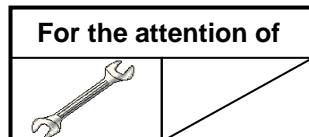


Civil version(s): C1, L1, L2  
 Military version(s): M1

# SERVICE BULLETIN

## PRODUCT IMPROVEMENT

**ROTOR FLIGHT CONTROLS - Yaw controls**  
**Reinforcement of the yaw damper support**  
 Corresponds to modification 0728207



Revision No.	Date of issue
Revision 0	2020-03-02

### Summary:

The purpose of this Service Bulletin is to replace the yaw damper support with a new reinforced support. Compliance with this Service Bulletin cancels compliance with ALERT SERVICE BULLETIN No. 05.00.98 for L2 version helicopters.

### Compliance:

Airbus Helicopters recommends compliance with this Service Bulletin.

## 1. PLANNING INFORMATION

### 1.A. EFFECTIVITY

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

- C1, L1 and M1 version helicopters that are POST MOD 0726640 and PRE MOD 0728207.
- L2 version helicopters that are PRE MOD 0728207.

#### **NOTE 1**

*Modification 0726640 consists in changing the flight controls and the hydraulic system.*

#### **NOTE 2**

*Refer to the Individual Inspection Log Book (RIC AMS) and the Aircraft Log Book to identify the current modification status of the helicopter.*

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

Yaw damper support P/N 332A25-1334-00.

### 1.B. ASSOCIATED REQUIREMENTS

Not applicable.

### 1.C. REASON

Airbus Helicopters has been informed of several cases of cracks on the two front attachments of the yaw control damper support. Investigations have shown that the actions on the pedal block generate loads on the damper support attachments, which can lead to the initiation of cracks in the damper support.

Consequently, Airbus Helicopters has defined modification 0728207 to replace the yaw control damper support with a new reinforced support.

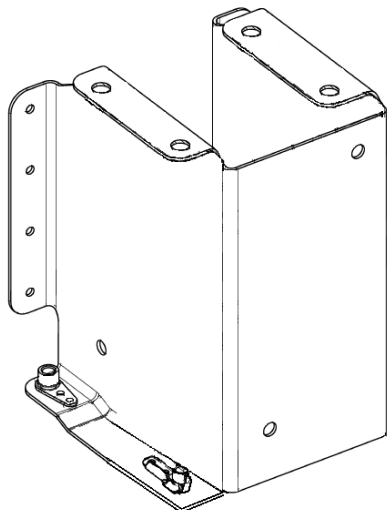
Compliance with this Service Bulletin cancels compliance with ALERT SERVICE BULLETIN No. 05.00.98 for L2 version helicopters.

## 1.D. DESCRIPTION

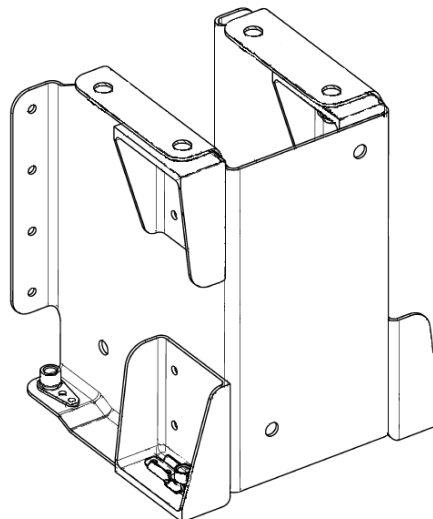
Modification 0728207 consists in:

- removing the yaw damper and its support,
- installing the new reinforced support and the yaw damper.

PRE MOD



POST MOD



## 1.E. COMPLIANCE

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

Not applicable.

### 1.E.2. Compliance in service

Helicopters/installed equipment or parts:

The work must be performed on the helicopter by the operator.

C1, L1 and M1 version helicopters:

Airbus Helicopters recommends compliance with paragraph [3.](#) except paragraph 3.B.2.c. of this Service Bulletin during one of the next maintenance inspections as per operational constraints.

L2 version helicopters:

Airbus Helicopters recommends compliance with paragraph [3.](#) except paragraph 3.B.2.b. of this Service Bulletin during one of the next maintenance inspections as per operational constraints.

Non-installed equipment or parts:

The build-up of stocks for compliance with this Service Bulletin is left to the operator's initiative.

## 1.F. APPROVAL

### Approval of modifications:

The information or instructions relate to modification 0728207 issue 4, which was approved on September 14, 2017 under the authority of EASA Design Organization Approval No. 21J.700 for civil version helicopters subject to an Airworthiness Certificate.

The information or instructions relate to modification 0728207 issue 3, which was approved on October 06, 2017 under the prerogatives of the recognition of design capability FRA21J-002-DGA for French Government helicopters.

The information or instructions relate to modification 0728207 issue 3, which was approved on October 06, 2017 by the Airbus Helicopters Airworthiness Department for export military versions.



### Approval of this document:

The technical information contained in this Service Bulletin Revision 0 was approved on January 20, 2020 under the authority of EASA Design Organization Approval No. 21J.700 for civil version helicopters subject to an Airworthiness Certificate.

