

## **Welding of combustion tube in Janitrol B Series Aircraft Heaters (Supercedes Janitrol Aero SB 73)**

### **INTRODUCTION:**

After many years of service in the field, the common practice of welding pin holes, cracks and other damage in Janitrol B Series aircraft heaters was determined to put safe operation of the heater at risk. As a response to several FAA AD's and service difficulties regarding the combustion air tube, Janitrol Aero Division of Midland Ross issued Service Bulletin 73 on October 10, 1983. This Service Bulletin prohibited welding of any combustion air tube installed in B Series Aircraft Heaters Models B-1500, B-2030, B-3040, and B-4050. Since the time this Service Bulletin was issued we have added Models B-2500, B-3500, and B-4500. In addition, new B Series Aircraft Heaters may incorporate and extended life tube (EL) which is coated with special material which is destroyed if a weld is applied after the initial treatment. The contents of this service bulletin shall supercede instructions of any and all revised or unrevised manuals or documents issued for the Janitrol B Series line of aircraft heaters.

This Service Bulletin is being issued to assure that any maintenance or overhaul being conducted on Kelly Aerospace Power Systems, Janitrol B Series heaters will not include welding of the combustion air tube.

### **COMPLIANCE:**

Prior to any service, overhaul, or maintenance activity on Janitrol B Series aircraft heaters, all welding practices on the combustion air tube shall be prohibited.

### **EFFECTIVITY:**

All Kelly Aerospace Power Systems, Janitrol B Series, Models B-1500, B-2030, B-2500, B-3040, B-3500, B-4050, and B-4500 as installed in any aircraft or rotorcraft.

### **PROCEDURE:**

#### **Note:**

The Janitrol B Series combustion heater has been in service for many years and there have been many different maintenance manuals, overhaul manuals and maintenance instructions issued for individual or groups of heater models. Many of these may exist in their original issued condition and indicate that welding is acceptable based on the ability of and skill of the repairman or facility. The purpose of this Service Bulletin is to restrict welding activity on the combustion air tube regardless of any contrary information.

## **PROCEDURE: (cont'd)**

### **WARNING:**

Welding of the combustion air tube in any B Series aircraft heater may result in failure of the heater. If a failure occurs, smoke, noxious gas, and the potential for an uncontained fire may ensue. This condition may result in serious injury to crew and passengers.

Immediately upon receipt of this service bulletin, all welding practices on B Series combustion air tubes shall be prohibited. The following practice shall be followed:

1. There shall be no welding of any combustion air tube assembly for B Series Aircraft heaters. Any combustion air tube assembly which fails to pass the pressure decay test as prescribed by the maintenance and overhaul manual P/N 24E25-I (for standard tube) as reissued January 29, 2007 or P/N 94E47 (for extended life tube) issued January 29, 2007, shall be replaced.

*Refer to FAA A.D. Note 2004-21-05 (or latest) for details on inspection, pressure decay requirements and combustion tube replacement. Compliance with the AD note is mandatory.*

2. When a specific heater manual (as previously issued) for one of the subject model heaters does not agree with manual P/N 24E25-I or P/N 94E47 on maintenance methods or recommendations, manual P/N 24E25-I or P/N 94E47 as applicable, shall be followed.

### **MATERIAL REQUIRED:**

If not already obtained: (as applicable to your model aircraft heater assembly)  
one (1) each, P/N 24E25-I (standard tube) maintenance and overhaul manual.  
one (1) each, P/N 94E47 (Extended Life tube) maintenance and overhaul manual.

### **PARTS AVAILABILITY:**

The maintenance and overhaul manual(s) may be purchased directly from Kelly Aerospace Power Systems. Contact Customer Service via fax (334) 386-5450. *You may also obtain a copy of our current publication order form by visiting our website, [www.kellyaerospace.com](http://www.kellyaerospace.com).*