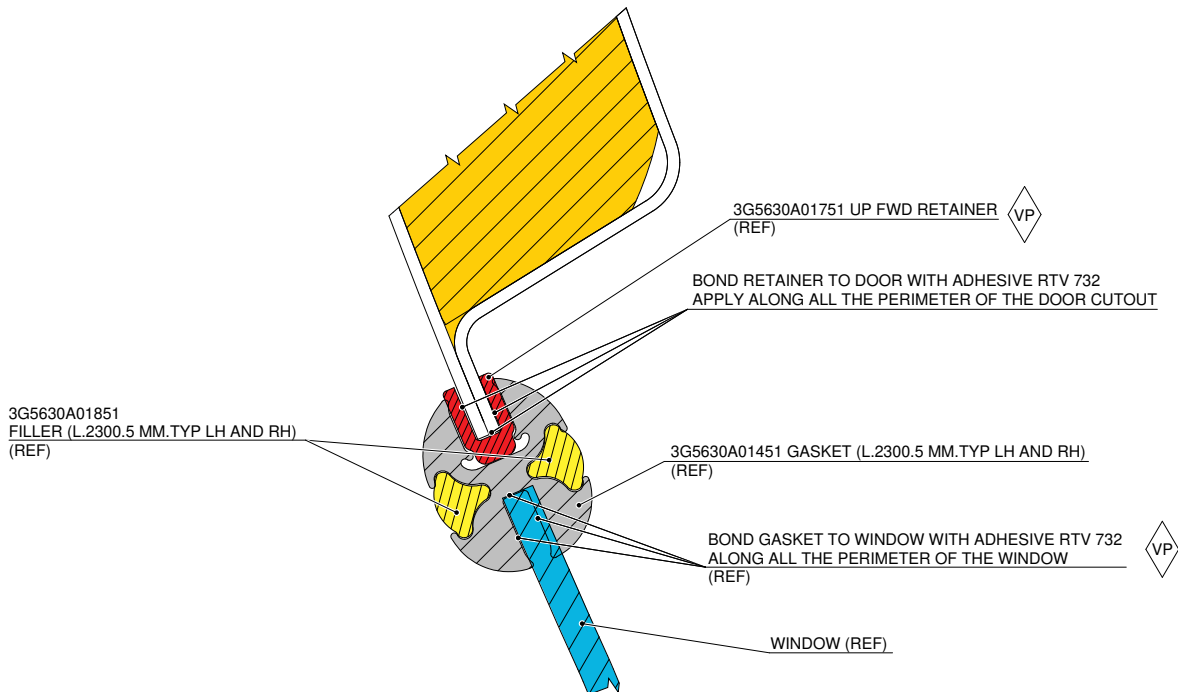
NOTES:

- ③ CHECK INSTALLATION DIMENSION, NO REWORKING ALLOWED.
- ④ ON INTERNAL FUSELAGE SIDE INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW.
- ⑤ ON EXTERNAL FUSELAGE SIDE:
-INSTALL FILLER STARTING FROM TOP SIDE OF FRAME WINDOW;
-CHECK IF THERE IS SQUEEZE OUT OF ADHESIVE ALL AROUND THE GASKET, IF NOT, LIFT THE SEAL EDGE AND FILL AGAIN.



SECTION A-A

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE



SECTION B-B

STRUCTURES AND SYSTEMS ARE PARTIALLY OMITTED FOR BETTER CLARITY PURPOSE

Figure 24

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

NOTE:

- ⑥ APPLY THE FILLET SEALANT ONLY AFTER INSTALLING THE CLIP P/N 3G5630A01351 AND FILLER P/N 3G5630A01851 IN THE GASKET SEAT. THE FILLET SEALANT MUST BE AS LONG AS THE CLIP TO PREVENT THE SQUEEZ OUT GOING ON FILLER INSIDE THE GASKET SEAT.

