

ROBINSON HELICOPTER COMPANY

24747 Crenshaw Blvd., Torrance, California 90505

(213) 539-0508 ■ Telex: 18-2554 ■ TWX: 910-347-6240

SERVICE BULLETIN #39

DATE: 17 February 1984

TO: R22 Owners and Operators

SUBJECT: Drilled head bolt installation lower LH frame to fuselage

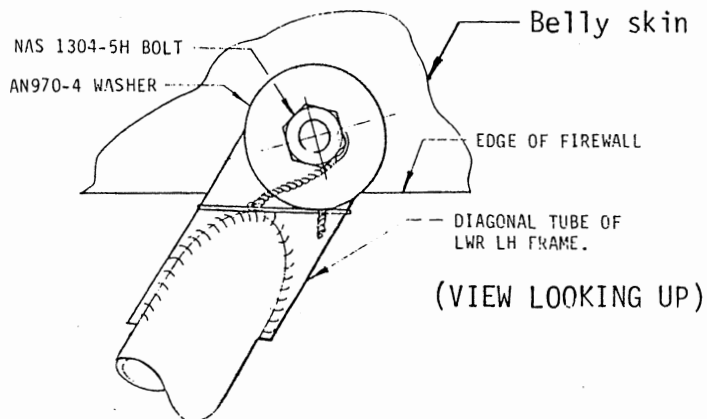
ROTORCRAFT AFFECTED: R22 Serial No. 0002 through 0383

TIME OF COMPLIANCE: Within the next 25 hours or 31 March 1984,
whichever occurs first

BACKGROUND: The left frame diagonal tube is attached to the belly of the fuselage with an NAS 1304 bolt. There have been reports of this bolt loosening in flight. To prevent this, the existing bolt is being replaced with a drilled head bolt and safety wired to the frame.

COMPLIANCE PROCEDURE:

1. Remove NAS 1304 bolt from diagonal tube of lower left hand frame at fuselage attach point.
2. Install NAS 1304-5H bolt with AN 970-4 washer under head.
3. Torque bolthead 100 in-lb. plus drag.
4. Safety wire bolthead to diagonal tube of frame with MS20995C .032 wire, running one loop around the frame.
5. Torque stripe bolthead to fuselage.



Material cost: Bolt supplied by RHC on request. No charge.

Labor: 1/4 hour