

No. AS365-53.00.59

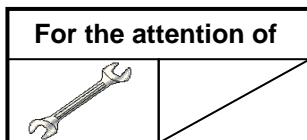
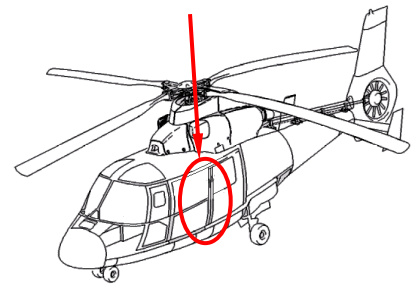


Military version(s): K, K2

ALERT SERVICE BULLETIN

CORRECTIVE MEASURE

REINFORCED STRUCTURE - 9° FRAME
Replacement of the 9° frame lateral parts
Corresponds to modification 0753D45



Revision No.	Date of issue
Revision 0	2015-12-01
Revision 1	2024-02-15

Summary:

The purpose of this ALERT SERVICE BULLETIN is to replace the lateral parts of 9° frame in compliance with the fatigue limits identified by Airbus Helicopters for version K2.

Reason for last Revision:

The purpose of revision 1 is to replace the lateral parts of the 9° frame to reset the cumulated flight hours and landings which avoid periodic mandatory inspection when thresholds are reached.

Compliance:

For Airbus Helicopters, it is essential to comply with the instructions contained in this ALERT SERVICE BULLETIN.

The safety concern described in this ALERT SERVICE BULLETIN is not expected to be mandated by any Airworthiness Directive. However, Airbus Helicopters requires implementation of this ALERT SERVICE BULLETIN.

Export Control:

US Export Control - No US content. This Item does not contain any U.S. origin ITAR or EAR content.

FR Export Control - Not Listed. This Item is not listed against the EC regulations in the EU/FR.

No. AS365-53.00.59

1. PLANNING INFORMATION

1.A. EFFECTIVITY



CAUTION

THIS ALERT SERVICE BULLETIN IS WRITTEN BASED ON THE ORIGINAL HELICOPTER CONFIGURATION (AS DEFINED IN THE INDIVIDUAL INSPECTION LOG BOOK (RIC)). IT ALSO TAKES INTO ACCOUNT ALL AIRBUS HELICOPTERS APPROVED CONFIGURATION CHANGES MADE AFTER DELIVERY, IF AIRBUS HELICOPTERS WAS INFORMED OF THEM. IT IS THE RESPONSIBILITY OF THE OPERATOR TO CHECK THE COMPATIBILITY OF ANY MODIFICATIONS WITH THE CURRENT HELICOPTER CONFIGURATION. IF MODIFICATIONS ARE NOT COMPATIBLE, IT IS THE RESPONSIBILITY OF THE OPERATOR TO DEFINE THE NECESSARY ADAPTATION WORK AND HAVE THEM APPROVED BY THE AIR TRANSPORT AUTHORITIES IN THE COUNTRY CONCERNED, AND TO MAKE SURE THAT THEIR AIRWORTHINESS IS FOLLOWED UP.

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

- Helicopters PRE MOD 0753D45.

NOTE

You can identify the modification status of the helicopter in the Section of applied modifications records in the Individual Inspection Log Book and/or the Aircraft Log Book.

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

Not applicable.

1.B. ASSOCIATED REQUIREMENTS

Not applicable.

1.C. REASON

Revision 0:

The purpose of this ALERT SERVICE BULLETIN is to replace the lateral parts of 9° frame in compliance with the fatigue limits identified by Airbus Helicopters for version K2.

The new lateral parts of 9° frame, installed as per this ALERT SERVICE BULLETIN, enable to have their TBO reinitialized as concerns both flight hours and number of take-off/landing cycles.

The safety level of the helicopter complies with the airworthiness regulations but the issue of this ALERT SERVICE BULLETIN makes the safety standards of Airbus Helicopters higher.

No. AS365-53.00.59

Revision 1:

The purpose of the revision 1 is to replace the lateral parts of the 9° frame through the compliance with MOD 0753D45 for all the AS365 versions K and K2 to reset the cumulated flight hours and landings which avoid periodic mandatory inspection when thresholds are reached.

This ALERT SERVICE BULLETIN validates the compliance with Temporary Technical Instruction (TTI) No. 01-2022 which was applied on helicopter S/N 6353.

Revision 1 of this ALERT SERVICE BULLETIN has an effect on the compliance with revision 0 of this ALERT SERVICE BULLETIN.

1.D. DESCRIPTION

This ALERT SERVICE BULLETIN includes the work steps that follow:

- Replace the stiffeners located on LH and RH lateral webs.
- Replace the LH and RH lateral webs.
- Replace the LH and RH inner angle.
- Replace the LH and RH exterior angle.
- Replace the splices with lower LH and RH parts.
- Replace the upper RH and LH splices.

1.E. COMPLIANCE

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

Not applicable.

1.E.2. Compliance in service

For the helicopter with Serial Number (S/N) 6353 only:

Record the full embodiment of modification 0753D45 in the helicopter documents. No other action is necessary.

Helicopters/installed equipment or parts:

It is the Airbus Helicopters specialists who do the installation on the helicopter and it is the operator who does the preliminary and final steps operations.

The preliminary steps (paragraph [3.B.1.](#)) and the final steps (paragraph [3.B.3.](#)) must be done on the helicopter by the operator.

The work steps (paragraph [3.B.2.](#)) must be done on the helicopter by a detachment of Airbus Helicopters specialists or by personnel with specific qualifications for this operation.

For helicopter version K:

Comply with paragraph [3.](#) of this ALERT SERVICE BULLETIN before you reach 10490 Flight Hours (FH) or 20980 Land Cycle (LC) (the first limit you get to is applicable),

For helicopter version K2:

Comply with paragraph [3.](#) of this ALERT SERVICE BULLETIN before you reach 7390 FH or 14780 LC (the first limit you get to is applicable).

Non-installed equipment or parts:

Not applicable.

No. AS365-53.00.59

1.F. APPROVAL



The technical content of this document is approved by Airbus Helicopters Airworthiness Department for export military versions.

1.G. MANPOWER



For compliance with this ALERT SERVICE BULLETIN, Airbus Helicopters recommends the following staff qualifications:

Qualification: 1 Airframe Technician.

Specialist: 1 Airbus Helicopters Airframe Technician with specific qualifications for compliance with this ALERT SERVICE BULLETIN.



The Estimated Man-hours are indicated for reference purposes only and based on a standard helicopter configuration.

Estimated Man-hours: 200 hours for the Airframe Technicians.

Estimated helicopter downtime is indicated for reference purposes only, based on a standard helicopter configuration.



Helicopter downtime is estimated at 25 days.

1.H. WEIGHT AND BALANCE

There is no change in weight and moment.

1.I. POWER CONSUMPTION

Not changed.

1.J. SOFTWARE UPGRADES/UPDATES

Not applicable.

1.K. REFERENCES

These documents are necessary to comply with this ALERT SERVICE BULLETIN:

Maintenance Manual (MET):

MET: 07-00-00-201: Jacking the aircraft - Jacking - Hoisting - Maintenance practices

MET: 08-00-00-602: Weighing with TESTUT weighing kit 333-45-4-162 - Levelling - Alignment - Weighing - Inspection / Check

MET: 08-00-00-603: Weighing with weighing kit SEP 370-81 or A22 - Levelling - Alignment - Weighing - Inspection / Check

No. AS365-53.00.59

MET: 23-40-01-501: System tests - NAT AA20 passenger address system - Adjustment / Test
MET: 23-41-19-501: ICS tests - Digital Audio Control System (DACS) - Adjustment / Test
MET: 28-20-01-408: Fuel pressure transmitter POST MOD 0771C40: Removal - Installation
MET: 28-41-01-601: Inspection of the installation - FAURE HERMAN fuel flowmeter - Inspection / Check
MET: 29-10-01-403: Manifold equipment: Removal - Installation
MET: 29-30-02-501: Hydraulic power system operation test
MET: 62-10-00-401: Removal-installation - Main rotor blades
MET: 63-40-00-501: Functional test MGB electrical magnetic plug
MET: 76-00-00-401: Flexible ball-type PRE MOD 0771B62: Removal - Installation - Engine controls
MET: 76-00-00-403: Ball controls POST MOD 0771B62: Removal - Installation - Engine controls
MET: 77-20-00-501: Check of the probes and the engine temperature indicator -Temperature and pressure monitoring
MET: 79-20-00-501: Checking engine oil temperature thermostatic switch

Standard Practices Manual (MTC):

MTC: 20-02-04-401: Installation of rivets - pitch and edge distance - Riveting
MTC: 20-02-04-402: Installation of rivets - retrofitting and repair - Riveting
MTC: 20-02-04-601: General riveting acceptance requirements - Riveting
MTC: 20-02-05-401: Fit clearances of structural parts - Joining
MTC: 20-02-05-404: Assembly by screws and nuts - Joining
MTC: 20-03-01-102: GENERAL REPAIR INSTRUCTIONS Unriveting principle - General repair instructions
MTC: 20-03-02-101: Replacement of rivets: General - General rivet replacement principles
MTC: 20-03-02-401: Installation of normal rivets - General rivet replacement principles
MTC: 20-03-02-406: Installation of "CHERRY-MAX" ASNA 0077 and 0078 rivets- General rivet replacement principles
MTC: 20-03-03-101: Replacement and relocation of anchor nuts: General - Replacement and relocation of anchor nuts
MTC: 20-04-04-403: Touch-up of the Alodine 1200 protection (Bonderite M-Cr 1200) - Surface treatment before painting
MTC: 20-04-04-404: Touch-up of protective treatment (phosphating and black anodizing) - Surface treatment before painting
MTC: 20-04-04-405: Touch-up on cadmium-plated surfaces (swab cadmium plating) - Surface treatment before painting
MTC: 20-04-05-402: Application of Epoxy primer P05 - P20 - Paint and primer application procedure
MTC: 20-05-01-101: General sealing methods - General sealing procedures
MTC: 20-05-01-211: Application of Sealing compound Mastinox 6856 K (CM 518) and 6856 H - General sealing procedure
MTC: 20-05-01-222: Application of PR 1771 B2 sealant - General sealing procedures
MTC: 20-05-01-223: Application of Sealing Compound PR 1782 S - General sealing procedure
MTC: 20-06-01-101: General rules for bonding with adhesives - Bonding with adhesives
MTC: 20-06-01-104: Bonding aluminum alloys - Bonding with adhesives
MTC: 20-06-01-418: Use of EA 9395 adhesive - Bonding with adhesives
MTC: 20-07-02-201: Helicopter parked in a repair shop - Safety instructions
MTC: 20-07-03-406: Instructions applicable when working on an aircraft electrical circuit and power generating systems - Technical instructions
MTC: 20-07-03-408: Appearance checks on an aircraft after an inspection or repair - Technical instructions
MTC: 20-08-05-102: Rules in force applicable for repair and maintenance of aircraft - General rules applicable to aircraft
MTC: 20-80-20-402: Installation / Removal of Cable Ties - Standard Practices - Electrical Power
MTC: 20-80-20-449: Protection of electrical wiring during maintenance operations -Standard Practices - Electrical Power
MTC: 20-80-20-402: Installation / Removal of Cable Ties - Standard Practices -Electrical Power
MTC: 20-80-20-441: Installation of electrical cable bundles and optical fibres -Standard Practices - Electrical Power

No. AS365-53.00.59

Information Notice (IN):

IN: 3481-I-00: The Marketplace: an AirbusWorld eOrdering service

IN: 3785-I-00: Introduction of the digital Service Bulletin reporting service SB Insight

Safety Promotion Notice (SPN):

SPN: 3703-P-00: GENERAL - Foreign Object Damage prevention

1.L. OTHER AFFECTED PUBLICATIONS

Not applicable.

1.M. PART INTERCHANGEABILITY OR MIXABILITY

This ALERT SERVICE BULLETIN has no effect on the interchangeability and mixability.

No. AS365-53.00.59

2. EQUIPMENT OR PARTS INFORMATION

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

Price

For information about the price of the modification kits and/or components, or for aid, contact the Airbus Helicopters Network Sales and Customer Relations Department.

Availability

Contact the Sales and Customer Relations Department to know the delivery lead time the operator's request.

Procurement

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

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

In the purchase order, write the information that follows:

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

2.B. LOGISTIC INFORMATION

- The work steps described in paragraph [3.B.2.](#) must be performed by Airbus Helicopters technicians, with the terms to be defined.
- The work steps described in paragraphs [3.B.1.](#), [3.B.3.](#), [3.B.4.](#) and Appendix [4.](#) must be performed by the operator.

The special tools will be provided on loan free of charge by Airbus Helicopters, with a security deposit.

No. AS365-53.00.59

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

Kits to be ordered for one helicopter or one assembly:

Key word	Qty	New reference	Item	Former reference	Instruction
<u>9° frame lateral parts</u>	1	<u>365A07-53D4-5471</u>			
Block radius EXT LH	1	365A08-4561-8051	1		
Inner lateral angle LH	1	365A21-3115-BE51	2		
Inner lateral angle RH	1	365A21-3115-BF51	3		
LH lateral web	1	365A21-3115-CY52	4		
RH lateral web	1	365A21-3115-CZ52	5		
Splice EXT RH	1	365A21-4220-34	6		
Splice INT RH	1	365A21-4220-35	7		
Splice EXT LH	1	365A21-4220-36	8		
Splice INT LH	1	365A21-4220-37	9		
Angle side EXT LH	1	365A21-3115-3454	10		
Angle side EXT RH	1	365A21-3115-3554	11		
RH upper lateral splice	1	365A21-3115-3351	12		
LH upper lateral splice	1	365A21-3115-5251	13		
LH Stiffener	1	365A21-3115-DE	14		
RH Stiffener	1	365A21-3115-DF	15		
LH Stiffener	1	365A21-3115-DG	16		
RH Stiffener	1	365A21-3115-DH	17		
LH Stiffener	1	365A21-3115-DJ	18		
RH Stiffener	1	365A21-3115-DK	19		
LH Stiffener	1	365A21-3115-DL	20		
RH Stiffener	1	365A21-3115-DM	21		
LH Stiffener	1	365A21-3115-DN	22		
RH Stiffener	1	365A21-3115-DP	23		
Block radius EXT LH	1	365A08-4561-8151	26		
Block radius EXT RH	1	365A08-4561-8251	27		
Block radius EXT RH	1	365A08-4561-8351	28		
Angle LH upper	1	365A21-3115-56	29		
Angle RH upper	1	365A21-3115-57	30		
Block radius INT LH	1	365A08-4561-7551	31		
Block radius INT RH	1	365A08-4561-7651	32		
Block radius INT LH	1	365A08-4561-87	33		
Block radius INT LH	1	365A08-4561-88	34		
Block radius INT RH	1	365A08-4561-89	35		
Block radius INT RH	1	365A08-4561-AG	36		
Block radius INT RH	1	365A08-4561-AH	37		
Support LH	1	365A21-4151-00	38		
Support RH	1	365A21-4151-01	39		
Support assy LH	1	365A21-4151-02	40		
Support assy RH	1	365A21-4151-03	41		
Support assy LH	1	365A21-4155-0051	42		
Support assy RH	1	365A21-4155-0151	43		
Support assy LH	1	365A21-4155-0251	44		
Support assy RH	1	365A21-4155-0351	45		
Support ambulance 1 RH	1	365A21-4152-03	46		
Support ambulance 3 RH	1	365A21-4152-07	47		
Support ambulance 2 RH	1	365A21-4152-05	48		
Support ambulance 4 RH	1	365A21-4152-09	49		
Support ambulance 1 LH	1	365A21-4152-02	50		

No. AS365-53.00.59

Kits to be ordered for one helicopter or one assembly (cond't):

Key word	Qty	New reference	Item	Former reference	Instruction
<u>9° frame lateral parts</u>	1	<u>365A07-53D4-5471</u>			
Support ambulance 3 LH	1	365A21-4152-06	51		
Support ambulance 2 LH	1	365A21-4152-04	52		
Support ambulance 4 LH	1	365A21-4152-08	53		
Gusset LH	1	365A08-4561-69	54		
Gusset RH	1	365A08-4561-70	55		
Shim	2	365A87-3009-20	114		
Shim	2	365A87-3009-21	115		

Key word	Qty	New reference	Item	Former reference	Instruction
<u>Kit, 9° frame catch</u>	1	<u>365A07-53D4-5571</u>			
LH support locking	1	365A21-6016-02	105		See NOTE 1
LH doubler	1	365A21-6017-00	107		
RH doubler	1	365A21-6017-01	108		
RH support locking	1	365A21-6016-03	111		See NOTE 2

NOTE 1

For item 105 instead of reference 365A21-6016-02 you can use reference 365A21-6016-0201.

