



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO N-132

DATE 7 Nov 1975

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FAA APPROVED

MANDATORY

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SUBJECT: INSPECTION - HORIZONTAL STABILIZER, FORWARD
BOOM ATTACH FITTING, PN 269A2518-3

MODELS AFFECTED: All Model 269C Helicopters

TIME OF COMPLIANCE: Part I - Shall be accomplished within next 25 hours of
helicopter operation.

Part II - Shall be accomplished at each 100-Hour Periodic
Inspection.

PREFACE: Field reports indicate corrosion induced cracking of the
subject horizontal stabilizer forward attach fitting has
occurred. The problem has been traced to the accumulation
of contaminants adjacent to the stabilizer skin and attach
fitting. Since the area is not readily visible, normal
inspection has not revealed the buildup until damage has
occurred.

This Service Information Notice lists a procedure for an
initial inspection (Part I) and a periodic inspection (Part II),
to determine the integrity of the fitting and provide repair
criteria if any damage is found.

The inspection procedure listed in Part II is to be considered
a part of the 100-Hour Periodic Inspection defined in the below
referenced HMI Appendix B.

Reference

269 Series - Basic HMI, Issued 1 April 1973; Revision No. 3, 15 March 1975

269 Series - HMI Appendix B, Issued 1 July 1973; Revision No. 4, 1 September 1975

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PARTS LIST (As Required)

<u>Nomenclature</u>	<u>Part Number</u>	<u>Qty</u>	<u>Mfr</u>
Fitting - Horizontal Stabilizer, Forward Boom Attach	80-269A2518-3	1	HH
Rivet	MS20470B4	6	Commercial

TOOLS AND EQUIPMENT (As Required)

Rivet gun; Rivset
Cleco fasteners; Cleco pliers
Drill motor, portable
Drill bit - 0.250/0.254 inch diameter
Drill bit - 0.190/0.194 inch diameter
Drill bit - 0.125 inch diameter (#30)

MATERIAL (As Required)

Kit, dye penetrant
Primer, zinc chromate
Paper, aluminum oxide (#220)
Plate, aluminum or steel (10.0 x 5.0 x 0.125 inch)
Plate, aluminum or steel (5.0 x 3.0 x 0.185 inch)
Bar, bucking - solid steel cylinder (12.0 x 1.0 inch diameter)
Brush, bonding (0.5 inch)

PART I - INITIAL INSPECTION

a. Using flashlight and mirror, inspect forward side of fitting inside stabilizer leading edge for evidence of cracking, corrosion or corrosion causing contaminants. Also, inspect protective coating of fitting for integrity.

NOTE

If inspection indicates that fitting is in satisfactory condition, no corrective action is required. Perform step g, Part I of this Notice.

b. Using solvent and swab, clean fitting area of any contaminants and/or corrosion.

NOTE

If fitting is free of cracking or corrosion pitting, perform step g, Part I of this Notice.

c. Remove horizontal stabilizer assembly, per HMI; remove fitting from stabilizer.

NOTE

Prior to removing fitting from stabilizer, fabricate a template and spacer (shim) of sheet aluminum or steel, per dimensions shown in Figure 1. Place fittings on template (use spacer to maintain template parallel); mark and drill template to match three fitting mounting holes as shown. Using template, mark and drill two mounting holes for 269A2515 fitting in spacer.

1. Use No. 220 aluminum oxide paper to remove any corrosion pitting. If pitting is still evident after sanding, install new fitting. Maximum allowable repair depth is 10 percent of original wall thickness of fitting.

