



HUGHES SERVICE INFORMATION NOTICE

NOTICE NO. N-115.1*

DATE 3 October 1975

PAGE 1 OF 5

*Supersedes Service Information
Notice No. N-115
dated 25 March 1974

SUBJECT: REWORK - ENGINE MOUNTING HANGER ASSEMBLIES 269A8617
AND 269A8618 TO ELIMINATE POSSIBLE ENGINE
CRANKCASE TO HANGER ASSEMBLY INTERFERENCE

MODELS AFFECTED: All 269A, 269A-1, 269A (TH-55A) and 269B Helicopters
269C Helicopter Serial No. 0001 thru 0264

And subject hanger assemblies that do not dimensionally
conform to rework requirements of this Notice, in
Spares Inventory.

TIME OF COMPLIANCE: At Owner's and/or Operator's discretion.

PREFACE: Interference between subject hanger assemblies and the crankcase of the
engine may occur, due to dimension change on current engine crankcase
castings. Interference does not occur with current production hanger
assemblies which conform with dimensions specified in this Notice.

This Service Information Notice furnishes a field procedure for rework
of early type hanger assemblies to eliminate the possibility of interference.
It is recommended that the procedure be accomplished for helicopter
equipped with a replacement engine, or for build-up of a replacement
engine, and, for hanger assemblies in spares inventory.

(**█**) Denotes portion of text added or revised

REFERENCES

- 269 Series - Basic HMI, Issued 1 April 1973; Revision No. 3, 15 March 1975
- 269 Series - HMI Supplement A/A-1, Issued 1 April 1973
- 269 Series - HMI Supplement B, Issued 1 March 1973
- 269 Series - HMI Supplement C, Issued 1 March 1973; Revision No. 2, 1 October 1974
- 269 Series - HMI Supplement TH-55A, Issued 1 September 1970, Revised 1 February 1972
- 269 Series - HMI Appendix B, Issued 1 July 1973; Revision No. 3, 15 April 1975

Customer Service Department

Hughes Helicopters

NOTICE NO. N-115.1
DATE 3 October 1975
PAGE 2 of 5

MATERIALS

| | | |
|--|------------------------------|----------------------|
| Cloth, Aluminum Oxide | Prepsol | DuPont |
| Thinner | Prepsol | DuPont |
| Chromic Acid Solution (pH 2.6 to 3.4) | Dow No. 19, or equivalent | Dow Chemical Co. |
| Wash Primer | PG60G2 | Sherwin-Williams Co. |
| Epoxy Primer | *E42GP15 | Sherwin-Williams Co. |
| Catalyst Reducer (for epoxy primer) | *R7K44 | Sherwin-Williams Co. |
| Epoxy Enamel | *Hughes Std (HS) 814-1011 | Sherwin-Williams Co. |
| Catalyst Reducer (for epoxy enamel) | *V66KP11 | Sherwin-Williams Co. |
| Enamel Reducer (for epoxy enamel) | *R7KP36 | Sherwin-Williams Co. |
| Primer, Zinc Chromate | MIL-P-8585 | Commercial |

*For information on compatible alternate and/or optional Manufacturer's paint materials, colors and applicability to specific helicopter model, refer to Section 2, Basic HMI.

PROCEDURE

a. Inspect for interference between engine mount hanger assemblies, PN 269A8617 and 269A8618, and engine crankcase.

b. If interference exists, remove hanger and rework as follows:

NOTE

Rework of the hanger assembly may be accomplished with the engine installed, or out of the helicopter. If the engine is to be removed follow procedures outlined in Section III of the Basic HMI; if rework is to be performed with the engine installed, this may be accomplished by

supporting the weight of the engine with a hydraulic jack and a suitable engine cradle, while the hanger is removed and reworked.

1. Remove engine mounting hanger from engine. (Refer to illustrations of engine mounts in Section 3, Basic HMI.)

NOTE

Damage to crankcase O-rings can result if care is not exercised when removing or installing mounting bolts.

2. Remove material and finish reworked area of left hand and/or right hand hanger as shown in Figure 1.
 3. Install reworked hanger assembly on engine in reverse order of removal; perform additional reassembly as required.
 4. Torque two lateral hanger mounting bolts to 300 - 350 inch-pounds.
- c. Record rework of left hand and/or right hand hanger assembly in Component Record of Helicopter Log Book.

