

**SERVICE LETTER**



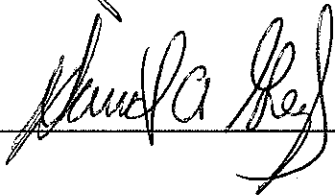
**SL 2007-005**

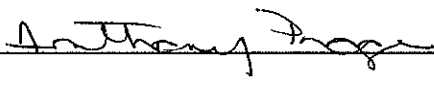
**INSTALLATION OF VACUUM BREAKER VALVE**

**IN HOVER REFILL ELBOW**

Used On: P333 DOOR SYSTEM S/N 001  
FOR INSTALLATION ON  
EUROCOPTER EC225

Production Manager:  Date: 6/19/07

Sales Manager:  Date: 6/19/07

Director of Engineering:  Date: 6/19/07

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# SERVICE LETTER



No: SL 2007-005

Initial release Date: 6/18/07

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Date: June.16, 2007

Revision: Initial Release

**PART NUMBERS AFFECTED:** P333-704200-001 HOVER PUMP SWIVEL ELBOW ASSEMBLY

**SYSTEM MODEL:** Model P333 Door System S/N 001

**COMPLIANCE:** Not Mandatory

**DESCRIPTION:** The service letter provides instructions on how to install a vacuum breaker valve into the hover refill elbow. The vacuum breaker valve improves the drainage characteristics of the hover refill hose after a fill cycle.

**APPROVAL:** None Required

**MANPOWER:** Estimated 3 MHRS

IF APPLICABLE, AN APPROPRIATE ENTRY SHOULD BE MADE IN THE ROTOCRAFT LOGBOOK UPON ACCOMPLISHMENT.  
IF OWNERSHIP OF SYSTEM HAS CHANGED, PLEASE FORWARD TO NEW OWNER.

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## MATERIAL:

The following materials are required for the accomplishment of this bulletin and may be obtained through Simplex Manufacturing:

Quantity	Part Number	Description	Item No.
1	000-152301-000	Inline Vacuum Breaking Valve 303 Ss, 1/2" NPT Male Inlet unthreaded	1
A/R	6802K12	1/2" PTFE Thread Seal Tape	2

## SPECIAL TOOLS:

1. 1/4 Drill Bit
2. 1/2 Drill Bit
3. 23/32 Drill Bit
4. 1/2 NPT Tap
5. 1/2" Drill
6. Tapping Oil

**WEIGHT AND BALANCE:** Not affected

**ELECTRICAL LOAD DATA:** Not affected

**REFERENCE:** Not affected

**PUBLICATIONS AFFECTED:** Not affected

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## ACCOMPLISHMENT INSTRUCTIONS

- 1) Disconnect the hover refill pumps electrical connector P3. The connector is located on the forward right hand side of the Model P333 Door System System.
- 2) Remove the hover pump assembly by first removing the safety wiring retaining the camloc arms then lower the camloc arms and slide the hover pump assembly away from the hover refill elbow.
- 3) Rotate the hover refill elbow so the inlet is parallel with the ground.
- 4) Make a mark on the Center Line of the elbow 4 inches in from the face of the elbow. See figure 1.

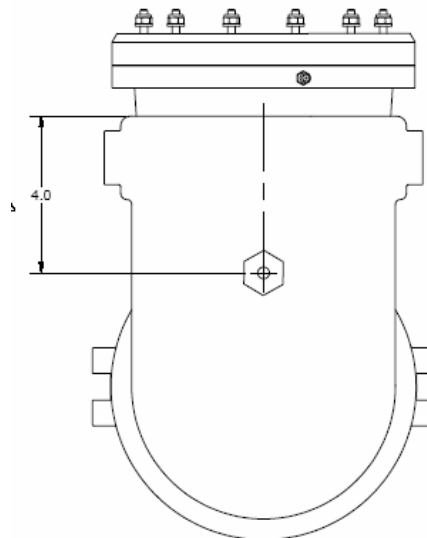


Figure 1

- 5) Place a hole in the elbow starting with the 1/4 inch drill bit, then the 1/2 inch, finish the hole with the 22/32 inch drill bit. Deburr the hole upon completion of drilling.
- 6) Using tapping oil tap hole with 1/2 inch NPT tap.
- 7) Thread vacuum breaking valve into housing. Wrap threads with PTFE Thread Seal Tape prior to installation.
- 8) Connect the hover pump assembly to the hover refill elbow, rotate the camloc arms up and safety wire them per best shop practices.
- 9) Connect electrical connector P3.

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