2. Dye penetrant inspect fitting, if cracking is suspected. Install new fitting, if any cracking is noted.

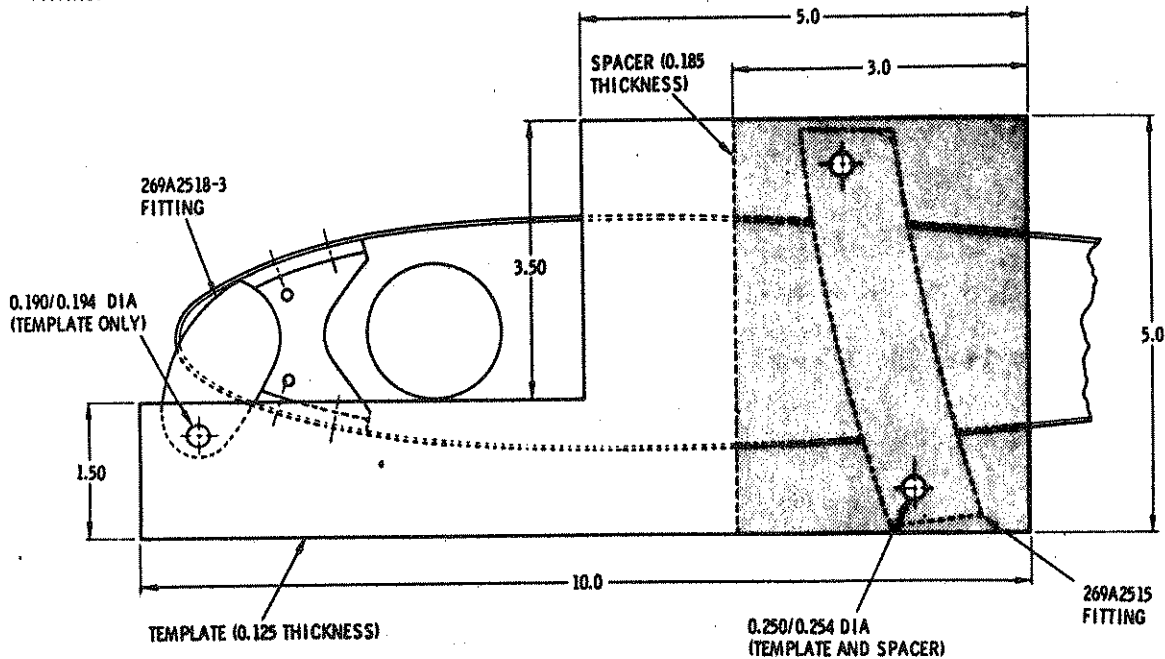
3. Restore finish to fitting, per HMI.

d. Install new or existing fitting, as applicable, to horizontal stabilizer. Use Cleco or similar fasteners to secure fitting in place; use zinc chromate when installing fitting and rivets.

NOTES:

1. ALL DIMENSIONS IN INCHES (APPROXIMATE); SCALE NOT SHOWN.
2. MATERIAL: STEEL OR ALUMINUM PLATE.
3. TEMPLATE THICKNESS 0.125 INCH; SPACER THICKNESS 0.185 INCH.
4. SHADED AREA DENOTES SPACER; POSITION BETWEEN TEMPLATE AND FITTING.

