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AgustaWestland Products

SERVICE BULLETIN

N° 119-094

ALERT

DATE: November 15, 2018

REV. : /

TITLE

ATA 56 - LEFT AND RIGHT PASSENGERS CABIN DOORS WINDOW BONDING.

REVISION LOG

New 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

Leonardo AW119MKII helicopters S/N 14831, 14834, 14838, 14840, 14841, 14842, 14843, 14844, 14901, 14904, 14905, 14906 and 14918.

B. COMPLIANCE

Within and not later than 100 flight hours or 6 months since the date of issuance of this Service Bulletin, whichever occurs first.

C. CONCURRENT REQUIREMENTS

N.A.

D. REASON

This Service Bulletin provides the necessary instructions to restore the passengers' cabin window bonding in accordance with the approved design data.

E. DESCRIPTION

During the replacement of a passengers' cabin window of an AW119MKII, the maintenance personnel have found difficulties in the window removal.
The investigation concluded that the gasket was bonded to the window (or on both sides) instead of to the door frame and that this configuration could be present on a batch of helicopters.

Due to this, Leonardo Helicopters issues this Service Bulletin in order to remove the standard windows installed on the affected helicopters and to reinstall them in accordance with the approved design data.

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 six (6) (MMH) are deemed necessary.
Maintenance-Man-Hours are based on hands-on time and can change with personnel and facilities available

H. WEIGHT AND BALANCE

N.A.

I. REFERENCES

1) PUBLICATIONS

DATA MODULE		DESCRIPTION
DM01	00-20	Helicopter on ground for a safe maintenance.

2) ACRONYMS

AMDI	Aircraft Material Data Information
DOA	Design Organization Approval
EASA	European Aviation Safety Agency
LHD	Leonardo Helicopter Division
MMH	Maintenance Man Hour
MMIR	Maintenance Malfunction Inspection Report
N.A.	Not Applicable
SB	Service Bulletin
P/N	Part Number
PTUM	Pictorial Tool Usage Manual

3) ANNEX

N.A.

J. PUBLICATIONS AFFECTED

A119 / AW119 MKII Maintenance Manual.

K. SOFTWARE ACCOMPLISHMENT SUMMARY

N.A.

2. MATERIAL INFORMATION

A. REQUIRED MATERIALS

1) PARTS

#	P/N	ALTERNATIVE P/N	DESCRIPTION	Q.TY	LVL	NOTE	LOG P/N
1	999-1700-48-101G	-	Rubber gasket	6 m	-	-	-
2	999-1700-49-101G	-	Rubber seal filler	6 m	-	-	-

2) CONSUMABLES

#	Spec./LHD code number	DESCRIPTION	Q.TY	NOTE	PART
3	199-05-152 TY I, CL 2 (AW code: 900003249)	Adhesive RTV732	AR	(1)	-
4	Solvent (AW code: 505405407)	Ardrox 5503	AR	(1)	-
5	CCC-C-46 (AW code: 590210190)	Soft Lint-Free Cloth	AR	(1)	-
6	Commercial (AW code: 590220125)	Masking tape	AR	(1)	-

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

NOTE

(1) Item to be procured as local supply.

B. SPECIAL TOOLS

The following special tools, or equivalent, are necessary to accomplish this Service Bulletin:

#	P/N	DESCRIPTION	Q.TY	NOTE	PART
7	3G5605G00132	TOOL KIT, WINDOWS INSTL	1	(B1)	-

Refer also to PTUM for the special tools required to comply with the Maintenance Manual DM referenced in the accomplishment instructions.

SPECIAL TOOLS NOTE

(B1) Please contact Leonardo Helicopters Division order administration to request the tools supply on loan. As soon as the present Service Bulletin is implemented the tools supplied on loan shall be promptly returned to Leonardo Helicopters Division.

C. INDUSTRY SUPPORT INFORMATION

Owners/Operators who comply with the instructions of this Service Bulletin no later than the applicable date in the “Compliance” section will be eligible to receive REQUIRED MATERIALS on free of charge basis, except for Consumable Materials and Special Tools.

