



SCHWEIZER SERVICE BULLETIN

B-247
30 Oct 1992

MANDATORY

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SUBJECT: TAIL ROTOR PEDAL BULKHEAD (FLOOR BEAM) GUSSET

APPROVAL STATUS: MODIFICATION IS FAA APPROVED.

MODELS AFFECTED: All Model 269A, TH55A, 269A-1, 269B and 269C Helicopters

TIME OF COMPLIANCE: ● Next 50 hour inspection

REFERENCE: ● 269 Series Basic HMI (Reissued: 15 March 1982; Revised 8 May 1992)

PREFACE: ● A field report indicates that tail rotor pedal gussets were not installed in a Model 269A aircraft. In other aircraft, gussets were found with cracks, elongated rivet holes, and loose or missing rivets.

- **PART I** provides a visual inspection for missing or cracked gussets, elongated rivet holes and loose or missing rivets.
- **PART II** provides instructions for initial installation of missing tail rotor pedal bulkhead gussets.
- **PART III** provides instructions for replacement of damaged tail rotor pedal bulkhead gussets and/or replacement of loose or missing rivets.
- Failure to comply with this Service Bulletin may lead to loss of control of the helicopter and subsequent serious injury, death and/or property damage.

PROCEDURE:

PART I- VISUAL INSPECTION

- a. Remove forward fairing assembly.
- b. Locate fuselage Sta 54.0 beam (tail rotor pedal bulkhead) (Figure B-247-1).
- c. Inspect for missing or cracked gussets, elongated rivet holes, and loose or missing rivets. If repair is required, refer to Part II and/or Part III, as applicable.
- d. If no discrepancies are found reinstall forward fairing assembly and record compliance with this Service Bulletin in the aircraft records.

PARTS

(As needed to replace missing or damaged parts)

| <u>Nomenclature</u> | <u>Part Number</u> | <u>Quantity</u> | <u>Source</u> |
|---------------------|--------------------|-----------------|---------------|
| Gusset | 269A2306-1* | AR | SAC |
| Gusset | 269A2306-3* | AR | SAC |
| Gusset | 269A2306-5** | AR | SAC |
| Gusset | 269A2306-7** | AR | SAC |
| Rivet | MS20470AD4 | AR | Commercial |

* Required part number when gusset was not installed.

** Required part number when gusset is being replaced.

PART II- INITIAL INSTALLATION OF MISSING 269A2306-1 AND -3 TAIL ROTOR PEDAL BULKHEAD GUSSETS

NOTE

Refer to Figure B-247-1 for location and installation of gussets and location of rivets.

- a. Clamp new gusset to beam assembly.

CAUTION

Maintain edge distance when drilling rivet holes.

- b. Drill #30 hole through gusset and beam and install clecos. Remove clamp(s) and drill remaining holes.
- c. Deburr rivet holes. Remove all metal particles and loose paint.
- d. Clean area with Methyl-Ethyl-Ketone (MEK).
- e. Apply zinc chromate primer to gusset and beam assembly.
- f. Install MS20470AD4 rivets using wet zinc chromate primer.
- g. Paint in accordance with Basic HMI Section 2.
- h. Reinstall forward fairing assembly.
- i. Record compliance with Part II of this Service Bulletin in the aircraft records.

**PART III- REPLACEMENT OF DAMAGED 269A2306-5 AND -7 TAIL ROTOR PEDAL BULKHEAD
GUSSETS AND RIVETS**

NOTE

For replacement of loose or missing rivets, perform only applicable steps of the following procedure. In addition, all loose and/or missing AD42H aluminum rivets shall be replaced with MS20470AD4 aluminum rivets.

- a. Carefully remove rivets from gusset (Figure B-247-1).
- b. Cleco new gusset through existing hole to beam assembly.
- c. Clamp gusset to beam assembly.

CAUTION

Maintain edge distance when drilling rivet holes.

- d. Using a #30 hole finder, locate and drill remaining holes in gusset. Remove clamp(s) and cleco.
- e. Deburr rivet holes and remove all metal particles and loose paint.
- f. Clean area with Methyl-Ethyl-Ketone (MEK).
- g. Apply zinc chromate primer to gusset and beam assembly.
- h. Using wet zinc chromate primer, install MS20470AD4 rivets.
- i. Paint in accordance with Basic HMI Section 2.
- j. Reinstall fairing assembly.
- k. Record compliance with Part III of this Service Bulletin in the aircraft records.