The technical information contained in this Service Bulletin Revision 0 was approved on January 20, 2020 under the prerogatives of the recognition of design capability FRA21J-002-DGA for French Government helicopters.

The technical information contained in this Service Bulletin Revision 0 was approved on January 20, 2020 by the Airbus Helicopters Airworthiness Department for export military versions.

## 1.G. MANPOWER



For compliance with this Service Bulletin, Airbus Helicopters recommends the following staff qualifications:

Qualification:           - 1 Mechanical Technician,  
                                  - 1 Airframe Technician.



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

Estimated Man-hours:   - 4 hours for the Mechanical Technician,  
                                  - 4 hours for the Airframe Technician.



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

Helicopter downtime is estimated at 1 day.

## 1.H. WEIGHT AND BALANCE



### C1, L1 and M1 version helicopters:

Weight: + 0.074 kg  
Longitudinal moment: +0.052 m.kg  
Lateral moment: +0.09 m.kg

### L2 version helicopters:

Weight: + 0.065 kg  
Longitudinal moment: +0.047 m.kg  
Lateral moment: +0.078 m.kg

After work completion, record new weights and moments in your dedicated document.

## 1.I. POWER CONSUMPTION

Not applicable.

## 1.J. SOFTWARE UPGRADES/UPDATES

Not applicable.

## 1.K. REFERENCES

The following documents are required for compliance with this Service Bulletin.

### Standard Practices Manual (MTC):

MTC: 20-02-04-401: Installation of rivets - pitch and edge distance - Riveting  
MTC: 20-02-04-601: General riveting acceptance requirements - Riveting  
MTC: 20-02-05-404: Assembly by screws and nuts - Joining  
MTC: 20-02-07-407: Use of conductive paste CHO-LUB E117 - Electrical bonding  
MTC: 20-03-01-102: 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: 20-04-01-102: Use of cleaning products on individual parts and on helicopters - Cleaning  
MTC: 20-04-04-403: Touch-up the Alodine 1200 protection - Surface treatment before painting  
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 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

### Maintenance Manual (MET): (C1, L1 and M1 version helicopters)

MET: 67-00-00-301: General Instructions - General  
MET: 67-20-01-405: Removal - Installation of yaw damper POST MOD 0726640 - Tail rotor controls

Aircraft Maintenance Manual (MMA): (L2 version helicopters)

MMA: 67-00-00-611: General instructions - Rotor controls

MMA: 67-22-00-064: Yaw damper Removal - Installation - Yaw controls

## 1.L. OTHER AFFECTED PUBLICATIONS



### **CAUTION**

**TO COMPLY WITH THIS SERVICE BULLETIN, THE OPERATOR MUST MAKE SURE THAT ALL THE MAINTENANCE DOCUMENTS REQUIRED FOR THE MAINTENANCE OF THIS INSTALLATION ARE AVAILABLE. IF NOT, IT IS THE OPERATOR'S RESPONSIBILITY TO OBTAIN THE DOCUMENTS FROM THE USUAL AIRBUS HELICOPTERS CONTACT.**

This modification has been integrated into the following manuals:

- Maintenance Manual (MET),
- Aircraft Maintenance Manual (MMA).

These documents are distributed as per subscription.

Revision of the Illustrated Parts Catalog (IPC) will be updated on the customer's order.

## 1.M. PART INTERCHANGEABILITY OR MIXABILITY

Interchangeability:

PRE MOD and POST MOD parts are not interchangeable.

Mixability:

Not applicable.

## 2. EQUIPMENT OR PARTS INFORMATION

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

Price

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

Availability

Delivery lead times will be indicated by the Sales and Customer Relations Department on the operator's request.

Procurement conditions

Order the required quantity from the Airbus Helicopters Network Sales and Customer Relations Department:

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

**NOTE**

*On the purchase order, please specify the mode of transport, the destination and the serial numbers of the helicopters to be modified.*

### 2.B. LOGISTIC INFORMATION

Not applicable.

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

Kits to be ordered for one C1, L1 or M1 version helicopter:

Designation	Qty	New P/N	Item	Old P/N	→	Instruction
<b>YAW DAMPER SUPPORT REINFORCEMENT</b>		<b>332A07-2820-7171</b>				
Mushroom head bolt	2	22271TK050032X	2			
Hexagonal head bolt	2	22125BC050018L	3			
Hexagonal head bolt	2	22125BC050016L	5			
Countersunk head bolt	1	22252TK050024X	6			
Flat round-head rivet	8	ECS2151DXJ3208	7			
Washer	6	23111AG050LE	8			
Damper support (MK1)	1	332A25-1338-01	9	332A25-1334-00		Discard
Countersunk head bolt	1	22251BC050034L	10			

Kits to be ordered for one L2 version helicopter:

