

Sikorsky  
6900 Main Street - P.O. Box 9729  
Stratford, Connecticut 06497-9129

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Date: 31 July 2017  
To: Thai Aviation Services Limited  
Attention: Grant Robinson  
Regarding: Tailpipe Crack-Request For Repair  
Technical Case #: C0066599

Grant Robinson,

The cracks have been reviewed by Sikorsky Engineering and the following guidance is provided:

1. Prepare the aircraft for ground maintenance.
2. Gain access to the repair area.
3. Remove the tail pipe cover from the aircraft per the Maintenance Manual.
4. Stop drill all ends of the crack with a .098" diameter drill. Vacuum the area to remove any loose particles.
5. Clean the tail pipe cover around the repair area using a stainless steel wire brush or equivalent.
6. Degrease the repair area and the repair plug by wiping with a low-lint cleaning cloth (conforming to A-A-59323, Type II) using acetone (conforming to ASTM D329) or ethyl alcohol (conforming to A-A-51693). Wash with clean water to a water-break free condition and blow dry with compressed air.
7. Gas tungsten arc weld repair the crack per MIL-W-8611, using Type 347 stainless steel welding wire, specification MIL-R-5031, Class 5A or AWS-A519. Note: This procedure is outlined in the SA 4047-76-2 Maintenance Manual, Chapter 78-10-00. Also, welding specification MIL-STD-2219, Class A, may be used as an alternative to MIL-W-8611.
8. Clean the metal around the weld using a stainless steel wire brush or equivalent.
9. Blend / finish the weld area if desired, or if required for a flat mating/bolt-up surface. If further assistance is required, please contact Service Engineering.

Regards,  
Kenneth Welch

SIKORSKY AIRCRAFT CORPORATION

**Kenneth Welch**  
Service Engineering (Airframe)  
Sikorsky Aircraft Corporation  
124 Quarry Rd.  
Trumbull, Ct 06611-0868  
T: +1(203)416-4052  
[Kenneth.Welch@sikorsky.com](mailto:Kenneth.Welch@sikorsky.com)

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