



SCHWEIZER SERVICE BULLETIN

B-253
03 Sep 1993

MANDATORY

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SUBJECT: TAILBOOM SUPPORT STRUTS CORROSION INSPECTION

APPROVAL STATUS: MODIFICATION FAA APPROVED

MODELS AFFECTED: ● PART I:

- ✘ All 269A, TH-55A, 269A-1, and 269B Helicopters, and 269C Helicopters Serial Number 0004 through 1165
- ✘ 269C Helicopters subsequent to Serial Number 1165 that have tailboom support struts replaced in the field

● PART II:

- ✘ All 269A, TH-55A, 269A-1, 269B, and 269C Helicopters operated in a corrosive and/or agricultural environment

TIME OF COMPLIANCE: ● PART I shall be accomplished on affected helicopters within next 100-Hours time in service or 6 months from issue date of this Service Bulletin, whichever occurs first.

● PART II shall be accomplished on affected helicopters within next 100-Hours time in service or 6 months from issue date of this Service Bulletin, whichever occurs first, and at 12-month intervals (Annual Inspection) thereafter.

REFERENCES: ● 269 Series Basic HMI (Reissued: 15 March 1982; Revised 08 May 1992)

- 269 Series HMI, Appendix B (Reissued: 20 May 1993)
- Service Information Notice N-109.2 (01 Sep 1976)

PREFACE: ● Field reports indicate that some tailboom support strut assemblies have developed internal corrosion.

- PART I provides a one-time inspection to check for proper sealing of strut tube components, and corrective action if not sealed properly.
- PART II provides periodic inspection data for helicopters operated in a corrosive and/or agricultural environment.
- Requirements of Service Information Notice N-109.2, if applicable, must be complied with prior to complying with this Service Bulletin.
- Failure to comply with this Service Bulletin may lead to a loss of control of the helicopter and subsequent serious injury, death and/or property damage.

PROCEDURE:

PART I: ONE-TIME INSPECTION FOR SEALING COMPOUND

- a. Without removing paint, check for sealing compound application at joints between strut tubes, end fittings, and end fitting attachment hardware (Figure B-253-1). Perform step (1) or (2) below, as applicable.
 - (1) If sealing compound IS found, no corrective action is required. (Record PART I compliance, step g.)
 - (2) If sealing compound IS NOT found, perform corrective action in accordance with the following.

NOTE

Parts replacement is required only when parts are corroded or otherwise damaged.

PARTS (If Required)

<u>Nomenclature</u>	<u>Part Number</u>	<u>Quantity</u>	<u>Source</u>
Bolt	NAS1304-19	A/R	Commercial
End fitting, lower	269A2017-5	A/R	SAC
End fitting, upper	269A2017-3	A/R	SAC
Nut	MS21042-4	A/R	Commercial
Support strut assembly	269A2015-9*	A/R	SAC
Support strut assembly	269A2015-11**	A/R	SAC
Washer (steel)	AN960C416	A/R	Commercial
Washer	AN960KD416	A/R	Commercial

* Replacement tailboom support strut for 269A, TH-55A, 269A-1 and 269B helicopters

** Replacement tailboom support strut for 269C helicopters

MATERIAL (As Required)

<u>Nomenclature</u>	<u>Source</u>
Paint - epoxy enamel - color match (optional)	Commercial
Paint stripper - acid fortified - A202	Cee Bee Chemical Co, or equivalent
Primer - zinc chromate	Commercial
Sealing Compound - Proseal #890 or PR1221	Product Research, Burbank, CA
Solvent - methylethylketone (MEK) or equivalent	Commercial

CAUTION

When removal of either or both support strut assemblies is required, the tailboom must be supported prior to strut removal.

- b. Remove affected support strut assembly from aircraft. Mark index position of end fittings to ensure correct reinstallation, and remove both end fittings from strut tube.
- c. Clean strut tube and inspect for internal corrosion and cracks. Also inspect hardware for corrosion and damage.
 - (1) If internal corrosion or cracks are found, the strut tube is not serviceable and must be replaced.
 - (2) Replace any corroded or damaged hardware.

NOTE

Service Notice N-109.2 applies to certain 269 Series Helicopters. If applicable, the requirements of N-109.2 must be complied with prior to performing the following procedure.

