

## Grant Robinson

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**Subject:** FW: [External] HTH MLG Actuator Bushing Details

**From:** McConnell, David P SIK

**Sent:** Friday, December 4, 2015 09:04

**To:** 'Grant Robinson' <[Grant\\_r@tasl.co.th](mailto:Grant_r@tasl.co.th)>

**Subject:** RE: [External] HTH MLG Actuator Bushing Details

Grant;

The response to my original FTR was as follows: "...inspect the holes in the fitting meet B/P requirements."

The B/P dimensions for the two bushing bores in the attach fitting are 0.9375 in. +0.0005 / -0.0010 in. after line reaming.

Please advise if you need this in another format such as FTR response or DocPak'd letter.

Dave

Grant;

Following is the response to my request to CSE to approve the proposed MLG actuator airframe fitting bushing replacement procedure.

Log Number:	76927
FTR Number:	10615T108
FTR Date:	Aug 19 2015 12:39AM
Operator:	Thai Aviation Services (CHC)
Aircraft S/N:	920XXX
Aircraft Model:	S-92A
Part ID:	92201-08111
Part Serial #:	N/A
CSE:	SmithJe
ATA:	32
Ref Docs:	
FTR Subject:	MLG Actuator Aft Attach Bolt Bushing Replacement Procedure

### Problem Description:

TAS maintainers have noted a frozen P/N 2392-2317-005 aft bolt in an MLG retract actuator on A/C S/N 920146. Attempts to free the bolt have been unsuccessful.

TAS anticipates that when the bolt is eventually freed damage will be found on the P/N NAS537-12P062 and 92201-08111-103 bushings in the Sta 462 sponson bulkhead.

The AMM currently has no procedure for changing these bushings. TAS proposes the following procedure:

- 1) Press out installed NAS537-12P062 and 92201-08111-103 bushings using suitable locally manufactured tooling.
- 2) Perform visual and FPI inspection of bushing bores and lugs for cracks.
- 3) Chill replacement bushings with Freeze & Release (Loctite 996456, Freeze 75 or equivalent) or dry ice to a temperature no lower than 110 deg F (-79 deg C).

- 4) Apply a coat of epoxy primer (MIL-PRF-85582 or equivalent, alternate MIL-P23377 or equivalent) to the outer surface of the replacement bushings.
- 5) Press in bushings with suitable locally manufactured tooling.
- 6) Line ream bushings to 0.7495 to 0.7505 inches.
- 7) Apply brush cadmium plating (Cadmium No-Bake 2023 or equivalent) to internal surfaces of bushings. If brush cadmium plating equipment is not available, apply non-curing sealant Cor-Ban 27L to internal surfaces of bushings.
- 8) Seal the edges of the installed bushings with ASM3265 sealant.

Please advise if the above proposed procedure is acceptable to engineering, or please provide an alternate procedure as appropriate. EoM

**Problem Resolution:**

Per Sikorsky Engineering we agree with the procedure stated by TAS. Sikorsky Engineering would like to add that you also inspect the holes in the fitting meet B/P requirements.

**David P. McConnell**

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Sikorsky Aircraft Corporation  
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**From:** Grant Robinson [[mailto:Grant\\_r@tasl.co.th](mailto:Grant_r@tasl.co.th)]  
**Sent:** Thursday, December 03, 2015 8:38 PM  
**To:** McConnell, David P SIK  
**Subject:** Re: [External] HTH MLG Actuator Bushing Details

Hi Dave. Thx

It was a dimension from a drawing. Perhaps we can get that on our docpac. Thx again. Hi to Maricyl. (and the snakes.....ewwwh)

Regards,  
Grant Robinson  
Type Engineer - Sikorsky  
Thai Aviation Services (TAS)  
Mobile: +66 (0)9 2224-5937

Sent from my iPhone

On Dec 3, 2015, at 7:35 PM, McConnell, David P SIK <[DMcConnell@SIKORSKY.COM](mailto:DMcConnell@SIKORSKY.COM)> wrote:

Grant;

Without immediately access to my computer, off the top of my head wasn't there an FTR response that included procedures?

If not I will research tomorrow and FTR as required.

I'm in the PI now so only one hour time difference.

Dave

Sent from my Windows Phone

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**From:** [Grant Robinson](#)  
**Sent:** 12/3/2015 11:07  
**To:** [McConnell, David P](#) [SIK](#)  
**Subject:** [External] HTH MLG Actuator Bushing Details

Hi Dave, sorry to bother you.

We are ready to attempt to replace the aft MLG Actuator pin on HTH. We discussed this earlier but did not pursue it. I know there are dimensions to adhere to when installing the bushings. Is it possible to arrange for that drawing to make its way into our Docpac for our use please? Not sure of the process. Thx

Best Regards,

Grant Robinson  
Type Engineer – Sikorsky Products

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