

**R44 SERVICE BULLETIN SB-72**

**DATE:** 30 April 2010

**TO:** R44 and R44 II owners, operators, and maintenance personnel

**SUBJECT:** Main Rotor Blade Bond Inspection

**ROTORCRAFT AFFECTED:** R44 helicopters with C016-2 main rotor blades, and R44 II helicopters with C016-5 main rotor blades.

**TIME OF COMPLIANCE:** At next 100-hour inspection, annual inspection, or by 31 July 2010, whichever occurs first, and at each 100-hour and annual inspection thereafter.

**BACKGROUND:** Debonding of 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. Debonding resulting from improper inspection and maintenance could cause a catastrophic accident.

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**COMPLIANCE PROCEDURE:**

NOTE

To facilitate inspection, blade may be teetered down, collective fully raised, and cyclic stick positioned to apply maximum up pitch.

1. Refer to Figures 1 and 2. Remove both main rotor blade tip covers and clean the blades.
2. Using 10x magnification, visually inspect uncovered skin-to-tip cap bond joints. Using a 1965-or-later United States quarter-dollar coin, tap test skin-to-tip cap bond joints on both upper and lower surfaces. If corrosion, separation, or voids are detected, blade is unairworthy. Tap test tutorial video is available at: [www.robinsonheli.com/support.htm](http://www.robinsonheli.com/support.htm).
3. Using 10x magnification, visually inspect any exposed skin-to-spar bond line for gaps (empty space between skin and spar). Blade is unairworthy if any gap, including "pin hole(s)", is detected in the bond line.
4. Refer to Figure 2. Mark outboard 135 inches of blade lower surface as shown to identify skin-to-spar bond joint area.

(OVER)

5. Verify no visible dents within the bond joint area. Blade is unairworthy if bond joint area is dented.
6. Tap test the lower skin-to-spar bond joint and verify no voids exist. Blade is unairworthy if a void is detected.
7. Refinish all exposed bare metal per R44 SL-32B.
8. Install blade tip covers, ensuring cover edges are flush with blade profile.
9. Make appropriate maintenance record entries.

**Approximate Cost:**

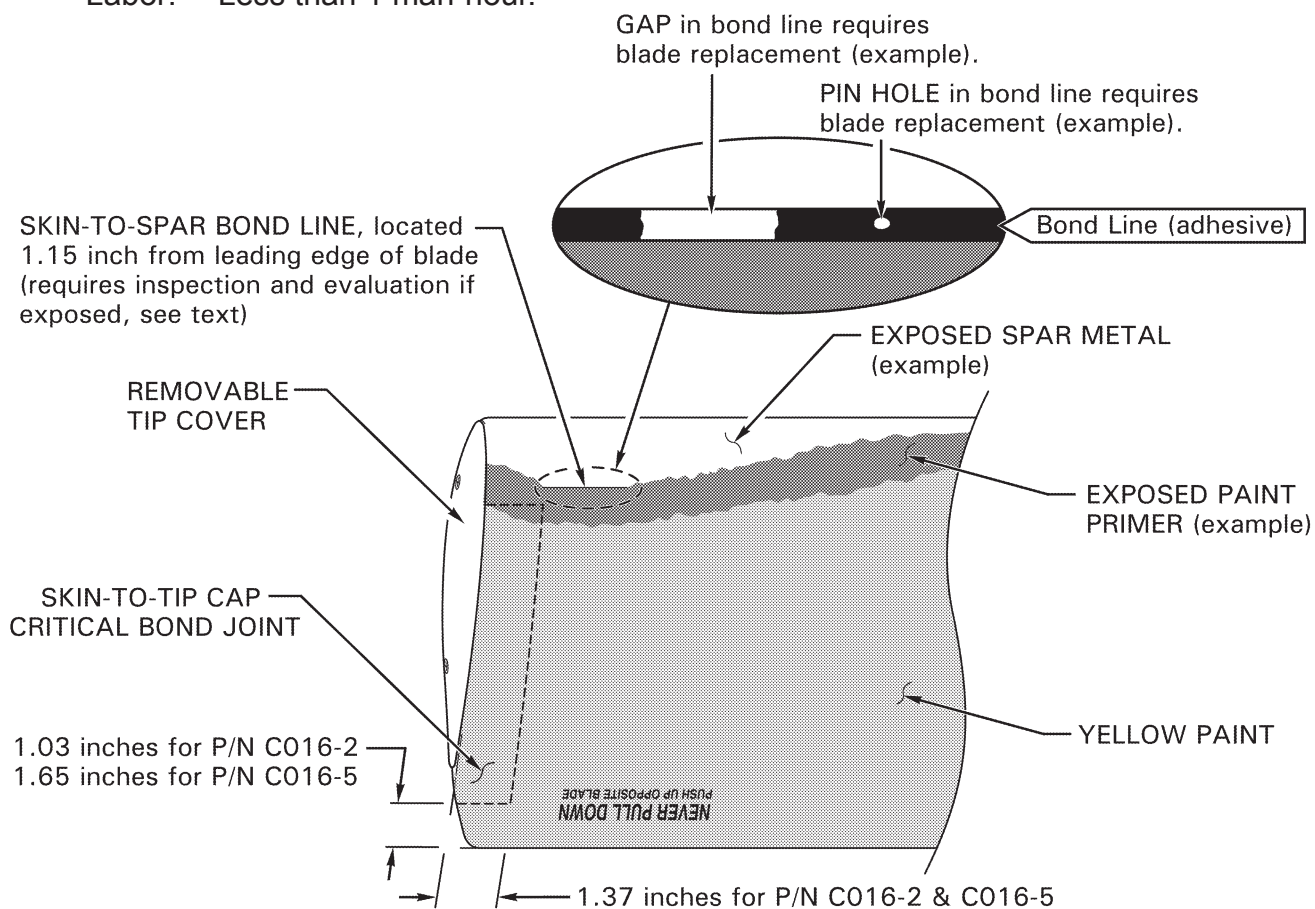
Parts: \$5 for KI-200 Kit if ordered by 31 July 2010.