NOTE 2

For item 111 instead of reference 365A21-6016-03 you can use reference 365A21-6016-0301.

No. AS365-53.00.59

Kits to be ordered for one helicopter or one assembly (cond't):

Key word	Qty	New reference	Item	Former reference	Instruction
<u>9° frame hardware lateral parts</u>	1	<u>365A07-53D4-5671</u>			
Rivet	9	21217DC2406J	25		
Multi clamp angeled	3	ECS6089G1D11	56		
Blind rivet	44	ASNA0078A403	57		
Screw	5	22271BC050014L	58		
Flat washer	13	23111AG050LE	59		
Nut clip self locking	5	SL211M5-1	60		
Bolt	5	22125BC050016L	61		
Self locking hex nut	9	ASN52320BH050N	62		
Blind rivet	35	ASNA0078A405	63		
Screw	9	22202BC050009L	64		
Washer	17	23112AG050LE	65		
Bracket clamp	9	E0498-01	66		
Nut anchor	5	52353CBD050N	67		
Blind rivet	66	ASNA0077A403	68		
Bolt	3	22125BC040014L	69		
Hex head bolt	5	22208BC050014L	70		
Stud flexible	17	704A31-2110-20	72		
Flat washer	3	23111AG040LE	73		
Rivet	59	ECS2151DXJ3207	74		
Rivet	114	ASNA2050DXJ4813	75		
Rivet	55	ASNA2050DXJ4814	76		
Rivet	90	ASNA2050DXJ4815	77		
Rivet	5	ECS2151DXJ3214	78		
Rivet 100 csk head	5	ECS2152DXJ3210	79		
Blind rivet	3	ASNA0363T0807	80		
Blind rivet	14	ASNA0363T0605	81		
Blind rivet	52	ASNA0078A404	82		
Rivet	19	ASNA2050DXJ4010	83		
Rivet	7	ASNA2050DXJ4816	84		
Rivet	33	ASNA2050DXJ4811	85		
Rivet	118	ASNA2050DXJ4812	86		
Rivet 100 csk head	33	ASNA2051DXJ4812	87		
Rivet 100 csk head	5	ASNA2051DXJ4813	88		
Rivet	3	ASNA0077A606	89		
Blind rivet	3	ASNA0077A404	90		
Rivet 100 csk head	9	ECS2152DXJ3209	91		
Rivet 100 csk head	9	ASNA2051DXJ4012	92		
Rivet	28	21217DC3207J	93		
Rivet	17	ECS2151DXJ3208	94		
Rivet	13	ASNA2050DXJ4820	95		
Blind rivet	7	NAS1921B04S04U	96		
Rivet	3	21217DC3210J	97		
Rivet	9	ASNA2051DXJ4817	112		
Rivet	35	ASNA2050DXJ4817	113		

No. AS365-53.00.59

Kits to be ordered for one helicopter or one assembly (cond't):

Key word	Qty	New reference	Item	Former reference	Instruction
<u>9° frame hardware lateral parts</u>	1	<u>365A07-53D4-5671</u>			
Rivet	9	21217DC3208J	116		
Rivet	11	21217DC4816J	117		
Rivet	3	21217DC4815J	118		
Rivet	59	21217DC3206J	119		
Rivet	28	21215DC3206J	120		
Blind rivet	46	ASNA0078A402	121		
Blind rivet	11	ASNA0077A402	122		
Rivet	5	21217DC4010J	123		
Blind bolt	3	ASNA0081-404	124		
Rivet	5	21215DC3209J	125		

Equipment or parts to be ordered separately:

Key word	Qty	New reference	Item	Former reference	Instruction
Support	11	E0708G1D	71		
Profile	2	365A21-3115-78	104		Install if necessary

Consumables to be ordered separately:

Refer to Work Cards and Tasks mentioned in this ALERT SERVICE BULLETIN and list below:

Key word	Qty	Product reference	CM	Item
Mastinox	AR	ECS7009	518	24
Surface protection	AR	Prestoblack (Magic Bluer)	3001	98
Transformation agent	AR	Alodine 1200	316	99
Primer	AR	DHS186-111-20	487	100
Primer	AR	DHS186-111-40	488	101
Adhesive	AR	ECS0010.20	6041	102
PR sealing compound	AR	ECS2339.00	6068	103

You can order the consumables from the AirbusWorld Marketplace through e-ordering (IN 3481-I-00). If you cannot get access to e-ordering, please contact your Logistic Focal Point.

No. AS365-53.00.59

Special tools:

Compliance with this ALERT SERVICE BULLETIN requires the use of the special tool listed below.

Key word	Qty	Tool reference or equivalent	Item
Shoring tool	1	365A214138_R6201	zz
Drill Ø3.2 mm	1	Off the shelf	yy
Drill Ø4.8 mm	1	Off the shelf	xx
Drill Ø5 mm	1	Off the shelf	ww
Drill Ø4 mm	1	Off the shelf	vv
Boring tool Ø 5G6	1	Off the shelf	uu

2.D. EQUIPMENT OR PARTS TO BE RETURNED

Not applicable.

No. AS365-53.00.59

3. ACCOMPLISHMENT INSTRUCTIONS

3.A. GENERAL

- Comply with the assembly by screws and nuts. Refer to Work card 20-02-05-404 (MTC),
- Comply with the instructions concerning riveting. Refer to Work Cards 20-02-04-401, 20-02-04-402, 20-02-04-601, 20-02-05-401, 20-03-02-401 and 20-03-02-406 (MTC).
- Comply with the instructions concerning rivet removal and replacement. Refer to Work Cards 20-03-01-102 and 20-03-02-101 (MTC).
- Comply with the general instructions for replacing and moving anchor nuts. Refer to Work Card 20-03-03-101 (MTC).
- Comply with the instructions for touch-ups using Alodine 1200. Refer to Work Card 20-04-04-403 (MTC).
- Comply with the instructions concerning the application of EPOXY primer P05-P20 and P50. Refer to Work Card 20-04-05-402 (MTC).
- Comply with the instructions concerning General sealing methods. Refer to Work Card 20-05-01-101 (MTC).
- Comply with the instructions concerning the application of Mastinox sealing compound 6856 K and 6856 H. Refer to Work Card 20-05-01-211 (MTC).
- Comply with the instructions concerning the application of PR 1771 B2 sealing compound. Refer to Work Cards 20-05-01-222 and 20-05-01-223 (MTC).
- Comply with the instructions for helicopters parked in a repair shop. Refer to Work Card 20-07-02-201 (MTC).
- Comply with instructions for work on an aircraft electrical network and with ground power supply for networks. Refer to Work Card 20-07-03-406 (MTC).
- Comply with the rules in force applicable to repair and maintenance of aircraft. Refer to Work Card 20-08-05-102 (MTC).
- Comply with the instructions concerning cable binding methods. Refer to Work Card 20-80-20-402 (MTC).
- Comply with the instructions concerning the installation of electrical wire bundles and cable binding methods. Refer to Work Cards 20-80-20-402 and 20-80-20-441 (MTC).

3.B. WORK STEPS



CAUTION

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

NOTE 1

The various photographs used as illustrations for this ALERT SERVICE BULLETIN are taken from a mock-up of a N3 version helicopter.

No. AS365-53.00.59

3.B.1. Preliminary steps



CAUTION

CHECK THE STRAPS REFER TO [APPENDIX 4.A](#). IF THE STRAPS ARE OUTSIDE THE TOLERANCE LIMITS, CONTACT AIRBUS HELICOPTERS AT THE FOLLOWING ADDRESS:

support.technical-airframe.ah@airbus.com.



CAUTION

TAKE GREAT CARE WHEN REMOVING THE 4.8 mm DIAMETER RIVETS.

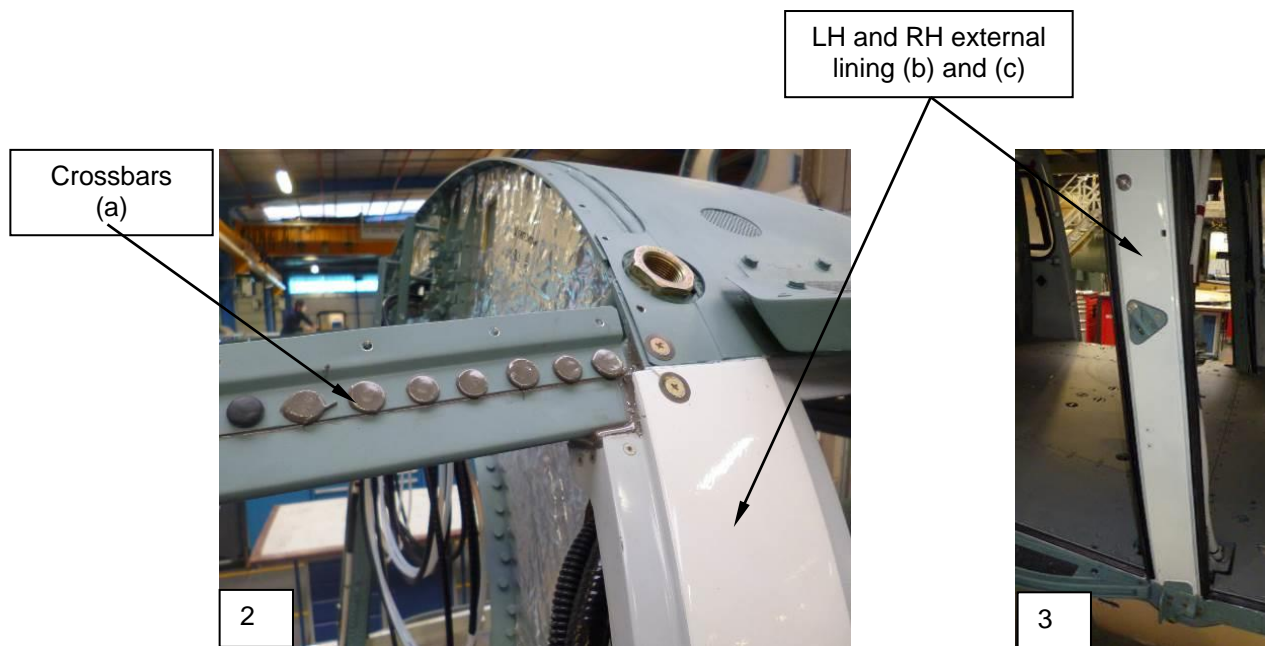
- Disconnect all power supplies, refer to Work Card 20-07-03-406 (MTC).
- Put the helicopter on wheels and on jacks, refer to Work Card 20-07-02-201(MTC).
- Lift the helicopter on jacks, refer to Work Card 07-00-00-201 (MET).
- Install a hydraulic jack with protective wooden blocks under the helicopter beneath the 9° frame and along the helicopter's centerline (Photo 1).



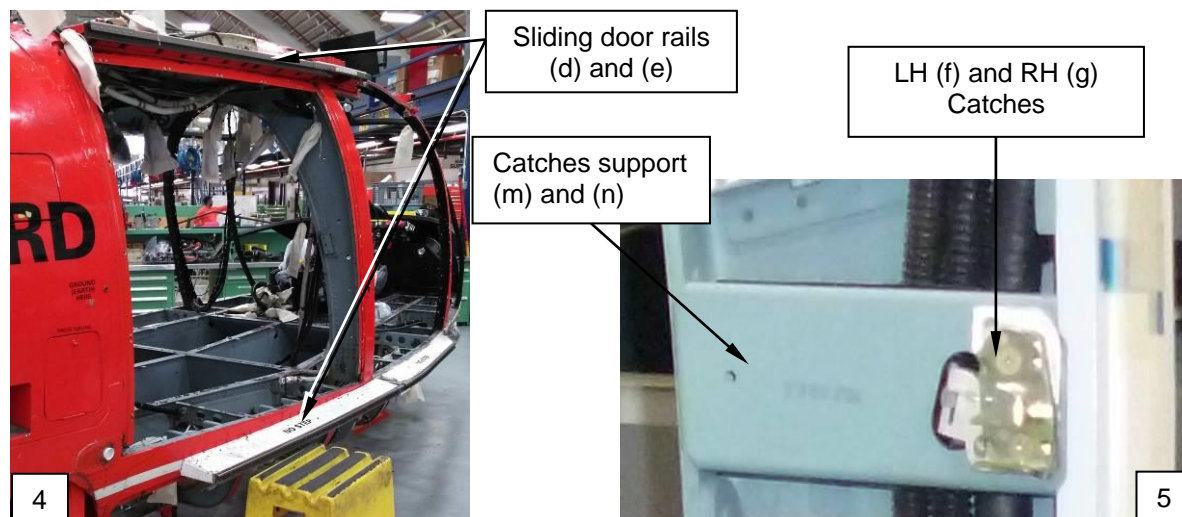
- Remove the main rotor blades, refer to Work Card 62-10-00-401 (MET).
- Remove the canopy.
- Remove the wiring passing through the 9° frame, such as:
 - . The fuel flowmeter sensor
 - . The hoist
 - . The pyrotechnic circuit of the hoist
 - . The cabin lighting
 - . The hydraulic control, refer to Work Card 29-10-01-403 (MET)
 - . The fuel pressure, refer to Work Card 28-20-01-408 (MET)
 - . The engine temperature indicator,
 - . The passenger intercommunication
 - . The DACS intercommunication
 - . The ice detector
 - . The MGB oil temperature probe
 - . The engine oil temperature probe.
- Remove engine controls, refer to Work Card 76-00-00-401 or Work Card 76-00-00-403 (MET).
- Protect the electrical wiring in the work area. Refer to Work Card 20-80-20-449 (MTC).
- Remove and/or open all cowlings, panels, doors and all equipment items to enable adequate access to the various work areas.

No. AS365-53.00.59

- Remove the crossbars (a) between the 14° frame and the 9° frame (Photo 2).
- Remove the LH and RH external linings (b) and (c) from the 9° frame (Photos 2 and 3). Refer to Figure 12, Detail Z).
- Keep the LH and RH external linings (b) and (c).
- Remove the door seal.
- If necessary, remove the soundproofing coverings.
- Discard the soundproofing coverings.