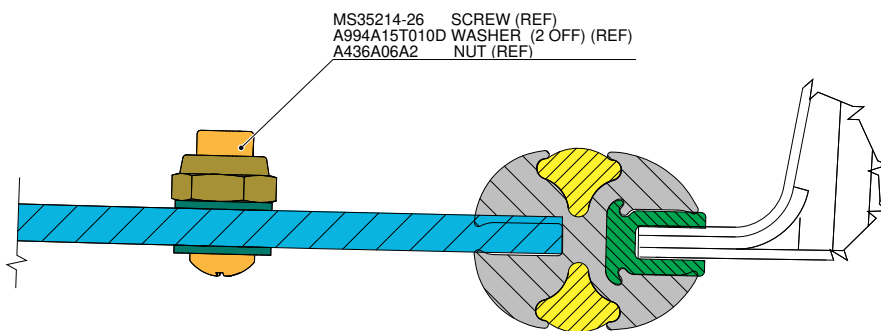
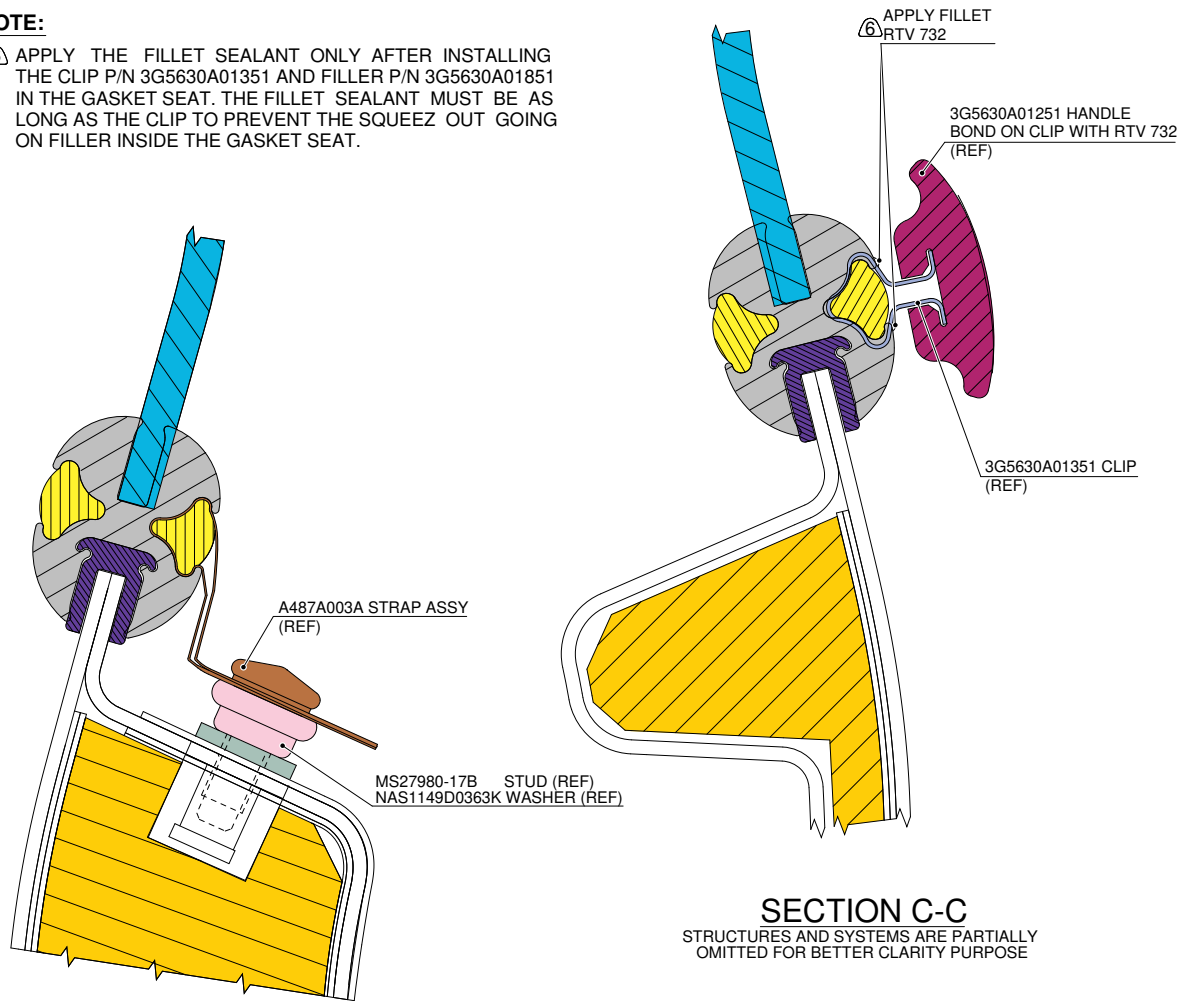