Designation	Qty	New P/N	Item	Old P/N	→	Instruction
<b>YAW DAMPER SUPPORT REINFORCEMENT</b>		<b>332A07-2820-7071</b>				
Support assembly	1	332A25-1334-01	1	332A25-1334-00		Discard
Mushroom head bolt	2	22271TK050032X	2			
Hexagonal head bolt	2	22125BC050018L	3			
Mushroom head bolt	1	22271BC050032L	4			
Hexagonal head bolt	2	22125BC050016L	5			
Countersunk head bolt	1	22252TK050024X	6			
Flat round-head rivet	8	ECS2151DXJ3208	7			
Washer	7	23111AG050LE	8			

Consumables to be ordered separately:

As per the Work Cards and/or Tasks indicated in this Service Bulletin and the table below:

Designation	Qty	Consumable P/N	CM	Item
Chemical conversion material	0.1L	ALODINE 1132 TOUCH-N-PREP	CM0316	11

The consumables can be ordered separately from the following companies:

Aviatec global aviation

Website: [www.aviatec.net](http://www.aviatec.net)  
 Telephone: +33 1.34.46.45.24 or +49 4193 8803 630  
 Fax: +33 1.34.46.45.26 or +49 4193 8803 699  
 AOG: +49 4193 8803 660  
 AOG e-mail: [aog@aviatec.aero](mailto:aog@aviatec.aero)

Gaches chimie

Website: [www.gaches.com](http://www.gaches.com)  
 Telephone: +33 5.61.31.64.45  
 Fax: +33 5.61.40.98.63  
 AOG e-mail: [marketplace@gaches.com](mailto:marketplace@gaches.com)

BDSI

Website: [www.boeingdistribution.com](http://www.boeingdistribution.com)  
 Telephone: +1.305.925.2600  
 Fax: +1.305.507.7191  
 AOG: +1.305.471.8888  
 AOG e-mail: [AOGdesk@Boeingdistribution.com](mailto:AOGdesk@Boeingdistribution.com)

Special tools:

As per the Work Cards indicated in this Service Bulletin.

## 2.D. EQUIPMENT OR PARTS TO BE RETURNED

Not applicable.



### 3. ACCOMPLISHMENT INSTRUCTIONS

#### 3.A. GENERAL

- As per Work Card 20-02-04-401 (MTC), read and comply with the instructions for the installation of rivets.
- As per Work Card 20-02-04-601 (MTC), read and comply with the riveting acceptance requirements.
- As per Work Card 20-03-01-102 (MTC), read and comply with the unriveting instructions.
- As per Work Card 20-03-02-101 (MTC), read and comply with the general instructions for rivet replacement.
- As per Work Card 20-03-02-401 (MTC), read and comply with the instructions for the installation of normal rivets.
- As per Work Card 20-04-01-102 (MTC), read and comply with the instructions on the use of cleaning products on individual parts and on aircraft.
- As per Work Card 20-07-02-201 (MTC), read and comply with the safety instructions for helicopters parked in a repair shop.
- As per Work Card 20-07-03-406 (MTC), read and comply with the instructions applicable when working on an aircraft electrical circuit and power generating systems.
- As per Work Card 20-08-05-102 (MTC), read and comply with the rules applicable to the repair and maintenance of aircraft.
- As per Work Card 67-00-00-301 (MET) or Task 67-00-00-611 (MMA), read and comply with the general instructions for rotors.

Unless differently specified, tighten the bolts to standard torque as per Work Card 20-02-05-404 (MTC).

#### 3.B. WORK STEPS

##### 3.B.1. Preliminary steps

- Park the helicopter in a maintenance shop.
- Install appropriate access equipment.
- Disconnect all electrical power supplies.
- Remove equipment and furnishings to enable adequate access to the various work areas.

##### 3.B.2. Procedure

###### 3.B.2.a. Removal of the yaw damper support ([Figure 1](#))

- Remove the yaw damper (b) as per Work Card 67-20-01-405 (MET) (C1, L1, M1 version helicopters) or as per Sub-task 67-22-00-034-001 of Task 67-22-00-064 (MMA) (L2 version helicopters).
- Discard the attachment components.
- Remove and discard the bolts (d) and (f) and the washers (e).
- Remove the eight rivets (c).
- Remove and discard the yaw damper support (a).
- Clean and remove grease from the work area.

###### 3.B.2.b. Installation of the damper support (C1, L1, M1 version helicopters [Figure 2](#))

- Position the damper support (9) on the structure.
- Counter drill the holes (A) of the damper support (9) to 3.3 mm diameter to match the structure.
- Temporarily attach the damper support (9) to the structure.
- Drill the holes (B) in the damper support (9) to 3.3 mm diameter to match the existing holes in the structure.
- Trim the damper support (9) to obtain an edge distance of  $8^{+1}$  mm (Detail D).

- Perform protective touch-ups using chemical conversion material CM 316 (11) as per Work Card 20-04-04-403 (MTC).
- Perform the electrical bonding between the damper support (9) and the structure as per Work Card 20-02-07-407 (MTC).
- Attach the damper support (9) using the eight rivets (7) (SECTION C-C).
- Install the washers (8) and the bolts (2), (6) and (10).
- Tighten the bolts (2), (6) and (10) to standard torque.
- Install the yaw damper (b) using the washers (8) and the bolts (3) and (5) as per Work Card 67-20-01-405 (MET).