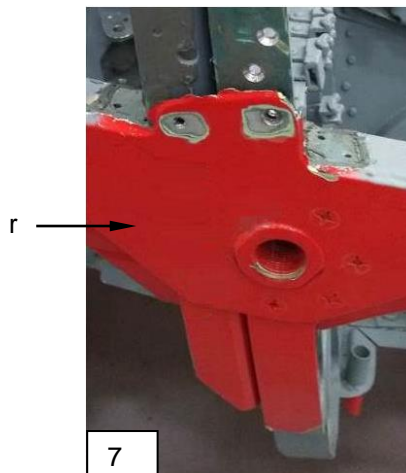
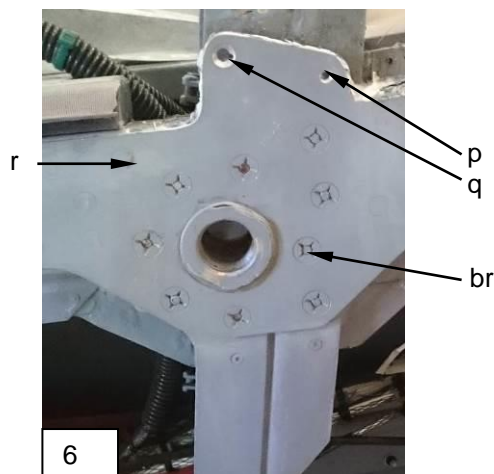
- If necessary, remove the hoist brackets and the fixed parts of the ambulance installation.
- Remove the upper rails (d) and lower rails (e) of the sliding door (Photo 4).
- Remove the flight control support located in the quarter shell.



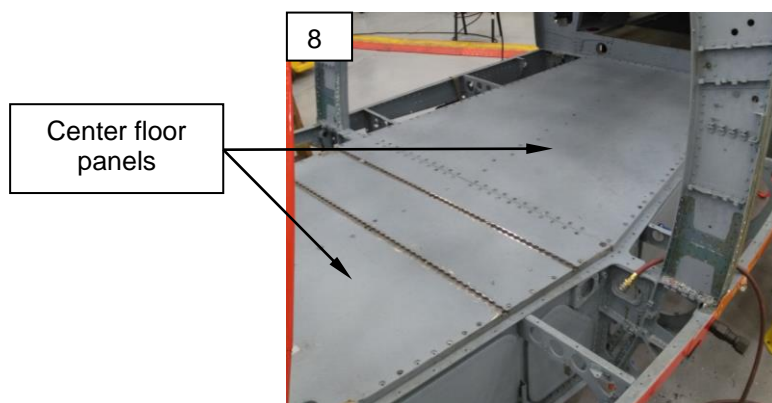
- Remove the LH (f) and RH (g) catches (Photo 5) and the catch supports (m) and (n).
- Discard the LH (f) and RH (g) catches and the catch supports (m) and (n).
- Remove the micro switches (h) (not shown) and (k) (not shown).
- Keep the micro switches (h) and (k).

No. AS365-53.00.59

- Remove the rivets (p) and the blind bolts (q) and (br) of lower splices (r), refer to Figure 5, Detail C (Photos 6 and 7).



- Remove and discard the gussets (s), refer to Figure 2.
- Install two center floor panels and protect them (Photo 8).



- Remove the rivets (az) from the RH welded reinforcement (ba) ((bc) for LH side). Refer to Figure 11, Details W and X.
- Remove the rivets (az) from the airframe. Refer to Figure 11, Detail V.
- Remove the rivets (az) from the RH plate for hoist (bd) ((be) (not shown) for LH side). Refer to Figure 12, Section X-X.
- Keep the LH and RH plate for hoist (bd) and (be).
- Remove the rivets (az) from the RH sheet closing (bf) ((bg) for LH side). Refer to Figure 12, Section X-X.
- Keep the LH and RH sheet closing (bf) and (bg).
- Remove the rivets (az) from the RH reinforcements (bh) and (bk) ((bh) and (bk) for LH side). Refer to Figure 12, Detail Y-Y.
- Keep the LH and RH reinforcements (bh) and (bk).
- Remove the rivets (az) from the RH splint (bl) ((bm) for LH side). Refer to Figure 12, Detail AB.
- Keep the LH and RH splint (bl) and (bm).
- Remove the attachments (bn) from the RH fitting (bo) ((bp) for the LH side). Refer to Figure 12, Detail AE.
- Keep the attachments (bn) and the LH and RH fitting (bo) and (bp).
- Remove the rivets (az) from the hoist connector bracket (bq). Refer to Figure 11, Detail Y.
- Keep the hoist connector bracket (bq).
- Remove and discard the nut plate (bs) (not shown) from the lower bracket (as). Refer to Figure 5, Detail T).
- Clean the work zone and the previously removed parts.

No. AS365-53.00.59

- Install and tighten until contact the reference tool (zz) (Photo 9).



9

3.B.2. Replacement of the lateral parts on the 9° frame

Only the RH side lateral parts is described. Do the lateral parts on the LH side with the same operational procedure.

3.B.2.a. Removal of the lateral parts from the 9° frame (Figures 1 and 2)

- On the front of the 9° frame (u), remove:
 - . The RH equipped angles (ag) (equipped angles (ah) for the LH side)
 - . The RH lower splice (ak) (lower splice (am) for LH side)
 - . The RH upper lateral splice (an) (upper lateral splice (ap) for LH side)
 - . The support assy (at) and the supports (au) (support assy (at) and support (au) for the LH side)
- Keep the support assy (at).
- Discard all the others items.
- On the rear of the 9° frame (u), remove:
 - . The center splice (t)
 - . The RH flight control support (v) (flight control support (w) for LH side)
 - . The supports (x) (support (x) for LH side)
 - . The RH upper angle (y) (upper angle (z) for LH side)
 - . The RH outer lateral angle (ab) (outer lateral angle (ac) for LH side)
 - . The RH inner lateral angle (ad) (inner lateral angle (ae) for LH side).
 - . The rivets (af)
 - . The RH spacer shim (aw) (spacer shim (aw) for the LH side)
- Remove the RH lateral web (aq) (lateral web (ar) for the LH side).
- Remove the shims (ax) and (ay) from the flight control support (v) (shims (ax) and (ay) on flight control support (w) for the LH side). Refer to Figure 2, Sections T-T and U-U.
- Keep the RH flight control support (v) (flight control support (w) for LH side), the supports (x), the spacer shims (aw), the shims (ax) and (ay) and the center splice (t).
- Discard all the others items.

No. AS365-53.00.59

3.B.2.b. Preparation of the lateral webs

- Install the supports (71) with the rivets (82) on (Figure 6):
 - . The RH stiffener (15) (stiffener (14) for the LH side) (Section A-A)
 - . The RH stiffener (21) (stiffener (20) for the LH side) (Section F-F)
 - . The RH stiffener (23) (stiffener (22) for the LH side) (Section G-G).
- Install the supports (71) with the rivets (63) on (Figure 6):
 - . The RH stiffener (17) (stiffener (16) for the LH side) (Section C-C)
 - . The RH stiffener (19) (stiffener (18) for the LH side) (Section D-D).
- Install the Multi clamp angeled (56) with the rivets (57) on stiffener (av) (Figure 3, Details D and E).
- Install the support (x) (support (x) for LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (74) (Figure 4, Detail F and Figure 6 Detail C and Section E-E).
- Install on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (74) (Figure 6):
 - . The RH stiffener (23) (stiffener (22) for the LH side) (Section G-G)
 - . The RH stiffener (21) (stiffener (20) for the LH side) (Section F-F)
 - . The RH stiffener (15) (stiffener (14) for the LH side) (Section A-A).
- Install on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (94), (Figure 6, Sections C-C and D-D):
 - . The RH stiffener (17) (stiffener (16) for the LH side) (Section C-C)
 - . The RH stiffener (19) (stiffener (18) for the LH side) (Section D-D).
- Install the bracket clamp (66) (bracket clamp (66) for LH side) with the rivets (91) (Figure 6, Detail P).
- Install the nut anchors (67) (nut anchor (67) for LH side) with rivets (25) (Figure 6, Detail P).

No. AS365-53.00.59

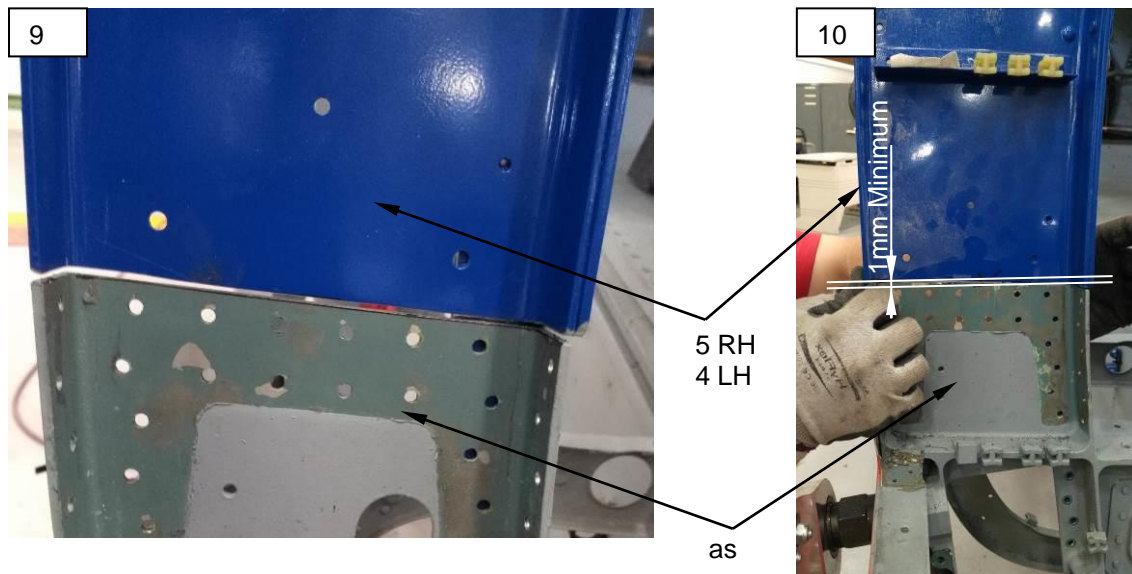
3.B.2.c. Location of the lateral webs (Figures 3 and 4)



CAUTION

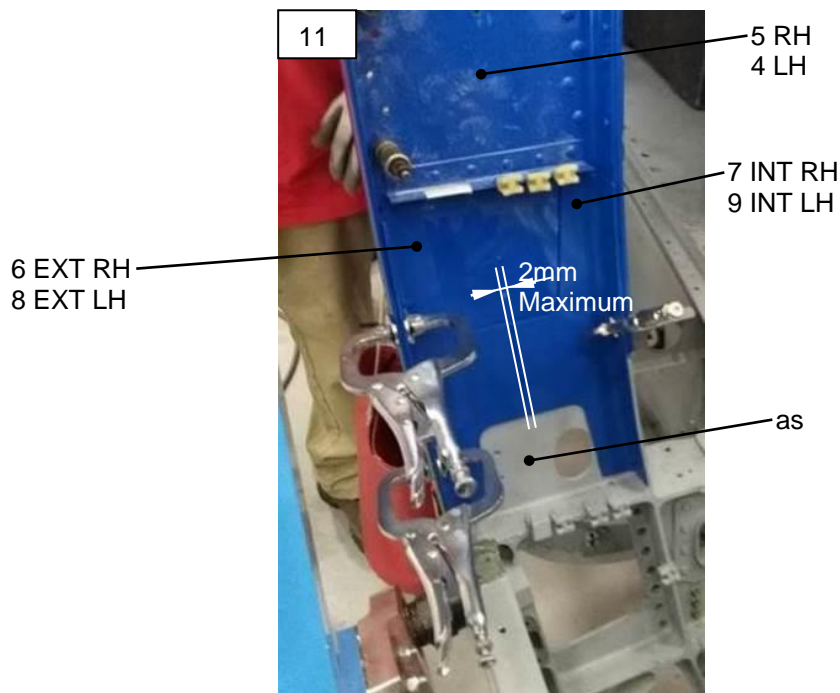
MAKE SURE TO RESPECT THE 1 mm MINIMUM (0.04 in) CLEARANCE BETWEEN THE RH LATERAL WEB (5) (LATERAL WEB (4) FOR THE LH SIDE) AND THE LOWER BRACKET (as) (PHOTOS 9 AND 10).

- Position in place the RH lateral web (5) (lateral web (4) for the LH side) in alignment with the lower bracket (as).



No. AS365-53.00.59

- Position and secure (Photo 11) the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) on RH lateral web (5) (lateral web (4) for the LH side) and the lower bracket (as) (Figure 5, Detail B) (adjust to the profile if necessary).
- Evenly space the clearance between the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) which must be between 1.7 mm (.066 in) and 2 mm (.08 in) (Photo 11).



NOTE 2

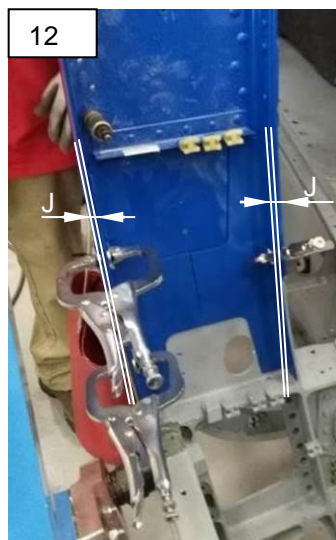
Pin screws and nuts, or other means corresponding to the drilling diameter, attach at least 50% of the RH lateral web (5) (lateral web (4) for the LH side) to the existing structure to hold the RH lateral web (5) (lateral web (4) for the LH side) in place.

No. AS365-53.00.59

- Measure and record the clearance J (Photo 12)



IF THE CLEARANCE “J” IS GREATER THAN 0.8 mm (.031 in), DISCARD THE RH LATERAL WEB (5) (LATERAL WEB (4) FOR THE LH SIDE).



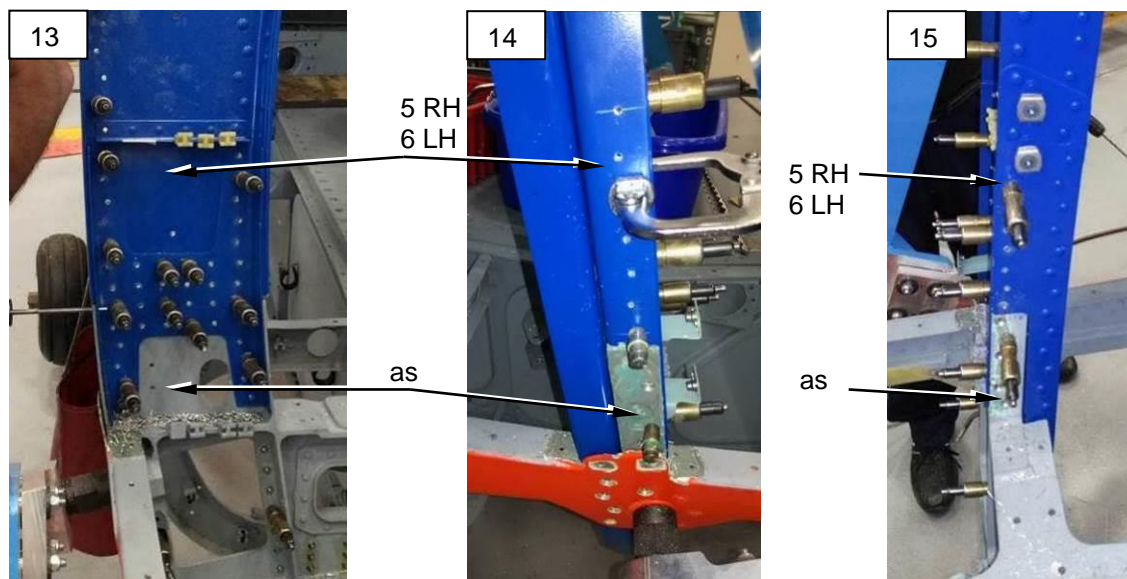
3.B.2.d. Preparation for the installation of the lateral webs



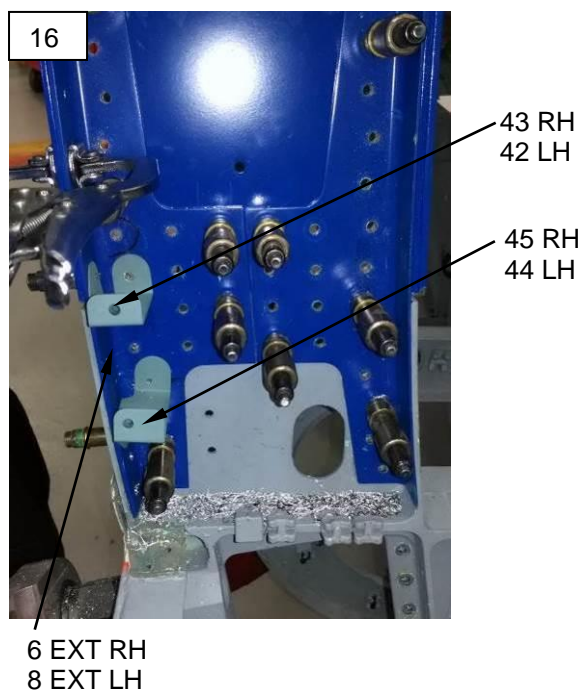
BEFORE COUNTER-DRILLING THE RH LATERAL WEB (5) (LATERAL WEB (4) FOR THE LH SIDE) MAKE SURE THAT IT HAS BEEN CORRECTLY ALIGNED WITH THE LOWER BRACKET (as), THE RH EXTERIOR SPLICES (6) AND THE RH INTERIOR SPLICE (7) (EXTERIOR SPLICES (8) AND INTERIOR SPLICE (9) FOR THE LH SIDE) AFTER IT IS LOCKED IN PLACE.

