

R66 SERVICE BULLETIN SB-16

DATE: 15 December 2015

TO: R66 Owners, Operators, and Maintenance Personnel

SUBJECT: "LOT 20" F642-1 Shaft Corrosion

ROTORCRAFT AFFECTED: R66 Helicopters S/N 0143 thru 0172.

TIME OF COMPLIANCE: Within next 100 flight hours or by 31 January 2016, whichever occurs first.

BACKGROUND: A "LOT 20" F642-1 shaft weldment failed due to internal corrosion. This bulletin requires a specific lot number (LOT 20) of earlier F642-1 shafts to be upgraded to (current design) F642-6 shaft weldments, which have additional corrosion protection.

COMPLIANCE PROCEDURE:

1. Refer to Figure 1. Visually inspect forward end of installed F642 shaft weldment for a visible change in diameter. Shafts with a change in diameter at location shown are not affected by this bulletin; no further action is required.
2. If installed shaft does not have a change in diameter at location shown, locate ink-marked lot number on F642-1 shaft (adjacent to ink-marked part number and revision letter). Ink-mark may be located on shaft or flanges (disassembly from flex plates may be required; refer to R66 Maintenance Manual [MM] § 63-10).
3. If shaft is marked "LOT 20", or if the lot number cannot be determined, remove shaft per MM § 63-10, order one R9535 kit from [RHC Customer Service](#), and install kit per MM § 63-10.
4. Make appropriate maintenance record entries. No change to helicopter weight and balance.

APPROXIMATE COST:

Parts: No charge for R9535 kit if ordered by 31 January 2016. Reference helicopter serial number and email photo(s) of affected shaft to ts2@robinsonheli.com.

Labor: Up to 1 man-hour for inspection; approximately 5-6 man-hours for kit installation.

(OVER)

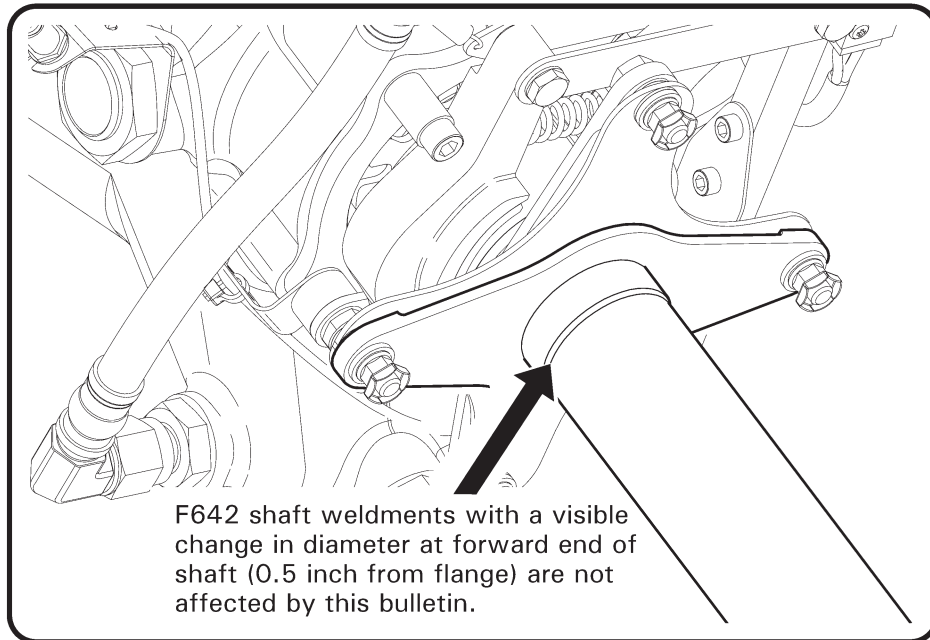


FIGURE 1