

## **MAIN ROTOR BLADE DRAIN HOLE CLEARANCE**

### **SUMMARY:**

HTC has observed completely or partially blocked Drain Holes in the Tip-End on fielded Main Rotor Blades. Trapped water can cause a Failure of the Aft Tip Cap bond, Departure of the Aft Tip Cap in-flight, onset of significant vibration, and other significant damage to the internal structure of the Main Rotor Blade, including corrosion.

Procedures in this service notice provide owners and operators with information pertaining to clearing the Drain Hole in the Tip-End on Main Rotor Blades.

### **PURPOSE:**

The purpose of this notice is to provide a procedure for clearing the Drain Holes in the Tip-End on Main Rotor Blades.

Failure to comply with this bulletin may result in significant Main Rotor Vibration, Corrosion, and/or Damage to the internal structure of the blade.

### **PART NUMBERS AND SERIAL NUMBERS AFFECTED:**

500P2100-BSC, and -BSC-1 (STC Number SR09172RC) All Serial Numbers.

500P2100-101, -103, and -105 (STC Number SR09047RC) All Serial Numbers.

These blades are also known as MD Helicopters, Inc. Part Number 369D21120-501, -503, and -505 and all references in MD Helicopters, Inc. CSP-HMI-2 that pertain to Part Number 369D21120-501, -503, and -505 pertain to HTC Part Number 500P2100-101, -103, and -105 as well.

500P2100-301, -303, and -305 (STC Number SR09184RC) All Serial Numbers.

These blades are also known as MD Helicopters, Inc. Part Number 369D21123-501, -503, and -505 and all references in MD Helicopters, Inc. CSP-HMI-2 that pertain to Part Number 369D21123-501, -503, and -505 pertain to HTC Part Number 500P2100-301, -303, and -305 as well.

500P2300-501, -503, and -505 (STC Number SR01050LA) All Serial Numbers.

These blades are also known as MD Helicopters, Inc. Part Number 369D21121-501, -503, and -505 and all references in MD Helicopters, Inc. CSP-HMI-2 that pertain to Part Number 369D21121-501, -503, and -505 pertain to HTC Part Number 500P2300-501, -503, and -505 as well.

### **HELICOPTER MODELS AFFECTED:**

MD Helicopters, Inc. Models 369A, H, HE, HM, HS, D, E, FF, 500N and 600N.

**Service  
Notice**

**MAIN ROTOR BLADE DRAIN HOLE CLEARANCE**

**TIME OF COMPLIANCE:**

This bulletin shall be accomplished within 25 hours of receipt of this notice and at every 100 Hour Inspection thereafter.

**FAA APPROVAL:**

N/A.

**MANPOWER:**

Approximately 0.5 man-hours will be required to accomplish this notice.

**WARRANTY POLICY:**

N/A

**DISPOSITION OF PARTS REMOVED:**

N/A

**REFERENCES:**

- 1) MD Helicopters, Inc. Handbook of Maintenance Instructions (CSP-H-2), Revision 17, dated May 15, 2001 or later
- 2) MD Helicopters, Inc. Appendix B (CSP-H-4), Revision 1, dated May 14, 2001 or later
- 3) MD Helicopters, Inc. Handbook of Maintenance Instructions (CSP-HMI-2), Revision 29, dated May 11, 2001 or later
- 4) MD Helicopters, Inc. Rotorcraft Log Book (CSP-RLB), Revision 2, dated February 17, 2000 or later
- 5) Maintenance Manual HTCM-001, Main Rotor Blades (Installation and Maintenance), Revision H, dated February 12, 2009 or later.

**REQUIRED MATERIALS:**

- 1) Naphtha or Rubbing Alcohol
- 2) Kim Wipes or equivalent clean lint-free wipes.
- 3) 5/32 (0.156 inch diameter) Jobber Length Drill Bit
- 4) #60 (0.040 inch diameter) Jobber Length Drill Bit
- 5) Touch-Up Paint

