



R22 SERVICE BULLETIN SB-122

DATE: 27 June 2024

TO: R22-series Owners, Operators, and Maintenance Personnel

SUBJECT: Clutch Assembly Retainer Replacement

EFFECTIVITY: A018-1 & -2 clutch assemblies with early forward and/or aft retainer, described below.

TIME OF COMPLIANCE: When A018-x clutch assembly is removed from helicopter, or by 31 May 2027, whichever occurs first.

BACKGROUND: RHC has received reports of A018 clutch assembly's seals separating from earlier design retainers causing lubricant leakage and drive belt contamination. This bulletin requires replacing earlier retainers with a retainer having an integral seal-retention lip.

COMPLIANCE PROCEDURE:

1. Refer to Figure 1. If cap screws are not present then submit clutch assembly for upgrade at an R22 Service Center authorized to perform Component Maintenance. Alternately, replace clutch assembly with compliant version.
2. If cap screws are present, but (2) B289-3 screws are not present, then order
 - 1ea A168-4 retainer,
 - 1ea A215-035 o-ring,
 - 1ea A966-1 seal, &
 - 2ea B289-3 screws

NOTE

All A168-4 retainers have an integral seal-retention lip.

3. Refer to Figure 2. If aft retainer does not have pictured 0.1-inch wide X 45-degree chamfer, order:
 - 1ea A168-3 Rev L (or subsequent) retainer,
 - 1ea A215-035 o-ring, &
 - 1ea A966-1 seal
4. Per R22 Maintenance Manual (MM) § 7.213, remove & discard affected retainer(s).
5. Using MT642-3 pressing tool (or equivalent), press new, dry A966-1 seal flat-face first into counterbore of room-temperature replacement retainer(s), until seal contacts retention lip.
6. Using new o-ring, install replacement retainer(s) with seal per MM § 7.213.

(OVER)

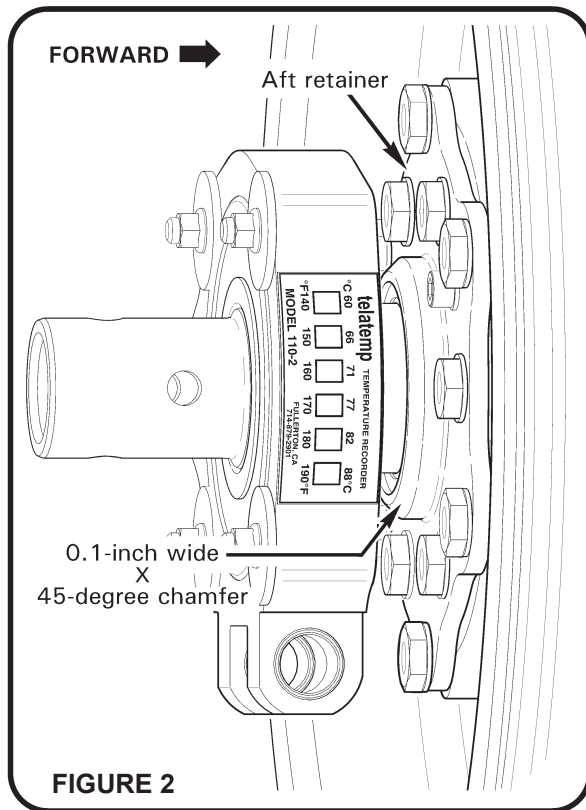


FIGURE 2

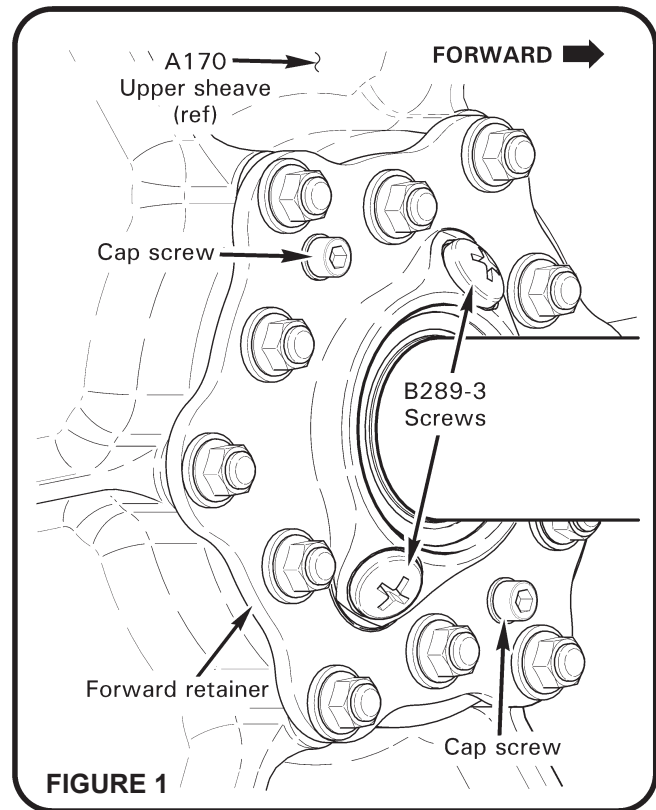


FIGURE 1

7. After torquing nuts, mask clutch shaft-to-seal juncture on replacement retainers.
8. Refer to MM § 23-60. Prime & paint replacement retainer(s).

NOTE
New retainers are chemical conversion coated.

9. Remove masking at shaft-to-seal junctures.
10. Apply B270-21 protectant to forward & aft shaft-to-seal junctures.
11. Torque stripe nuts per MM Figure 2-1.
12. Make appropriate maintenance record entries.

APPROXIMATE COST:

Parts: A168-3 retainer, \$179 ea	A966-1 seal, \$17.50 ea
A168-4 retainer, \$179 ea	B289-3 screw, \$14.75 ea
A215-035 o-ring, \$2.50 ea	MT642-3 pressing tool, \$115 ea

Parts pricing is provided for initial release as reference only and is subject to change. Refer to current Parts Price List or contact [RHC Customer Support](#) for current pricing.

Labor: 8 labor-hours if both retainers require replacement.

THE DESIGN ENGINEERING ASPECTS OF THIS BULLETIN HAVE BEEN SHOWN TO COMPLY WITH APPLICABLE FEDERAL AVIATION REGULATIONS AND ARE FAA APPROVED.