



	Service Letter SL 51-1 R4	DO - No. EASA.21J.020
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Installation of Protective Erosion Tape on De-Ice Boots

Affected Aircraft: Pilatus PC12 / KingAir 90/200/300/350 series / Beech 1900 series
SA-227-AT/-AC/-BC/-TT/-CC/-DC/ SA-226-TB / Metro 3 / Merlin 4

Affected Propeller: MTV-27-1-E-C-F-R(P)/CFR210-58d
MTV-27-1-E-C-F-R(P)/CFR225-55f
MTV-27-1-E-C-F-R(G)/CFR250-103
MTV-27-1-E-C-F-R(P)/CFR260-65b
MTV-27-1-(E)/(N)-C-F-R(P)/CFR260-65k
MTV-27-1-N-C-F-R(P)/CFR260-65a
MTV-47-1-N-C-F-R(P)-(-)/CFR260-361

Required Material:

1. Erosion Tape
2. 3M Adhesive Promoter

Part No:

- C-110-() or 3M8663
Promoter 86, Optional

Expandable Material:

Clean Lint-Free Cloths
Cleaning Solvents, MEK, Toluene or Isopropyl Alcohol

NOTE:

APPLICATION OF EROSION TAPE MUST BE PERFORMED AT OR ABOVE 16°C (60°F).

HANDS MUST BE KEPT CLEAN AT ALL TIMES!

1. In case the optional promoter is applied, use a tape to mask the area where the erosion tape is installed to apply the promoter.
2. Cut pieces of 340 mm (13,4 inch) lengths of protective erosion tape. (KingAir 90/200 series)
Cut pieces of 440 mm (17,3 inch) lengths of protective erosion tape. (SA-227-AT/-AC/-BC/-TT/-CC/-DC/, SA-226-TB / Metro 3 / Merlin 4 / Pilatus PC12 / Beech 1900 / KingAir 300/350)
Radius the corners to (12.7 mm ½ inch) to prevent any sharp corners from remaining.
3. Measure and mark a centerline lengthwise on the non-adhesive side of the erosion tape sections using a ball point pen. This will assist in positioning the tape during installation.
4. Clean the de-ice boot surfaces thoroughly with a clean cloth saturated with solvent (MEK, Toluene or Isopropyl Alcohol). Clean the application area, immediately wiping dry with a lint-free cloth. Allow to dry. Repeat cleaning and drying of the application area. **It is mandatory that the de-ice boot is completely clean!** Do not allow solvent to come in contact with the de-ice boot edge seal!

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5. Apply optional Promoter 86 adhesive to the propeller blade:

NOTE: PROMOTER 86 WILL INCREASE THE ADHESIVE STRENGTH BETWEEN THE EROSION TAPE AND THE DE-ICE BOOT.

- a) Apply a thin of Promoter 86 to the bonding surface. Use only a minimum amount that will fully coat the contact surface. Remove plastic tape used to mask off the perimeter area.
- b) Allow the promoter to air dry for no less than 15 minutes, and no more than 60 minutes at room temperature.
- c) Apply the tape C-110-() or 3M Tape 8663 on the de-ice boot.

NOTE: THE PROMOTER WILL BEGIN TO LOSE EFFECTIVE ADHESION AFTER 60 MINUTES AT ROOM TEMPERATURE.