- Counter-drill the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) with the lower bracket (as) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 5, Details B, C and K) (photos 13, 14 and 15).
- Counter-drill the RH exterior splices (6) (exterior splices (8) for the LH side) and the lower bracket (as) to a diameter (B) of 5 mm (.196 in) with the drill (ww), refer to Figure 5, Section P-P (photo 14).
- Counter-drill the RH exterior splices (6) (exterior splices (8) for the LH side) and the lower bracket (as) to a diameter (C) of 3.2 mm (.126 in) with the drill (yy), refer to Figure 5, Detail C (photo 14).

No. AS365-53.00.59



- Position and secure the support assy RH (43) and (45) (support assy (42) and (44) for LH side) on the RH exterior splices (6) (exterior splices (8) for the LH side) (Photo 16) (Figure 5, Detail B).



- Counter-drill the support assy RH (43) and (45) (support assy (42) and (44) for LH side) on the RH exterior splices (6) (exterior splices (8)) and the lower bracket (as) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 5, Detail B.

No. AS365-53.00.59

- Position the RH inner lateral angle (3) (inner lateral angle (2) for LH side) on the RH lateral web (5) (lateral web (4) for LH side) and the 9° frame (u) (Figure 4, Detail F).
- Counter-drill the RH inner lateral angle (3) (inner lateral angle (2) for LH side) with the RH lateral web (5) (lateral web (4) for LH side) and the 9° frame (u) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 6, Detail C and Figure 7, Detail J.
- Counter-drill the RH inner lateral angle (3) (inner lateral angle (2) for LH side) with the RH lateral web (5) (lateral web (4) for LH side) and the 9° frame (u) to a diameter of 3.2 mm (C) (.196 in) with the drill (yy), refer to Figure 7, Detail J.
- Counter-drill the RH inner lateral angle (3) (inner lateral angle (2) for LH side) with the lower bracket (as) according to existing holes to a diameter of 5G6 mm with the boring tool (uu), refer to Figure 4, Details H and I.

- Position the RH outer lateral angle (11) (outer lateral angle (10) for LH side) on the RH lateral web (5) (lateral web (4) for LH side) (Figure 4, Detail F).
- Counter-drill the RH outer lateral angle (11) (outer lateral angle (10) for LH side) with the RH lateral web (5) (lateral web (4) for LH side) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 6, Detail C.
- Counter-drill the RH outer lateral angle (11) (outer lateral angle (10) for LH side) with the RH lateral web (5) (lateral web (4) for LH side) to a diameter (D) of 4 mm (.157 in) with the drill (vv), refer to Figure 6, Detail C.
- Counter-drill the RH outer lateral angle (11) (outer lateral angle (10) for LH side) with the lower bracket (as) (lower bracket (as) for LH side) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 5, Detail C.

- Counter-drill the RH outer lateral angle (11) (outer lateral angle (10) for LH side) with the lower splice (r) (lower splice (r) for LH side) to a diameter (B) of 3.2 mm (C) (.126 in) with the drill (yy), refer to Figure 5, Detail C.

- Counter-drill the RH lateral web (5) (lateral web (4) for LH side) with the 9° frame (u) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 7, Detail J.

- Position the RH upper lateral splice (12) (upper lateral splice (13) for the LH side) on the RH lateral web (5) (lateral web (4) for LH side) and the 9° frame (u), refer to Figure 3, Detail A.
- Counter-drill the RH upper lateral splice (12) (upper lateral splice (13) for the LH side) with the RH lateral web (5) (lateral web (4) for LH side) and the 9° frame (u) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 7, Detail J.

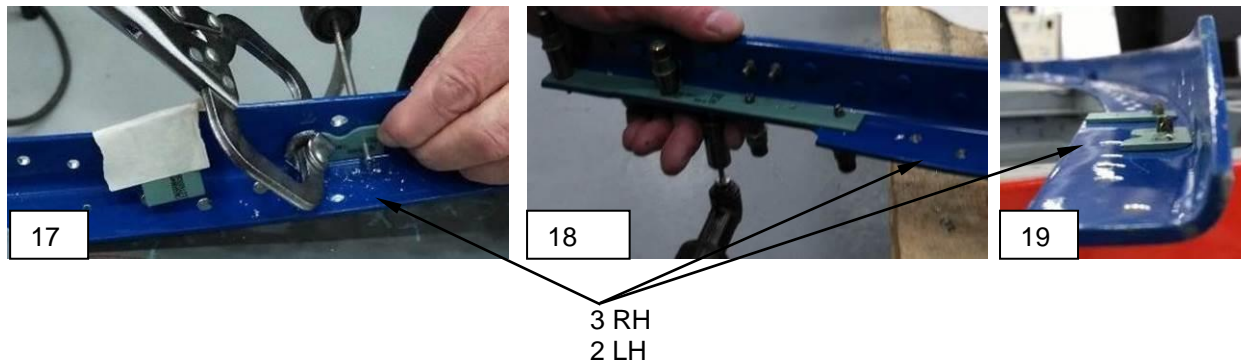
- Position the center splice (t) on the RH inner lateral angle (3) (inner lateral angle (2) for LH side) and the 9° frame (u), refer to Figure 7, Detail J and Section Q-Q.
- Counter-drill the center splice (t) with the RH inner lateral angle (3) (inner lateral angle (2) for LH side) and the 9° frame (u), to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 7, Detail J and Section Q-Q.
- Counter-drill the center splice (t) with the RH inner lateral angle (3) (inner lateral angle (2) for LH side) and the 9° frame (u), to a diameter (C) of 3.2 mm (.126 in) with the drill (xx), refer to Figure 7, Detail J.

No. AS365-53.00.59

- Position the RH upper angle (30) (upper angle (29) for LH side) on the RH exterior angle (11) (exterior angle (10) for LH side), refer to Figure 4, Detail F.
- Counter-drill the RH upper angle (30) (upper angle (29) for LH side) with the RH exterior angle (11) (exterior angle (10) for LH side), to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 6, Detail C.
- Position the RH supports (39) and (41) (supports (38) and (40) for LH side) on the RH lateral web (5) (lateral web (4) for the LH side), refer to Figure 3, Detail A.
- Counter-drill the RH supports (39) and (41) (supports (38) and (40) for LH side) with the RH lateral web (5) (lateral web (4) for the LH side) to a diameter (A) of 4.8 mm (.189 in) with the drill (xx), refer to Figure 6, Detail C.
- Position the RH flight control support (v) (flight control support (w) for LH side) with the shims (ax) and (ay) (shims ((ax) and (ay) for the LH side), refer to Figure 4, Detail F and Sections L-L and M-M.
- Counter-drill the RH flight control support (v) (flight control support (w) for LH side), the shims (ax) and (ay) (shims ((ax) and (ay) for the LH side) with the RH lateral web (5) (lateral web (4) for the LH side), to a diameter (A) of 4.8 mm (.189 in) with the drill (vv), refer to Figure 6, Detail C.
- Position the RH gusset (55) (gusset (54) for LH side), refer to Figure 4, Detail H and I.
- Counter-drill the RH gusset (55) (gusset (54) for LH side) with the lower bracket (as) (lower bracket (as) for the LH side), to a diameter (D) of 4 mm (.157 in) with the drill (vv), refer to Figure 10, Section O-O.
- Position the RH support ambulances (46), (47), (48) and (49) (support ambulances (50), (51), (52) and (53) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side), refer to Figure 9, Section J-J.
- Counter-drill the support ambulances (46), (47), (48) and (49) (support ambulances (50), (51), (52) and (53) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with the RH lateral web (5) (lateral web (4) for the LH side), to a diameter (D) of 4 mm (.157 in) with the drill (vv), refer to Figure 9, Section J-J.
- Position the RH spacer shim (aw) (spacer shim (aw) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side), refer to Figure 4, Detail G.
- Counter-drill the RH spacer shim (aw) (spacer shim (aw) for the LH side) with the RH lateral web (5) (lateral web (4) for the LH side) to a diameter (C) of 3.2 mm (.126 in) with the drill (yy), refer to Figure 4, Detail G.
- Remove:
 - . The RH spacer shim (aw) (spacer shim (aw) for the LH side)
 - . The RH support ambulances (46), (47), (48) and (49) (support ambulances (50), (51), (52) and (53) for the LH side)
 - . The RH gusset (55) (gusset (54) for LH side)
 - . The RH flight control support (v) (flight control support (w) for LH side), the shims (ax) and (ay) (shims ((ax) and (ay) for the LH side)
 - . The RH supports (39) and (41) (supports (38) and (40) for LH side)
 - . The RH upper angle (30) (upper angle (29) for LH side)
 - . The center splice (t)
 - . The RH upper lateral splice (12) (upper lateral splice (13) for the LH side)
 - . The RH outer lateral angle (11) (outer lateral angle (10) for LH side)
 - . The RH inner lateral angle (3) (inner lateral angle (2) for LH side)
 - . The support assy RH (43) and (45) (support assy (42) and (44) for LH side)
 - . The RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side).
 - . The RH lateral web (5) (lateral web (4) for the LH side).

No. AS365-53.00.59

- Position the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) on the RH outer lateral angle (11) (outer lateral angle (10) for LH side) (Figure 4, Details H and I).
- Counter-drill the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) with the RH outer lateral angle (11) (outer lateral angle (10) for LH side) to a diameter (B) of 5 mm (.196 in) with the drill (ww), refer to Figure 4, Details H and I.
- Remove the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) from the RH outer lateral angle (11) (outer lateral angle (10) for LH side).
- Position the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side) on the RH inner lateral angle (3) (inner lateral angle (2) for LH side) (Photos 17, 18 and 19) (Figure 4, Details H and I).



- Counter-drill the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side) with the RH inner lateral angle (3) (inner lateral angle (2) for LH side) to a diameter of 5G6 mm with the boring tool (uu) according to the existing holes, refer to Figure 4, Details H and I and the lower bracket (as).
- Remove the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side).

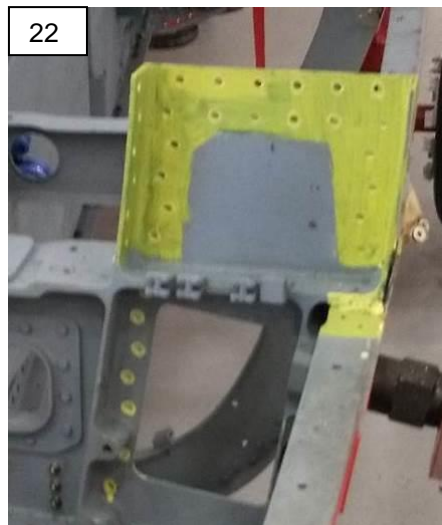
3.B.2.e. Protection touch-up

- Deburr all the previously drilled holes.



- If necessary, do the touch-ups on the splices (7), and (9):
 - . The cadmium plating, refer to Work Card 20-04-04-405 (MTC),
 OR
 - . The protection with the surface protection (98), refer to Work Card 20-04-04-404 (MTC).
- If necessary, perform the touch-ups on the splices (6) and (8) using Alodine, refer to Work Card 20-04-04-403 (MTC).
- Do touch-ups on the protection using the transformation agent (99), refer to Work Card 20-04-04-403 (MTC).
- Do touch-ups on the protection using the Epoxy primer (100) and (101), refer to Work Card 20-04-05-402 (MTC) (Photos 21, 22 and 23).

No. AS365-53.00.59



3.B.2.f. Installation of the lateral parts



CAUTION

BEFORE INSTALLATION, CHECK THE THICKNESS TO BE TIGHTENED TO MAKE SURE OF THE CORRECT LENGTH OF THE RIVETS.

THE INDICATED LENGTH OF THE RIVETS IN THE KIT OF THIS ALERT SERVICE BULLETIN IS THE THEORETICAL LENGTH. IT IS POSSIBLE THAT THE ACTUAL THICKNESS TO BE TIGHTENED WILL VARY WITH THE PARTS STACKED, THEIR NUMBER AND THEIR PROTECTIVE TREATMENTS. DEPENDING ON THE GAUGED THICKNESS OF THE ASSEMBLY, IT IS PERMISSIBLE TO REPLACE THE RIVET INDICATED IN THE KIT WITH A RIVET OF THE SAME STANDARD BUT WITH A HIGHER OR LOWER LENGTH CODE.

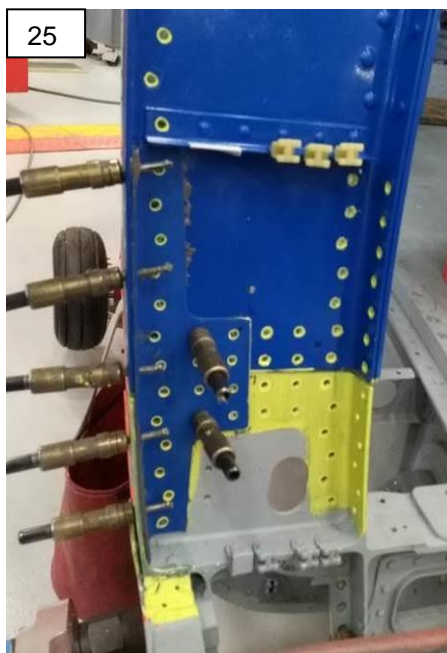
- Position in place the RH lateral web (5) (lateral web (4) for the LH side) in alignment with the lower bracket (as).
- Take into account the clearance J recorded previously with paragraph [3.B.2.c.](#) and, refer to Figure [3](#), Section K-K.
- If the clearance J is less than 0.5 mm (.019 in), continue the process.
- If clearance J is between 0.5 mm (.019 in) and 0.8 mm (.031 in):
 - . Make a shim (static load) on the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) refer to paragraph "H.2.b" of Work Card 20-06-01-418 (MTC).
 - . Prepare the contact surfaces of the RH exterior splices (6) (exterior splices (8) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side) and the lower brackets (as), refer to "C.2.b, SPECIAL CASE" of Work Card 20-06-01-101 (MTC).
 - . Prepare the contact surfaces of the RH interior splice splices (7) (interior splices (9) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side) and the lower brackets (as), refer to paragraph "C.2.a" of Work Card 20-06-01-101 (MTC).
 - . Make a liquid shim, refer to Work Cards 20-06-01-404 and 20-06-01-418 (MTC) with adhesive (102).

