

Thanakom Panyothin

To: Mcconnell, DAVE P
Subject: RE: S-76D Exhaust duct doubler - riveted installation

From: Mcconnell, DAVE P (TH)
Sent: Saturday, July 28, 2018 08:49
To: Thanakom Panyothin (thanakom_p@tasl.co.th) <thanakom_p@tasl.co.th>
Cc: Grant Robinson <Grant_r@tasl.co.th>
Subject: S-76D Exhaust duct doubler - riveted installation
Importance: High

Khun San

Following is an alternate procedure to add riveted doublers instead of welded doublers on S-76D engine exhaust duct flanges.

Case Number: C0100507
Customer: Thai Aviation Services Limited
Aircraft S/N: 761000
Aircraft Model: S-76D
ATA: 78
Part Number: 76308-77003 / 76308-77004
Part Description: EXHAUST ASSY LHS
Case Subject: Exhaust Duct Flange Doubler-Riveted Installation ILO Welding

Problem Description:

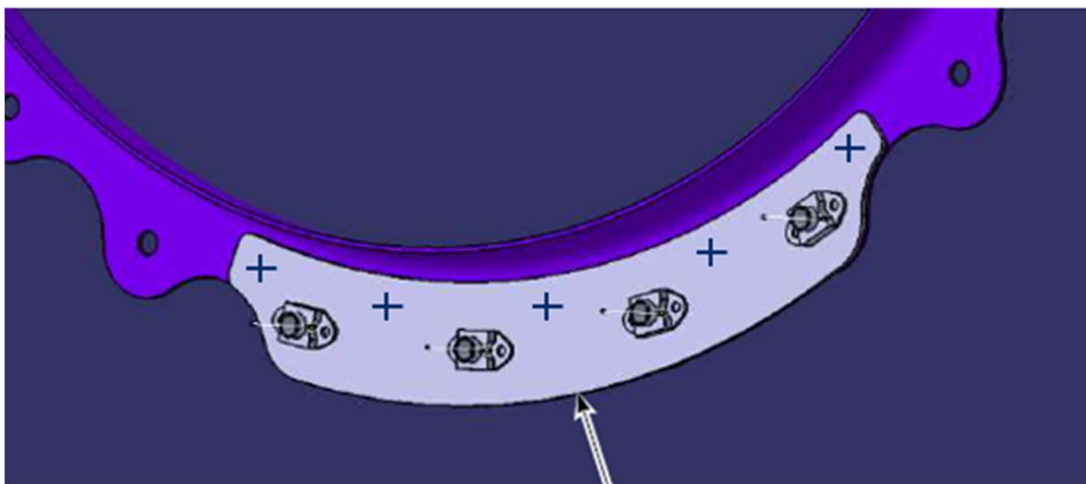
TAS has reported several instances of P/N 76308-77003 and 76308-77004 post CSN 76-262 exhaust ducts developing an out-of-round condition after incorporation of welded flange doublers per AMM Subtask 78-10-01-020-003.

The out-of-round condition makes the duct unserviceable and is contributing to ongoing AOGs on two A/C.

Problem Resolution:

A Deviation to Subtask 78-10-01-020-003 is permitted to allow riveted installation of the repair doubler instead of the specified welded installation.

- 1) Disregard Task references pertinent only to welding.
- 2) Fabricate the doubler per existing Task instructions.
- 3) Attach the doubler to the exhaust duct flange at the existing nutplate fastener holes using fastener P/N CCR264CS-3-XX, or equivalent, with length appropriate to the combined flange and doubler thickness. Install new P/N MS21076-3N nutplates as required.
- 4) Add additional field fasteners as shown. Fasteners are to be of a heat resistant material spec. Diameter should be 0.125 in. minimum. EoM



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