



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. N-154

DATE 25 September 1978

PAGE 1 OF 6

**SUBJECT: FIELD MODIFICATION TO NEW 4-BOLT ATTACHMENT
CONFIGURATION - TAIL SKID TUBE, TAIL BOOM ADAPTER
AND TRANSMISSION HOUSING**

**MODELS AFFECTED: All Model 269A, TH-55A, 269A-1 and 269B Helicopters;
Model 269C Helicopter Serial No. 0004 thru 0687**

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: The method of securing the skid tube to the LTS tail boom adapter or HTS transmission housing has been improved. The change incorporates the use of four bolts inserted through the tail boom adapter or transmission housing boss and then threaded into nutplates mounted inside the skid tube.

The four-bolt attachment configuration is standard on the new PN 269A6045-11 tail boom adapter for all helicopters with LTS tail rotor; the new PN 269A2305-9 skid tube for 269C helicopters; and the new PN 269A2305-11 skid tube for 269A, TH-55A, 269A-1 and 269B helicopters.

It is to be noted that earlier configurations of the tail boom adapter and tail skid assemblies will no longer be stocked or sold when existing inventories are depleted.

The information given in this Service Information Notice provides instructions for field rework of an existing tail boom adapter or HTS tail rotor transmission housing to accommodate installation of the new PN 269A2305-9 or -11 tail skid assembly. Instructions are also provided for rework of an existing skid tube to the four-bolt attachment configuration, when the new PN 269A6045-11 tail boom adapter is installed.

Customer Service Department

Reference

269 Series - Basic HMI, Issued 1 April 1973; Revision No. 5, 1 February 1978

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfr</u>
Bolt	NAS1304-7	4	Commercial
Washer	NAS1197-416	4	Commercial
*Nutplate	RM12LHA797-048	4	HH
*Rivet	MS20605M3W3	8	

*Required for rework of tail skid only

MATERIALS

Primer, zinc chromate	MIL-P-8585	Commercial
Sealant	PR1221	Product Research Burbank, CA
Coating, Corrosion Preventative	MIL-M-3171	Dichromate Type III (Dow 7)

TOOLS & EQUIPMENT

Drill motor, portable
 Drill bit - 0.265/0.273 inch diameter
 Drill bit - 0.260/0.267 inch diameter
 Drill bit - 0.096 inch diameter
 Spotface tool - 0.620 inch diameter
 Torque wrench - 0 to 500 inch-pounds

PART I - Rework of PN 269A6045 or PN 269A6045-5 Tail Boom Adapter;
 or PN 269A5640 Tail Rotor Transmission Housing

NOTE

Perform the following rework to accommodate installation of new PN 269A2305-9 or -11 tail rotor skid assembly.

- a. Remove existing dual bolt mounting hardware securing tail skid assembly; remove tail skid assembly.
- b. Drill 0.265/0.273 inch diameter hole through one wall on adapter or transmission housing, two additional places 90° to each other, per dimensions shown in Figure 1, to match additional nutplate locations on new PN 269A2305-9 or -11 tail skid assembly.
- c. Using spotface tool, spotface 0.620 inch diameter to depth required to clean up 0.500 inch wide surface, two places at new hole locations as shown.
- d. Touch up reworked areas with corrosion preventative coating.
- e. Install new PN 269A2305-9 or -11 tail skid assembly, as applicable, using four NAS1304-7 bolts and NAS1197-416 washers. Apply wet zinc chromate primer to bolts prior to installation.
- f. Torque bolts to 90 to 110 inch-pounds.
- g. Plug remaining open holes, two places, with sealant.
- h. Check field rework and installation of tail skid for discrepancies.

Part II - Rework of PN 269A2305 Basic or PN 269A2305-5 Tail Skid Assembly

NOTE

Perform the following rework of tail skid to accommodate installation of tail boom adapter or transmission housing incorporating 4-bolt attachment configuration.

- a. Remove existing dual bolt attachment hardware securing tail skid assembly; remove tail skid assembly.

b. Drill 0.260/0.267 inch diameter hole through one wall on tail skid, two additional places 90° to each other, per dimensions shown in Figure 2, to match additional attachment holes in adapter or transmission housing.

c. Touch up reworked areas with corrosion preventative coating.

d. Mark and drill two 0.096 inch diameter rivet holes at each of the four attachment holes, as shown.

e. Install nutplates, four places, with rivets; install rivets with zinc chromate primer.

f. Install reworked tail skid assembly, using four NAS1304-7 bolts and NAS1197-416 washers. Apply wet zinc chromate primer to bolts prior to installation.

