



**HUGHES  
SERVICE INFORMATION  
NOTICE**

NOTICE NO. N-13

DATE September 29, 1966

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**SUBJECT: FIELD MODIFICATION - ENGINE COOLING SCROLL**

**MODELS AFFECTED: 269A (TH55A) Serial No's. 0315 and subsequent.**

**TIME OF COMPLIANCE: At owners/operators discretion.**

**PURPOSE: To provide improved attaching hardware to secure the engine oil cooler to the scroll.**

**Reference**

**269A/A-1 Handbook of Maintenance Instructions  
TH55A HMI Addendum**

- 1. Nut Plate Strip Fabrication**
  - a. Cut aluminum strip to dimensions shown on Figure 1 and deburr.**
  - b. Drill holes in accordance with size and dimensions shown; deburr.**

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c. Secure nut plate assemblies to strips using rivets.

## 2. Installation Preparation For Nut Plate Strips.

a. Remove six studs and retaining rings securing oil cooler to scroll.

### NOTE

It is not necessary to disconnect the oil cooler lines. Support the cooler to prevent damage.

b. Using mallet and drift, peel old nut plate strips (2) from aft side of oil cooler scroll mounting flange and discard.

c. Abrade nut plate mounting surfaces using sandpaper.

d. Using solvent and clean cloth, remove dirt and foreign material from faying surfaces of scroll.

## 3. Nut Plate Strip Installation

a. Using cement, coat faying surfaces of oil cooler scroll mounting flange and two new nut plate strips.

b. Position nut plate strips on aft side of oil cooler scroll mounting flange. Align nut plate assemblies with existing holes in oil cooler mounting flange.

c. Press surfaces together using hand pressure.

d. Install oil cooler using six bolts and washers.

### NOTE

Curing is complete in 8 hours at room temperature, or 1 hour at 150°F. Heat lamps may be used to accelerate curing time.

Parts List

<u>Nomenclature</u>	<u>Quantity</u>	<u>Manufacturer</u>
Aluminum Strip	Raw Stock	2024T3 Alum. Clad
Nut Plate	6	NAS 1031A3
Rivet	12	MS 20426AD3
Bolt	6	AN 3-4A
Washer	6	AN 960PD10L

Materials

Cement	Lefkoweld 109 or equivalent	Commercial
Sandpaper	Medium	Commercial
Solvent	MEK, naptha or equivalent	Commercial

Weight & Balance Data

No appreciable change.

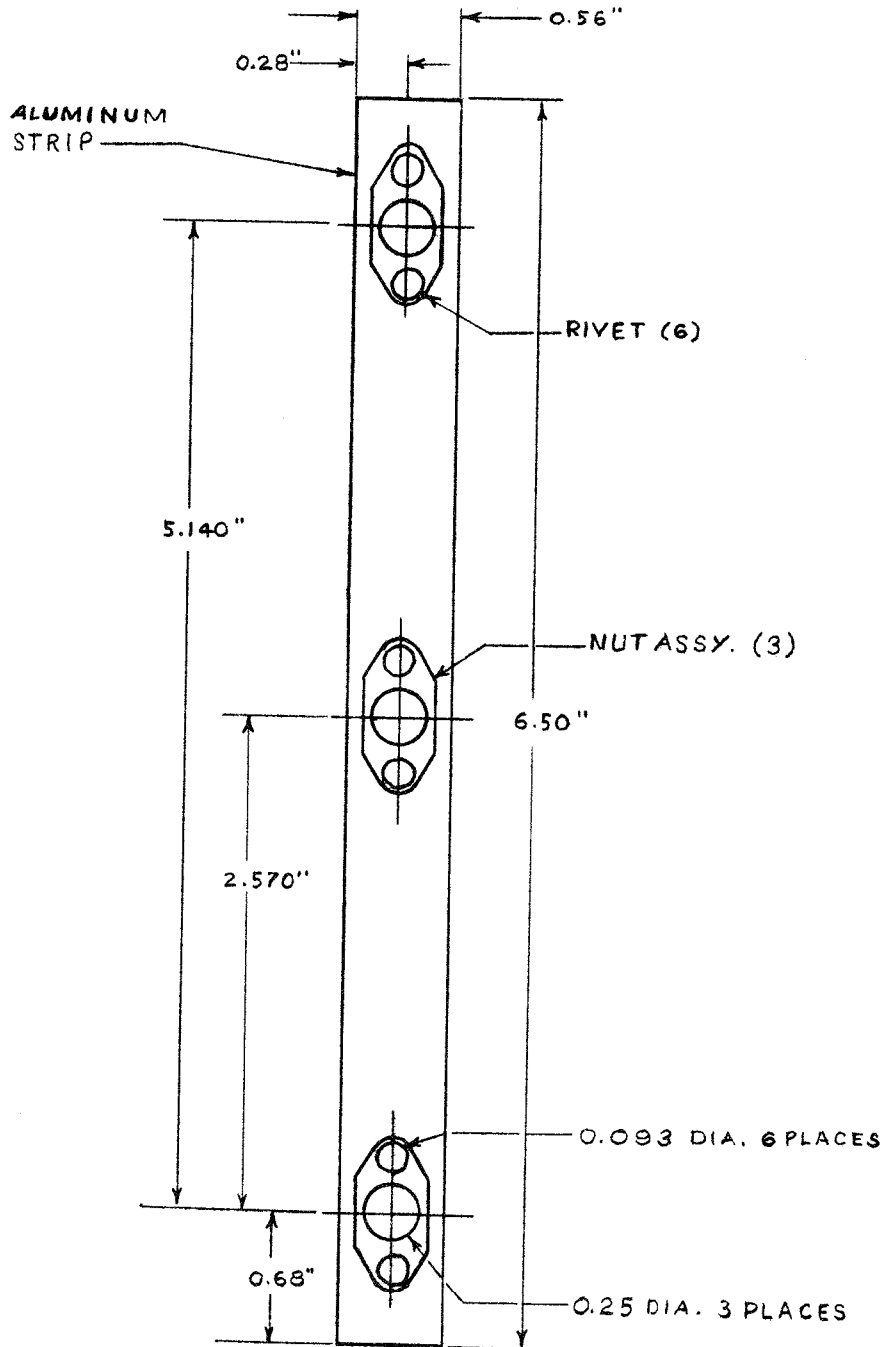


Figure 1  
Nut Plate Fabrication