KI-200 Kit includes:

1 ea MT332-44 tool

1 ea SAN30001 Sharpie® marker

Labor: Less than 1 man-hour.



**FIGURE 1 TIP AREA AND LOWER SURFACE**  
(Example, Blade with Excessive Paint Erosion)

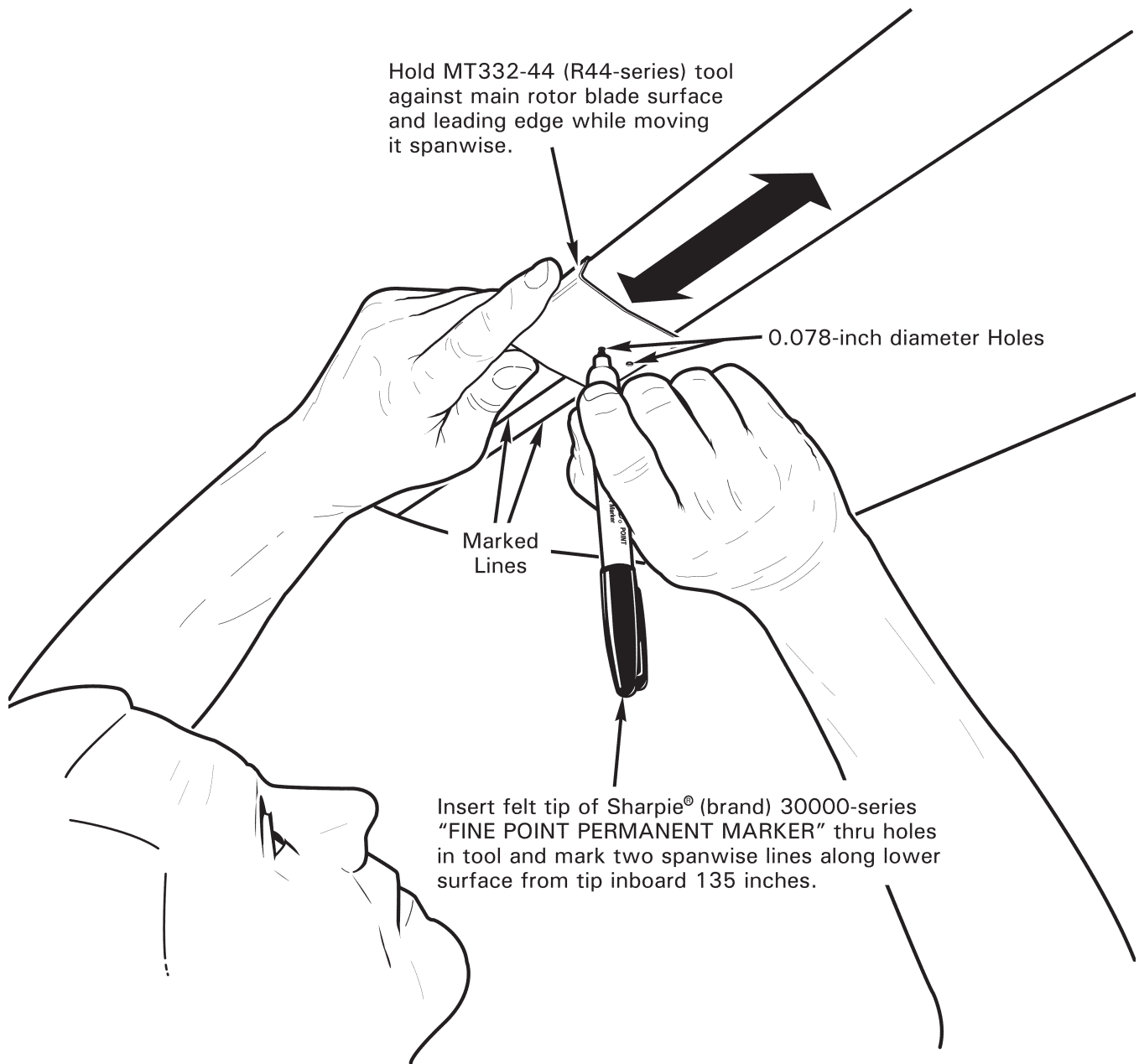


FIGURE 2 MARKING LOWER SKIN-TO-SPAR BOND JOINT AREA