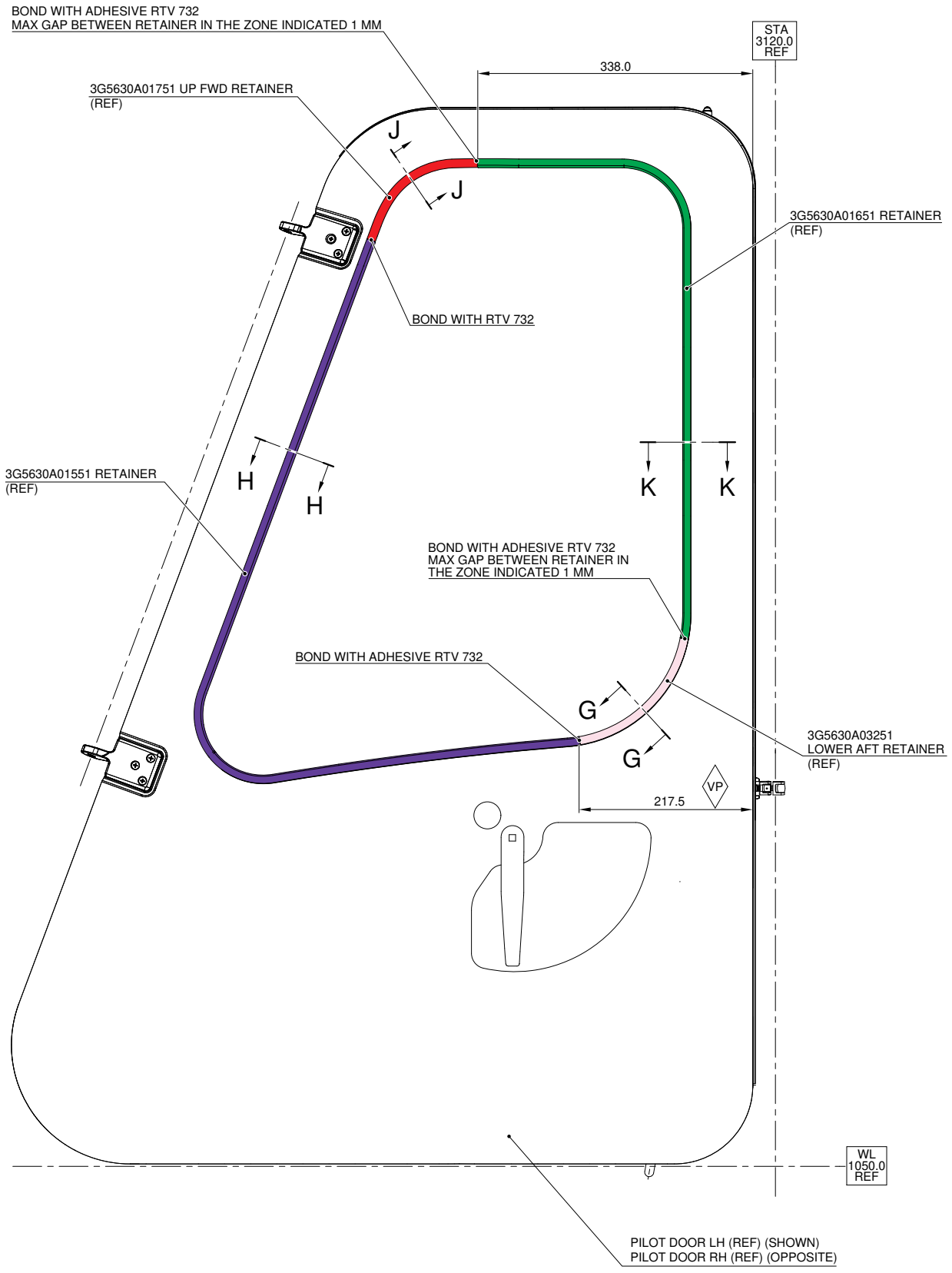