- d. Install end fittings in strut tube as follows:
 - (1) Apply a .090 inch diameter bead of sealing compound (Proseal #890 or PR1221) to inside surface of strut tube, 1.25 inches from each end (Figure B-253-1).
 - (2) Apply wet zinc chromate primer to end fittings, align index marks and insert end fittings into respective ends of strut tube while sealing compound is still tacky.
- e. Install support strut hardware as follows (Figure B-253-1):
 - (1) Assemble AN960KD416 washer on NAS1304-19 bolt, apply sealing compound to both sides of washer and wet zinc chromate primer to bolt shaft. Insert bolt through strut tube and end fitting.
 - (2) Apply sealing compound to both sides of second AN960KD416 washer and install washer on bolt. Install AN960C416 steel washer and MS21042-4 nut on bolt - verify that steel washer is installed adjacent to nut.
 - (3) Torque nuts 110 to 130 in.-lbs., back-off and retorque 90 to 110 in.-lbs. (contour forming of washers that results from compression is allowable).
 - (4) Apply sealing compound to joints between strut tubes, end fittings, and end fitting attachment hardware.
 - (5) Paint touchup support strut assembly as required (Basic HMI, Section 2).
- f. Reinstall support strut assembly on helicopter.
- g. Record compliance with PART I of this Service Bulletin in the aircraft records.

PART II: PERIODIC INSPECTION

- a. For helicopters operated in a corrosive and/or agricultural environment, perform corrosion inspection on support strut assemblies in accordance with Basic HMI, Section 13.
- b. Record compliance with PART II of this Service Bulletin in the aircraft records.

WEIGHT AND BALANCE DATA

Weight and Balance are not affected.

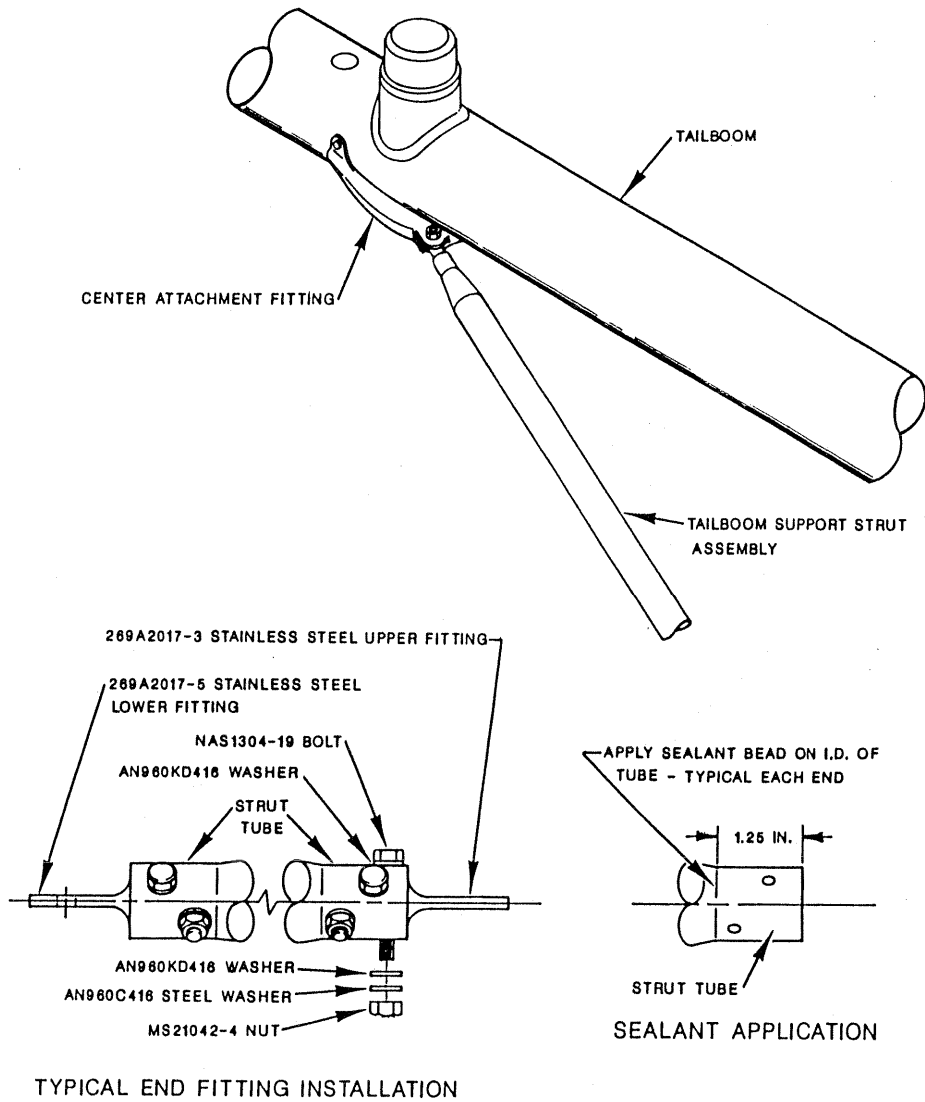


Figure B-253-1. Typical Tailboom Support Strut Assembly