No. AS365-53.00.59

- Coat the contact surfaces of the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) with sealing compound (103) (Photo 24) (Figure 5, Section P-P).

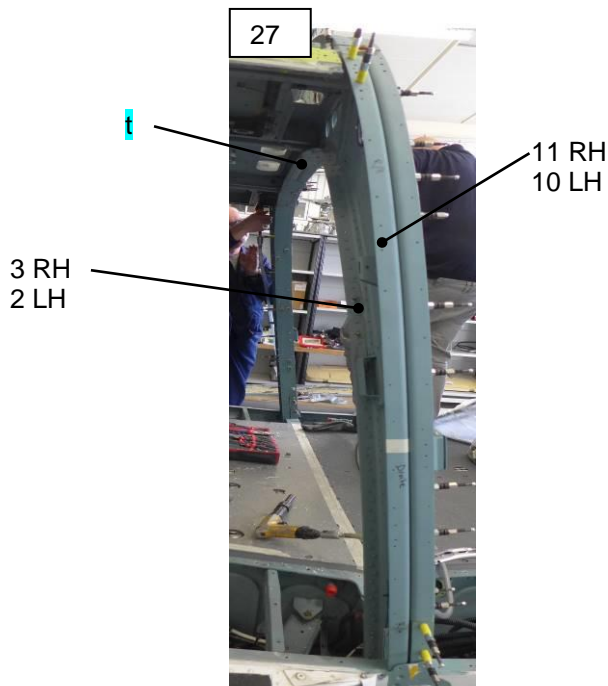


- Position the RH exterior splices (6) and the RH interior splice (7) (exterior splices (8) and interior splice (9) for the LH side) (Photos 25 and 26) (Figure 5, Detail B).

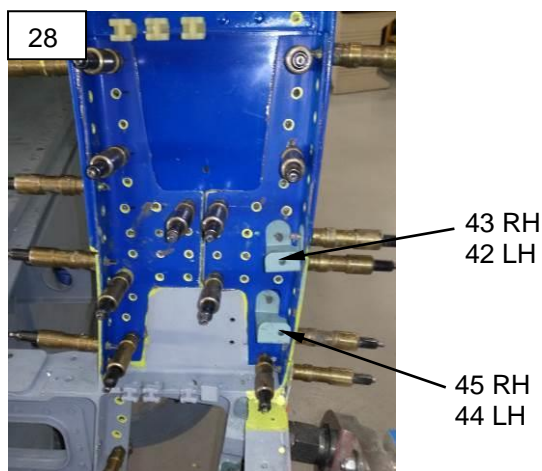


No. AS365-53.00.59

- Position the RH inner lateral angle (3) (inner lateral angle (2) for LH side) (Photo 27) (Figure 4, Detail F).

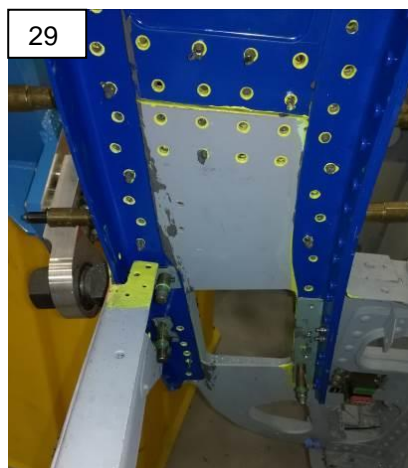


- Position the RH flight control support (v) (flight control support (w) for LH side) and the shims (ax) and (ay) (shims (ax) and (ay) for the LH side) (Figure 4, Detail F and Sections L-L and M-M).
- Position the RH upper angle (30) (upper angle (29) for LH side) (Figure 4, Detail F).
- Position the RH gusset (55) (gusset (54) for LH side) (Figure 4, Details H and I).
- Position the center splice (t) (Photo 27) (Figure 4, Detail F and Figure 7, Detail J and Section Q-Q).
- Position the RH outer lateral angle (11) (outer lateral angle (10) for LH side) (Photo 27) (Figure 4, Detail F).
- Position the RH supports (39) and (41) (supports (38) and (40) for LH side) (Figure 3, Detail A).
- Position the RH upper lateral splice (12) (upper lateral splice (13) for the LH side) (Figure 3, Detail A).
- Position support assy RH (43) and (45) (support assy (42) and (44) for LH side) (Photo 28).
- Immobilize the assembly (Figure 5, Detail B).



No. AS365-53.00.59

- Coat the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) with sealing compound (103) (Figure 4, Details H and I).
- Position the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) on the on the RH outer lateral angle (11) (outer lateral angle (10) for LH side) (Figure 4, Details H and I).
- Coat the contact surfaces of the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side) with sealing compound (103) (Figure 4, Details H and I).
- Position the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side) on the RH inner lateral angle (3) (inner lateral angle (2) for LH side) and (Photos 29 and 30) (Figure 4, Details H and I).



- Install the RH interior splice (7) (interior splice (9) for the LH side) with the rivets (76), (85) and (87) (Photo 31) (Figure 3, Detail A and Figure 5, Detail B).



No. AS365-53.00.59



CAUTION

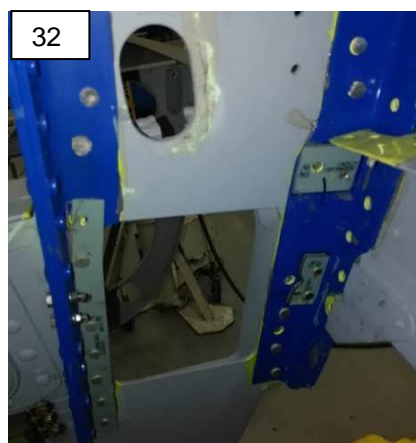
THE RIVETS HEADS (80) AND (81) MUST BE ON THE LOWER BRACKET (as) SIDE.



CAUTION

THE RIVETS HEADS (80) AND (81) MUST NOT BE IN CONTACT WITH RADIUS OF THE RH INNER LATERAL ANGLE (3) (INNER LATERAL ANGLE (2) FOR LH SIDE).

- Coat the contact surfaces of the rivets (80) and (81) with Mastinox (24).
- Install the RH inner lateral angle (3) (inner lateral angle (2) for LH side) and the RH interior block radius (32), (35), (36) and (37) (interior block radius (31), (33) and (34) for LH side) on the lower bracket (as) with the rivets (80) and (81) (Figure 4, Details H and I) (Photo 32).



- Install the RH outer lateral angle (11) (outer lateral angle (10) for LH side) and the RH gusset (55) (gusset (54) for LH side), the block radius EXT RH (27) and (28) ((1) and (26) for the LH side) on the lower bracket (as) with the rivets (75), the screws (64), the washers (65) and the nuts (62), refer to Figure 4, Details H and I and Figure 10, section N-N and O-O (Photo 32).
- Tighten the nuts (62) to the standard torque.
- Install the RH exterior splice (6) (interior splice (8) for the LH side) with the rivets (77), (86), (87), (88) and (89), the screws (61), the washers (59) and the nuts (62) (Photo 31) (Figure 5, Details B and C and Section P-P).
- Tighten the nuts (62) to the standard torque.
- Install the RH outer lateral angle (11) (outer lateral angle (10) for LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with rivets (76), (77), (84), (86), (90) (92) and (124) (Photo 27) (Figure 5, Detail C, Figure 6, Detail C and Figure 7, Detail J).
- Install the support assy RH (43) and (45) (support assy (42) and (44) for LH side) on the RH exterior splice (6) (interior splice (8) for the LH side) with the rivets (84) (Figure 5, Detail B).
- Install the RH inner lateral angle (3) (inner lateral angle (2) for LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with rivets (75), (76), (77), (86), (95), (112) and (113) (Figure 6, Detail C and Figure 7, Detail J).
- install the center splice (t) on the RH inner lateral angle (3) and the LH inner lateral angle (2) with the rivets (75), (77) and (78) (Figure 7, Detail J).

No. AS365-53.00.59

- Install the RH upper lateral splice (12) (upper lateral splice (13) for the LH side) on the on the RH lateral web (5) (lateral web (4) for the LH side) and the 9° frame (u) with rivets (75), (77) and (95) (Figure 3, Detail A and Figure 7, Detail J).
- Install the RH flight control support (v) (flight control support (w) for LH side) and the shims (ax) and (ay) (shims ((ax) and (ay) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (112) (113) and (95) (Figure 10, Sections L-L and M-M and Figure 6, Detail C and Section S-S).
- Install the spacer shims (aw) on the on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (79) (Figure 4, Detail G).
- Install the RH upper angle (30) (upper angle (29) for LH side) on RH outer lateral angle (11) (outer lateral angle (10) for LH side) with the rivets (84) and (86) (Figure 4, Detail F and Figure 6, Details C and P).
- Install the RH lateral web (5) (lateral web (4) for the LH side) on the 9° frame (u) with the rivets (75) and (76). Refer to Figure 7, Detail J.
- Install the RH supports (39) and (41) (supports (38) and (40) for LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (76) (Figure 3, Detail A and Figure 6, Detail C).
- Install the support ambulances (46), (47), (48) and (49) (support ambulances (50), (51), (52) and (53) for the LH side) on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (83) (Figure 3, Section J-J).
- Install the stiffener (av) on the RH lateral web (5) (lateral web (4) for the LH side) with the rivets (74) and (75) (Figure 9, Section H-H and I-I).
- Install the support assy (at) on the stiffner (av) (stiffener (av) for the LH side) with the screws (58), the washers (59) and the nuts (60) (Figure 9, Section H-H and I-I).
- Install on the 9° frame (u), according to claddings, the stud flexible (72) with the rivets (57) (Figure 7, Detail L).
- Install on the RH lateral web (5) (lateral web (4) for the LH side), according to claddings, the stud flexible (72) and the shims (114) and (115) with the rivets (57) (Figure 7, Details M, N and O).
- If necessary, install the profile (104) on the RH lateral web (5) (lateral web (4) for the LH side) (Figure 4, Detail F).

3.B.2.g. Installation of the catches on the lateral parts (Figure 3, Detail A, Figure 6, Detail P and Section B-B and Figure 8)

- Install on RH lateral web (5) (lateral web (4) for the LH side):
 - . The LH support locking (105).
 - . The RH support locking (111).
 - . The LH doubler (107).
 - . The RH doubler (108).
 - . The micro switches (h) (not shown), (k) (not shown)
 - . The screws (61), (69), (70).
 - . The washers (59), (73)
 - . The rivets (96).

No. AS365-53.00.59

3.B.3. Final steps

- Install the rivets (123) on the RH welded reinforcement (ba) ((bc) for LH side). Refer to Figure [11](#), Details W and X.
- Install the rivets (122) and (121) on the airframe. Refer to Figure [11](#), Detail V.
- Install the RH sheet closing (bf) ((bg) for LH side) with the rivets (120) and (121). Refer to Figure [12](#), Section X-X.
- Install the RH plate for hoist (bd) with the rivets (68). Refer to Figure [12](#), Detail AC.
- Install the LH plate for hoist (be) with the rivets (121). Refer to Figure [12](#), Detail AC.
- Install the RH reinforcements (bh) and (bk) ((bh) and (bk) for LH side) with the rivets (121). Refer to Figure [12](#), Section Y-Y.
- install the RH splint (bl) ((bm) for LH side) with the rivets (93), (97), (116), (117), (118) and (119). Refer to Figure [12](#), Detail AB.
- Install the RH fitting (bo) ((bp) for the LH side) with the attachments (bn). Refer to Figure [12](#), Detail AE.
- Install the hoist connector bracket (bq) with the rivets (125). Refer to Figure [11](#), Detail Y.
- Fill the holes (bt) with sealing compound (103). Refer to Figure [5](#), Detail T.
- Install the LH and RH external linings (b) and (c) with rivets (68). Refer to Figure [12](#), Detail Z.
- Remove the reference tool (zz) (Photo 9).
- Install all the equipment removed during the preliminary steps (paragraph [3.B.1.](#)).
- Do an appearance check on aircraft after inspection or repair, refer to Work Card 20-07-03-408 (MTC).
- Install again or close all cowlings, panels, doors and equipment removed and/or opened during preliminary steps (paragraph [3.B.1.](#) of this ALERT SERVICE BULLETIN).
- Connect all power supplies, refer to Work Card 20-07-03-406 (MTC).

3.B.4. Ground run-up / flight test

- Set the helicopter to test condition. E.g.: electrical and hydraulic connections, air, water, oil, fuel.
- Make sure that the physical embodiment of the modification is compatible with the actual modification status of the helicopter: no interferences, sufficient space foreseen, no deviations between the actual and defined configurations, points to be checked have been defined, etc...
- Inspect the fuel flowmeter, refer to Task 28-41-01-601 (MET).
- Perform the functional tests of the hydraulic power systems, refer to Task 29-30-02-501 (MET).
- Check the sensors and the PRE MOD 0771B62 engine temperature indicator, refer to Task 77-20-00-501 (MET).
- Perform the tests of the passenger intercommunication installation, refer to Task 23-40-01-501 (MET).
- Perform the intercommunication tests (DACS), refer to Task 23-41-19-501 (MET).
- Check the thermo-contact and the MGB oil temperature alarm circuit, refer to Task 63-40-00-501 (MET).
- Check the engine oil temperature thermostatic contactor, refer to Task 79-20-00-501 (MET).

No. AS365-53.00.59

3.C. RECORD OF COMPLIANCE

Compliance with this document:

- Record the full compliance with this ALERT SERVICE BULLETIN, with the revision number, in the helicopter documents.
- Record the full embodiment of modification 0753D45 in the helicopter documents.
- Record compliance with this ALERT SERVICE BULLETIN (see IN 3785-I-00 for instructions):
QR code or hypertext link



NOTE 3

The recording of compliance with ALERT SERVICE BULLETINS in the SB Insight tool does not replace the recording in the helicopter documents.

