



A Textron Company

TECHNICAL BULLETIN

505-18-13

PSL 700000281

28 November 2018

MODEL AFFECTED: 505

SUBJECT: AFT ROOF PANELS AND CEILING AREA,
INSPECTION AND PROTECTION OF.

HELICOPTERS AFFECTED: Serial numbers 65013, 65014, 65018 through
65020, 65022 through 65028, 65030 through 65032,
and 65034 through 65036.

[Serial numbers 65011, 65012, 65015 through 65017,
65021, 65029 ,65033, and 65037 and subsequent
have the intent of the bulletin incorporated and are not
affected by this bulletin.]

COMPLIANCE: At customer's option.

DESCRIPTION:

Bell is aware of a possible issue with hydraulic fluid pooling on the upper aft roof panels, migrating through the roof panels, and staining the underside. The intent of this Technical Bulletin (TB) is to permit the application of protective layers onto the roof panels.

-NOTE-

The word "wicking" is a term that is defined as "to move moisture by capillary action from an inside surface to the outside surface".

After accomplishment of this Technical Bulletin, wicking stains may be observed on the passenger cabin area ceiling panels for an undetermined period due to residual hydraulic fluid. Wipe clean as required the ceiling panels using the solvent mixture in accordance with this TB until wicking stops.

Owner/Operators may contact Product Support Engineering for additional ceiling panel covering options, if needed.

APPROVAL:

The engineering design aspects of this bulletin are Transport Canada Civil Aviation (TCCA) approved.

CONTACT INFO:

For any questions regarding this bulletin, please contact:

Bell Product Support Engineering - Light Helicopters
Tel: 450-437-2862 / 1-800-363-8023 / productsupport@bellflight.com

MANPOWER:

The approximate man-hours required to accomplish this technical bulletin are provided below. This estimate is based on a hands-on time, roof panels porosity, servo leak rate and may vary with personnel and facilities available.

PART I: Inspection and repair of the upper roof panels and the passenger cabin ceiling panels. (No wicking observed) - 12 man-hours.

PART II: Repair of upper aft roof panels - 19 man-hours.

WARRANTY:

Owners / Operators of Bell Helicopters who comply with the instructions in this Bulletin will be eligible to receive non-prorated replacement Kit as applicable, listed in the bulletin. Bell Helicopter has recently introduced enhancements to the VISTA Portal which allocates specific warranty entitlement for an aircraft by serial number. The Product Service Letter (PSL) number which will be listed below the bulletin number on the introduction page is going to be a required field when submitting a claim for replacement parts, labor, and/or freight. If you receive an ASB or TB that does not have a PSL number, then there is no warranty entitlement for that bulletin.

Labor entitlement: **PART I** - \$1,020.00 USD
PART II - \$1615.00 USD

To receive parts, labor, under warranty:

- Comply with the instructions contained in this Bulletin no later than the applicable date in the “compliance section”.
- If there is a PSL number identified in the bulletin, you will be required to enter this PSL number which will validate warranty entitlement for the selected aircraft. Please ensure that you use the Bulletin tab on the warranty section in VISTA to file your claim.

NOTE: Customers who fail to comply with the instructions in this Technical Bulletin within one year from date of issuance will not be eligible for the special warranty listed above.

MATERIAL:

Required Material:

The following material is required for the accomplishment of this bulletin and may be obtained through your Bell Helicopter Textron Supply Center. Take notice, the materials supplied being consumables with shelf life expiration dates, once order is placed, anticipate a reasonable lead time delay to obtain since these are special order items and not all are readily stocked or available on demand. Order **CT-505-18-13** kit that consists of the followings.

Part Number	Nomenclature	(Note)
2230-00368-00	Coating, Polyurethane, Aircraft Support, Color to be 17295 per AMS-STD-595 (white)	(1)
2230-00720-00	Coating, Epoxy Primer, Waterborne	(1)
2000-01137-00	Adhesive, Epoxy Base, Room Temperature Cure, High Peel Strength	(1)
2010-00070-00	SEALANT-TY II, CL1, GR B-2	(1)
2010-00154-00	Compound - 3M piranha putty - 05821	(1)

NOTE 1: Refer to the consumable material list for details.

Consumable Material:

The following material is required to accomplish this bulletin, but may not require ordering, depending on the operator's consumable material stock levels. This material may be obtained through your Bell Supply Center.

Part Number	Nomenclature	Qty (Note)	Reference *
2230-00368-00	Coating, Polyurethane, Aircraft Support, Color to be 17295 per AMS-STD-595 (white)	1 GAL (2) (4)	C-245
2230-00720-00	Coating, Epoxy Primer, Waterborne	1 QT (2) (4)	C-246
2000-01137-00	Adhesive, Epoxy Base, Room Temperature Cure, High Peel Strength	1 PT (2) (4)	C-322
2010-00070-00	SEALANT-TY II, CL1, GR B-2	3.5 OZ (2) (4)	C-251
2010-00154-00	Compound- 3M piranha putty - 05821	24 OZ (709 ml) (2) (4)	C-266

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty (Note)</u>	<u>Reference *</u>
2000-06383-00	Tape, Masking (1 inch wide)	Roll (1)	C-426
Commercial	Cheese cloth, Rymple cloth	Roll (1)	C-486
Commercial	Shop rags	AR (1)	
Commercial	Isopropyl Alcohol	AR (1)	C-285
2100-00061-00	Acetone	1 GAL (1) (2)	C-316
5060-60154-00	Sheet Cloth (180 Grit)	AR (1)	C-406
Commercial	Abrasive Cloth or Paper 220 grit	AR (1)	
5060-60160-00	Silicon Carbide Abrasive Cloth or Paper (400 Grit)	AR (1)	C-423
Commercial	Abrasive pad (RED)	AR (1)	
2000-08884-02	Tape, Aluminum Foil/Glass Cloth, High Temperature	Roll (2 inch wide) (1)	C-401
2010-11492-00	Sealant Tape, Extruded, General Purpose, Cure Temp <375 F	AR (1)	C-259
Commercial	Acid Brush	AR (1)	
Commercial	Breather Felt, Non-Woven, Polyester, 10 oz, High Pressure	AR (1)	C-565
Commercial	Bagging Film, Nylon	AR (1)	C-257
Commercial	Spatula (plastic) soft and hard 3" inches wide	AR (1)	
Commercial	Release Film, Fluoropolymer, Non-perforated	AR (1)	C-256
Commercial	Plastic tubing .250 Dia.	AR (1)	
Commercial	Paint brush 1" inch	AR (1)	
Commercial	Roller 3" inches	AR (1)	
Commercial	Cable tie	AR (1) (3)	
Commercial	Syringe	AR (1)	

* C-XXX numbers refer to the consumables list in the BHT-ALL-SPM, Standard Practices Manual

NOTES:

1. May be procured commercially.
2. Quantity indicated is the format that the product is delivered in. Actual quantity required to accomplish the instructions in this bulletin may be less than what has been delivered.
3. Used with the air-conditioning ducts.
4. Included in **CT-505-18-13** kit.