#### 3.B.2.c. Installation of the equipped support (L2 version helicopters, [Figure 3](#))

- Position the equipped support (1) on the structure.
- Counter drill the holes (A) of the equipped support (1) to 3.3 mm diameter to match the structure.
- Perform the electrical bonding between the equipped support (1) and the structure as per Work Card 20-02-07-407 (MTC).
- Attach the equipped support (1) using the eight rivets (7) (SECTION C-C).
- Install the washers (8) and the bolts (2), (4) and (6).
- Tighten the bolts (2), (4) and (6) to standard torque.
- Install the yaw damper (b) using the washers (8) and the bolts (3) and (5) as per Sub-task 67-22-00-434-001 of Task 67-22-00-064 (MMA).

#### 3.B.3. Final steps

- Clean and restore the work areas and the helicopter as per Work Card 20-07-03-408 (MTC).
- Install the equipment and furnishings removed during preliminary steps (paragraph [3.B.1.](#)).
- Remove the access equipment.
- Set the helicopter to flight condition.

### 3.C. RECORD OF COMPLIANCE

#### Compliance with this document:

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

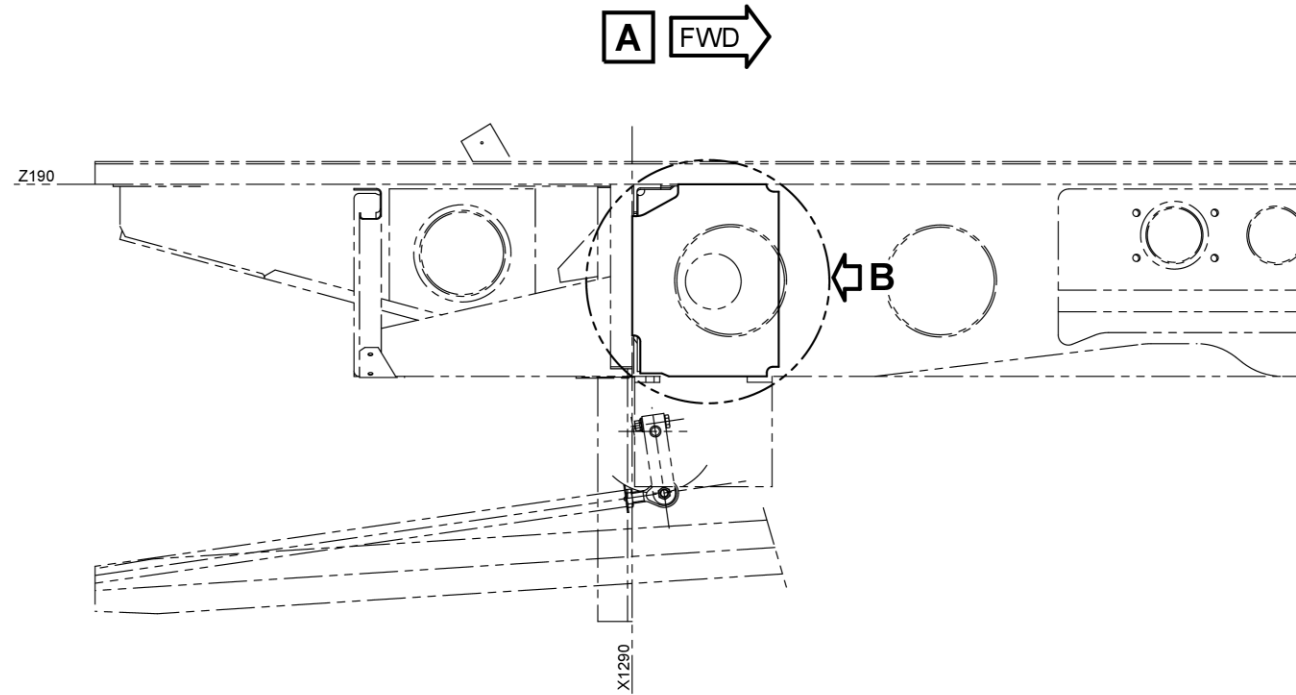
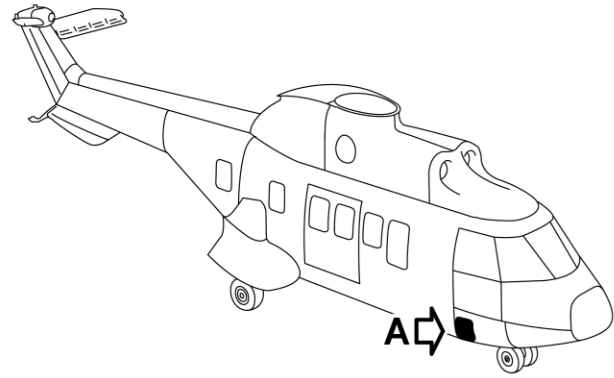
#### Tracking of modifications in the documentation:

Record full embodiment of modification 0728207 in the helicopter documents.