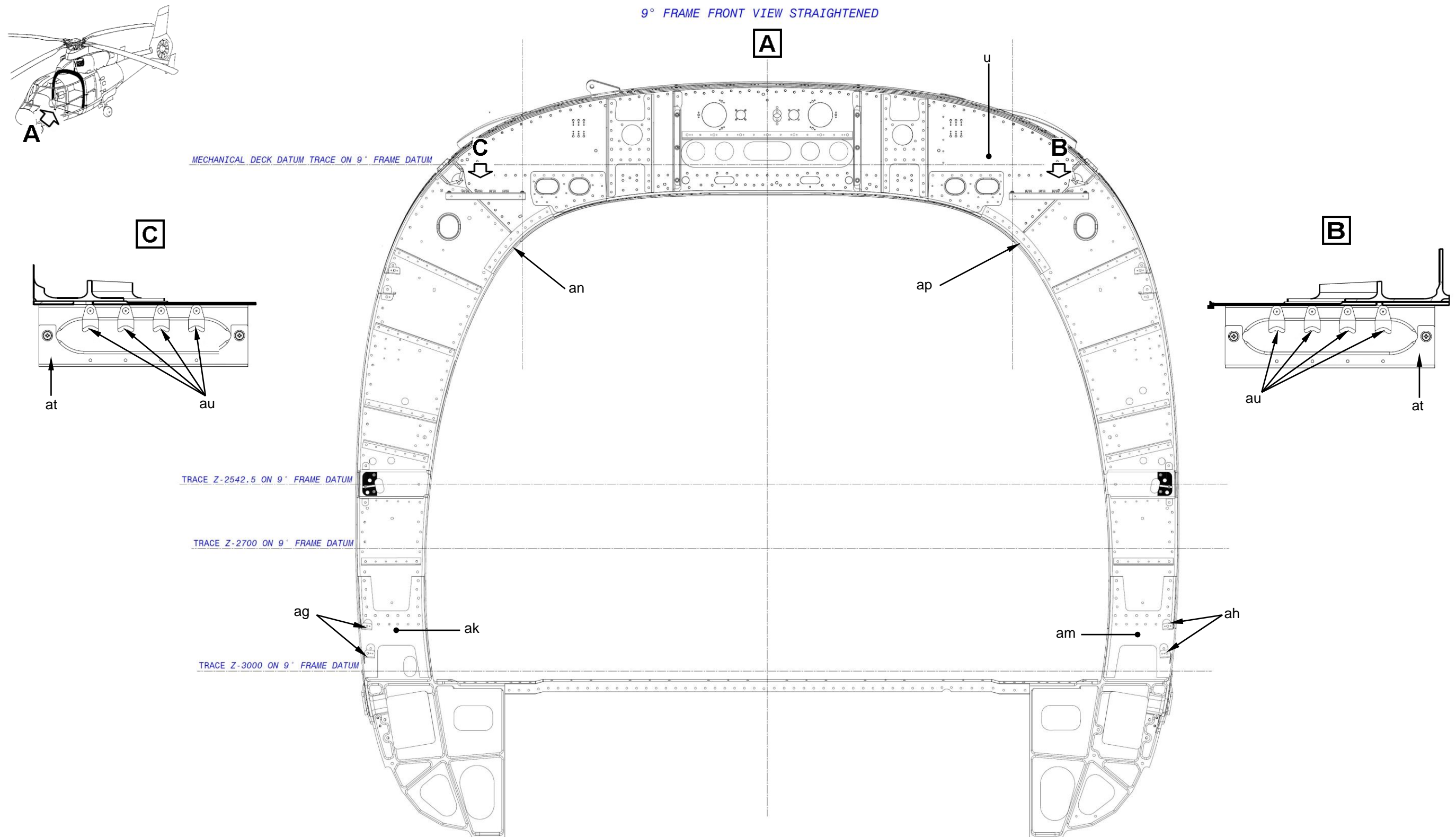
[ASB AS365-53.00.59](#)

3.D. OPERATING AND MAINTENANCE INSTRUCTIONS

Not applicable.

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



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

Figure 1

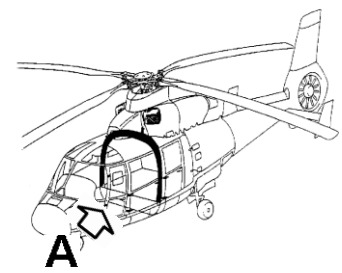
No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

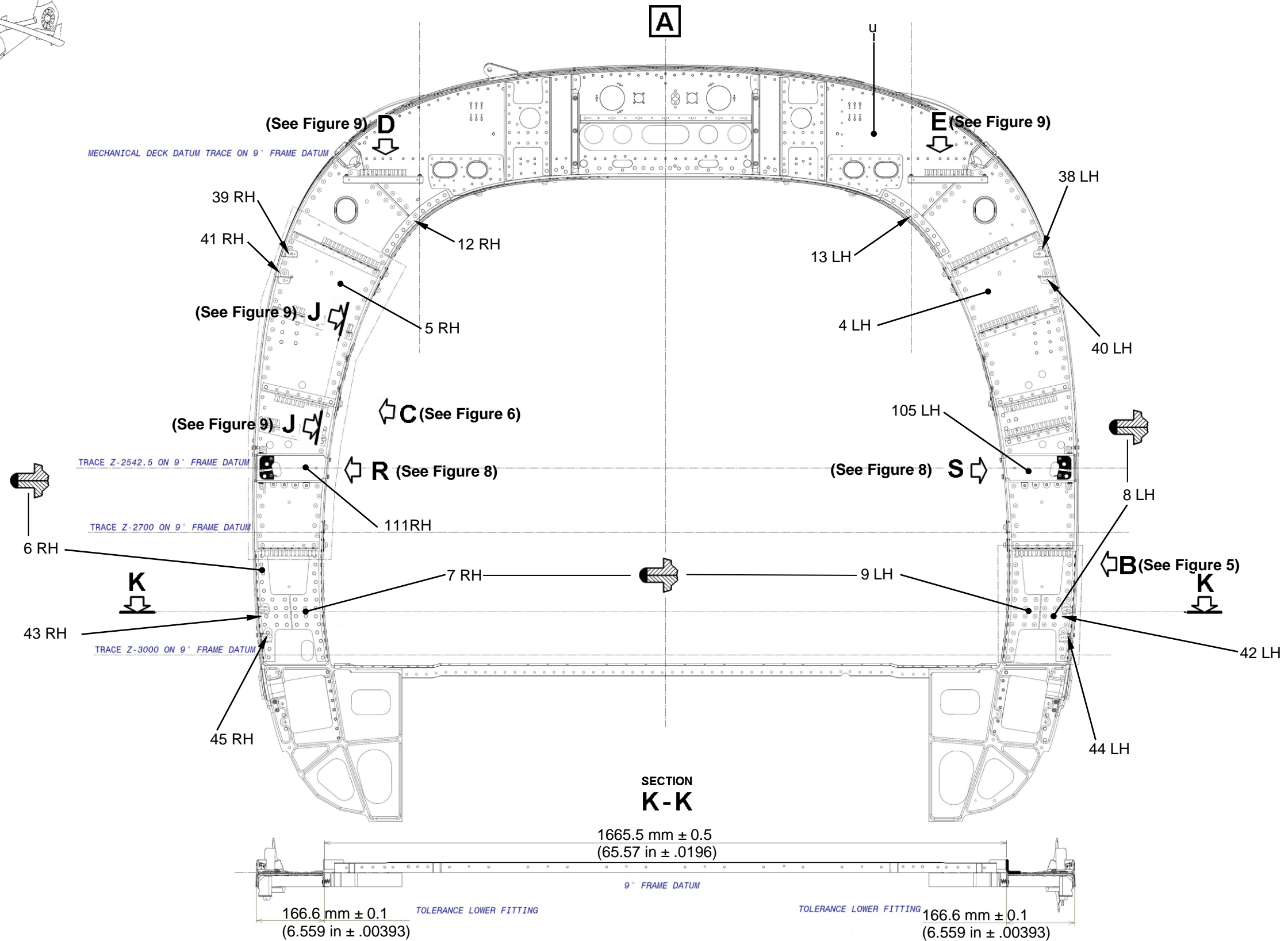
No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



9° FRAME FRONT VIEW STRAIGHTENED



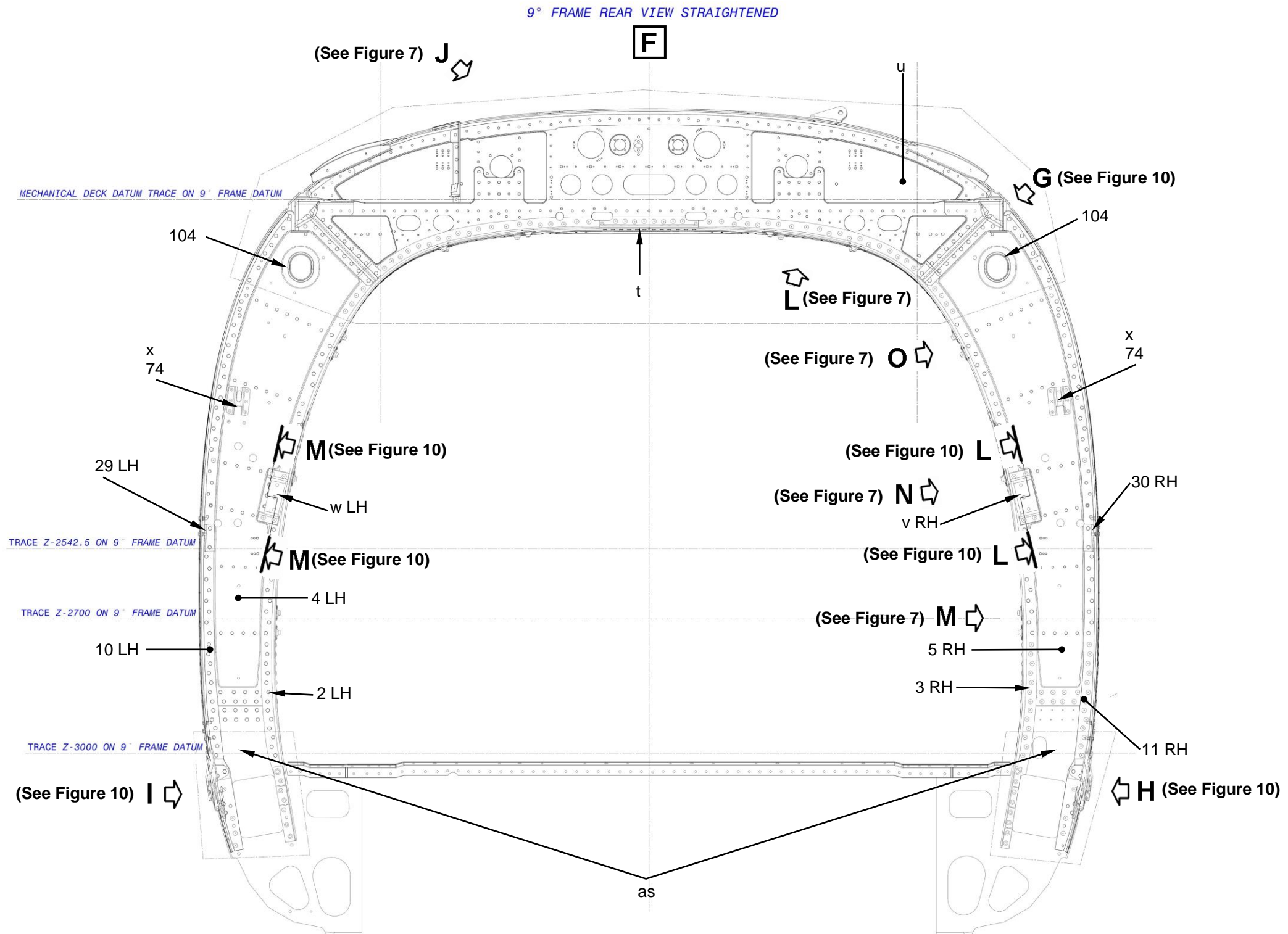
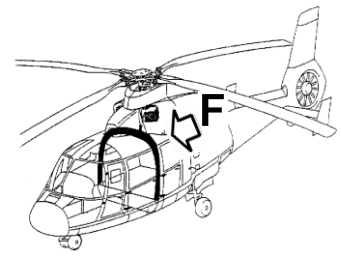
Back to paragraphs [3.B.2.b.](#), [3.B.2.c.](#), [3.B.2.d.](#), [3.B.2.f.](#), [Figure 5](#), [Figure 6](#), [Figure 8](#) and [Figure 9](#)

Figure 3

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



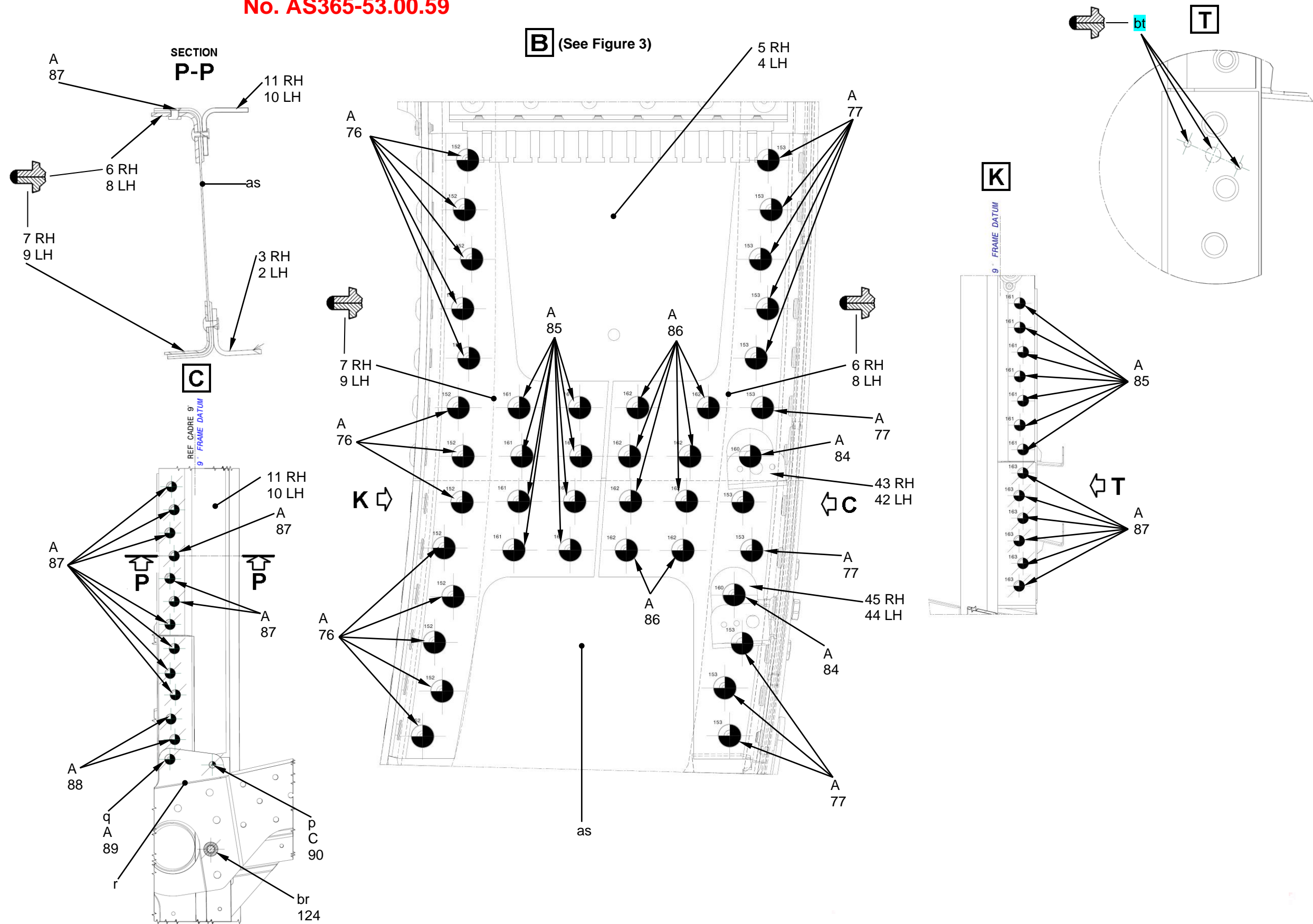
Back to paragraphs [3.B.2.b.](#), [3.B.2.c.](#), [3.B.2.f.](#), [3.B.2.d.](#), [Figure 7](#) and [Figure 10](#).

