



REVOLUTION

HELICOPTER CORP., INC.



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December 6, 1995

Revolution Helicopter Airworthiness Directive (AD) #111395A

Effectuated Aircraft: All Mini-500 Helicopters.

AD Type: Urgent (Must be complied with before further operation of the aircraft).

Subject: This is a follow up on AD #111395. As stated in that AD, one of our overseas distributors lost the tip from one of his tail rotor blades during a ground run. We have examined the blade, (the tip was not found), and determined that the tip was contaminated when it was bonded in the tail rotor. When the tips are made they have release agent on them when they come out of the mold. On this tip, the release agent was not cleaned off before it was bonded into the tail rotor. To prove this, we have constructed a whirl stand. We intentionally bonded in a tip that had release agent on it. We then put the blade on the whirl stand and spun it up. The rivet sheered and the tip threw out before we even got up to full RPM. We then put two off-the-shelf blades on the stand. We ran these blades up to an RPM that gave us a centrifugal loading that was 50 percent over the loading that the blades could see at the RPM red line of the aircraft. The blades were then examined and found to be in perfect condition.

Corrective Action:

We believe that there are no more contaminated tips in the field. However, in the interest of safety, we want to be 100 percent positive. For this reason, we want everyone to send your tail rotor blades to us, and we will put them on the whirl stand and run them up to a 50 percent overload condition. Our tests have proven that if the blade tip stays in place at this loading, then it is a good blade. We will test the blades as soon as we receive them and get them back out to you as soon as possible to keep your down time to a minimum. **You must pay for shipping to and from Revolution Helicopter, and you must let us know how would you like to pay for shipping the blades back to you.** If you want us to ship your blades overnight, please let us know. Upon receipt of your blades, we will test them, and repair or replace defective blades at no charge. **Please, package the blades carefully to prevent shipping damage, and insure them for \$1,000. Revolution Helicopter is not responsible for any damages during shipping.**

We are modifying our manufacturing procedures to insure that this will not happen in the future. As a reminder, Revolution Helicopter will be shut down from December 25 to January 1 in observance of the holidays. If you want us to ship your blades before we close for the holidays, we must receive them by December 18, 1995. In any case, all blades should be sent to us by January 15, 1996. Please date, sign, and fax or mail a copy of this AD to Revolution Helicopter immediately upon receipt, or include it when you send the blades back.

If you have any questions, contact: Revolution Helicopter Corp. Inc.
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Print Name: _____

Date: _____

Signature: _____