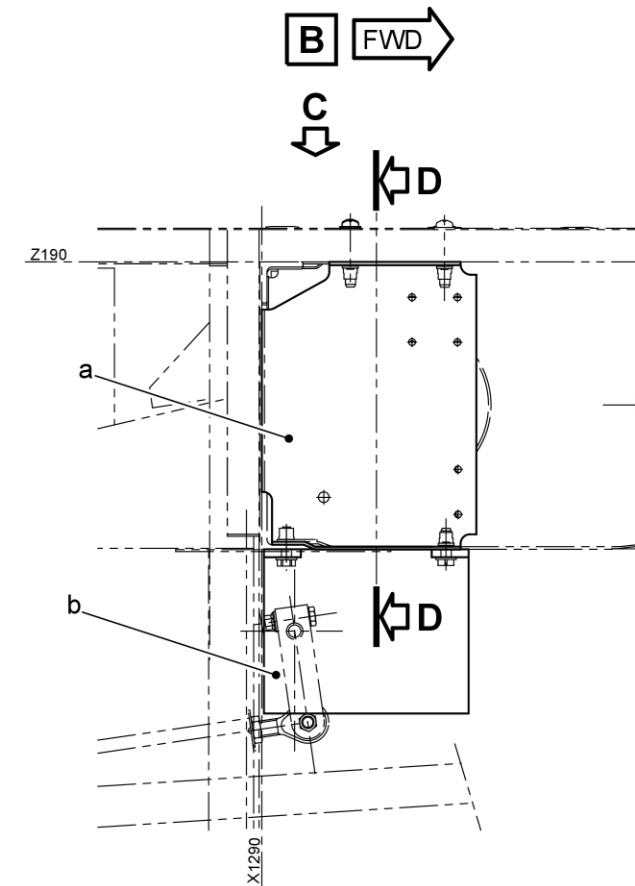
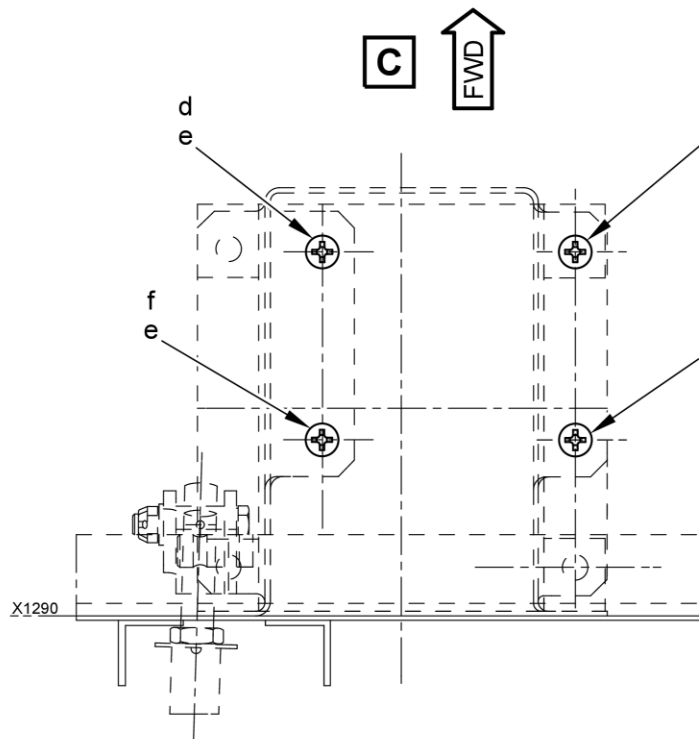
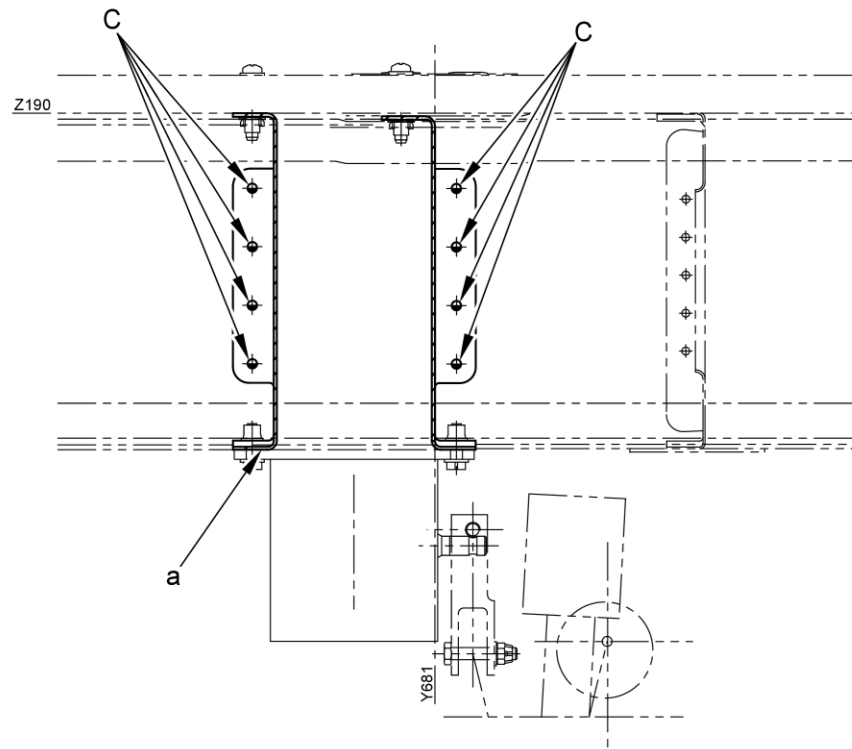
### 3.D. OPERATING AND MAINTENANCE INSTRUCTIONS

Not applicable.