SPECIAL TOOLS:

Vacuum fitting
Vacuum pump
Work aids (Figure 10)

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-505-IPC, Illustrated Parts Catalogue
BHT-ALL-SPM, Standard Practices Manual
BHT-505-MM, Maintenance Manual
BHT-505-AC-120M Air Conditioning System Maintenance Manual Vendor Data
IL GEN-04-96 General Information Letter - Procedure for Requesting BHT-Approved Structural Repairs

PUBLICATIONS AFFECTED:

Not affected.

ACCOMPLISHMENT INSTRUCTIONS:

PART I: Inspection of the upper roof panels and the passenger cabin ceiling panels.

1. Prepare the helicopter for maintenance.
2. Remove left transmission fairing (DMC-505-A-53-40-01-00A-520A-A) and right transmission fairing (DMC-505-A-53-40-02-00A-520A-A).

-NOTE-

The word “wicking” is a term that is defined as “to move moisture by capillary action from an inside surface to the outside surface”.

3. Disconnect the two connectors (2312AT1P1 and 2312AT1P2) from the COMM/GPS antenna (DMC-505-A-23-10-01-00A-520A-A). Remove the cable tie securing the wires. Pull back the wires and temporarily secure them out of the way.

4. If equipped with air conditioning, remove the applicable ducting and prevent FOD from entering the ducts and inlets on the upper roof area (BHT-505-AC-120M).
5. Inspect the left and right upper roof panels (Figure 1, Detail A, Sheet 1 of 2) and the interior ceiling panels in the passenger area (Figure 1, Detail B, Sheet 2 of 2) for wicking stains.
 - a. If no wicking stains are observed on the panels, go to step 6.
 - b. If wicking stains are observed on the upper roof panels and/or on the passenger cabin ceiling panels, go to **PART II**.
6. Clean and prepare the left and right upper roof panels as follows:
 - a. Clean and protect the components around the work area and the external perimeter around the roof upper surfaces (Figure 2) using protective material and masking tape (C-426), or equivalent, to hold in place the protective material.
 - b. Lay masking tape (C-426), or equivalent, around the external perimeters of the left and right upper roof panels.

WARNING

MAKE SURE YOU OBEY ALL THE SAFETY PRECAUTIONS WHEN YOU USE SOLVENTS. FAILURE TO DO SO MAY RESULT IN INJURIES TO PERSONS AND/OR DAMAGE TO COMPONENTS (BHT-ALL-SPM Chapter 11).

-NOTE-

In this Technical Bulletin, we will refer often to “the solvent mixture”. The solvent mixture will have to be locally mixed by mixing equal parts by volume of Acetone (C-316) and Alcohol (C-285).

- c. Prepare the solvent mixture.
 - d. Wipe clean both upper roof panels (Figure 2) using cheesecloth (C-486), or equivalent, saturated with the solvent mixture.
 - e. Wait a minimum of 20 minutes prior to proceeding to the next step.
7. Inspect for wicking (Figure 3).
 - a. If wicking is observed, go to **PART II**.

- b. If no wicking is observed, go to step 8.
8. Prepare the left and right upper roof panels for repair as follows:

-NOTE-

Do not sand into the fibers of the upper roof panels.

- a. Using 180 grit or finer abrasive paper or cloth (C-406) and the solvent mixture, wet abrade by hand the primer on both upper roof panels (Figure 4, Sheet 1 of 2) down to the pores.
 - i. Additional abrading of the roof surfaces may be required to open the panel pores using abrasive pad (RED), or equivalent, and as applicable. Do not sand into the fibers.
 - b. Wipe clean the surfaces using cheesecloth (C-486), or equivalent, wet with the solvent mixture.
 - c. Allow a minimum of 15 minutes for solvent to evaporate.
9. Seal the pores of the left and right upper roof panels as follows:

-NOTE-

Mix only quantities that can be applied within 3 minutes.
The finishing glaze compound (C-266) typically hardens within 5 minutes. Refer to the manufacturer's instructions to mix and apply the filler finishing glaze.

- a. Using a spatula, or equivalent, apply the finishing glaze compound (C-266) in a thin layer with sufficient pressure to force it into the pores of the roof panel (Figure 5).
- b. Let the finishing glaze compound (C-266) dry at room temperature for 30 minutes after the last application.

-NOTE-

If pin hole filler compound was used during manufacturing process on the roof panel to seal pores, make sure during sanding of the finishing glaze compound (C-266) to remove high spots. Some of finishing glaze may come off where pin hole filler compound was applied (Figure 6).

- c. Lightly sand the finishing glaze compound (C-266) using 180 grit or finer abrasive cloth (C-406) and/or 400 grit (C-423), or equivalent, to remove high spots.
- d. Wipe clean the repair area with the solvent mixture and allow a minimum of 15 minutes for solvent to evaporate.

-NOTE-

For cure time of the different products below, refer to the BHT-ALL-SPM unless otherwise stated.

- e. Apply sealant (C-251) to the rivet heads (Figure 8, Sheet 1 of 2) using an acid brush, or equivalent (Workaid, Figure 10).
 - f. Apply adhesive (C-322) uniformly on the repaired area (Figure 8, Sheet 2 of 2) using a spatula or equivalent (Workaid, Figure 10).
 - g. Allow the adhesive (C-322) to dry and cure.
10. Apply epoxy primer (C-246) as follows:
- a. Using a soft tip paint brush, or equivalent, apply a thin coat of epoxy primer (C-246) on the surfaces (Figure 9).
 - b. Allow the epoxy primer (C-246) to dry and cure for a minimum of 2 hours at room temperature. Heat application shall not be used.
11. Apply paint (C-245) on top of the epoxy primer (C-246) as follows:
- a. Prepare the paint (C-245) per the manufacturer's instructions.
 - b. Mix enough material to have a minimum of 16.9 ounces (500 milliliters).
 - c. Using a soft tip brush, or equivalent, apply the paint (C-245) over the primed surface (Figure 9).
 - d. Allow a minimum of 60 minutes at room temperature prior to proceeding with the next step.
 - e. Apply second coat of paint (C-245).
 - f. Allow the paint to dry and cure per the manufacturer's instructions.
12. Install and reconnect the COMM/GPS antenna wires (DMC-505-A-23-10-01-00A-720A-A). Install cable ties on associated wiring as applicable.

