



A Textron Company

OPERATION SAFETY NOTICE

206-18-41  
206L-18-53  
230-18-09  
407-18-22  
430-18-07  
27 February 2018

**TO: All owners and operators of Model 206A/B and TH-67, 206L, 206L-1, 206L-3 and 206L-4, 206L4-T, 230, 407, and 430 Helicopters.**

**SUBJECT: ENHANCED AWARENESS OF LOOSE OR BROKEN ENGINE COMPRESSOR SPLIT LINE BOLTS/STUDS**

The purpose of this bulletin is to achieve complete distribution of the attached supplier bulletin to the current affected model Technical Publications distribution list on record by Bell Helicopter Textron.

For any questions regarding this letter, please contact:

Rolls-Royce M250 Customer Support Group at:  
Domestic 1-888-255-4766  
International 1-317-230-2720  
Fax 1-317-230-1422  
Email [helicoptercustsupp@rolls-royce.com](mailto:helicoptercustsupp@rolls-royce.com)

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Approved for public release.



## ENHANCED AWARENESS OF LOOSE OR BROKEN SPLIT LINE BOLTS/STUDS

### 1. General

This Commercial Service Letter (CSL) has been released by Rolls-Royce to address some recent events where operators have discovered loose or broken split line studs on the compressor diffuser. Rolls-Royce would like to heighten the operator's awareness of detecting these issues.

Each M250<sup>®</sup> Operations and Maintenance Manual (OMM) has pre-flight, post-flight, and scheduled inspections. Item #1 of these inspections discusses the general visual review of the entire engine looking for loose bolts, broken or loose connections, and the security of components. [Figures 1](#) and [2](#) show examples of broken studs on a compressor diffuser.

**WARNING:** It is the owner/operator's sole responsibility to comply with these inspections or risk a potential for loss of aircraft or loss of life. Rolls-Royce is not responsible for an owner/operator's failure to comply.

If you have any questions, please contact the Rolls-Royce M250 Customer Support Group at:

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International	1-317-230-2720
Fax	1-317-230-1422
Email	helicoptercustsupp@rolls-royce.com

CUSTOMER SUPPORT  
ROLLS-ROYCE

February 9, 2018

M250-C18 Series	CSL-A-261	M250-C40B	CSL-A-5149
M250-C20 Series	CSL-A-1277	M250-C47 Series	CSL-A-6158
M250-C28 Series	CSL-A-2212	M250-B15G	TP CSL-A-189
M250-C30 Series	CSL-A-3248	M250-B17 Series	TP CSL-A-1228
M250-C20R Series	CSL-A-4153	M250-B17F Series	TP CSL-A-2143



Example of Broken Compressor Diffuser Studs  
Figure 1



Example of Broken Compressor Diffuser Stud  
Figure 2

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