PRE MOD 0728207



SECTION  
D-D

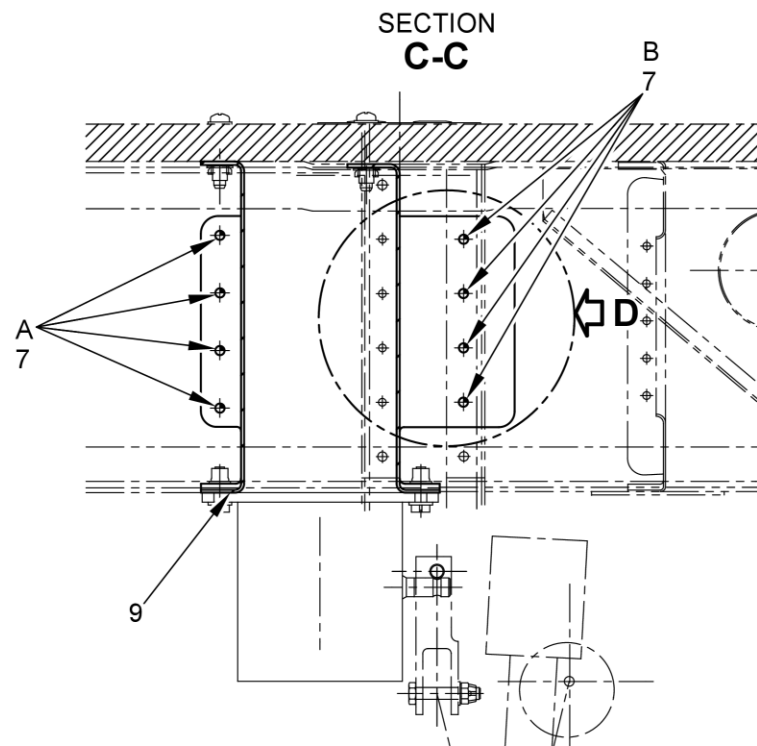
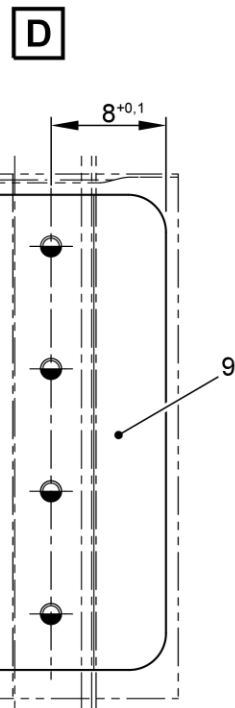
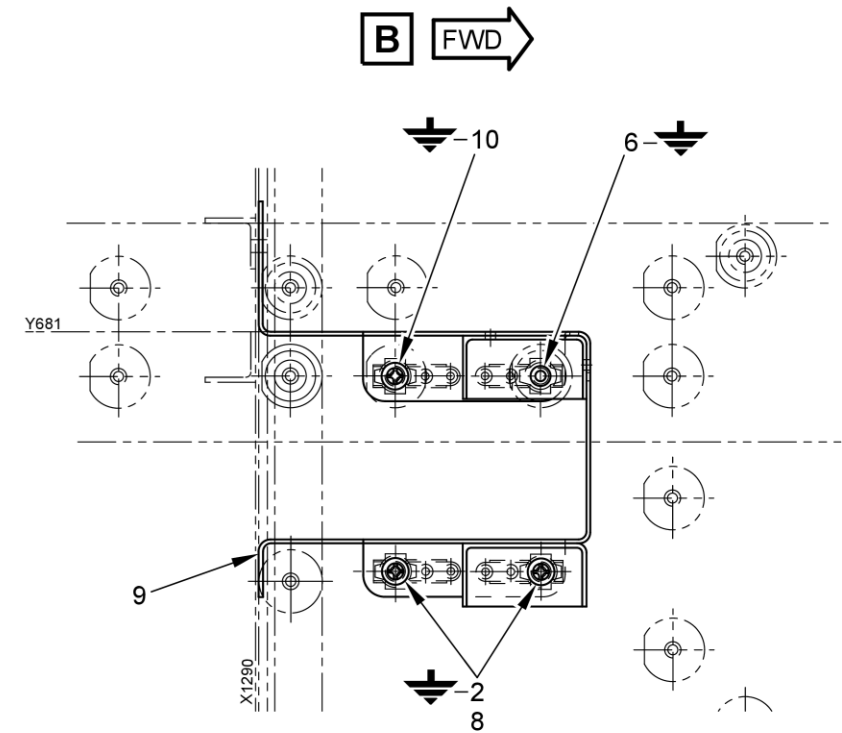
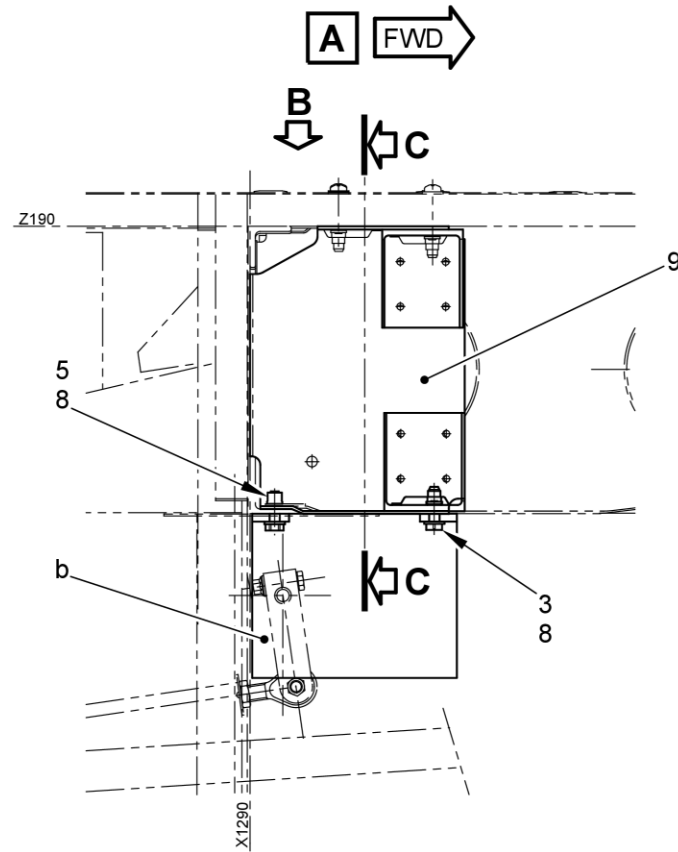
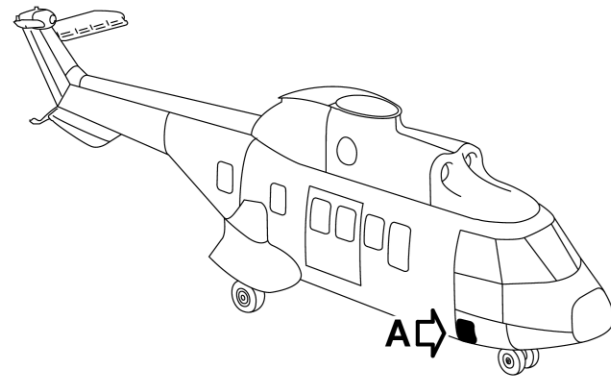