13. Reinstall air conditioning ducting if removed in step 4 (BHT-505-AC-120M).
14. Reinstall the left transmission fairing (DMC-505-A-53-40-01-00A-720A-A) and right transmission fairing (DMC-505-A-53-40-02-00A-720A-A).
15. Make an entry in the helicopter logbook and historical service records indicating compliance with **PART I** of this Technical Bulletin.

PART II: Repair of upper aft roof panels.

1. Clean and prepare the left and right upper roof panels as follows:
 - a. Clean and protect the components around the work area and the external perimeter around the roof upper surfaces (Figure 2) using protective material and masking tape (C-426), or equivalent, to hold in place the protective material.
 - b. Lay masking tape (C-426), or equivalent, around the external perimeters of the left and right upper roof panels.

WARNING

MAKE SURE YOU OBEY ALL THE SAFETY PRECAUTIONS WHEN YOU USE SOLVENTS. FAILURE TO DO SO MAY RESULT IN INJURIES TO PERSONS AND/OR DAMAGE TO COMPONENTS (BHT-ALL-SPM Chapter 11).

-NOTE-

In this Technical Bulletin we will refer often to “the solvent mixture”. The solvent mixture will have to be locally mixed by mixing equal parts by volume of Acetone (C-316) and Alcohol (C-285).

2. Prepare the solvent mixture.
3. Wipe clean both upper roof panels (Figure 2) using cheesecloth (C-486), or equivalent, saturated with the solvent mixture.
4. Prepare the left upper roof panel for repair as follows:

-NOTE-

Do not sand into the fibers of the upper roof panels.

- a. Using 180 grit or finer abrasive paper or cloth (C-406) and the solvent mixture, wet abrade by hand the primer on the left upper roof panel (Figure 4, Sheet 1 of 2) down to the pores.
 - ii. Additional abrading of the roof surface may be required to open the panel pores using abrasive pad (RED), or equivalent, and as applicable. Do not sand into the fibers.
- b. Wipe clean the surface using cheesecloth (C-486), or equivalent, wet with the solvent mixture.
- c. Saturate the left upper roof panel with the solvent mixture. Wait one minute to let some of the mixture infiltrate the roof panel pores.

-NOTE-

If pin hole filler compound was used during manufacturing process on the roof panel to seal pores, some of the solvent mixture may remain on the top surface and/or may not evaporate.

- d. Rub the left upper roof surface until the solvent mixture has either evaporated or infiltrated into the upper roof panel. Remove the excess solvent mixture before the next step.
- e. Repeat steps 4.a. through 4.d. for the right upper roof panel.

-NOTE-

Fluids may have infiltrated into only one side of the upper roof panel either the left or the right side panel, or into both panels. Fluid wicking may reappear up to 20 minutes after the wipe cleaning procedure done in step 4.d. above.

- f. Wait 20 minutes before proceeding with the next step.

-NOTE-

The word “wicking” is a term that is defined as “to move moisture by capillary action from an inside surface to the outside surface”.

5. Check for wicking on the upper roof panels (Figure 4, Sheet 2 of 2) and accomplish the surface cleaning as follows:

- a. If wicking stains are limited in number (five or less) and in size (0.250 inch (6.35 mm) diameter or less), it is permissible to further abrade the area using abrasive pad (RED) to open the pores and to wipe clean the surfaces using the solvent mixture. Wait an additional 20 minutes to check for further wicking.
- b. As applicable, repeat this procedure until wicking is no longer observed for a minimum period of 20 minutes, or go to step 5.c.

-NOTE-

Vacuum bagging process is required to extract some of the trapped fluids on either the left and/or the right roof panel. Vacuum bags can be installed on both the left and right upper roof panels as applicable. Tape (C-401) is recommend for the next step; it will ease the removal of the sealant tape (C-259).

- c. Place tape (C-401), or equivalent, around the perimeter (Figure 7, View A and B, Sheet 1 of 2) which needs to be vacuum bag cleaned or place sealant tape (C-259) directly on the upper panel surface around the perimeter or on top of the tape (C-401) as applicable.
- d. Cut to size a shop rag, or equivalent, to fit the repair area.
- e. Cut to size breather felt material (C-565) to fit the repair area.
- f. Prepare a plastic tube approximately (0.250 inch (6.35 mm) diameter) 36 inches (0.91 m) long. Drill small holes in the plastic tube side wall section (Figure 7, View C, Sheet 2 of 2) that will be inserted into the vacuum bag. Plug both ends of the tube with sealant tape (C-259) (Figure 7, View C and D, Sheet 2 of 2).
- g. Cut to size bagging film material (C-257) that will be used on top of sealant tape (C-259).
- h. Saturate the shop rag with the solvent mixture and lay the shop rag material, or equivalent, on top of the repair area.
- i. Lay the breather felt (C-565) on top of the shop rag material, or equivalent.
- j. Place the plastic tube with the end with the small drilled holes on top of the breather felt material (C-565).
- k. Install the bagging film (C-257) on the applicable repair area, and start bonding the bagging film (C-257) to the sealant tape (C-259). Insert the vacuum fittings in the bag.

- l. Cut holes in the bagging film (C-257) for the installation of the vacuum hose and the monitor hose. Bond the remaining bagging film (C-257) to the sealant tape (C-259) (Figure 9).
 - m. Start vacuuming. Minimum vacuum level to be 20 inch Hg.
 - n. Using a syringe, or equivalent, pour solvent mixture in the plastic tube to keep the shop rag saturated at an interval of 20 to 30 minutes.
 - o. Run vacuum for 1.5 hours.
 - p. Remove the bagging film, shop rag and the breather felt from the cabin ceiling.
 - q. Inspect for wicking (Figure 4, Sheet 2 of 2).
 - i. If wicking stains are limited in number (five or less) and in size (0.250 inch (6.35 mm) diameter or less), it is permissible to further abrade the area using abrasive pad (RED) to open the pores. Wipe clean the surfaces using the solvent mixture and wait an additional 20 minutes. Do not sand into the fibers.
 - ii. Check for wicking and as applicable repeat the procedure in step 5.q.i. until wicking is no longer observed for a minimum period of 20 minutes, or go to step 5.r. below.
 - r. If wicking is observed within a period of less than 20 minute, repeat steps 5.a. through 5.q. in their entirety.
 - s. As applicable, repeat steps 5.a. through 5.q. above for the remaining upper roof panel if both upper roof panels need to be vacuum bag cleaned.
6. When wicking is no longer observed on either the left or the right roof panel for a period of at least 20 minutes, go to step 7.
 7. As applicable, wipe clean the upper roof repair area with the solvent mixture. Allow a minimum of 15 minutes for solvent to evaporate.
 8. Seal the panel pores of the left and right upper roof panels as follows:

-NOTE-

Mix only quantities that can be applied within 3 minutes. The finishing glaze compound (C-266) typically hardens within 5 minutes. Refer to the manufacturer's instructions to mix and apply the filler finishing glaze.