WEIGHT AND BALANCE

Weight and balance are not affected.

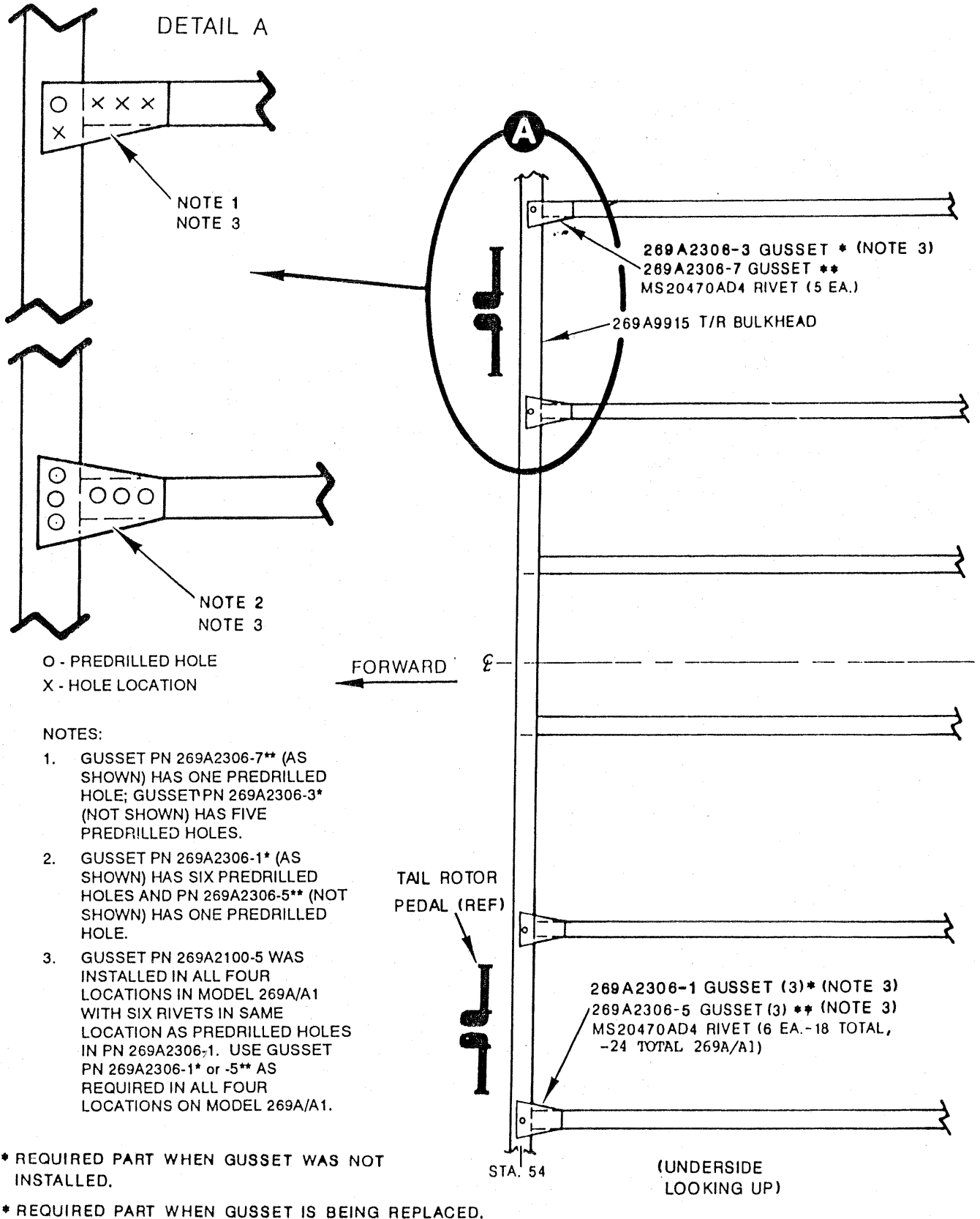


Figure B-247-1. Floor Construction