Figure 25



DETAIL F
(SHOWN RETAINERS ONLY OMITTED OTHER PARTS FOR CLARITY)
(TYP RIGHT SIDE)

Figure 26

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

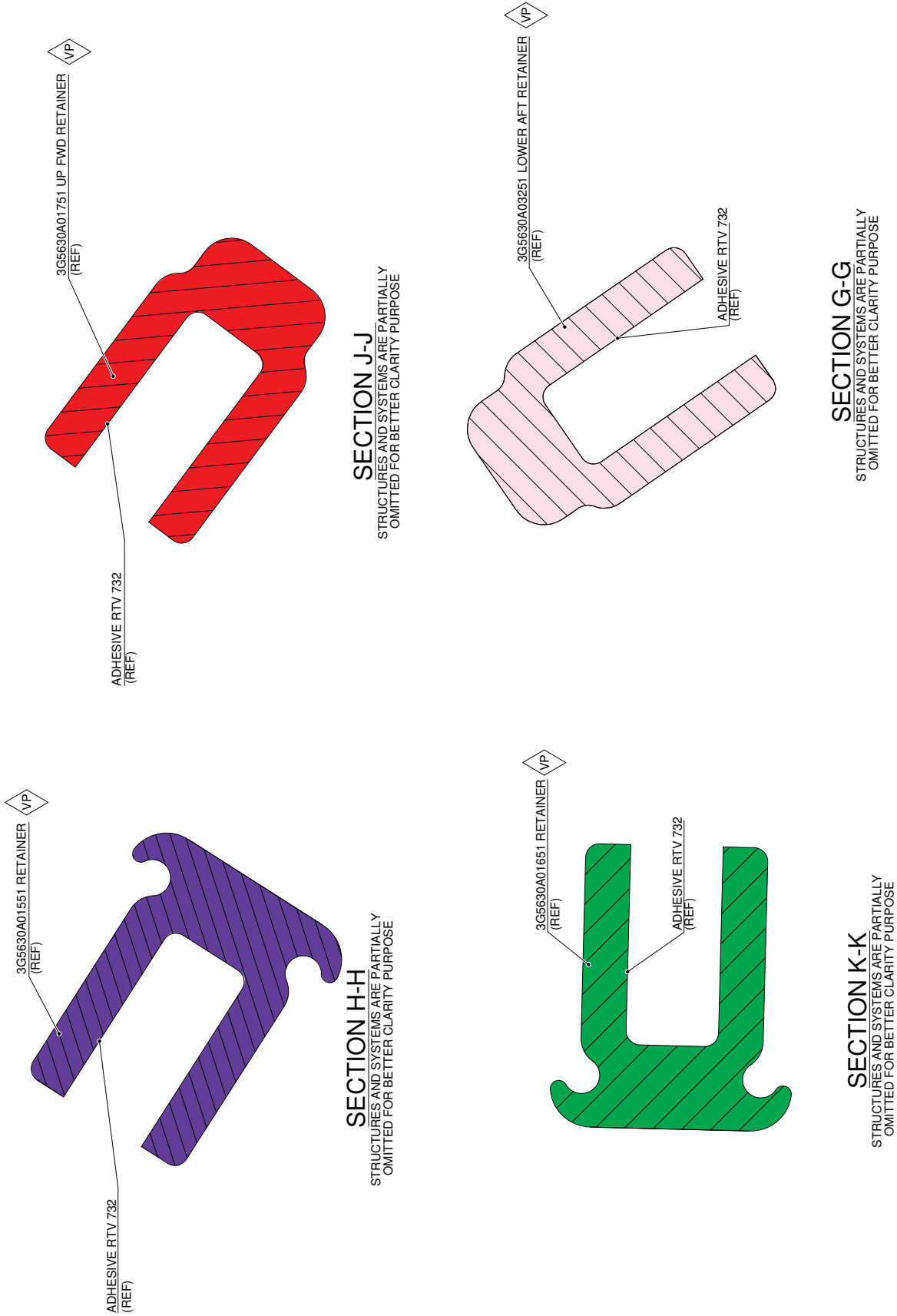


Figure 27

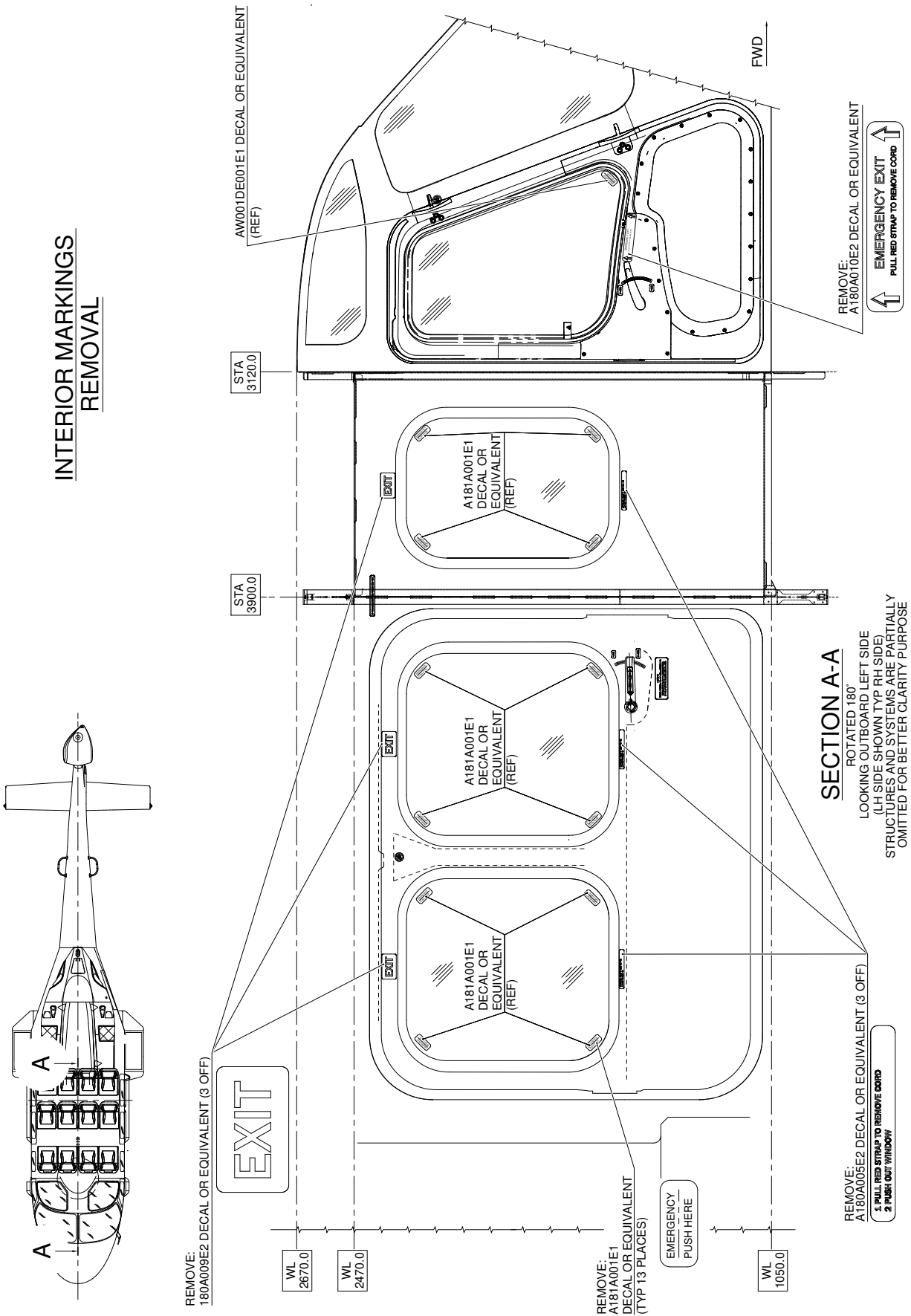


Figure 28

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

