



## **SERVICE BULLETIN**

**TO** : All S-76 A+ / A++ / C / C+ / C++ Operators  
**FROM** : FDC/aerofilter Engineering  
**SB NUMBER** : SB.FDC.S76.0015  
**CATEGORY** : Optional Service Bulletin  
**EFFECTIVITY** : All S-76 C++ Helicopters  
All S-76 Helicopters modified IAW STC SR01616SE  
**DATE** : Thursday, January 29, 2009

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### **S-76 MAIN FILTER ELEMENT SEAL REPLACEMENT**

#### **1.0 BACKGROUND**

On occasion, it becomes necessary to repair or replace the rear seal (P/N 1076P14-3) on the S-76 Main filter element (P/N 1076A2-1) through wear or inadvertent damage. This Service Bulletin details the field removal and replacement procedure for this seal.

#### **2.0 COMPLIANCE**

As required

#### **3.0 COMPLIANCE TIME**

As required

#### **4.0 SPARE KIT AVAILABILITY**

N/A

#### **5.0 INSTALLATION TIME**

Estimated 0.5 man-hours

#### **6.0 WEIGHT & BALANCE**

Not Effected

#### **7.0 FLIGHT MANUAL REVISION**

Not Applicable

#### **8.0 DOCUMENTS**

Not Effected

## 9.0 REPAIR INSTRUCTIONS

**NOTE:** Ensure that you comply with standard practices as per AC43.

- a) Remove main filter element from aircraft per 1076-SERIES-ICA-1, §4.2.
- b) Place main filter element rear-side up on a padded workbench.
- c) Remove existing rear seal, carefully peeling it away from the filter element. If necessary, a Xylene-based solvent or citrus-based adhesive removal compound may be used to loosen the adhesive.
- d) Clean off any remaining adhesive with a suitable solvent as in step (c) leaving a flat, clean surface for new seal application.
- e) Perform a dry fit of the new main filter element seal to ensure proper fit. Prepare 3M 1300L adhesive per manufacturer's directions for steps (f) – (h).
- f) Apply one even coat of 3M 1300L adhesive onto the backside of the Main filter element and one even coat to the bonding side of the new seal. Let air dry for at least 1 hour.
- g) Apply a second even brush coat of 1300L to the backside of the main filter element and to the bonding side of the new seal. Allow to dry until tacky – usually 5 minutes (depending on temperature and relative humidity).
- h) Fit the new seal to the main filter element, taking care to align the cutouts and hole pattern of the new seal with the features of the main filter element. Remove any trapped air and ensure the seal lays flat against the backside of the main filter element.
- i) Remove any excess adhesive with a suitable solvent as in step (c).
- j) Allow minimum adhesive cure time of 12 hours before returning the main filter element to service.

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