NOTE: Customers who fail to comply with the instructions in this Service Bulletin before the compliance date are not eligible for the aforementioned special policy.

Please Issue relevant MMIR form to your Warranty Administration Dpt.

3. ACCOMPLISHMENT INSTRUCTIONS

GENERAL NOTES

a) Replace the hardware found damaged during the following operation.

b) Let adhesive and sealant cure at room temperature for at least 24 hours unless otherwise specified.

c) At the end of the rework operations, remove all the used tools and completely remove any working residual using a suitable air cleaner.

d) All lengths are in mm.

e) Refer to CSRP-A-CSRP-00-X for the applicable structural standard practice procedures.

1. In accordance with Maintenance Manual Section 00-20 prepare the helicopter on ground for a safe maintenance. Disconnect the battery, all electrical power sources and/or the external power supply.
2. With reference to Figure 1, proceed in the rework of the left passengers cabin door window installation as described in the following procedure:
   - 2.1 With reference to Figure 1, pull the strap assy P/N A487A002A and remove the seal filler P/N 109-0361-72-111 from the gasket P/N 109-0361-72-113. Discard the seal filler and keep the strap assy for later reuse.
   - 2.2 Hold the left window P/N 109-0821-34-105 or P/N 109-0822-68-137 externally to make sure that it does not fall down.
   - 2.3 Carefully push the window P/N 109-0821-34-105 or P/N 109-0822-68-137 outboard.
   - 2.4 Remove and discard the gasket P/N 109-0361-72-113 from the window or from the passengers' cabin door structure.
   - 2.5 If necessary, remove the rubber particles from the window or from the passengers' cabin door structure with the plastic scraper. Clean the seal seat on the window and from the passengers' cabin door structure with a soft lint-free cloth and the cleaning solvent Ardrox 5503. Dry the cleaned area with a clean cloth.
   - 2.6 Cut the rubber gasket P/N 999-1700-48-101G at a length of 2700 mm to obtain the new gasket P/N 109-0361-72-113.
   - 2.7 Cut the rubber seal filler P/N 999-1700-49-101G at a length of 2700 mm to obtain the new seal filler P/N 109-0361-72-111.

CAUTION

Surfaces to be bonded shall be clean, dry and free of oil or grease.

2.8 Clean the internal tight groove of the gasket P/N 109-0361-72-113 and the gasket seat on the door structure with a soft lint-free cloth and the cleaning solvent Ardrox 5503. Dry the cleaned area with a clean cloth.

NOTE

The tight groove of the gasket P/N 109-0361-72-113 engages the door structure as per Figure 1 section A-A.

NOTE

Make sure that there is no clearance between the two ends of the gasket.

2.9 With reference to Figure 1 section A-A and Detail Gasket, install the gasket P/N 109-0361-72-113 on the window frame of the left door structure with the filler seal groove facing inboard. The joint line of the gasket must be positioned as shown in Figure 1.

CAUTION

Perform the operation carefully to avoid damaging the gasket.

2.10 Install the left window P/N 109-0821-34-105 or P/N 109-0822-68-137 by means of a suitable plastic scraper, in the gasket P/N 109-0361-72-113 previously installed on the window frame of the door structure.

2.11 Apply the masking tape along the entire perimeter of the door structure near the gasket P/N 109-0361-72-113 to prevent the same from being soiled with adhesive in the subsequent operation.

WARNING

DO NOT APPLY ADHESIVE BETWEEN GASKET AND THE LOWER CORNER RADIUS OF THE DOOR STRUCTURE AS PER FIGURE 1.

2.12 With reference to Figure 1, on the internal side of the passengers' cabin door, bond the edges of the door structure in the groove of the gasket P/N 109-0361-72-113 by means of the 199-05-152 TY I CL 2 adhesive. Make sure to apply the correct quantity of the adhesive in the groove of the gasket. Do not let the adhesive squeeze out of the gasket.