9. Using a spatula, or equivalent, apply the finishing glaze compound (C-266) in a thin layer with sufficient pressure to force it into the pores of the roof panel (Figure 5).

10. Let the finishing glaze compound (C-266) dry at room temperature for 30 minutes after the last application.

-NOTE-

If pin hole filler compound was used during manufacturing process on the roof panel to seal pores, during the sanding of the finishing glaze compound (C-266) to remove high spots, some of finishing glaze may come off where pin hole filler compound was applied (Figure 6).

11. Lightly sand the finishing glaze compound (C-266) using 180 grit or finer abrasive cloth (C-406) and/or 400 grit (C-423), or equivalent, to remove high spots.
12. Wipe clean the repair area with the solvent mixture. Allow a minimum of 15 minutes for solvent to evaporate.

-NOTE-

For cure time of the different products used in this repair, refer to the BHT-ALL-SPM unless otherwise stated.

-NOTE-

Protect components in the area prior to the application of primer using masking tape (C-426), or equivalent.

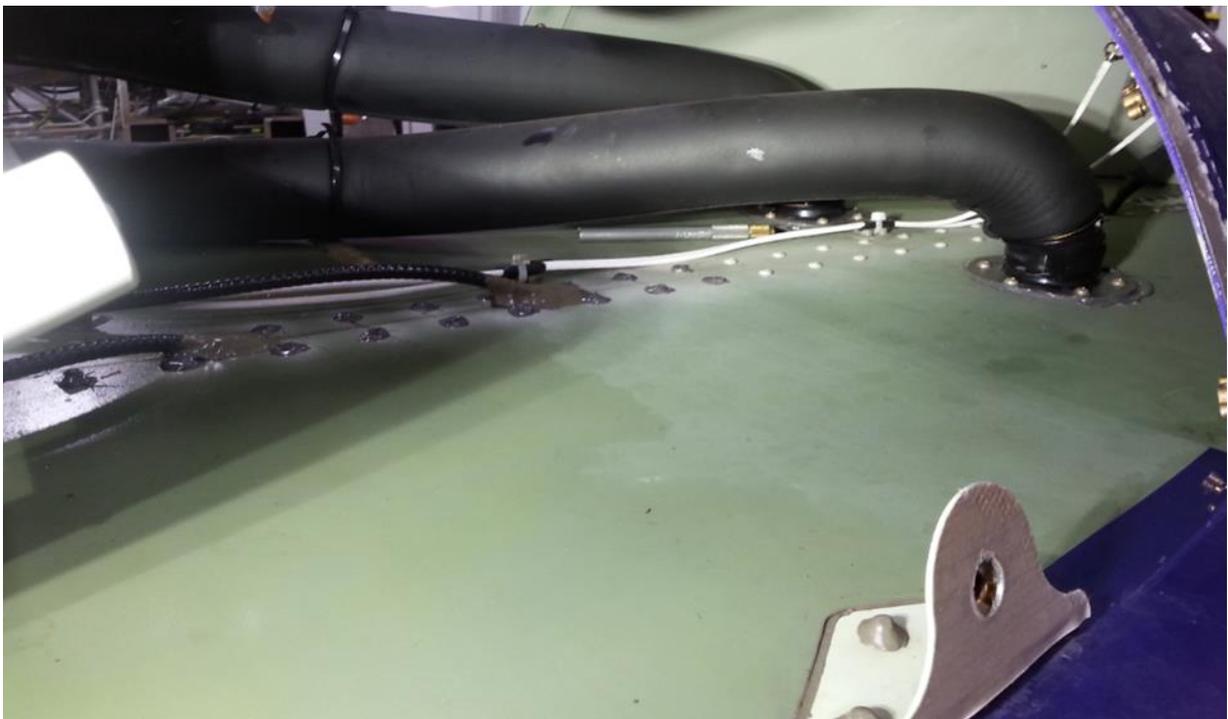
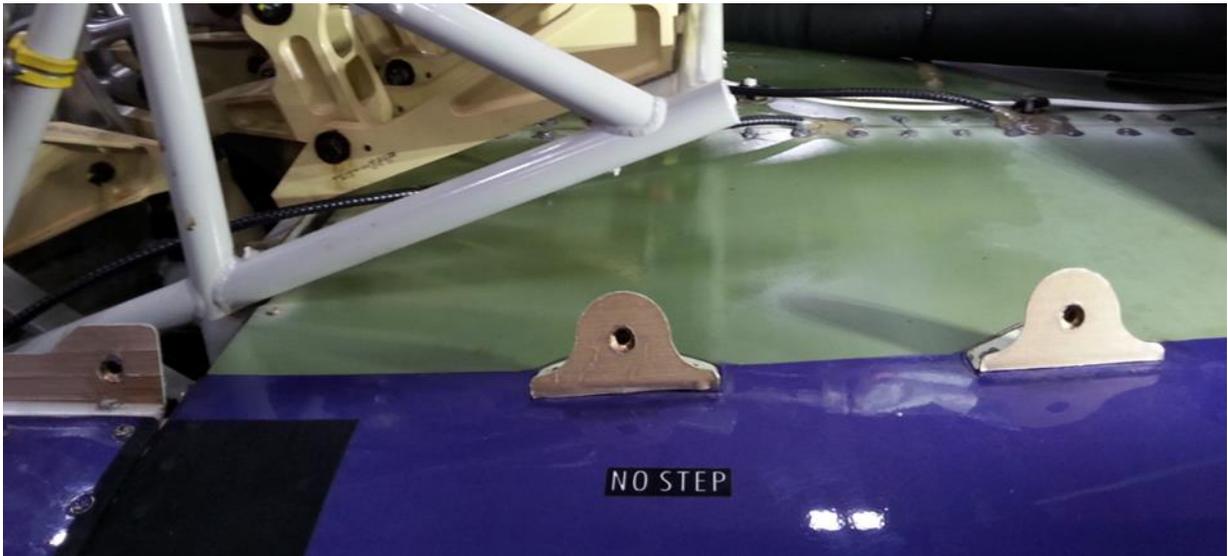
13. Apply sealant (C-251) to the rivet heads (Figure 8, Sheet 1 of 2) using an acid brush, or equivalent (Workaid, Figure 10).
14. Apply adhesive (C-322) uniformly on the repaired area (Figure 8, Sheet 2 of 2) using a spatula, or equivalent (Workaid, Figure 10).
15. Allow the adhesive (C-322) to dry and cure.
16. Apply epoxy primer (C-246) as follows:
 - a. Using a soft tip paint brush, or equivalent, apply a thin coat of epoxy primer (C-246) on the surfaces (Figure 9).
 - b. Allow the epoxy primer (C-246) to dry and cure for a minimum of 2 hours at room temperature. Heat application shall not be used.