Figure 4

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



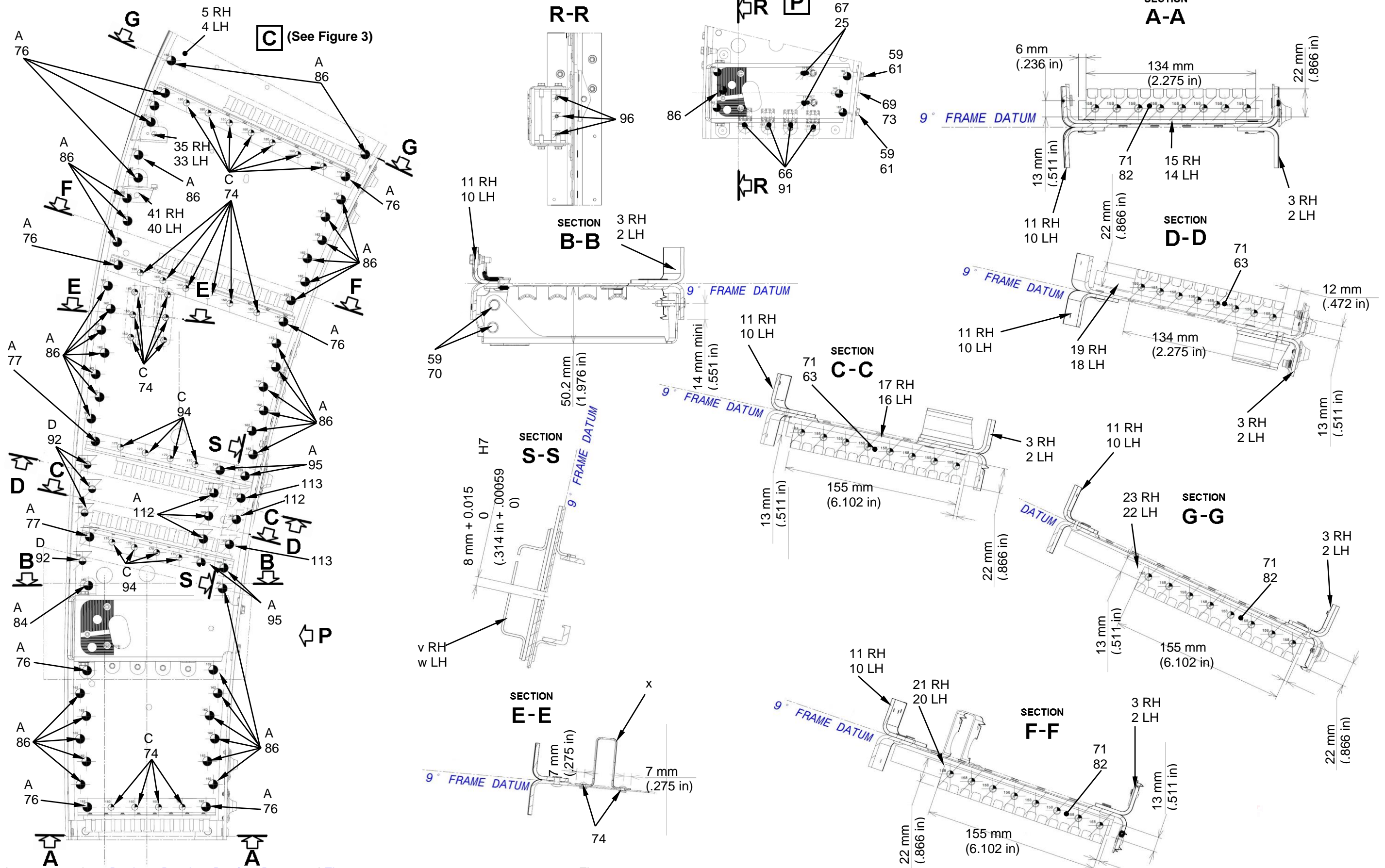
Back to paragraphs [3.B.2.c.](#), [3.B.2.d.](#), [3.B.2.f.](#), and Figure 3.

Figure 5

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



Back to paragraphs 3.B.2.b., 3.B.2.d., 3.B.2.f., 3.B.2.g. and Figure 3.

Revision 0 2015-12-01
Revision 1 2024-02-15

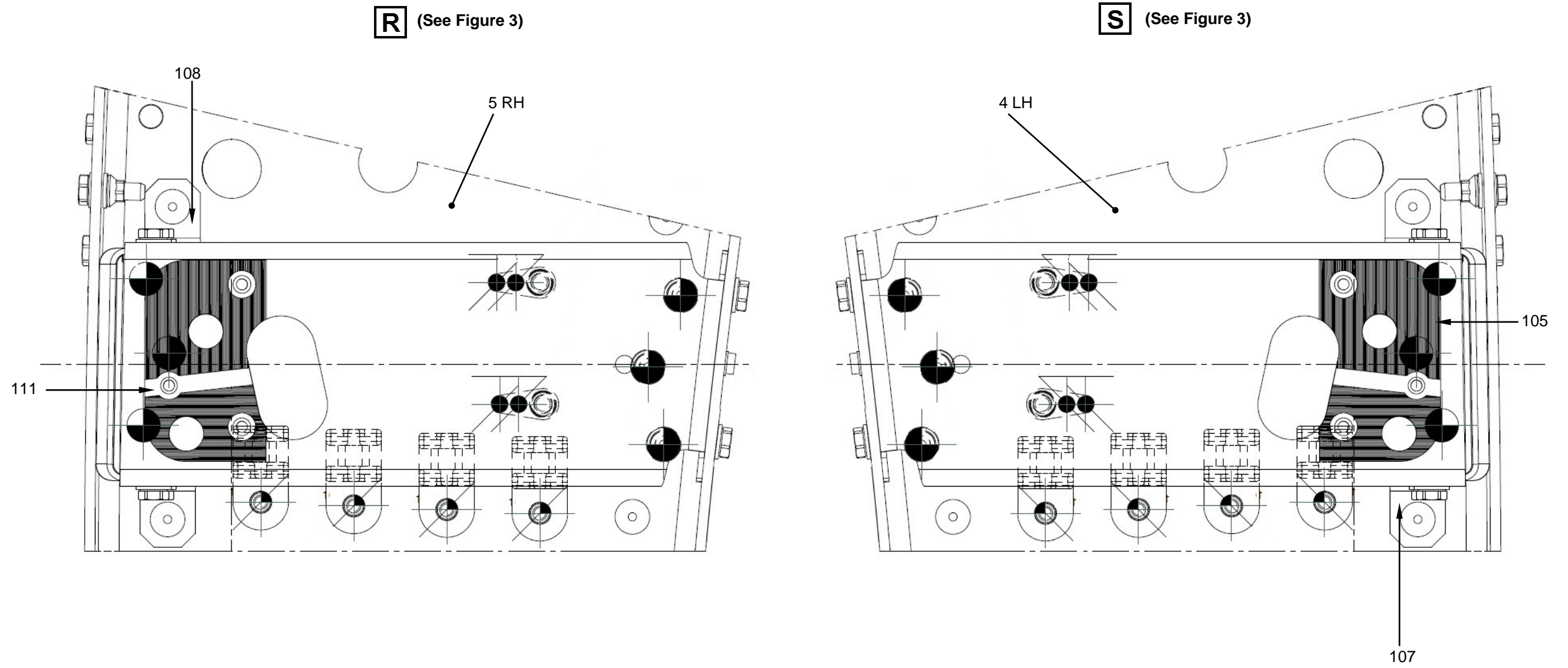
Figure 6

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY



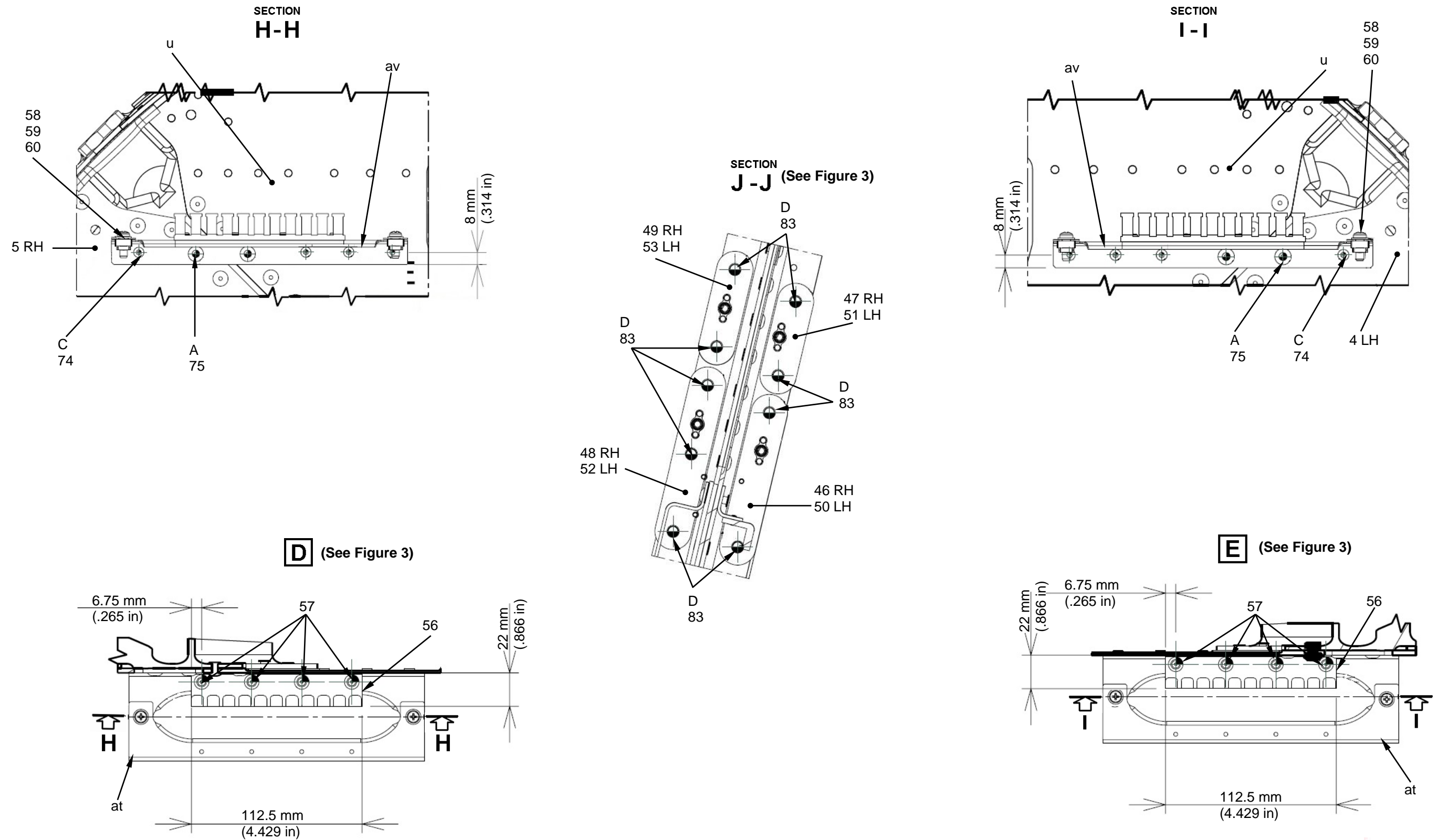
Back to paragraph [3.B.2.g.](#) and [Figure 3.](#)

Figure 8

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



Back to [Figure 3](#)