**EXTERIOR MARKINGS
INSTALLATION**

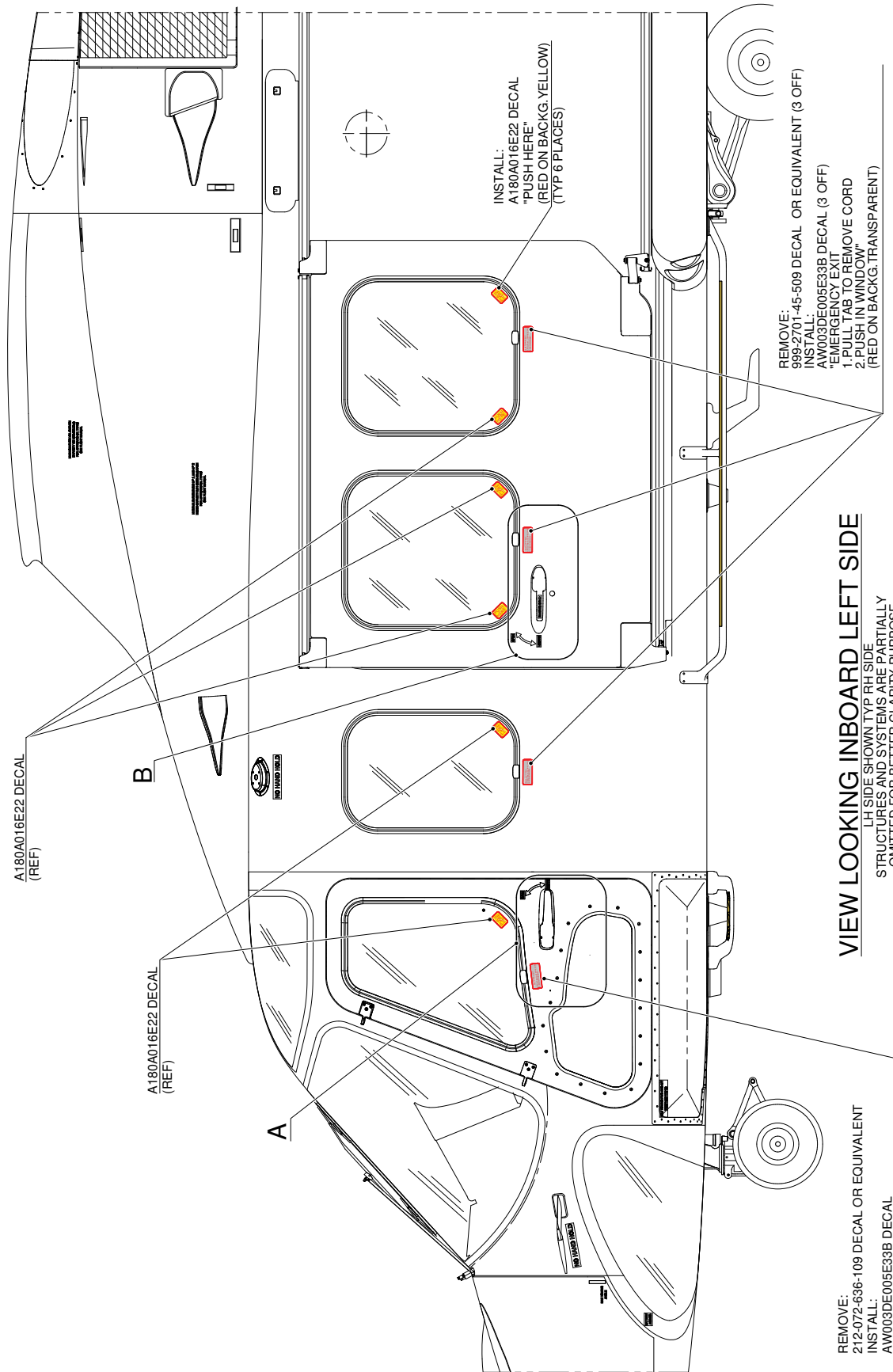
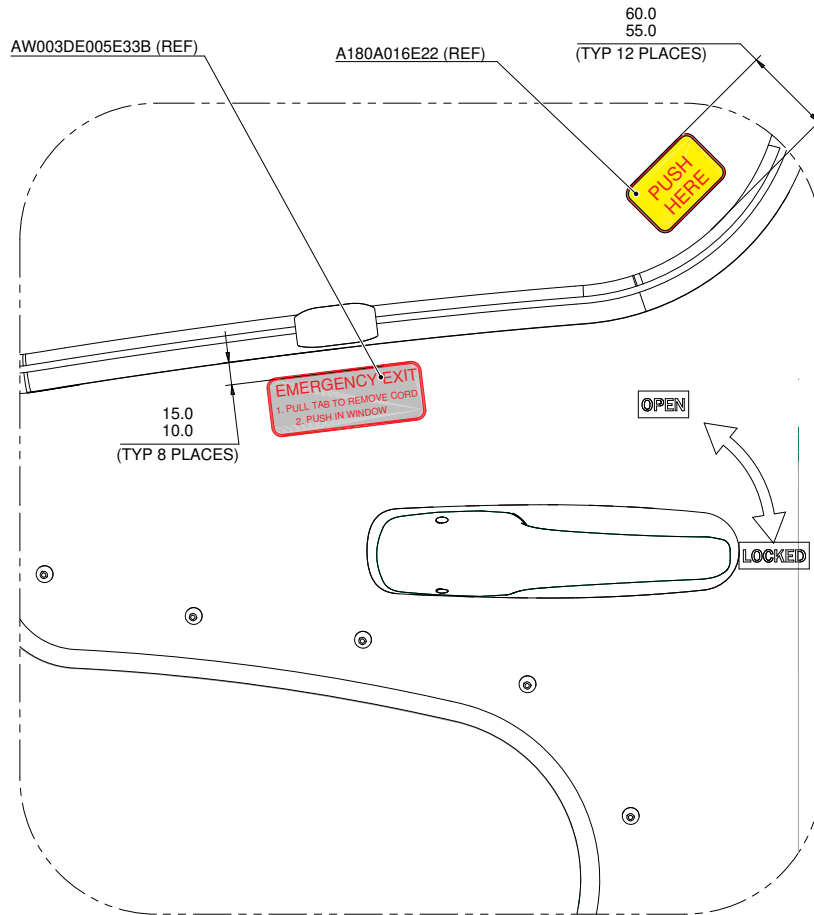
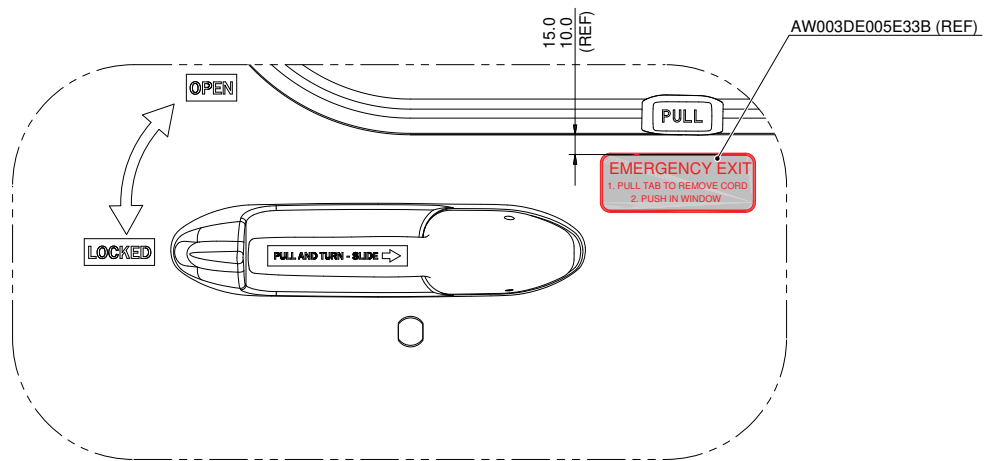