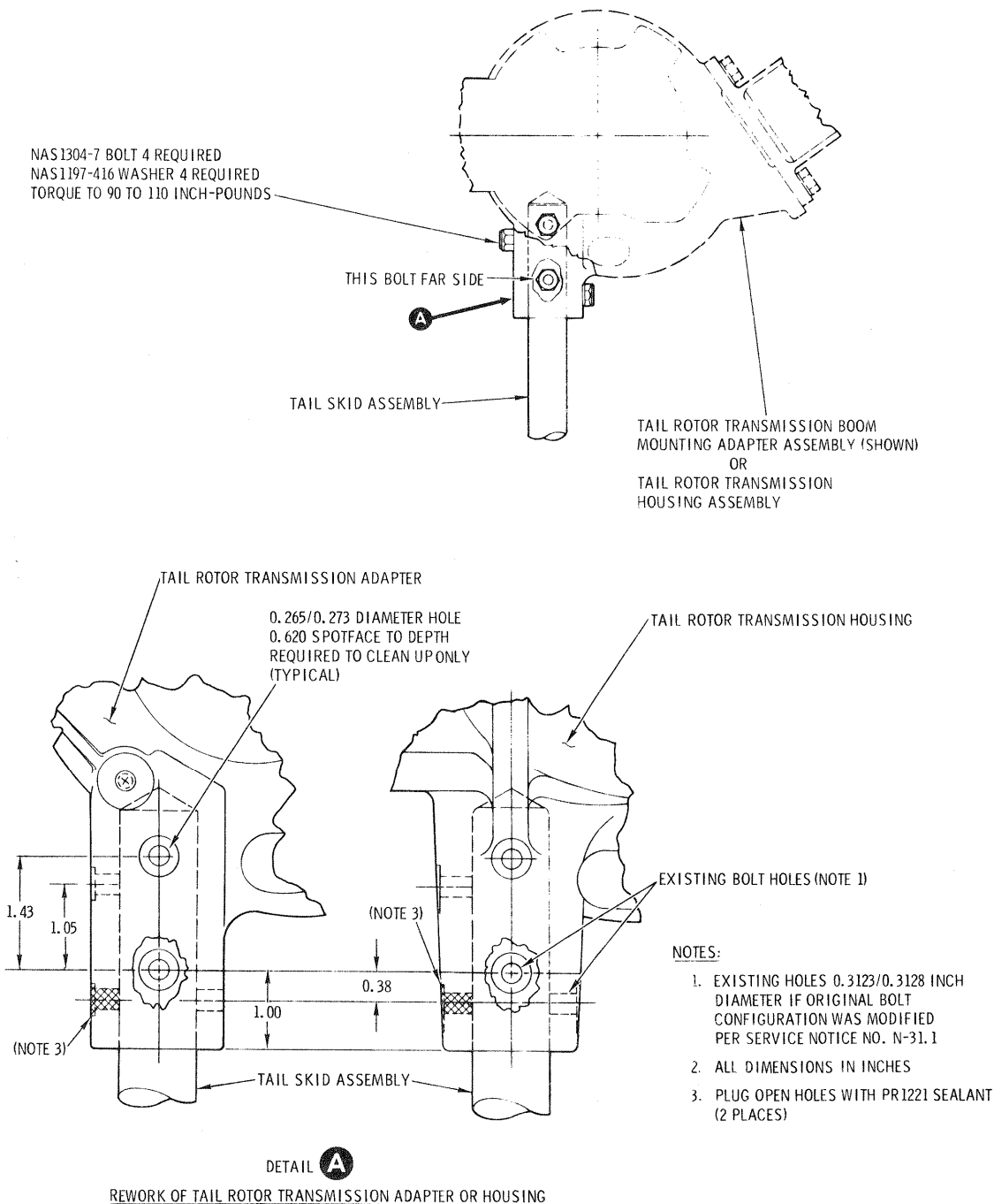
g. Torque bolts to 90 to 110 inch-pounds.

h. Plug remaining open holes, two places, with sealant.

i. Check field rework and installation of tail skid assembly for discrepancies.