17. Apply paint (C-245) on top of the epoxy primer (C-246) as follows:
 - a. Prepare the paint (C-245) per the manufacturer's instructions.
 - b. Mix enough material to have a minimum of 16.9 ounces (500 milliliters).
 - c. Using a soft tip brush, or equivalent, apply the paint (C-245) over the primed surface (Figure 9).
 - d. Allow a flash-off time of 60 minutes at room temperature.
 - e. Apply second coat of paint (C-245).
 - f. Allow the paint to dry and cure per the manufacturer's instructions.
18. Install and reconnect the COMM/GPS antenna wires (DMC-505-A-23-10-01-00A-720A-A). Install cable ties on associated wiring as applicable.
19. Reinstall air conditioning ducting if removed in **PART I**, step 4 (BHT-505-AC-120M).
20. Reinstall the left transmission fairing (DMC-505-A-53-40-01-00A-720A-A) and right transmission fairing (DMC-505-A-53-40-02-00A-720A-A).

-NOTE-

Wicking stains may be observed on the passenger cabin area ceiling panels for an undetermined period after accomplishment of this Technical Bulletin. As applicable, wipe clean the ceiling panels using the solvent mixture in accordance with this Technical Bulletin until wicking stops. The ceiling wipe clean method can be accomplished at any given time and/or during an inspection.

21. Make an entry in the helicopter logbook and historical service records indicating compliance with **PART II** of this Technical Bulletin.



Typical signs of fluid leakage on upper roof panels.

Detail A

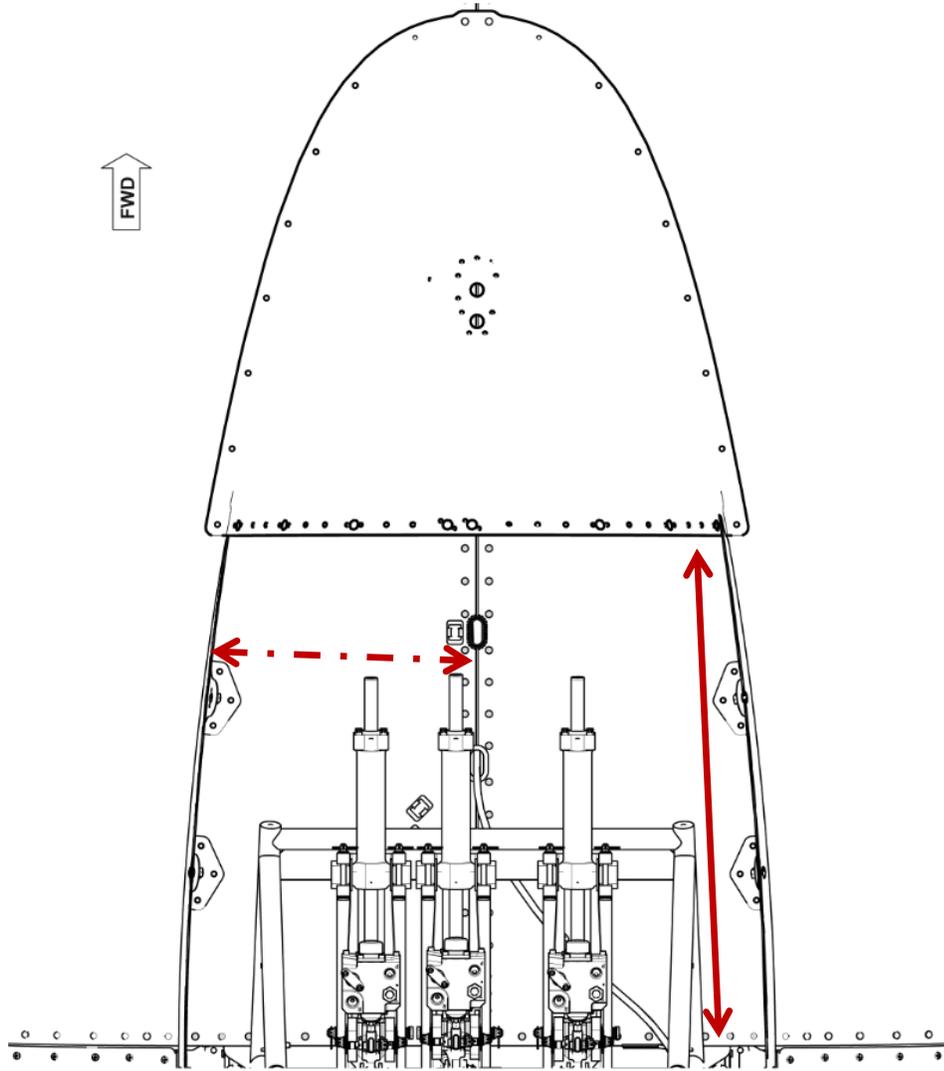
Figure 1 - Typical signs of fluid leakage (Sheet 1 of 2)



Typical sign of leakage ceiling panel (right side shown).