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Figure 1

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POST MOD 0728207  
MK1 versions

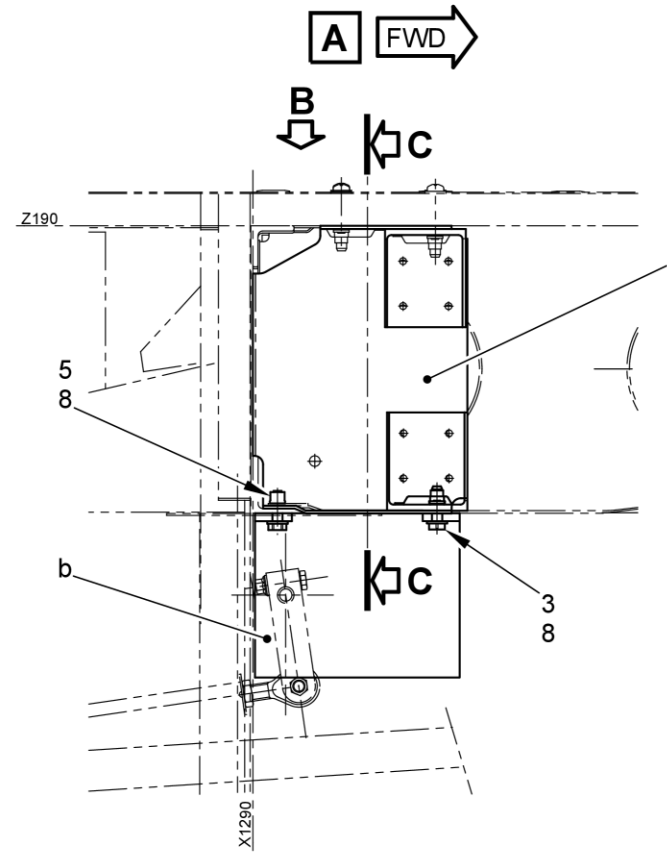
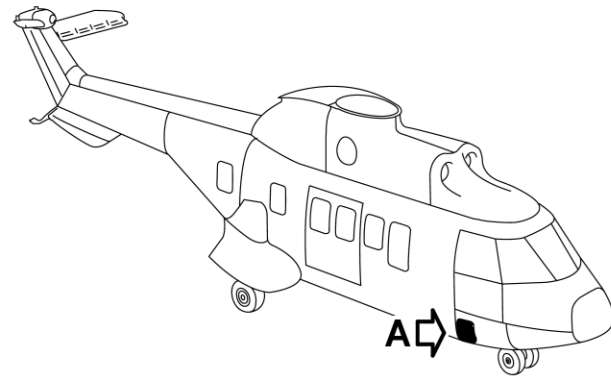