Figure 9

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59

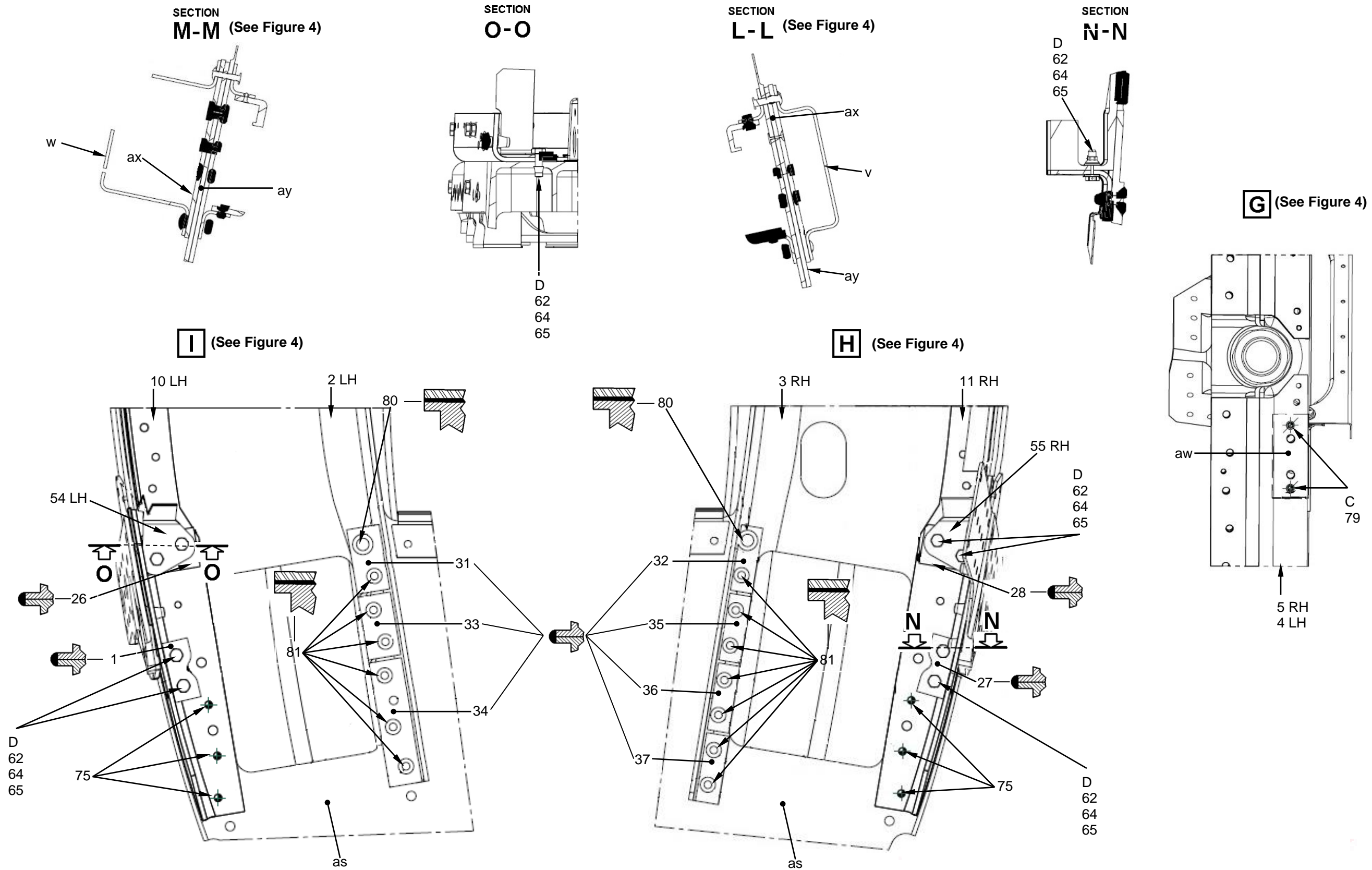


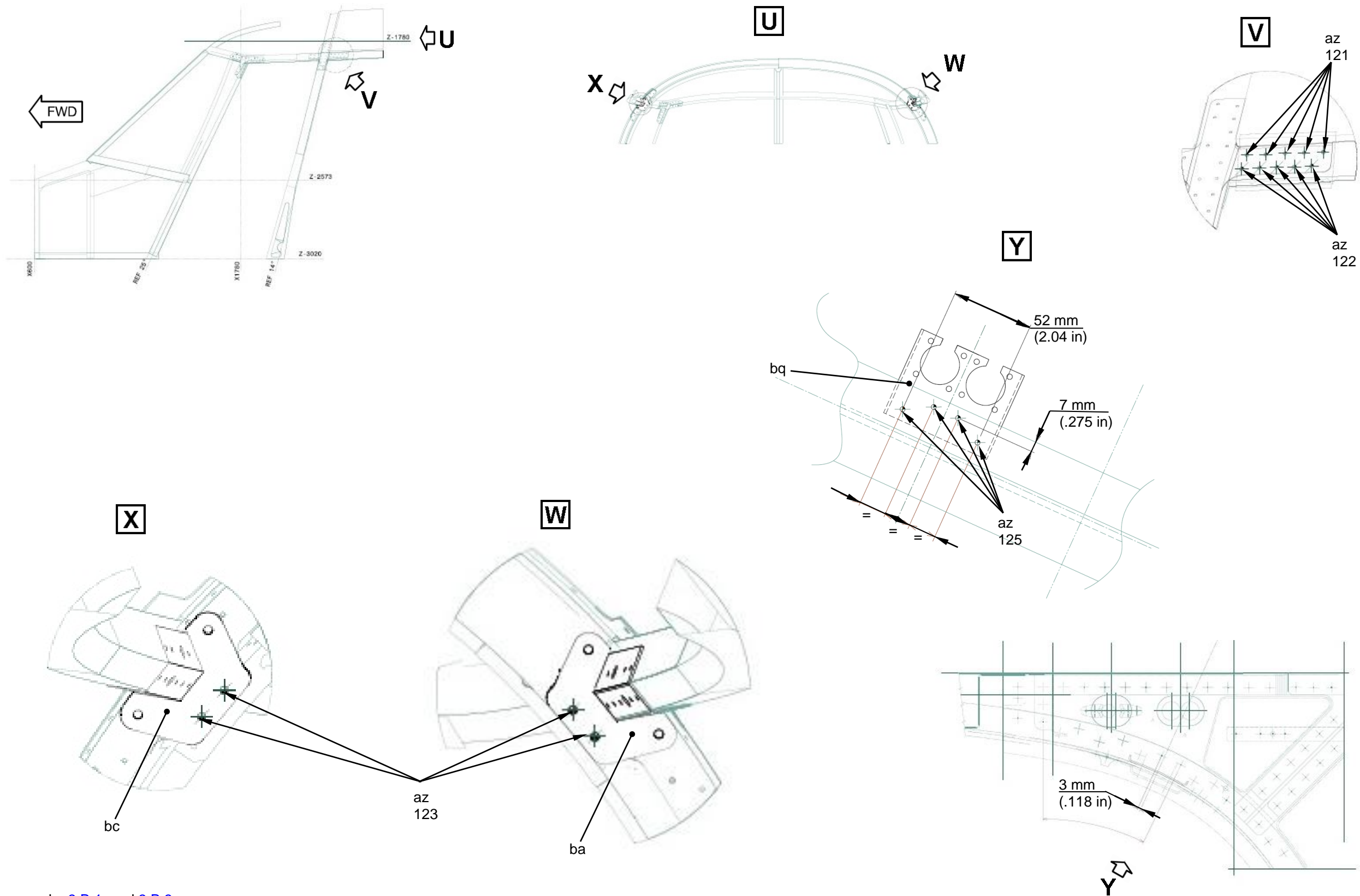
Figure 10

Back to [Figure 4](#)

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59



Back to paragraphs [3.B.1.](#) and [3.B.3.](#)

Figure 11

No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

No. AS365-53.00.59

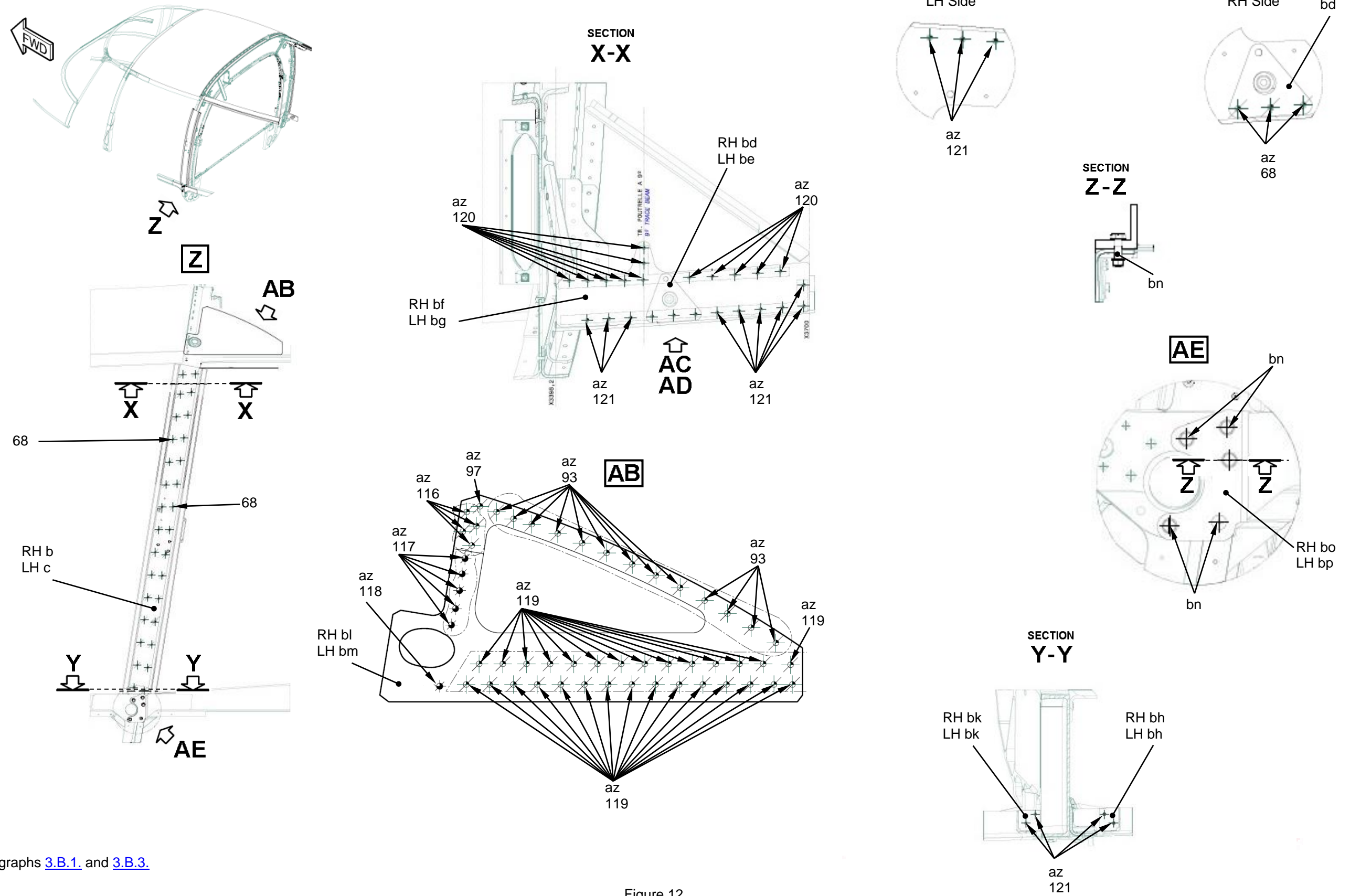


Figure 12

Back to paragraphs [3.B.1.](#) and [3.B.3.](#)

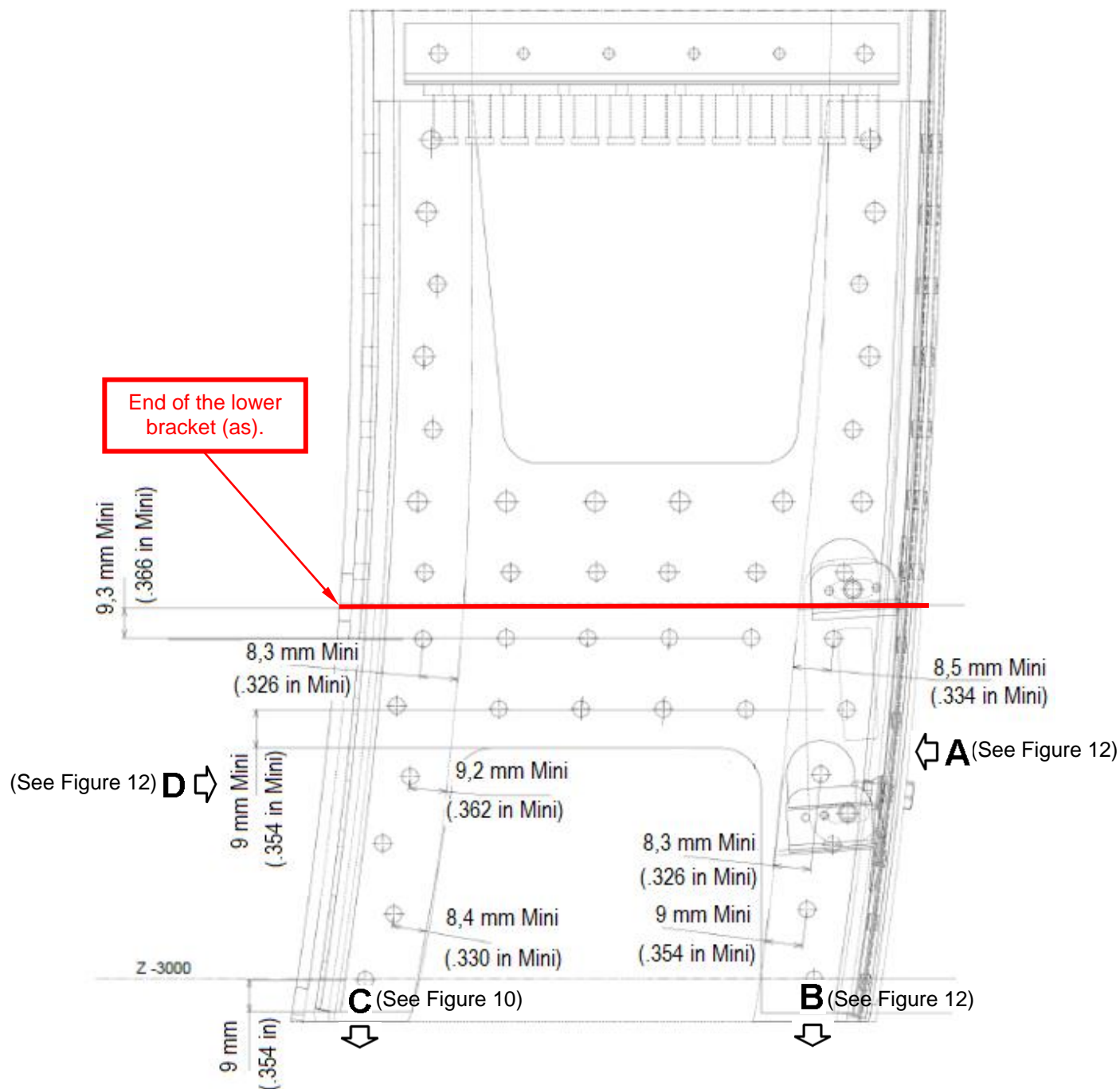
No. AS365-53.00.59

PAGE LEFT BLANK INTENTIONNALLY

4. APPENDIX

4.A. Check of the straps of the lower brackets

Lower bracket, front view
 LH SIDE IN DRAWING, RH SIDE SYMMETRICAL

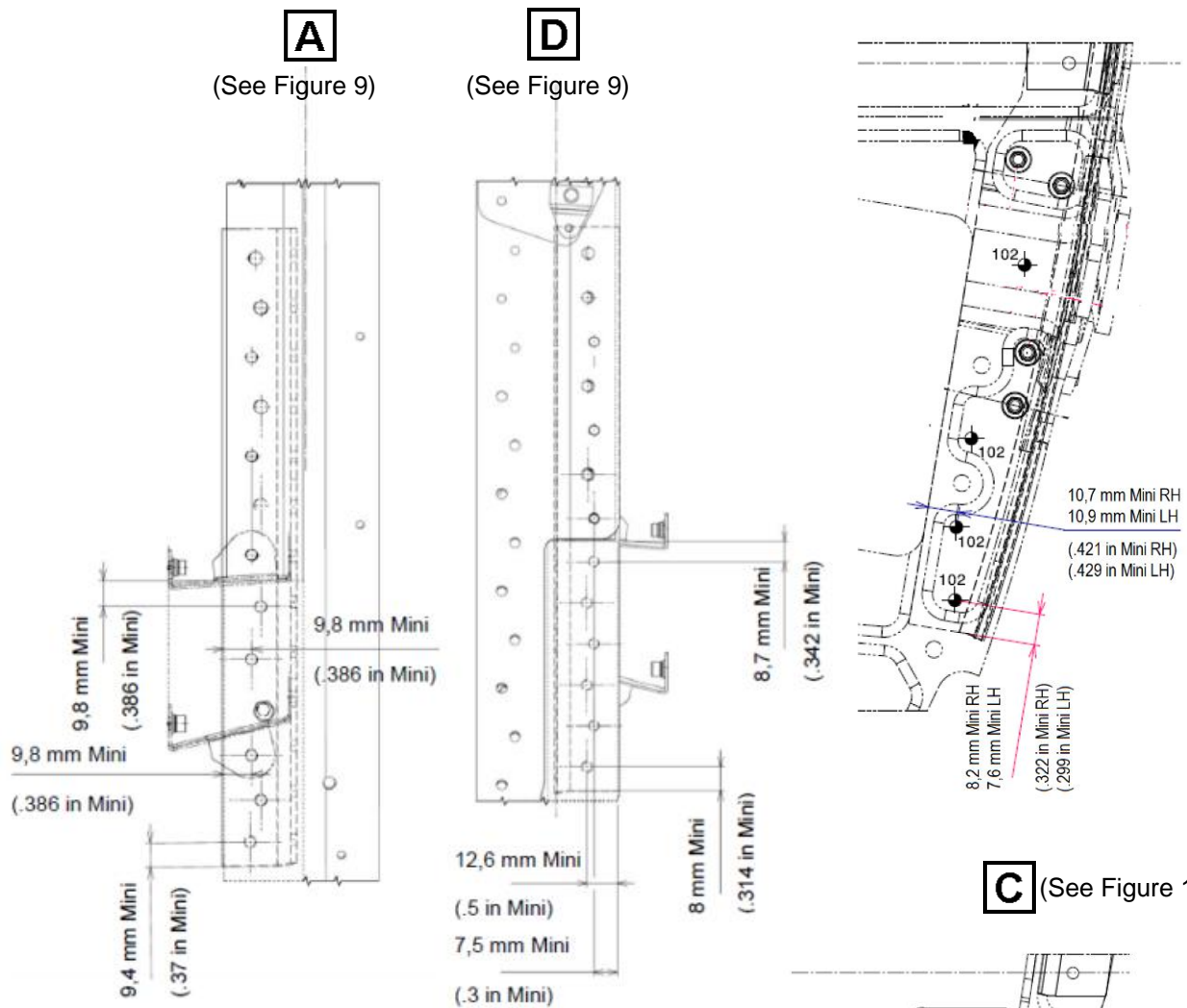


Back to paragraph [3.B.1.](#)

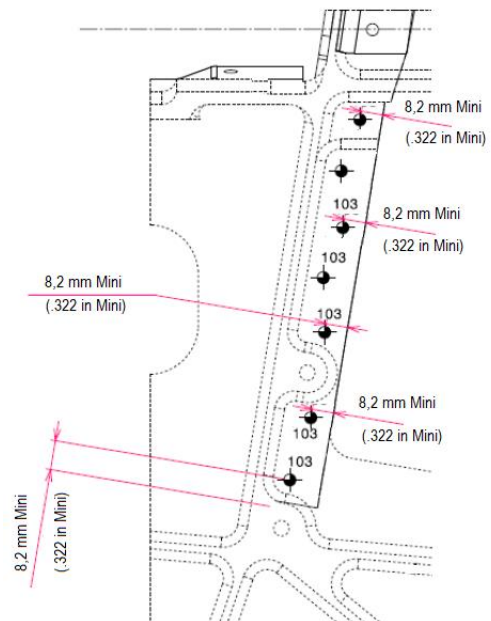
Figure 11

No. AS365-53.00.59

B (See Figure 11)



C (See Figure 11)



Back to paragraph [3.B.1.](#)

Figure 12