

Robinson Helicopter Company

24747 CRENSHAW BLVD., TORRANCE, CA 90505 TELEPHONE (213) 539-0508

SERVICE LETTER #13

Date: September 10, 1981

To: All owners and operators of Robinson R22 Helicopters

Subject: Loose horizontal firewall to steel tube frame attach bolts

Rotorcraft Affected: R22 Serial No. 0002 thru 0150, 0152-0182, 0184-0188
0190-0195, 0198

Time of Compliance: Within the next five hours time in service

Background: After inspecting a number of helicopters, several were found to have loose NAS1304-18 attach bolts fastening the upper steel tube frame (lower horizontal member) to the aft horizontal firewall. (See fig. #1) To prevent improper loading at these areas, the NAS1304-18 bolts must be checked for proper torque and retorqued as necessary to provide proper clamping of these joints.

Torque Check Procedure:

1. Using a suitable torque wrench, torque the bolts to 100 in/lbs plus nut drag.

NOTE:

Due to inaccessability of nut, it is permissible to hold the nut and torque the bolt.

2. Torque stripe the nut.

By: Frank H. Fisher
Service Department

P.S. If your ship has been sold, please forward to new owner.

Note:
Torque nuts to 100 inch/pounds
plus nut drag

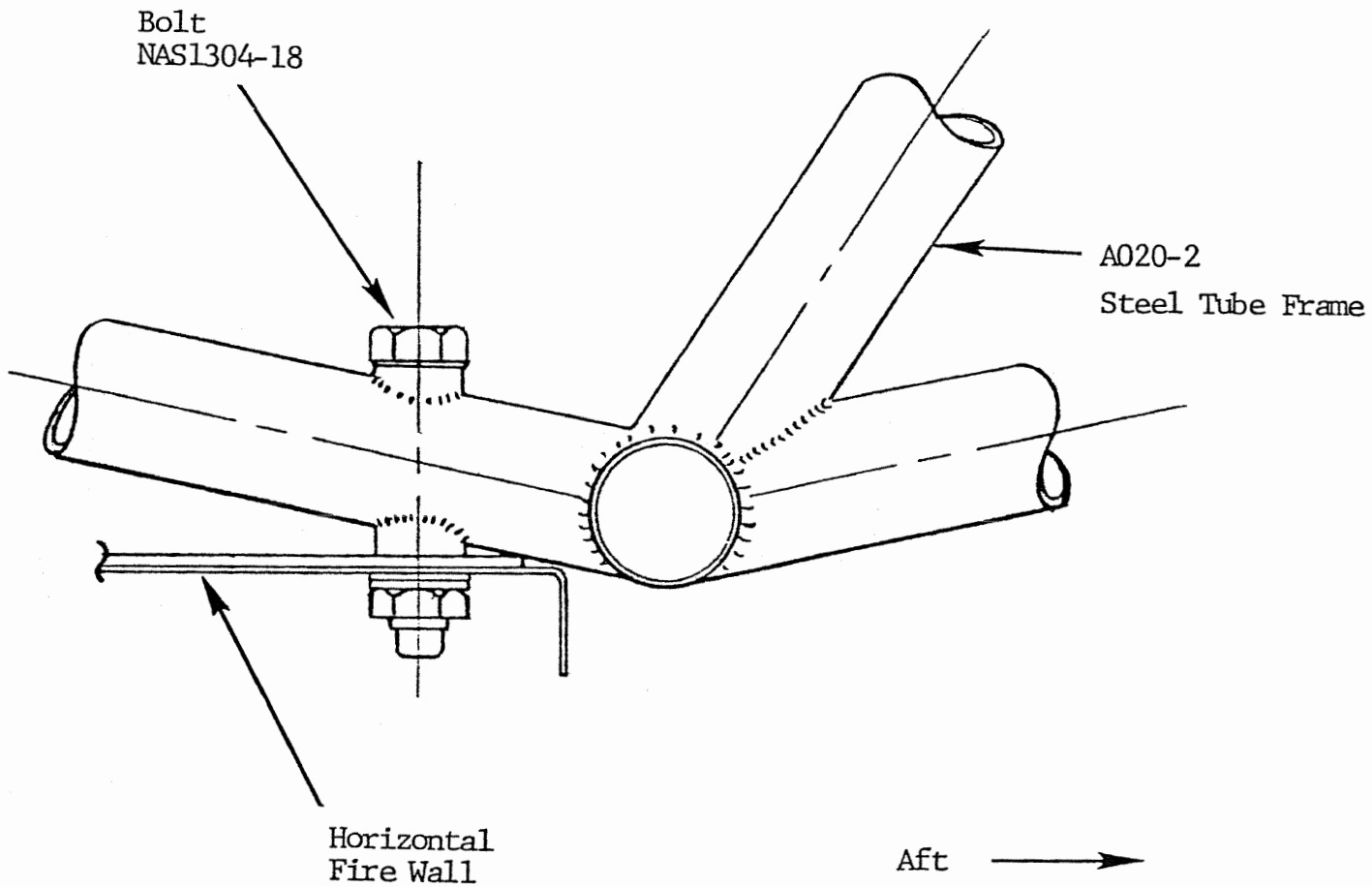


Fig #1