

September 8, 1992

TO ALL EXEC 90 BUILDERS

EXEC 90 MANDATORY COMPLIANCE BULLETIN M-06

THIS BULLETIN IS MANDATORY AND MUST BE COMPLIED WITH

History: Field inspection of EXEC helicopters has occasionally revealed improper installation of the four 1/4" bolts that attach the main sprocket to the sprocket hub. In some instances, incorrectly drilled holes and improperly torqued bolts may have resulted in the bolts shearing and dropping into the oil bath. The sheared bolt or nut may then become lodged in the drive chain causing a severe drive train problem.

Action: Drill the holes in a drill press, being careful to ensure that they are drilled perpendicular (90 degrees) to the face of the sprocket. **A LETTER "D" DRILL MUST BE USED** to achieve the proper fit. (If this drill is unavailable locally, it may be ordered from RotorWay, part number E08-3100.) The bolts should fit snug enough that it will be necessary to lightly tap them in place with a plastic hammer.

Replace your original main sprocket bolts with four new bolts, part number E00-2450 and four nuts part number E00-3410. These bolts have a drilled head and shank for safety wire. These bolts are currently available from RotorWay.

Install the new bolts from the bottom with the bolt head flush to the hub flange (no washer) and a combination of one or more washers on the nut end of the bolt. The nut must be in the proper location on the bolt after final torque (see attached drawing) and must not bottom out on the threads of the bolt. Torque the four bolts to 7 ft.lbs., then safety wire the bolts as shown on the attached drawings. Please note that it will be necessary to drill small holes through the sprocket (no larger than 1/16" diameter) so that each bolt head may be individually wired to the Sprocket. The shanks of the four bolts should then be wired together.

Every 100 hours at drive chain replacement, remove the safety wire and re-torque the bolts to 7 ft.lbs. All four bolts, nuts, and washers must be replaced every 500 hours. (Maintenance Manual pages 27 and 79 will be revised to reflect these maintenance intervals.)

DRAWING EXEC 90 MANDATORY BULLETIN M-06