Detail B

Figure 1 - Typical signs of fluid leakage (Sheet 2 of 2)

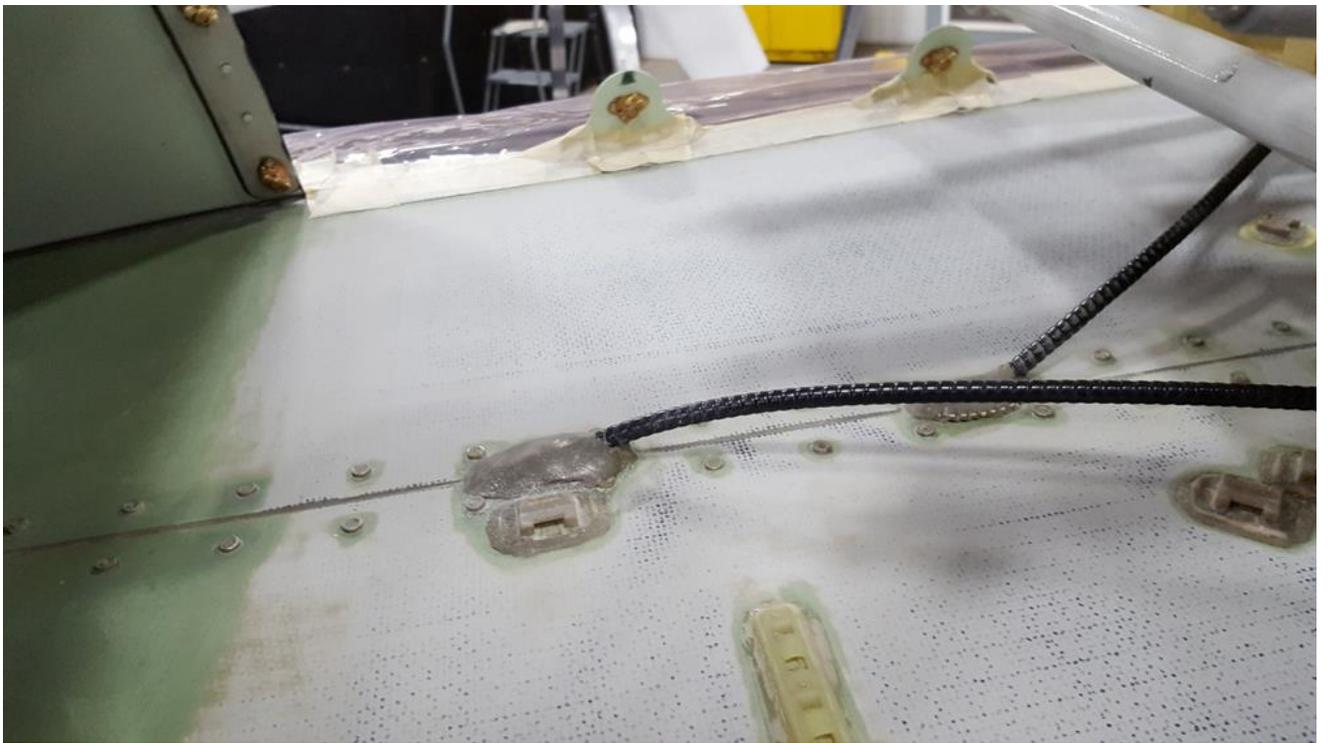


The repair area for the left and right side extends from the aft rivet line up to the forward cowling (COM/GPS antenna), and from the rivet center line up to the painted line for both sides.

Figure 2 – Roof Panel Repair Area



Figure 3 - Typical wicking stains (wet spots)



After wet abrasion.

Figure 4 - Upper roof panels (Sheet 1 of 2)



Signs of wicking appearing after wiping with the solvent mixture.

Figure 4 - Upper roof panels (Sheet 2 of 2)



Figure 5- Upper roof panels after finishing glaze compound (C-266) application.



Figure 6 – Finishing glaze compound (C-266) after sanding high spots results and when pin hole filler was used during manufacturing example.



View A

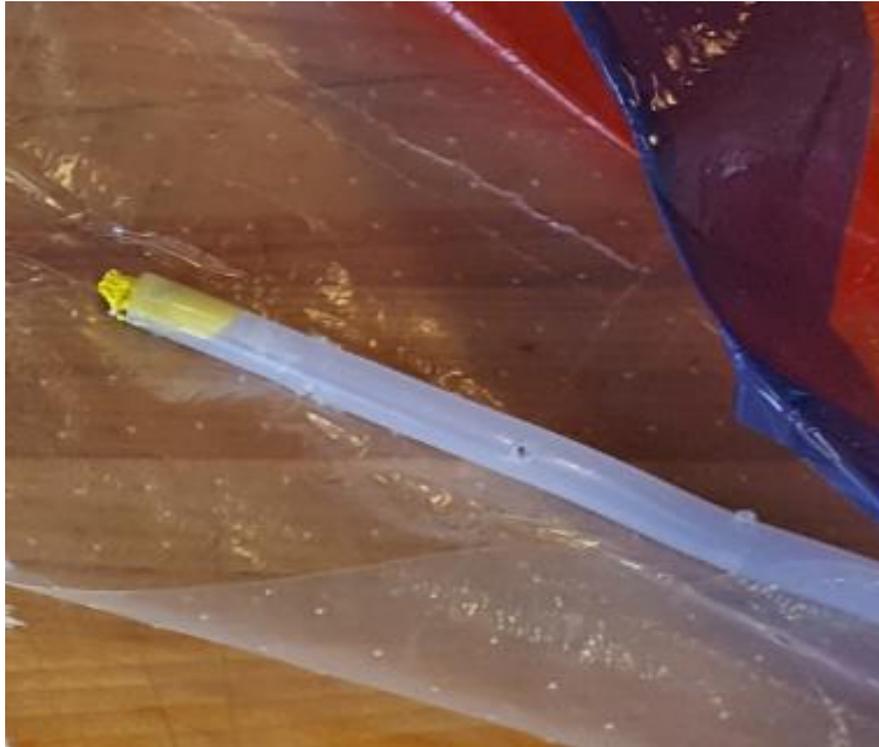
Sealant tape (C-259) and shop rag material on upper roof repair area perimeter.



