

### KI-207 R66 Baggage Door Seals Kit Instructions

For compliance with R66 Service Letter SL-02

NOTE

Visit [www.robinsonheli.com](http://www.robinsonheli.com) to verify kit instructions are current revision.

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY PER KI-207
KIT CONTENTS			
1	A226-7	Seal .....	2 ft
2	A701-1.5FT	Tape (5 ft A701-1 tape) .....	1
3	B270-13	Sealant (3 oz tube) .....	1
4	G260-5	Angle .....	2
5	G907-5	Angle (with attached A701-7 tape) .....	1
6	NAS9301B-4-01	Rivet .....	1
7	NAS9301B-4-02	Rivet .....	3
8	NAS9301B-4-03	Rivet .....	2
9	5541K11	Pipe Wrap .....	1 ft
10	93745K41	Seal .....	6 ft

### Consumables

- B270-8 adhesive, rubber (Stabond C160 or 3M847, or equivalent; ref R66 Maintenance Manual (MM) § 20-79)
- Scotch-Brite abrasive pad, or equivalent
- Acetone

### Kit Instructions

1. Verify kit contents match above list. Contact RHC Customer Service if parts are missing or damaged.
2. Review instructions before installation. Contact RHC Technical Support if you have questions.

NOTE

Verify baggage compartment door surfaces are clean (use a clean cloth wet with acetone) and dry before attaching angles, seals, tape, pipe wrap, or sealant.

### Kit Instructions (continued)

3. Refer to Figures 1 and 3. Open baggage compartment door. Using Scotch-Brite pad, abrade surface of baggage door where G907-5 angle will be attached. Clean up debris using a clean cloth wet with acetone. Remove liner from tape attached to G907-5 angle, align holes in angle with rivets on door, and attach angle to door. Verify security.
4. Trim A226-7 seal as required to fit length of G245-1 stiffener between G260-3 and G260-4 gussets as shown. Remove liner from seal as required. Using B270-8 adhesive, attach seal to stiffener. Remove excess adhesive. Verify security.
5. Refer to Figure 3. Cut two 0.8-inch long pieces of A701-1 tape from provided A701-1.5FT roll, remove liner, and attach tape to G907-1 stiffener, covering tooling holes as shown.
6. Refer to Figure 1. Cut two 2-inch long pieces of 5541K11 pipe wrap, remove liner, and attach pipe wrap to inboard side of G260-3 and G260-4 gussets, covering tooling holes as shown. Verify security.
7. Trim 93745K41 seal as required to fit length of G907-4 stiffener between G905-1 and G905-2 stiffeners as shown. Remove liner and attach seal to ledge of stiffener. Verify security.
8. Refer to Figures 1 and 2. Trim 93745K41 seal as required to fit length of G905-1, G905-2, G907-1, G907-2, and G907-3 stiffeners as shown. Remove liner and attach seal to ledge of stiffeners, and covering tooling holes as shown. Verify security.
9. Using B270-13 sealant, fill gap where G905-1 stiffener joins G907-2 stiffener, and where G905-2 stiffener joins G907-3 stiffener, and in corner reliefs as shown.
10. Using B270-13 sealant, seal along edges of G905-1, G905-2, G907-2, and G907-3 stiffeners where they attach to door as shown.
11. Remove hardware securing G904-1 gas strut ball stud to door frame and pull out stud.
12. Remove aft right back rest assembly. Drill out four rivets (two per gusset) securing G260-3 and G260-4 gussets to door frame as shown. Install G260-5 angles using specified NAS9301B-4-XX rivets. Verify security. Clean up debris.

**NOTE**

Install rivets in three (of four) holes per G260-5 angle.