WEIGHT AND BALANCE DATA

Weight and balance not affected



88-093

Figure 1. Rework of Tail Boom Adapter or Transmission Housing

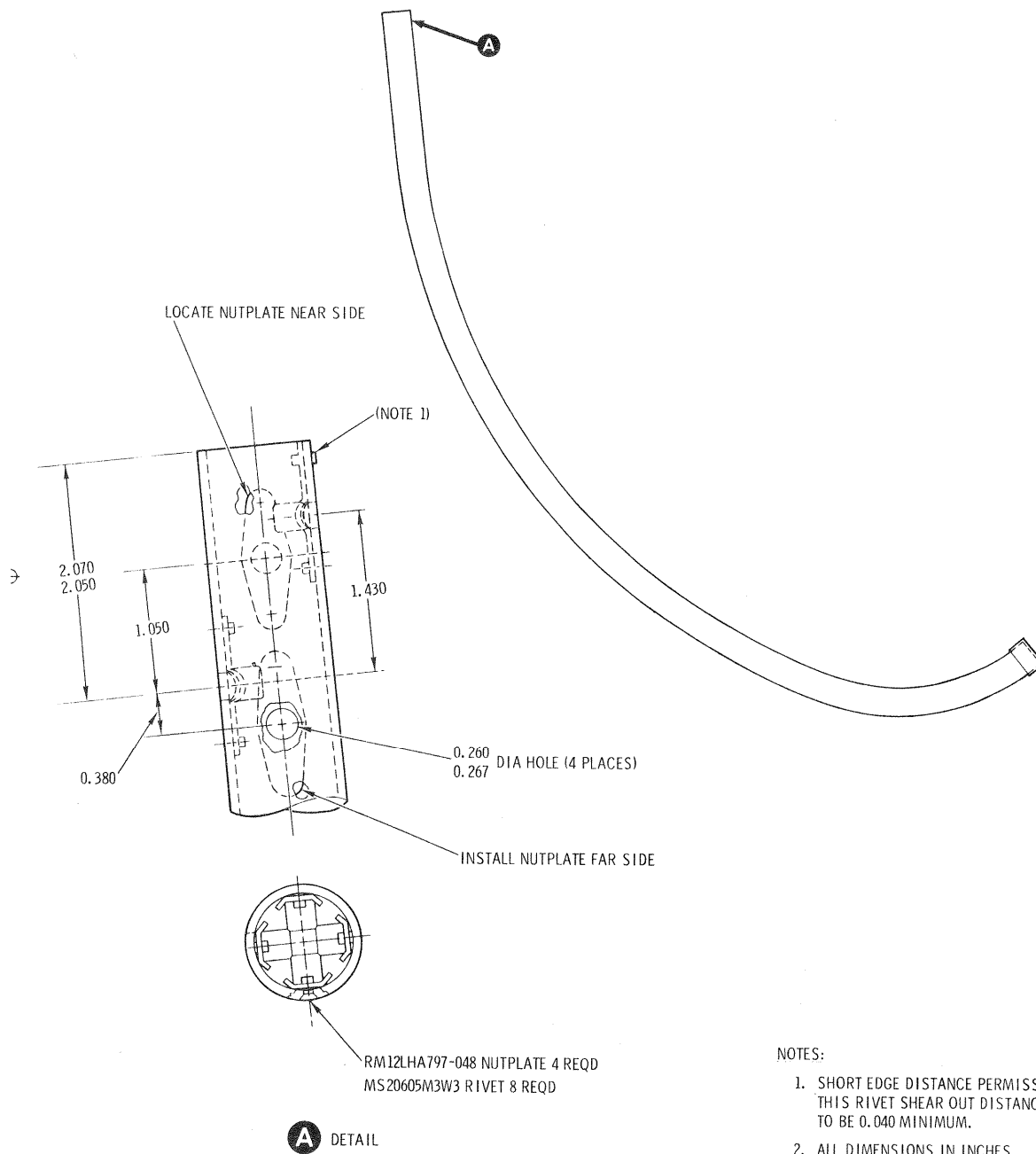


Figure 2. Rework of PN 269A2305 or 269A2305-5 Tail Skid Assembly