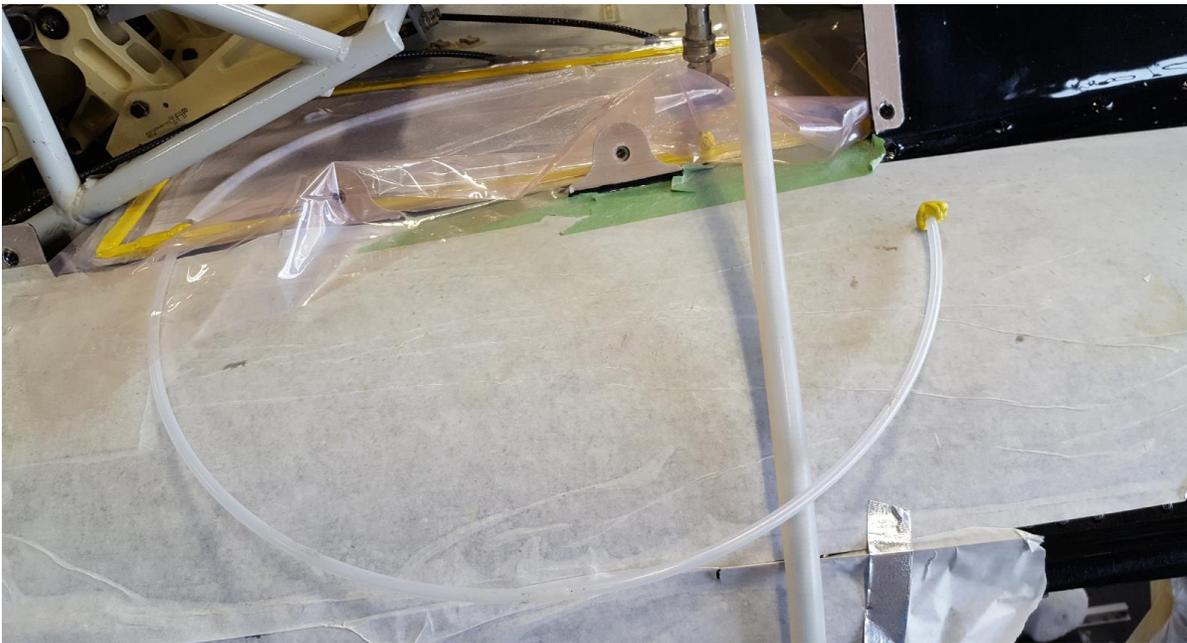
View B

Sealant tape (C-259) place on top of tape (C-401) and plastic tube inserted on top of breather material.

Figure 7 – Upper roof panel R/H side shown (Sheet 1 of 2).

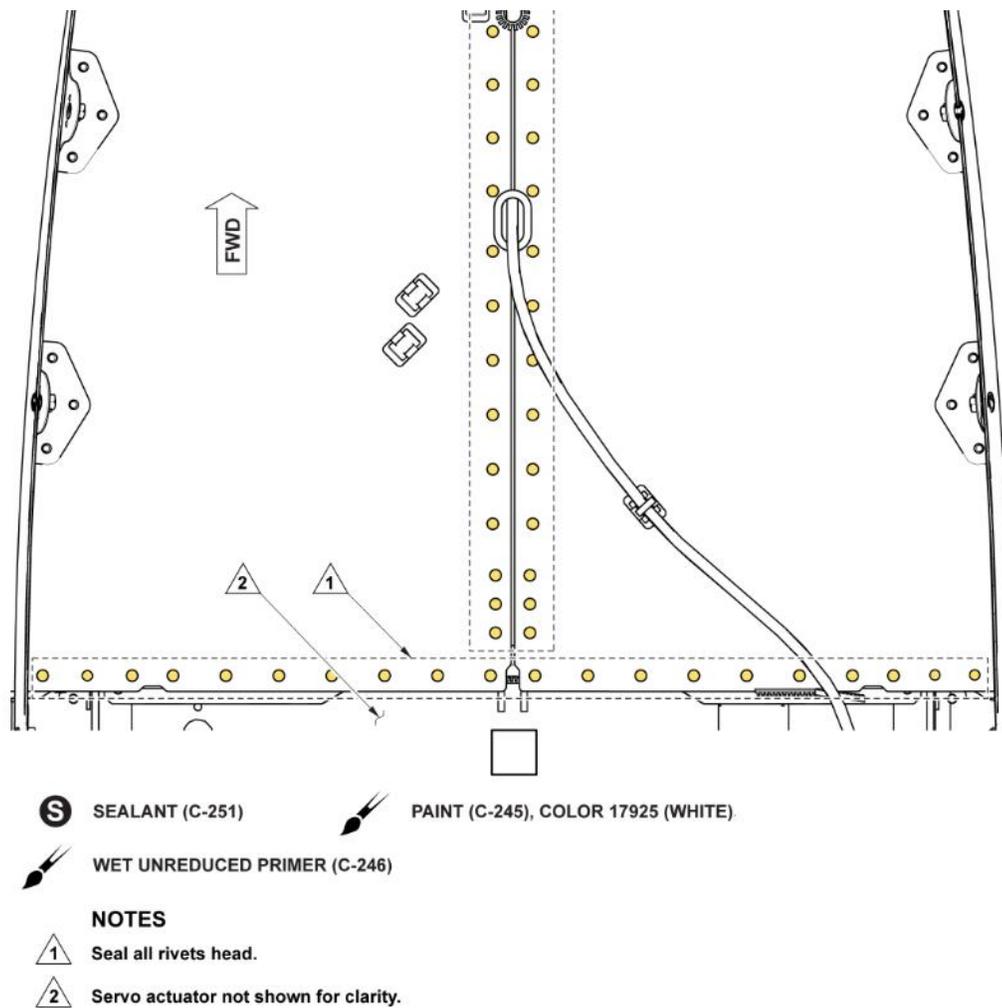


View C
Holes drilled into the plastic tube material.



