



EASTERN AERO MARINE

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SERVICE BULLETIN

EQUIPMENT/FURNISHINGS MODEL EAM-T46 LIFE RAFTS CONVERSION FROM VALVE P/N R0524-101 OR R0524-103 TO VALVE P/N R1129-101 OPTIONAL

I. PLANNING INFORMATION

- A. **Effectivity** - Eastern Aero Marine 46 person life rafts Model EAM-T46, P/N R0202- () and R0202A() equipped with cylinder and valve assembly R0032-12 (using valve P/N R0524-101) or R0032-13 (using valve P/N R0524-103).
- B. **Concurrent Requirements** - None
- C. **Reason** - The EAM P/N R1129-101 valve (used on EAM Cylinder and Valve Assembly R0032-2053) is now being used on new production rafts as an alternate to the EAM P/N R0524-101 (used on EAM Cylinder and Valve Assembly P/N R0032-12) and the EAM P/N R0524-103 (used on EAM Cylinder and Valve Assembly P/N R0032-13). Some EAM customers have requested procedures by which the current P/N R0524-101 or R0524-103 valve installed in their rafts can be replaced by the P/N R1129-101 valve. This Service Bulletin provides the procedures for this conversion.
- The P/N R1129-101 valve can be used to replace the R0524-101 or R0524-103 valve. However, this will require converting the cylinder and valve assembly from P/N R0032-12 or R0032-13 to P/N R0032-2053.
- D. **Description** - This Service Bulletin gives procedures to convert EAM life raft cylinder and valve assemblies P/N R0032-12 and R0032-13 (with P/N R0524-101 and R0524-103 valves installed) to cylinder and valve assembly P/N R0032-2053 (with P/N R1129-101 valve installed).
- E. **Compliance** - Optional.
- F. **Approval** - The P/N R0524-101, R0524-103, and R1129-101 valves are approved by the FAA for use on EAM's FAA TSO-C12c/C70a model T46 life rafts. This Service Bulletin contains no modification information that revises the approved configuration of EAM-T46 life rafts and therefore does not require governmental or other regulatory agency approval.
- G. **Manpower** - EAM estimates that one (1) man can accomplish this procedure in 2.0 hours. This time is in addition to that normally required for the raft to be removed from the aircraft, unpacked, inspected, repacked, and reinstalled.
- H. **Weights and Balance** - Negligible change in weight.



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- I. **Electrical Load Data** - Not applicable.
- J. **Software Accomplishment Summary** - Not applicable.
- K. **References**

25-60-11 Component Maintenance Manual, EAM-T46
(Revision 6, dated Sept 30/97 and subsequent)

- L. **Other Publications Affected** - None.
- M. **Interchangeability or Intermixability of Parts** -

Per Component Maintenance Manual 25-60-11, the P/N R0032-12 or R0032-13 assembly is interchangeable with and can be replaced by P/N R0032-2053 assembly.

Cable P/N R0336-101 and filler valve protector P/N R0513 can be salvaged from the P/N R0032-12 or R0032-13 cylinder and valve assembly and used in the conversion to the P/N R0032-2053 cylinder and valve assembly.

II. **MATERIAL INFORMATION**

- A. **Material - Price and Availability**

See *Material Necessary for Each Cylinder and Valve Assembly* below for parts list.
- B. **Industry Support Information** - None



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C. Material Necessary for Each Cylinder and Valve Assembly

(1) Material to be Purchased

The basis for the following material data is per cylinder and valve assembly {P/N R0032-()}. Each EAM-T46 life raft is equipped with two (2) cylinder and valve assemblies.

New P/N	Keyword	Old P/N	Qty.	Special Instructions/Disposition
R1129-101	Valve	R0524-101 or R0524-103	1	Remove and discard old P/N. Replace with new P/N.
R1133-1	Gauge Protector	R0388-2	1	Remove and discard old P/N. Replace with new P/N.
R1131-101	Regulator Bonnet	R0676-101 or R0676-103	1	Remove and discard old P/N. Replace with new P/N.
514-03	O-ring	514-03	1	Remove and discard old part. Replace with new part.
R0336-101	Cable	R0336-101	1	Part can be salvaged from old assembly or install new part.
R0513	Filler Valve Protector	R0513	1	Part can be salvaged from old assembly or install new part.

Contact EAM Sales Department for pricing and delivery information.

(2) Material Supplied by Operator - None.

D. Material Necessary for Each Spare - Same as above.

E. Reidentified Parts -

New Part Number	Qty.	Designation	Old Part Number
R0032-2053	1	Cylinder and Valve Assembly	R0032-12 or R0032-13



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F. **Tooling - Price and Availability** - None.

III. **ACCOMPLISHMENT INSTRUCTIONS**

NOTE: For Steps A through C below, refer to **Disassembly of Cylinder and Valve Assembly P/N R0032-12 and R0032-13** in **DISASSEMBLY** section of CMM 25-60-11. Also refer to CMM 25-60-11, IPL FIGs 2 and 3.

A. For Cylinder and Valve Assembly R0032-12, remove valve P/N R0524-101 from cylinder P/N 533-165. Retain valve and cylinder.

For Cylinder and Valve Assembly R0032-13, remove valve P/N R0524-103 from cylinder P/N 533-165. Retain valve and cylinder.

B. Remove and discard o-ring P/N 514-03 from valve.

C. Remove cable P/N R0336-101 and filler valve protector P/N R0513 from valve. They will be used later. Then discard old valve. Alternately, obtain new cable and filler valve protector.

NOTE: For Steps D through F below, refer to **Assembling Air-Aspirated Inflation System P/N R0032-2053 - Assembling Valve to Cylinder** in **ASSEMBLY** section of CMM 25-60-11. Also refer to CMM 25-60-11, IPL FIG 10.

D. Install new o-ring 514-03 on to new valve P/N R1129-101.

E. Install valve on to cylinder P/N 533-165.

F. Install new or salvaged filler valve protector P/N R0513 and cable P/N R0336-101 into valve.

G. Change the part number markings on the cylinder and valve assembly from the current part number R0032-12 or R0032-13 to the new part number R0032-2053.

H. Charge converted cylinder and valve assembly per CMM 25-60-11.

I. Install new bonnet P/N R1131-101 and gauge protector P/N R1133-1 on to valve and install cylinder and valve assembly on to raft per CMM 25-60-11.

IV. **APPENDIX**

None.