

# SERVICE LETTER



Service Letter SL 2005-003, Rev. B

Installation of Modified Tank

Top Skin Inserts on Simplex

Model 310-002 (1100 lt.) Fire Attack Systems

for Eurocopter De Mexico

Sales: Matt [Signature] Date: 7/18/05

Engineering: [Signature] Date: 7/18/05

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# SERVICE LETTER



Date: 7/11/05

Revision: I/R

**PART NUMBERS AFFECTED:** 310-000 000-002

**SYSTEM MODEL:** Simplex Fire Attack System, Model 310-002

**EFFECTIVITY:** Tank Serial Numbers 0029, 0030, 0031

**COMPLIANCE:** Required to fit helicopter.

**DESCRIPTION:** Eurocopter De Mexico's AS 350-B3 has an extra OAT sensor installed beneath the aircraft. The depression in the Simplex Fire Attack tank is not large enough to accommodate a second sensor. This document describes the solution.

**MANPOWER:** This modification requires 10 man-hours per system.

**ADDITIONAL DOCUMENTS:** SIMPLEX PROCESS SPECIFICATIONS SMC 2000-300, -032, -040, -041, -044.  
Drawing # P310-203 100-001

1. Disconnect all electrical connections. Remove Fire Attack Tank from aircraft.
2. Place tank on a secure padded support with left side edge up with doors open. Secure tank so it will stand vertically on edge during repair. Examine the inside of the tank in the area under the depression. Note the location of the drain pipe in the OAT clearance cavity. See Figure 1.



Figure 1

3. Using a Saws-All or a similar power saw cut smoothly around the outline of the insert as shown in Figure 2. Cut around the existing drain tube to approximate the shape of the insert. Do not cut into the center baffle or the drain tube.

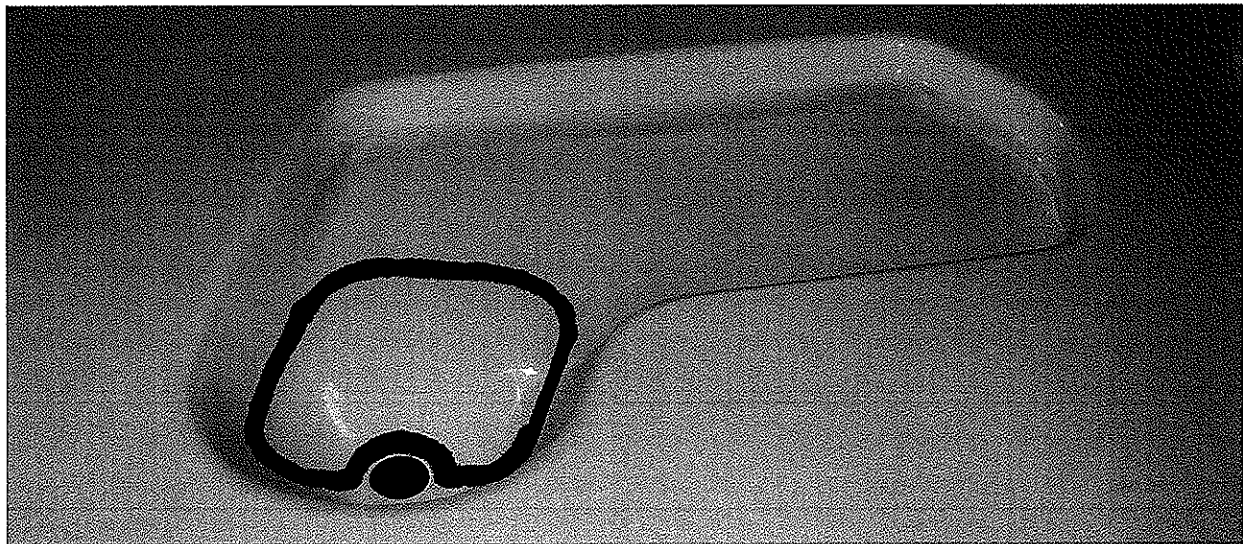


Figure 2


- 4. Using a grinder, carefully trim the hole to fit the insert p/n P 310-203 100-002 provided. Modify the insert to fit the drain tube if necessary. The object is to locate the insert flush with and sloping slightly downhill toward the existing drain tube. The insert may be trimmed if necessary to achieve a better fit.**
- 5. Prepare the inner surface of the cutout with a grinder, feathering the under surface per SMC 2000-300. Lightly grind away the sealant in those areas around the repair. Grind away remnants of lay up from the drain tube.**
- 6. Using tape, heat glue gun, or clamps to position the insert in place, bond in place per SMC 2000-300. Be certain that all original lay ups are replicated in the repair per SMC 2000-032. Also bond the drain tube in place per SMC 2000-032.**
- 7. Lightly grind away excess insert and the seam of the repair on the top surface and around the drain tube. Using surfacing putty and hand sanding, bring the tank surface back to a cosmetically acceptable finish. Apply gel coat per SMC 2000-044 to complete surface finish. Reapply interior surfacing agent per SMC 2000-041.**
- 8. After allowing 24 hours cure time for the repair, re-install the Fire Attack System on the aircraft and test the system for function.**

APPLICATION		REVISION HISTORY (Multi-sheet drawings carry same Rev level)			
NEXT ASSY.	USED ON	REV.	DESCRIPTION	DATE	APPROVED
	310 FIRE ATTACK				

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EUROCOPTER DE MEXICO REPAIR PARTS LIST

ITEM #	SMC #	DESCRIPTION	AMOUNT
1	751022	1-1/2 OZ. MAT	160 SQ. IN.
2	751026	9.7 OZ. CLOTH	160 SQ. IN.
3	751010 OR 751012	282 CARBON FIBER	80 SQ. IN.
4	751001	POLYESTER GEL COAT-WHITE	1 QUART
5	751034	VINYL ESTER RESIN	1 QUART
6	751039	HI-POINT 90 CATALYST (MEKP)	4 OZ.
7	MIXED PER SMC2000-040	HEIDI PUTTY	1 PINT
8	MIXED PER SMC2000-041	SURFACING AGENT	1 PINT
9	P310-203 100-002	OAT CLEARANCE INSERT	1 EACH
10	751049	BODY LITE FILLER	1 PINT
11	751050	BODY LITE FILLER HARDENER	3 OZ.
12	310-203 008-001	DRAIN TUBE	1 EA.
13	SMC 2000-300	PROCESS SPECIFICATION	1 EA.
14	SMC 2000-032	PROCESS SPECIFICATION	1 EA.
15	SMC 2000-040	PROCESS SPECIFICATION	1 EA.
16	SMC 2000-041	PROCESS SPECIFICATION	1 EA.
17	SMC 2000-044	PROCESS SPECIFICATION	1 EA.

DCN'S ATTACHED	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: -DO NOT SCALE DRAWING-		SIGNATURE	DATE	 <b>SIMPLEX</b> 13340 N.E. Whitaker Way, Portland, Oregon 97230 Ph. 503.257.3511
	#	MACHINE FINISH 125/	ANGLES + 1°	DIMENSIONS X ± .100 XX ± .010 XXX ± .005	
#	MATERIAL:		CHECKED BY:	PRODUCTION CONTROL:	TITLE EUROCOPTER DE MEXICO 310 OAT CLEARANCE PATCH
#	FINISH:		PROJECT ENG. APPROVAL:	CODE I.D. NO. 52905	DRAWING NO P310-203 100-001
#			FILE NAME:	SIZE <b>A</b>	REV <i>1/R</i>
			SCALE <i>NA</i>		SHEET <i>1</i> OF <i>1</i>