WEIGHT AND BALANCE DATA

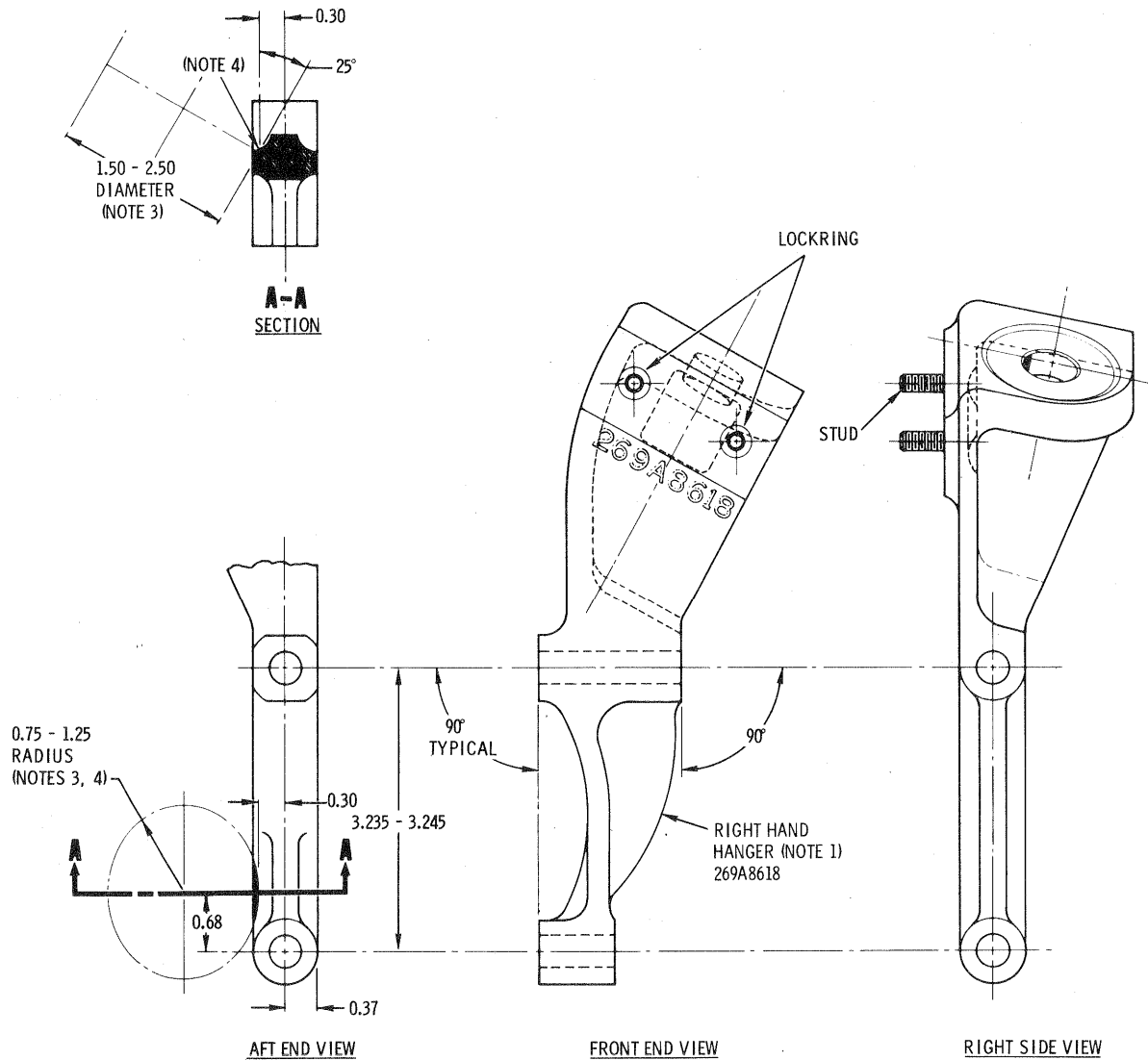
Weight and balance not affected.

