

SERVICE BULLETIN #49

DATE: 15 April 1986

TO: R22 Owners and Operators

SUBJECT: A740-1 Manifold Pressure Line

ROTORCRAFT AFFECTED: S/N 002 thru S/N 545

TIME OF COMPLIANCE: Within the next 50 flight hours or by 30 June 1986, whichever occurs first.

BACKGROUND: Chafing of the A740-1 Manifold Pressure Line has occurred on several helicopters. This chafing has occurred under the MS21919DG3 clamp that supports the Manifold Pressure Line. An erratic or high Manifold Pressure reading may occur if the chafing continues through the line.

METHOD OF COMPLIANCE:

1. Mark the location of the MS21919DG3 clamp which supports the line at the lower left hand frame member, with a soft marker material.
2. Remove the A740-1 Manifold Pressure Line by disconnecting the line from the firewall and the engine. Remove the MS21919 supporting clamps from the line and the lower frame brace. Disconnect the MS21919DG3 clamp from the cooling shroud.
3. Carefully inspect the Manifold Pressure Line for chafing wear in the area of the MS21919DG3 clamp. Chafing wear greater than .010 inch deep is cause for rejection of the Manifold Pressure Line.
4. Carefully straighten the two lower bends in the Manifold Pressure Line just enough to slide the flare nut fitting over them. Refer to the enclosed drawing.
5. Slide the flare nut up the Manifold Pressure Line past the point of the supporting clamp position that was marked in Step 1.
6. Slide the 1.5 inch piece of heat shrink over the lower end of the Manifold Pressure Line. Position the heat shrink over the supporting clamp position marked in Step 1.
7. Shrink the heat shrink with a heat gun or a suitable source of heat. Slide the flare nut back down the line into its original position.
8. Carefully form the two lower bends back to their original shapes. Connect the line to the firewall and the engine fitting. Reconnect the MS21919DG3 clamp at the cooling shroud.

(Continued on next page)

9. Install a new MS21919DG10 clamp over the steel frame member. Install a new MS21919DG3 clamp over the heat shrink and the line. Connect the two clamps with the existing hardware.

10. Order KI-46 Kit from RHC Customer Service.

KIT CONTENTS

| <u>Quantity</u> | <u>Part #</u> | <u>Description</u> |
|-----------------|-----------------|--------------------|
| 1 ea. | MS21919DG3 | Clamp |
| 1 ea. | MS21919DG10 | Clamp |
| 1 ea. | 7/16 X 1.5 inch | Heat Shrink |

| | | |
|-------------------|-----------|----------|
| APPROXIMATE COST: | Materials | \$1.25 |
| | Labor | 1/2 hour |