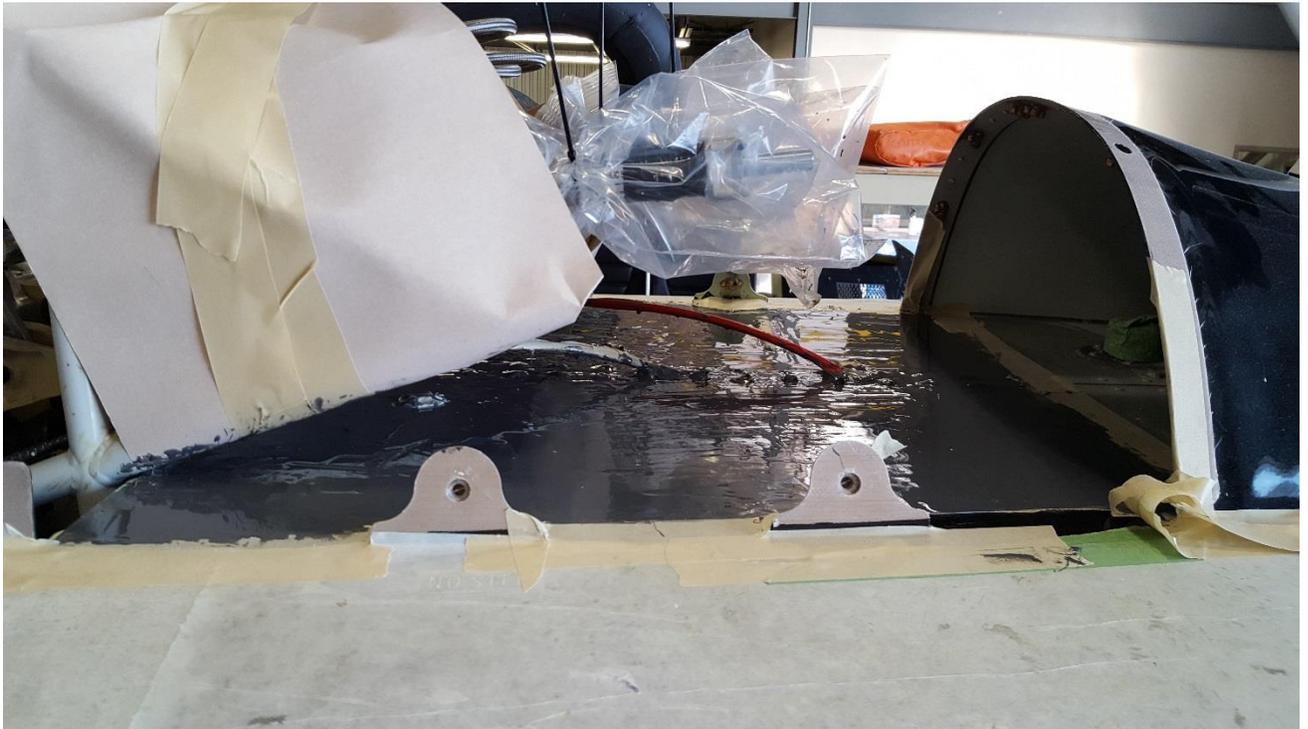
View D
Upper roof Vacuum bag and repair area perimeter.

Figure 7 – Upper roof panel R/H side shown (Sheet 2 of 2).



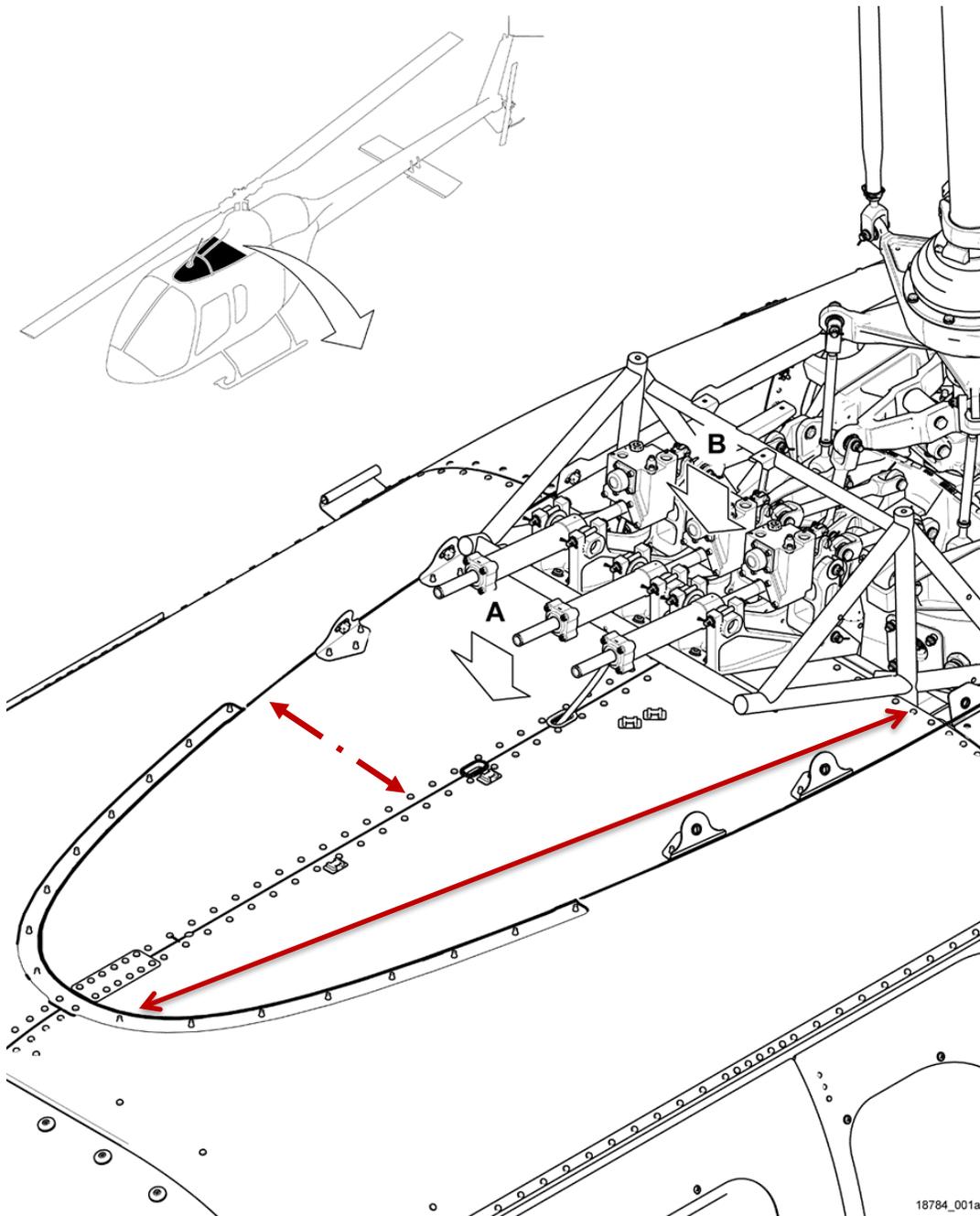
Rivet Head Sealant (C-251)

Figure 8– Sealant application (Sheet 1 of 2).



Sealant (C-322) applied on repaired surfaces.

Figure 8– Sealant application (Sheet 2 of 2).



1. Primer (C-246) can be applied on upper roof panel surfaces extending under the forward cowling (Antenna cowling not shown for clarity).
2. Top coat (C-245) to be applied between the aft rivets line up to the forward edge of forward cowling (Antenna cowling not shown for clarity).

Figure 9 - Primer (C-246) and Paint (C-245) Application for Upper Roof Surfaces



Plastic spatula (soft) cut to size used to spread sealant under the servo actuators.



Acid brush used to apply sealant on rivet heads. Bristles can be cut shorter as required.

Figure 10 - Workaid examples.