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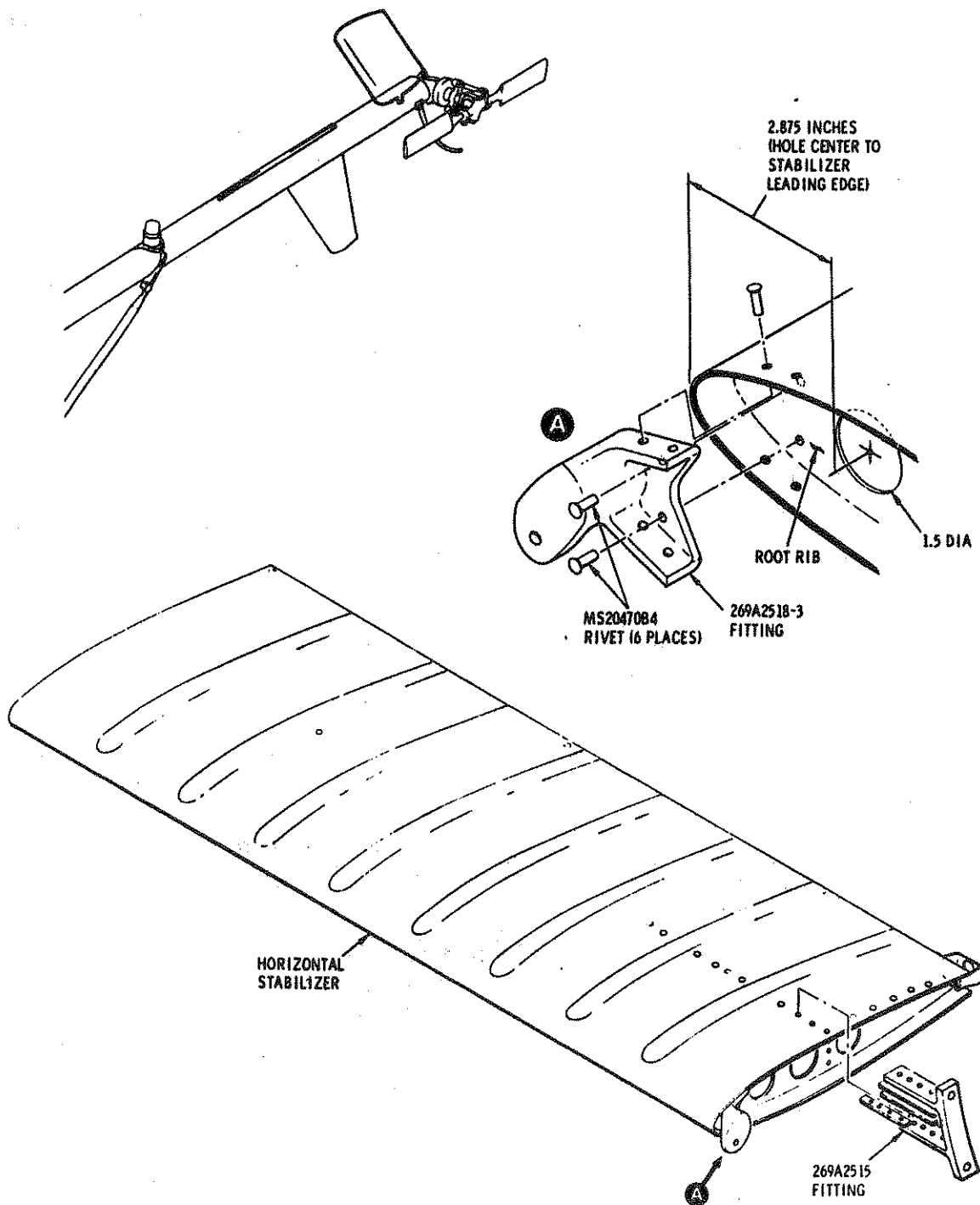
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Figure 1. Fabrication of template and spacer

NOTE

If new 269A2518-3 forward attach fitting is to be installed, perform the following:

1. Cut a 1.5 inch hole in centerline of stabilizer root rib and 2-7/8 inches from stabilizer leading edge. Deburr edges. (See Figure 2.)
2. Position fitting firmly (press down and forward) in place on stabilizer; insert scribe through hole made in rib to locate and mark the two base attachment holes on fitting.
3. Remove fitting and drill two base attachment holes; use #30 drill.
4. Install fitting and secure at base attachment holes with Cleco fasteners; drill four remaining attachment holes; locate from existing rivet pattern. Use #30 drill.



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Figure 2. Installation - 269A2518-3 Boom Forward Attach Fitting, Horizontal Stabilizer.

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5. Remove fitting and deburr; zinc chromate attachment surfaces.
6. Install two base attachment rivets; use bucking bar (with taped ends) inserted through hole in root rib. Install four remaining attach rivets.
7. Position template with spacer on 269A2515 fitting and secure with two 1/4-inch bolts and nuts. Drill mounting hole in 269A2518-3 fitting.
8. Remove template and spacer; deburr hole and zinc chromate. Clean attachment area of fitting with bonding brush.
 - e. Inspect fitting installation for discrepancies.
 - f. Install horizontal stabilizer, per HMI.
 - g. Record compliance with this Service Information Notice in Compliance Record of helicopter Log Book.

PART II - 100-HOUR PERIODIC INSPECTION

- a. At each 100-Hour Periodic Inspection, visually inspect horizontal stabilizer forward boom attach fitting for corrosion, cracking, and physical integrity, using procedure given in Part I of this Notice.

NOTE

The information given in this Service Information Notice has been incorporated in HMI Appendix B and will be incorporated in the Basic HMI.

WEIGHT AND BALANCE DATA

Weight and balance not affected.