Hughes Helicopters

NOTICE NO. N-115.1
 DATE 3 October 1975
 PAGE 4 of 5

NOTES:

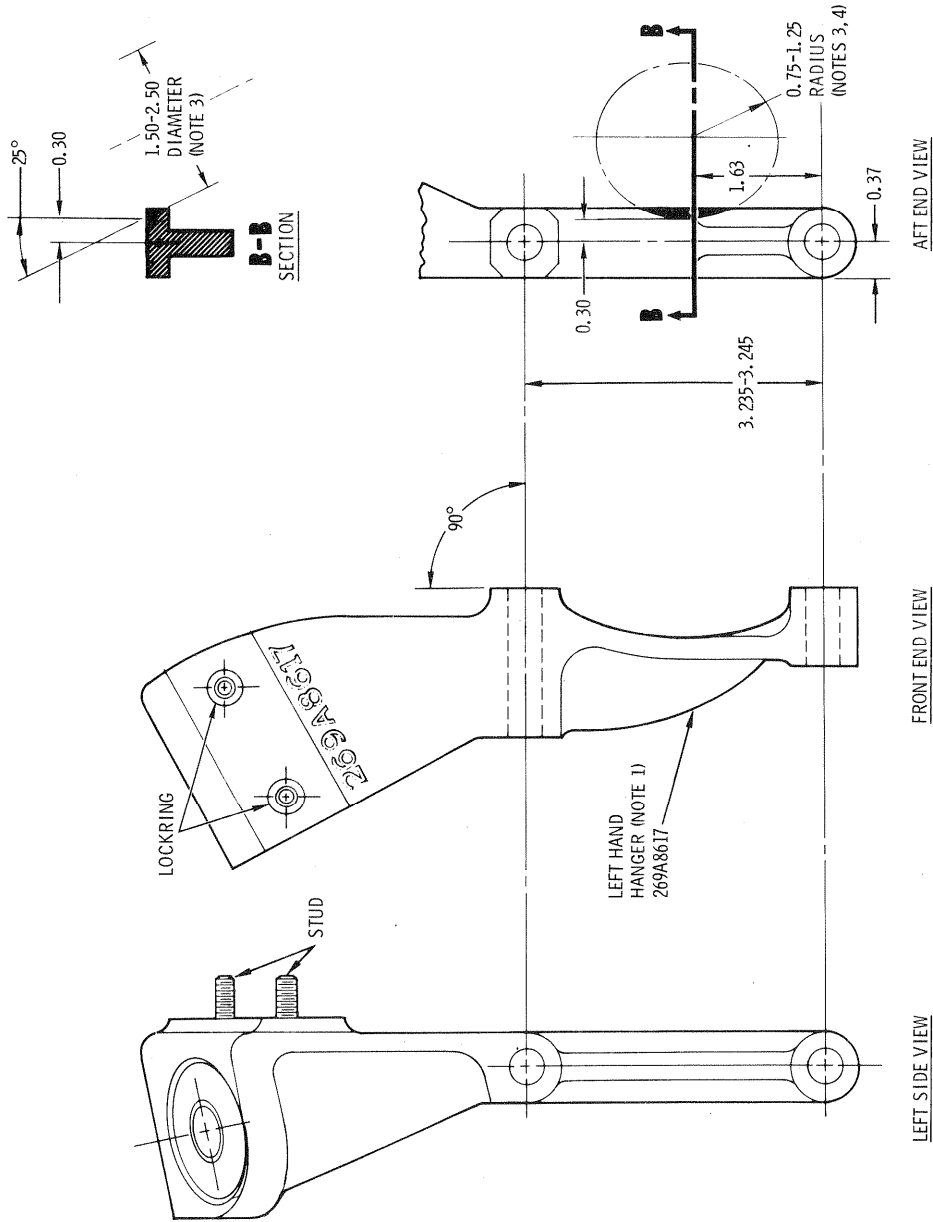
1. ALL DIMENSIONS IN INCHES.
2. MATERIAL IS CAST MAGNESIUM, AZ91C COMPOSITION, T6 TEMPER (QQ-M-56 OR QQ-M-55).
3. RADIUS AS REQUIRED FOR DIAMETER WITHIN LIMITS SPECIFIED FOR MATERIAL REMOVAL TO DIMENSIONS INDICATED.
4. SURFACE TO BE FINISHED TO 125 MICRO-INCHES RHR (ROUGHNESS HEIGHT RATING).
5. ACCOMPLISH EXTERIOR SURFACE TREATMENT OF MACHINED AREA (DOW NO. 19-MIL-M-3171, TYPE VI OR DOW NO. 1-MIL-M-3171, TYPE I), INCLUDING PAINT TOUCH-UP (SECTION 2, BASIC HMI).



RIGHT HAND ENGINE MOUNTING HANGER ASSEMBLY, PN269A8618

88-110-1

Figure 1. Engine Mounting Hanger Rework (sheet 1 of 2)



88-110-2

LEFT HAND ENGINE MOUNTING HANGER ASSEMBLY, PN269A8617

Figure 1. Engine Mounting Hanger Rework (sheet 2 of 2)