Figure 30

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /



DETAIL A
(LH SIDE SHOWN TYP RH SIDE)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE



DETAIL B
(LH SIDE SHOWN TYP RH SIDE)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 31

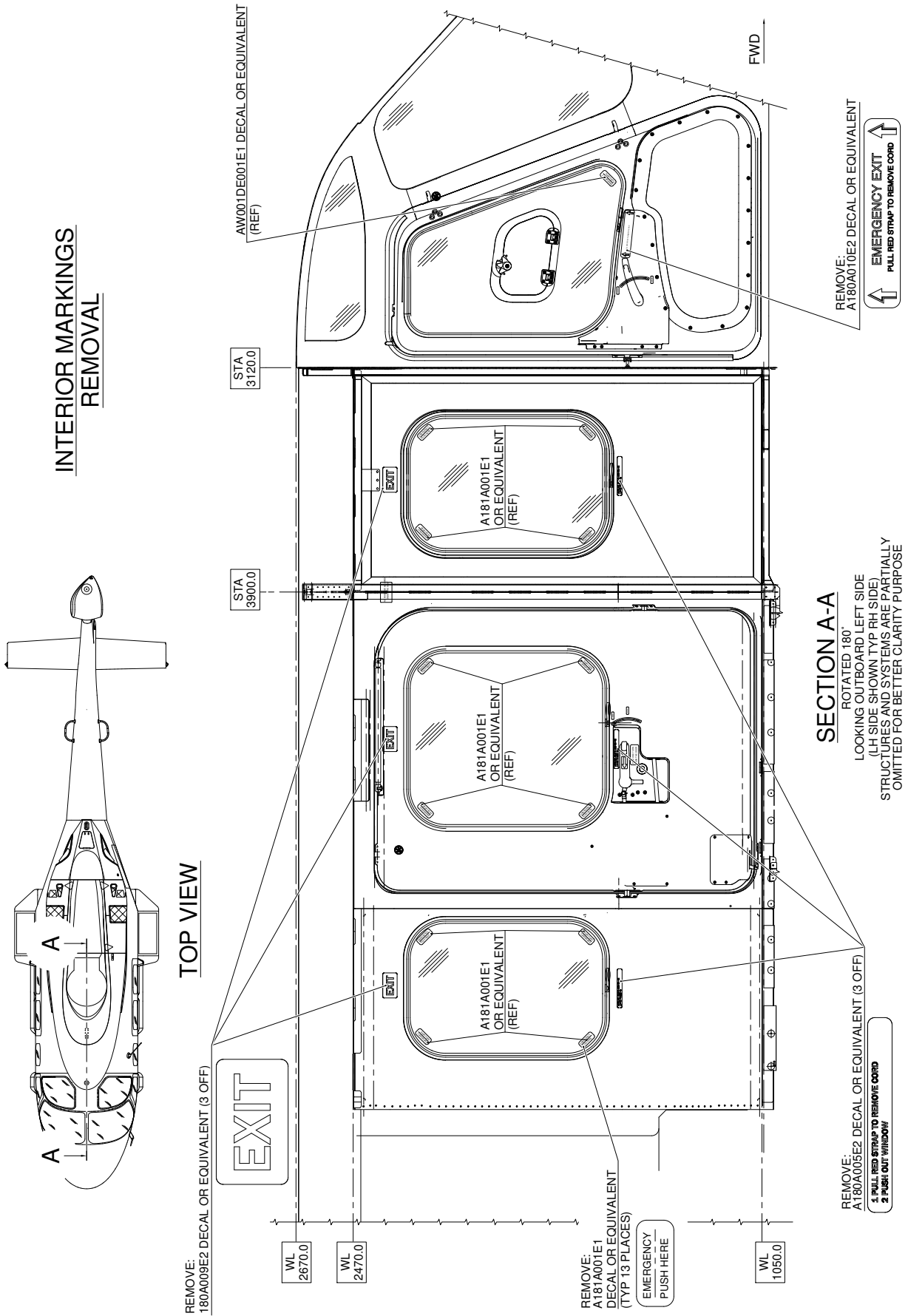


Figure 32

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

**INTERIOR MARKINGS
INSTALLATION**

