

Date: 15 November 2018
To: Thai Aviation Services Limited
Attention: Thanakom Panyothin
Regarding: MRB Patch P/N 70150-09161-049 ILO 76150-09050-049
Technical Case #: C0109948
Aircraft Serial #: 761059

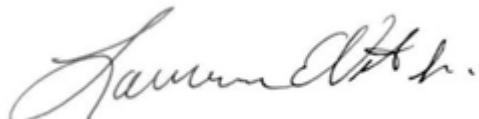
Thanakom Panyothin,

Sikorsky Blade Engineering recommends the following,

The customer can make a pre-cured wet layup patch of two plies of 7781 glass, one layer at +/-45 degrees and one layer at 0/90 degrees. The larger ply should be .5" larger diameter than the smaller ply. It can be layed up on nylon bagging material or a piece of peel ply. Work the EA9309.3NA or EA9359.3 adhesive into the fabric weave with brush or squeegee and wipe off excess. After cured, scuff the patch surface that is to be bonded to the blade with 150 grit or finer sandpaper even if peel ply is used. When the patch is bonded to the blade, the larger ply is on the outside and oriented at +/- 45 degrees. If a black sharpie marker is used to mark the larger ply fabric direction before it is wet layed up, it may show through after it is cured in order to orient it on the blade later on. Otherwise, a small area at the edge of the precured patch might have to be sanded down to the fibers to determine the fabric direction.

All surface prep and curing per the manual instructions, the following patch is for S76 MRB S/N A378-00500 only.

Respectfully,



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