ROBINSON
HELICOPTER COMPANY

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R22 SERVICE LETTER SL-56B

R44 SERVICE LETTER SL-32B

DATE: 30 April 2010

TO: R22 & R44 owners, operators, and maintenance personnel

SUBJECT: A016-4, C016-2, and C016-5 Main Rotor Blade Bond Maintenance

BACKGROUND: Debonding of main rotor blade skins can occur when the bond line is exposed due to erosion of the blade finish or when corrosion occurs on the internal aluminum tip cap. Proper inspection and protection (refinishing) of bonded areas is required.

COMPLIANCE PROCEDURE:

1. Remove main rotor blade tip cover(s) and clean the blade(s).

2. Feather edge of paint bordering bare metal by hand-sanding spanwise with 220-grit or finer wet-or-dry aluminum-oxide or silicon-carbide abrasive paper. Do not remove metal.

> **CAUTION**
>
> Do NOT use power tools or chemical paint strippers to remove paint.

3. Mask area to prevent overspray contamination.

4. Clean bare metal to be painted with a lint-free cloth dampened with enamel cleaner.

5. Prime bare metal, including any bare metal which will underlie tip covers, with at least two coats of Desoprime CA7501 epoxy primer (or equivalent). Scuff primer prior to applying second coat. Desoprime technical data is available online at:

    http://www.ppg.com/coatings/aerospace/coatings1/CA_7501CF_0803.pdf

6. Apply flat black Dupont Imron 373-P-29950 and/or yellow Imron K0680HK polyurethane enamel (or equivalent) to primed area in accordance with paint manufacturer's recommendations. Dupont technical data is available online at:

    http://pc.dupont.com/dpc/en/US/html/visitor/common/pdfs/b/product/dcf/OEM_Fleet/imron5000_2-8.pdf

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CAUTION

If force-drying paint, do not exceed 175ºF surface temperature on blade; monitor blade temperature.

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NOTE

Allow Imron paint to cure at least 72 hours before flying in erosive conditions (such as drizzle, rain, or dust).

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7. Install blade tip cover(s).

8. Make appropriate maintenance record entries.

Approximate Cost:

Parts: KI-188 Kit (if required), includes $190
              one quart each primer, black, & yellow