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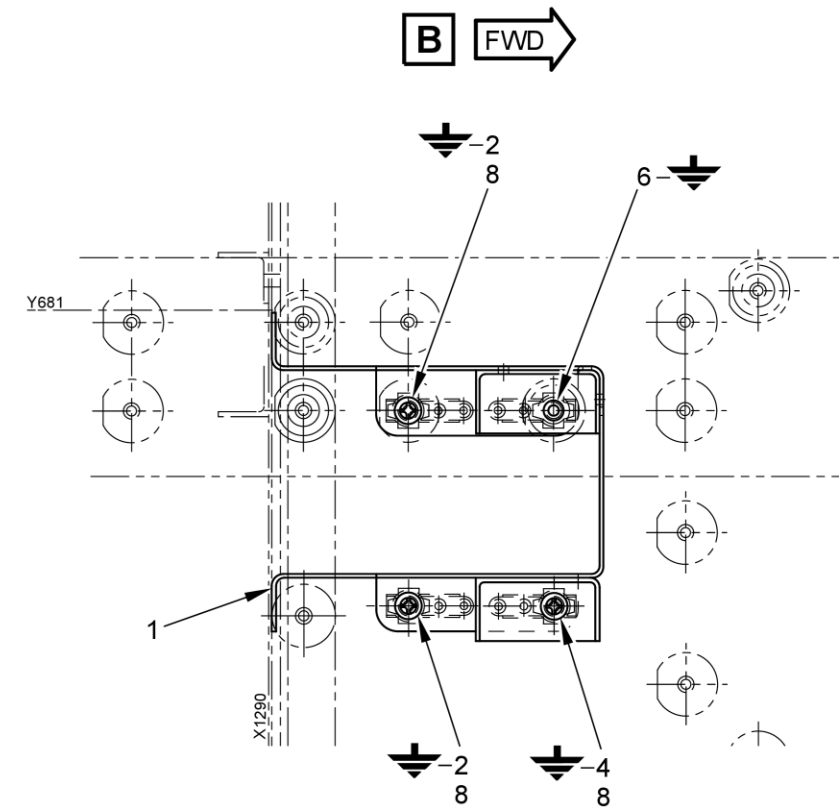
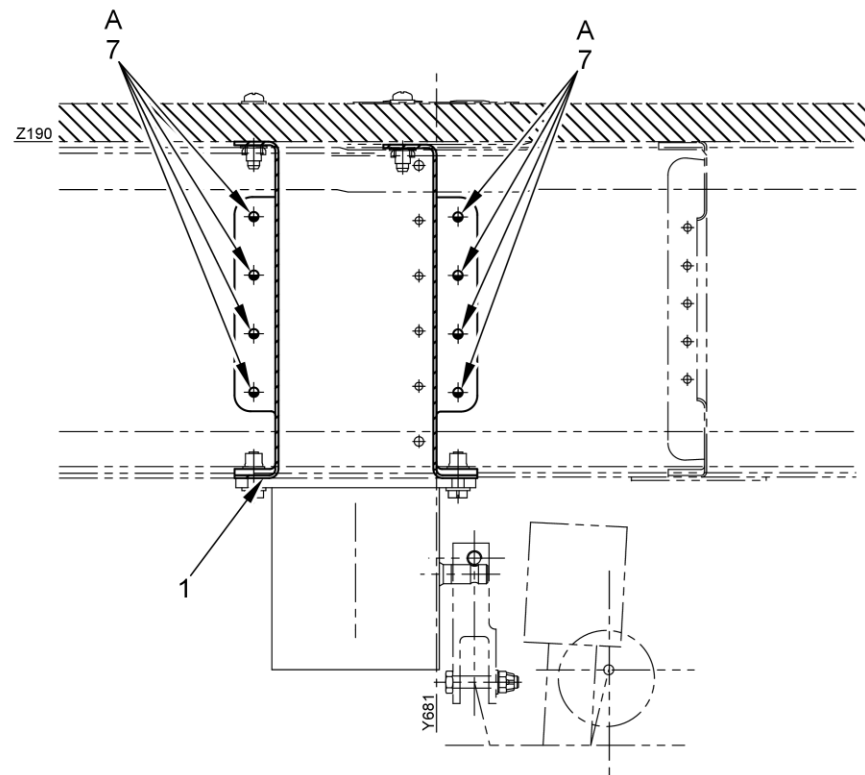
Figure 2

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POST MOD 0728207  
MK2 versions



SECTION  
C-C



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Figure 3