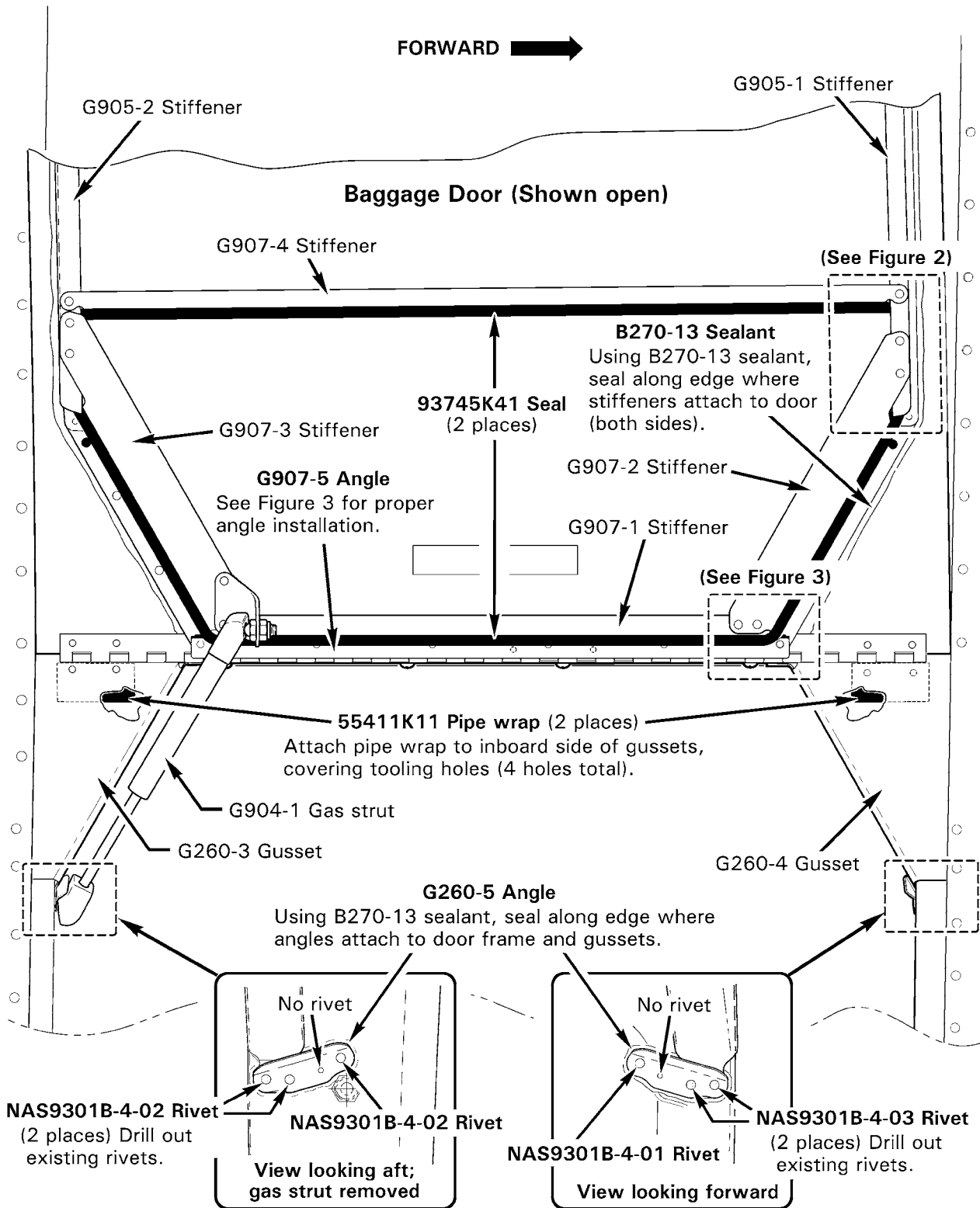
**CAUTION**

Do not drill thru wires behind door frame when drilling out forward rivets.

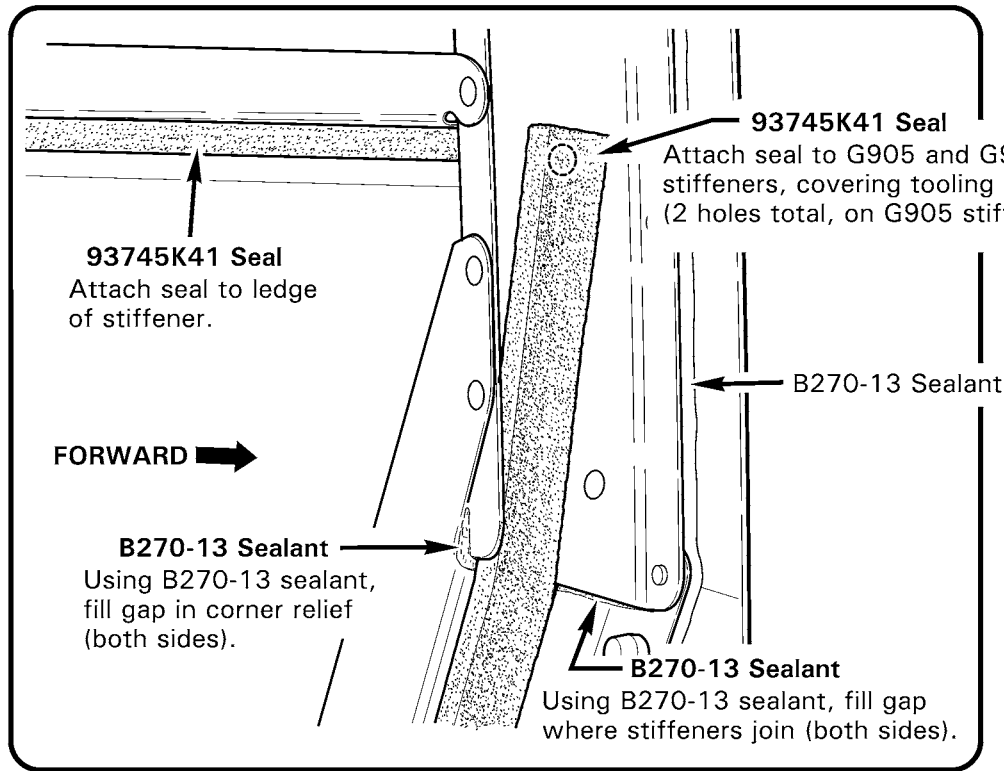
13. Using B270-13 sealant, seal along edge where G260-5 angles attach to door frame and gussets as shown.