2.13 If the window P/N 109-0821-34-105 or P/N 109-0822-68-137 is dirty, immediately clean the dirty area with a clean cloth.

NOTE

Do not pull the seal filler to try to make its installation easier. If you pull it, the seal filler contour gets a deformation. The deformation of the filler wedge contour decreases the seal strength.

NOTE

Do not torque the seal filler when you install it along the curved parts of the seal.

NOTE

The strap assy P/N A487A002A must be located in the upper part of the gasket (Ref. Figure 1).

2.14 Install the seal filler P/N 109-0361-72-111 as described in the following procedure:

2.14.1 With reference to Figure 1 section A-A, insert the seal filler P/N 109-0361-72-111 into the buttonhole of the strap assy P/N A487A002A.

2.14.2 Keep one end of the seal filler P/N 109-0361-72-111 in its position with the thumb. The joint line of the seal filler must be positioned exactly as shown in Figure 1.

2.14.3 Carefully put the seal filler P/N 109-0361-72-111 in the related groove of the gasket P/N 109-0361-72-113 by hand and tool kit 3G5605G00132.

2.14.4 Make sure that there is no clearance between the two ends of the seal filler P/N 109-0361-72-111.

2.14.5 With reference to Figure 1 section A-A, lock the strap assy P/N A487A002A to the stud P/N MS27980-17B.

WARNING

DO NOT APPLY ADHESIVE BETWEEN GASKET AND THE LOWER CORNER RADIUS OF THE DOOR STRUCTURE AS PER FIGURE 1.

2.15 With reference to Figure 1, on the external side of the passengers' cabin door, bond the edges of the door structure in the groove of the gasket P/N 109-0361-72-113 by means of the 199-05-152 TY I CL 2 adhesive. Make

sure to apply the correct quantity of the adhesive in the groove of the gasket. Do not let the adhesive go off from the gasket.

2.16 If the window P/N 109-0821-34-105 or P/N 109-0822-68-137 is dirty, immediately clean the dirty area with a clean cloth.

2.17 Remove the masking tape from the passengers' cabin door structure.

3. Repeat steps from 2.1 to 2.17 on the right passengers' cabin door window P/N 109-0821-34-106 or 109-0822-68-138.
4. Return the helicopter to a ready to flight condition and record for compliance with this Service Bulletin on the helicopter logbook.
5. Send the attached compliance form to the following mail box:

   aw109.mbx.aw@leonardocompany.com

   As an alternative, gain access to My Communications section on Leonardo WebPortal and compile the "Service Bulletin Application Communication".