## MAIN ROTOR BLADE DRAIN HOLE CLEARANCE

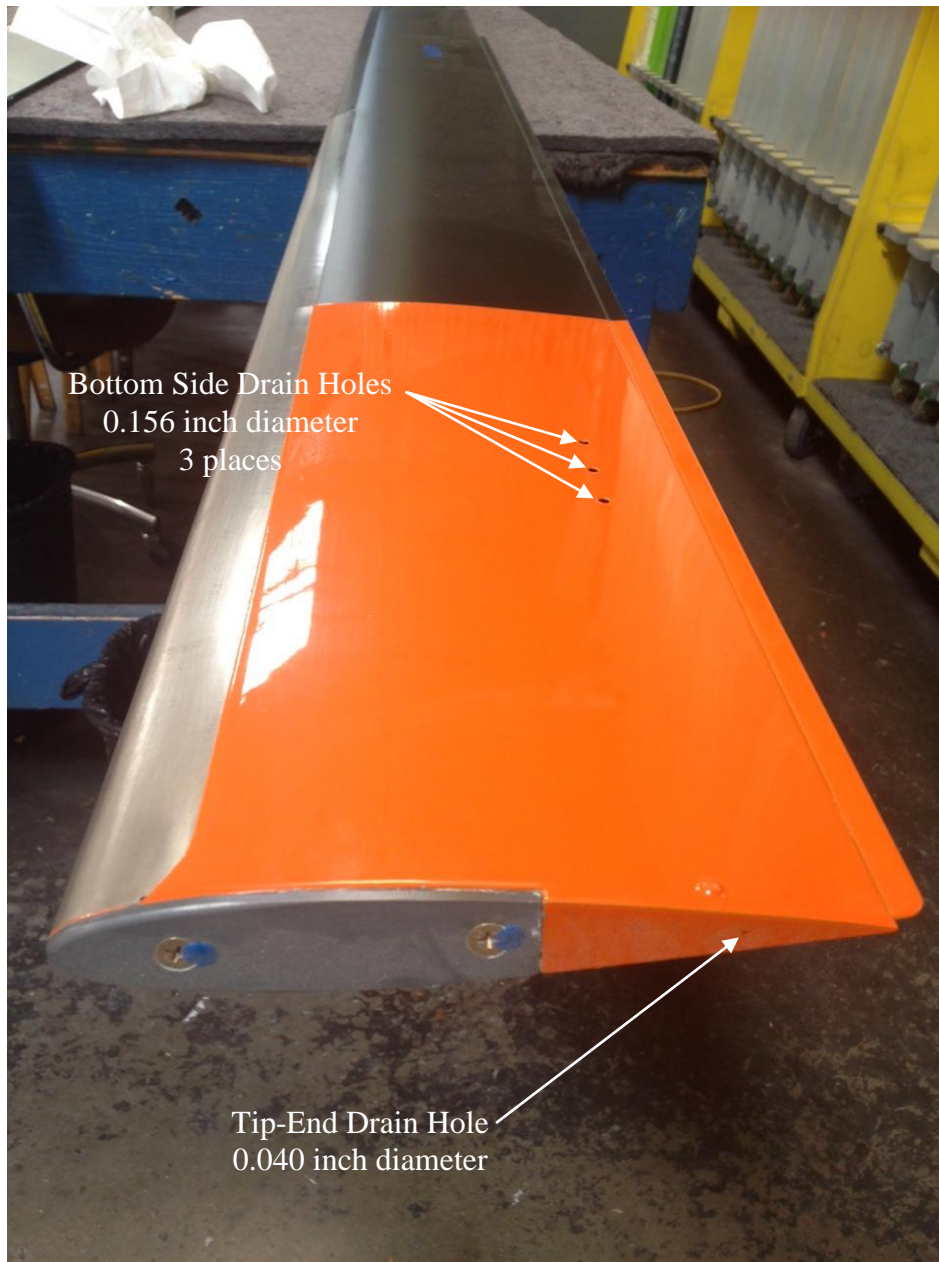


Figure 1 – Tip of Main Rotor Blade - Drain Holes (Bottom Side Shown)

Company, LLC

**Service  
Notice**

*Helicopter Technology*

**NOTICE No.:** 2100-7

**DATE:** 23 July 2015

**PAGE:** 4 of 4

## **MAIN ROTOR BLADE DRAIN HOLE CLEARANCE**

### **INSPECTION INSTRUCTIONS:**

- 1) Clean Tip-End area thoroughly with Solvent. Naphtha is recommended. MPK, MEK, or Acetone should not be used as they will remove the pigment from the paint. See Figure 1 above.
- 2) Visually Inspect areas to find evidence of Drain Hole Blockage. See Figure 1 above.
- 3) By hand, ensure that 5/32 Drill bit fits through each of the three (3) Bottom Side Drain Holes to a depth of 0.50 inch maximum. Do not nick far-side Blade Skin from inside with Drill Bit. See Figure 1 above.
- 4) If bare metal is exposed during the above step, touch-up paint as required.
- 5) By hand, ensure that #60 Drill bit fits through the Tip-End Drain Hole to a depth of 0.50 inch maximum. Do not nick far-side Blade Skin from inside with Drill Bit. See Figure 1 above.
- 6) No touch-up paint is required for the above step as it will likely re-block the Tip-End Drain Hole.

### **RECORDING AND COMPLIANCE:**

Record compliance with this Service Notice in the Technical Directives and Bulletins section of the rotor blade Serviceable Component Record.

### **POINTS OF CONTACT:**

For further information and rotor blade disposition, contact Helicopter Technology Company, LLC (HTC) at (310) 523-2750, or FAX (310) 523-2745. [www.helicoptertech.com](http://www.helicoptertech.com)