### **Kit Instructions (continued)**

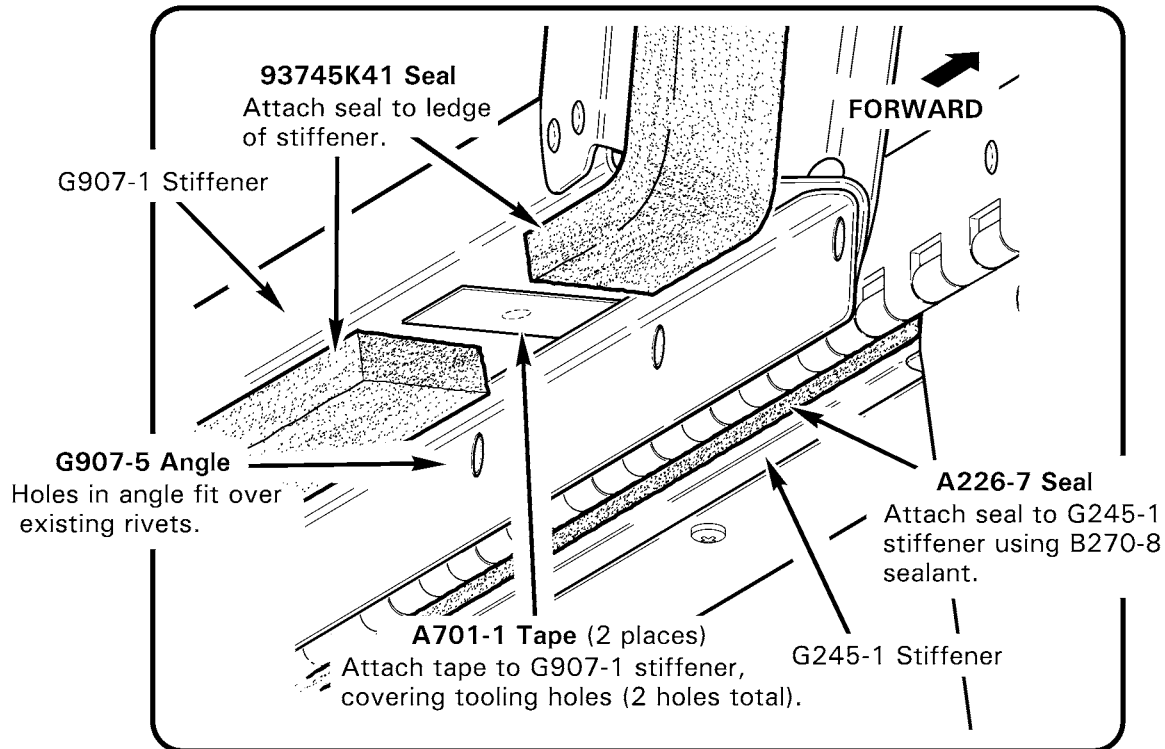
14. Insert gas strut ball stud thru door frame and install hardware. Special torque nut to 100 in.-lb.
15. Close and latch baggage compartment door. Carefully insert 0.032-inch thick sheet metal through gap at bottom edge of door, between door & sill, and door & skin and verify sufficient gap for water escape. As required, using fingers (do not use tools), make slight bends along the bottom edge of the door, parallel to the first row of rivets to create sufficient gap.
16. Install aft right back rest assembly. Make appropriate maintenance record entries.



**FIGURE 1**



**FIGURE 2**



**FIGURE 3**