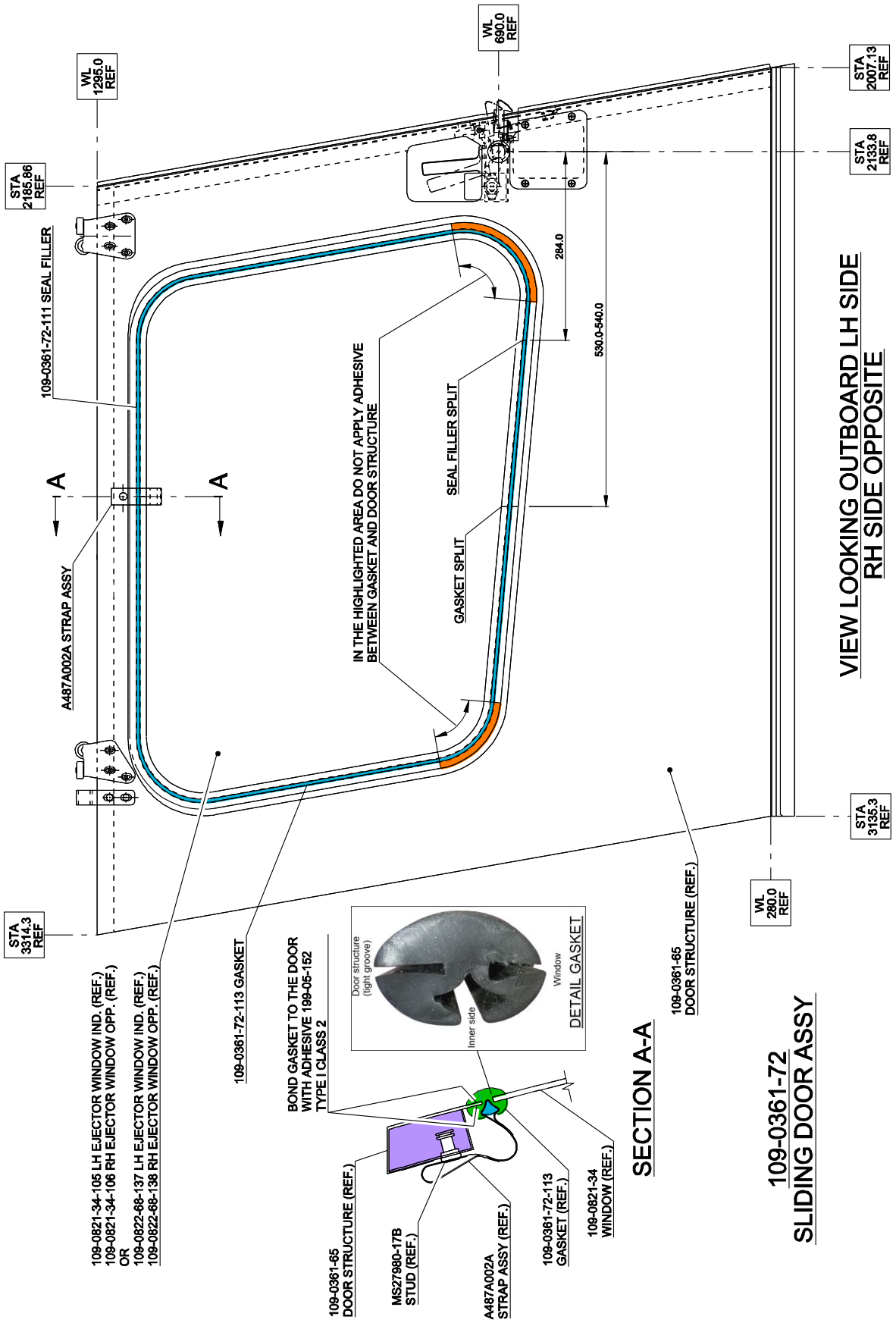

WL 690.0 REF
WL 1295.0 REF
STA 2007.13 REF
STA 2133.8 REF
STA 2185.86 REF
STA 3135.3 REF
STA 3314.3 REF
WL 280.0 REF
109-0361-72-111 SEAL FILLER
A487A002A STRAP ASSY
284.0
530.0-540.0
SEAL FILLER SPLIT
GASKET SPLIT
IN THE HIGHLIGHTED AREA DO NOT APPLY ADHESIVE BETWEEN GASKET AND DOOR STRUCTURE
VIEW LOOKING OUTBOARD LH SIDE
RH SIDE OPPOSITE
109-0821-34-105 LH EJECTOR WINDOW IND. (REF.)
109-0821-34-106 RH EJECTOR WINDOW OPP. (REF.)
OR
109-0822-68-137 LH EJECTOR WINDOW IND. (REF.)
109-0822-68-138 RH EJECTOR WINDOW OPP. (REF.)
109-0361-72-113 GASKET
BOND GASKET TO THE DOOR WITH ADHESIVE 199-05-152 TYPE I CLASS 2
Door structure (tight groove)
Window
Inner side
DETAIL GASKET
109-0361-65 DOOR STRUCTURE (REF.)
SECTION A-A
109-0361-65 DOOR STRUCTURE (REF.)
MS27980-17B STUD (REF.)
A487A002A STRAP ASSY (REF.)
109-0361-72-113 GASKET (REF.)
109-0821-34 WINDOW (REF.)
109-0361-72 SLIDING DOOR ASSY

Figure 1

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HELICOPTERS

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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.