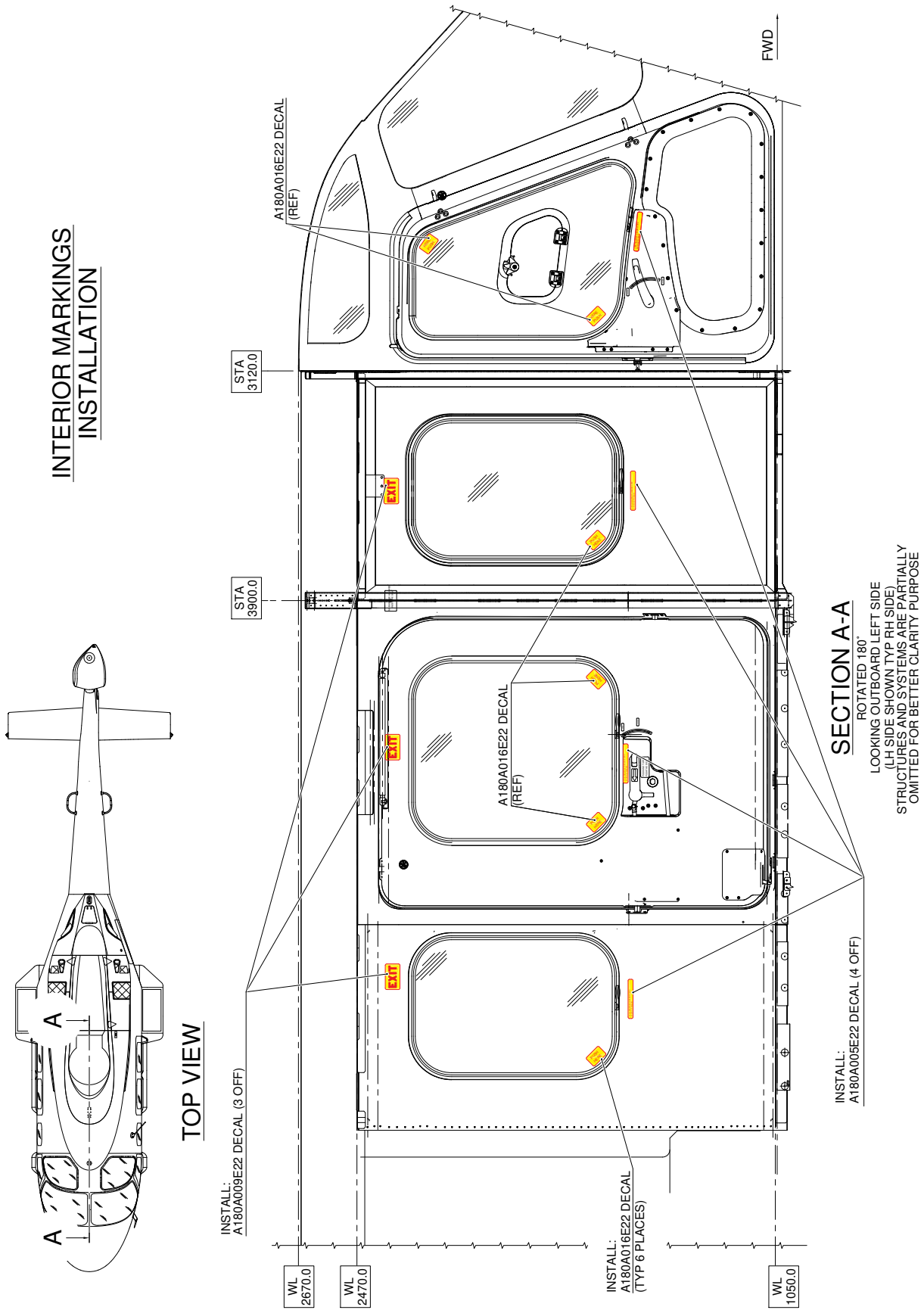
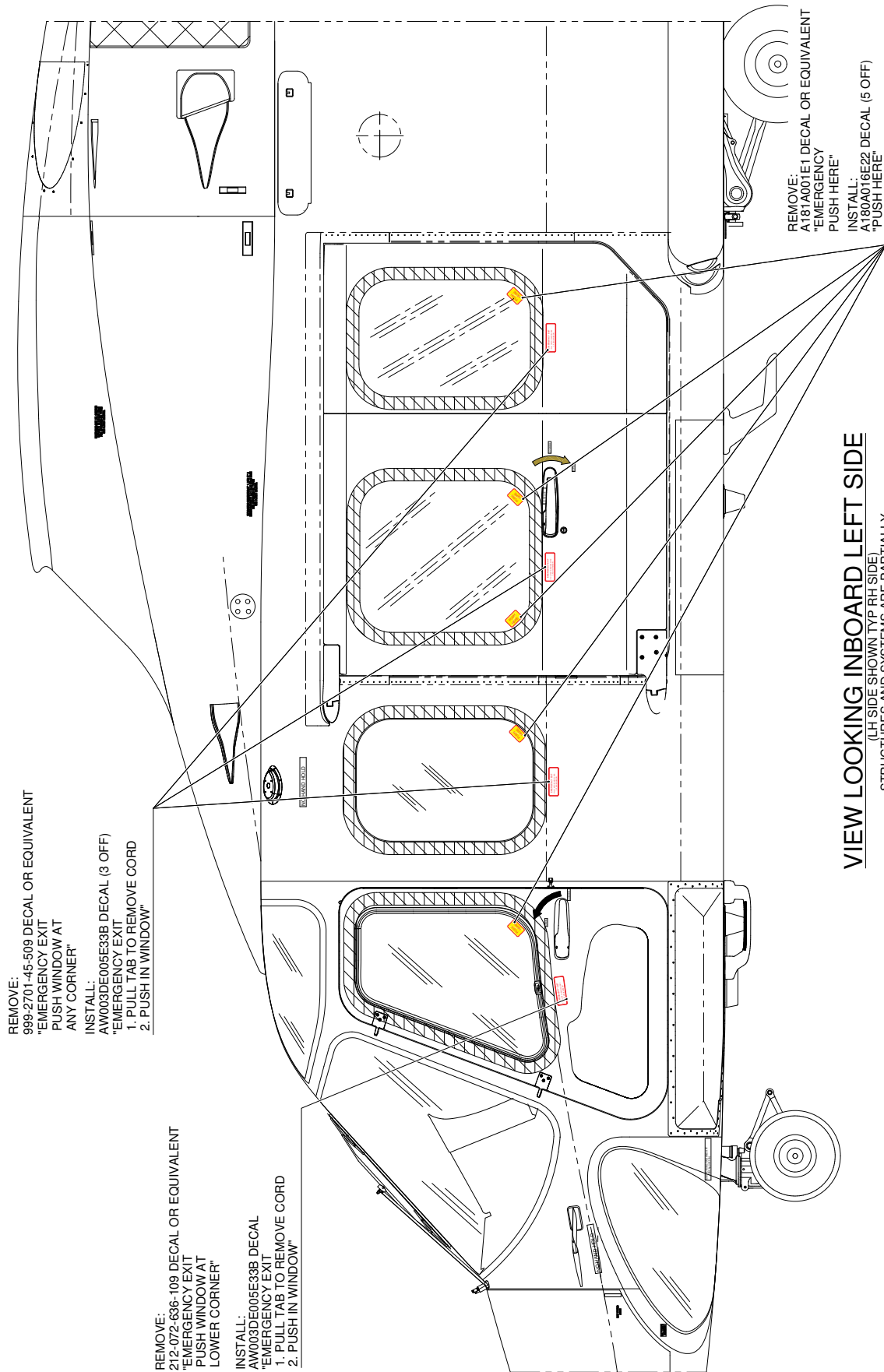


Figure 33

**EXTERIOR
MARKINGS INSTALLATION**



VIEW LOOKING INBOARD LEFT SIDE

(LH SIDE SHOWN TYP RH SIDE)
STRUCTURES AND SYSTEMS ARE PARTIALLY
OMITTED FOR BETTER CLARITY PURPOSE

Figure 34

S.B. N°139-694 RECOMMENDED
DATE: February 28, 2024
REVISION: /

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.