



# SCHWEIZER SERVICE BULLETIN

C1B-028  
24 Oct 2008

MANDATORY

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**SUBJECT:** MODIFICATION OF CABIN DOOR HINGES

**MODELS AFFECTED:** • 269C-1 Model Helicopters Serial No. 0001 through 347

**TIME OF COMPLIANCE:** Within 300 hours or 6 months whichever occurs first.

**REFERENCE:** 269C-1 Basic HMI, Revised: 17 Oct 2008, Appendix D, Revised: 26 Sep 2008.

**PREFACE:** • A report has been received that a cabin door separated from a helicopter in flight as a result of the door hinge pins disengaging from the hinge assembly. The hinge pins became free when a serrated release pin came out of the hinge pin. A modification of the door hinge plate has been developed that will prevent the hinge pins from disengaging if the release pins are lost.

## WARNING

**FAILURE TO COMPLY WITH THIS SERVICE BULLETIN CAN LEAD TO SEPARATION OF THE DOOR WHILE IN FLIGHT.**

**FAA APPROVAL:** The technical aspects of this Service Bulletin are FAA approved.

**PARTS REQUIRED:** .0625 (1/16) inch stainless steel welding rod As required

### PROCEDURE:

- a. As required, remove doors from helicopter.
- b. Measure the outside diameter of door hinge pin receptacle. Cut a length of stainless steel weld rod 0.125 inch longer than the diameter of the pin receptacle.

## NOTE

Instead of modifying the door hinge plates as directed below, the hinge plates may be replaced with a 269A4755-13 hinge half that has been reconfigured with a cap welded to the outside end of the door hinge pin receptacle.

- c. Remove paint from two pin receptacles of both door hinges. File small notches in outside edges of pin receptacle 180° apart and centered on holes as shown in Figure C1B-028-1. Do not exceed one half diameter of weld rod.
- d. Place weld rod in notches with 0.0625 inch overhang on each side. Using overhang as filter, TIG weld rod to edge of hinge receptacle in accordance with Advisory Circular AC 43.13-1B, Chapter 4, Section 5. File excess material flush with outside diameter of receptacle.
- e. Restore paint finish in accordance with HMI Appendix D.
- f. As required, install doors on helicopter.

- g. Record compliance with this Service Bulletin in the aircraft records.

WEIGHT AND BALANCE

Weight and Balance are not affected.

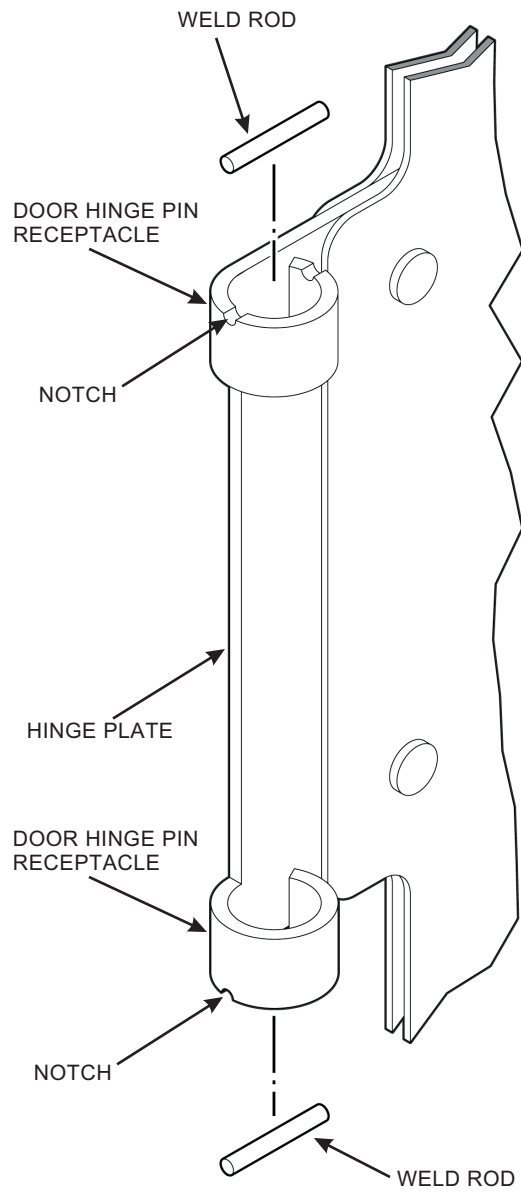


Figure C1B-028-1. Door Hinge Plate