

November 28, 1994

**ASYMMETRICAL ROTOR BLADE MANDATORY BULLETIN M-09 ACTION**  
**(blades manufactured after 9/90)**

INVESTIGATION: The investigation of the blade delamination that occurred during September 1994 is still open; however, our contract engineers have determined that an improved rivet pattern to the asymmetrical rotor blade would increase its structural integrity. RotorWay International has decided to make this modification mandatory before flight operations of your helicopter can be resumed.

MODIFICATION PROGRAM: A new rivet pattern has been designed, implemented, and tested on 3 sets of our rotor blades over the past 6 weeks. Our engineers have determined that once this modification is completed, the joining of the skin to the spar will be 16 times stronger than its current configuration.

The work consists of removing the existing paint and bondo from the seams and rivets of the blades and removal of the tip end plugs. The rivets are removed and a blade tapping hammer is used to verify the integrity of the adhesive bond of the trailing skin to the spar. After the integrity of the bond has been verified, rivets are replaced in the existing holes and a new rivet pattern is implemented between the existing rivets, where a new structural rivet is placed. The seam and rivets are covered with bondo, sanded, and the blade is repainted. The blades are then static balanced on the aircraft and new end plugs are installed. This process took us 7 hours for all removals and improvements and 5 hours for painting and balancing.

RotorWay International is offering 2 programs for your blade modification:

Program A: A modification kit is available for \$110.00 USD providing the necessary parts and instructions for you to complete work on your main rotor blades. Detailed See-Do instructions, structural rivets, new tip end plugs, adhesive kit, rivet countersink tool and bit, and a blade tapping hammer are all included in the kit. You complete the modification.

Program B: A combination of yourself and RotorWay International perform the modification for \$240.00 USD. You remove the tip end plugs from both blades and sand off the paint (if painted) and bondo from the seams and rivets. Return the blades to RotorWay International and we will remove the rivets, perform the bond integrity test, replace the rivets, add new rivets, and if you purchased Quick Kit blades, bondo the seam. After you receive the

blades, you will finish sand the blades, paint the blades, and balance the blades before installing the new tip end plugs. The customer pays \$240.00 and the freight to RotorWay. RotorWay will perform the work mentioned above and pay the return freight.

NOTE: PROGRAM B WILL OFFERED FOR A LIMITED TIME ONLY. IT IS ANTICIPATED THAT TEMPORARY PERSONNEL MAY HAVE TO BE ADDED TO PERFORM THIS WORKLOAD IF DEMAND IS LARGE. IF YOU CHOOSE PROGRAM B YOU MUST NOTIFY US BY DECEMBER 31, 1994. AFTER THIS DATE PROGRAM B WILL BE DISCONTINUED. Call us before you return your blades for modification scheduling.

In an attempt to provide acceptable customer service in regards to this bulletin and to determine our workload requirements, we request that you complete the attached questionnaire indicating your choice of Program A or Program B and return it to us as soon as possible.

NOTE: IT IS EXTREMELY IMPORTANT THAT YOU CONTACT ROTORWAY BEFORE YOU START EITHER PROGRAM. INSTRUCTIONS WILL BE PROVIDED TO YOU FOR EITHER PROGRAM. NO ATTEMPT SHOULD BE MADE TO MODIFY YOUR BLADES FROM THE ABOVE BRIEF EXPLANATION OF THE MODIFICATION.

To expedite your request, you can fax us your return. We apologize for the interruption of your flying enjoyment, however we feel that safety is and should always remain everyone's first concern. It is our goal to have you resume safe flight as quickly as possible.

Thank you for your patience.

RotorWay International