



SCHWEIZER SERVICE NOTICE

NOTICE NO. N-160.1*

DATE 12 August 1981

PAGE 1 OF 5

*Supersedes Service Information
Notice No. N-160, dated
28 September 1979

MANDATORY

MANDATORY

MANDATORY

SUBJECT: REWORK OF MAIN ROTOR MAST ASSEMBLY FOR IMPROVED
CORROSION PROTECTION

MODELS AFFECTED: All Model 269 Series Helicopters equipped with PN 269A5050-63
or 269A5050-73 Main Rotor Thrust Bearing

TIME OF COMPLIANCE: Shall be accomplished at next removal or at next Periodic
Inspection of Main Rotor Drive Shaft and Thrust Bearing
Assemblies

PREFACE: Field Reports indicate that corrosion has been noted around and under the
Hi-Shear fasteners securing the main rotor thrust bearing housing to the
main rotor mast. Part I of this Notice lists procedures for inspection and
removal of corrosion, and for coating and sealing the fasteners to inhibit
and minimize corrosion. Part II of this Notice provides instructions for
replacement of Hi-Shear fasteners if corrosion is found to extend under the
fasteners. This revision is issued to change the type of sealing compound
used in Part I to an improved sealant with corrosion inhibiting properties.
Sealant applied per the original issue of this Service Information Notice
may be replaced with the improved sealant at owners and operators
discretion.

Reference

269 Series - Basic HMI, Reissued 1 April 1980
269 Series - HMI Appendix B, Reissued 1 April 1980

PART I - INSPECTION AND REWORK

MATERIALS

Zinc chromate primer	MIL-P-6889	Commercial
Sealing compound	PR1436-G, Class B-2 MIL-S-81733, Type II-2 (Alt: PR1422G, Class B or PR1221)	Product Research Corp Burbank, CA

NOTE

Perform inspection and rework with main rotor drive shaft and thrust bearing removed from helicopter.

a. Remove paint from Hi-Shear Fasteners and surrounding areas of the main rotor mast exterior; inspect for evidence of corrosion. Also check fastener collars and areas of mast interior next to collars for corrosion.

NOTE

1. Remove any corrosion not exceeding limits, per Basic HMI, para 13-30.
2. If corrosion extends under fasteners remove fasteners, remove corrosion (per Basic HMI) and install new fasteners per Part II of this Notice.

b. Clean magnesium surfaces per Section 2 of Basic HMI, para 2-49a thru 2-49d.

c. Coat all surfaces of Hi-Shear fasteners including threads, washers and area immediately around fasteners with zinc chromate primer.

d. When primer is dry, seal all faying surfaces, including threads on top of fasteners, with PR1436-G sealing compound.

e. Repaint mast area. (Refer to Section 2 of Basic HMI, para 2-49e or f.)

f. Record compliance with Part I of this Service Information Notice in Compliance Record of helicopter Log Book.

PART II - REPLACEMENT OF HI-SHEAR FASTENERS

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfr</u>
* Pin and collar	HL19PB82-6APBW-7 or -8	AR	Hi-Shear Corp
* Pin (Oversize)	HL63PB-6-7 or -8	AR	Hi-Shear Corp
** Pin	HL19PB-6-7	AR	Hi-Shear Corp
** Collar	HL96-6	AR	Hi-Shear Corp
Washer	NAS620-10L	AR	Commercial

* Used on 269A2020-7 main rotor mast only

** Used on 269A2010-5 main rotor mast only

a. Remove Hi-Shear fastener(s) as applicable; use vise grip or equivalent to shear off collar and tap pin out towards center of mast.

b. Insert new Hi-Shear pin(s) from inside mast; install with wet zinc chromate primer. Press or tap pin until firmly seated and flush fit or better is obtained in countersink. (See Figure 1.)

CAUTION

1. Do not turn pin during installation or torquing.
2. Do not mar or damage head of pin, if tapping is required.
3. Pin must be seated flush fit or better in countersink, to prevent interference with thrust bearing or thrust bearing nut.

NOTE

Use oversize Hi-Shear where required.

c. Insert locking collars, and NAS620-10L washers under collars if required, to maintain fastener grip length. Torque each collar until nut portion shears; a minimum of two pin threads should be engaged by the collar before wrenching.

NOTICE NO. N-160.1

DATE 12 August 1981

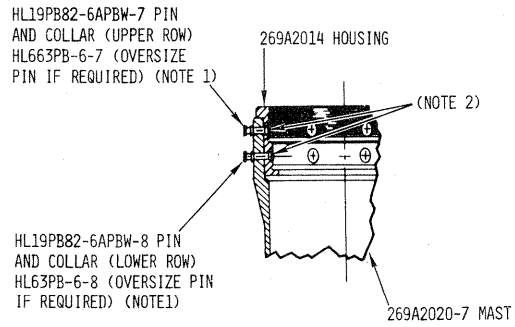
PAGE 4 OF 5

- d. Finish fasteners and mast per Part I, steps b thru e, of this Notice.

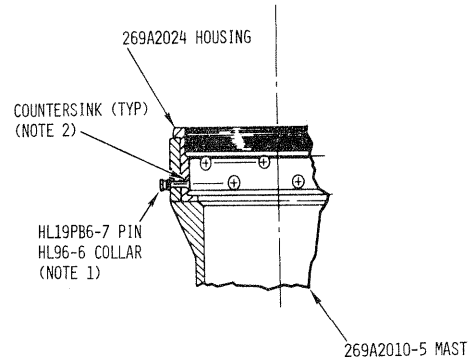
WEIGHT AND BALANCE DATA

Weight and balance not affected.

FAA/DER APPROVED 14 August 1981



HI-SHEAR FASTENER INSTALLATION
269A2020-7 MAIN ROTOR MAST



HI-SHEAR FASTENER INSTALLATION
269A2010-5 MAIN ROTOR MAST

NOTES:

1. NAS620-10L WASHER MAY BE USED UNDER COLLAR IF REQUIRED.
2. PIN HEADS FLUSH FIT OR BETTER IN COUNTERSINK.

88-353

Figure 1. Installation of Hi-Shear fasteners

REFERENCE SHEET

SERVICE INFORMATION NOTICES AND LETTERS

Action Reference: When performing maintenance or inspection of main rotor mast assembly, refer to Service Information Notice No. N-160.1.

HMI Reference: Insert this sheet in Basic HMI, Section 13, page 13-8.

This reference sheet shall be kept as a part of the manual until the data is incorporated at the next revision of the Basic HMI. (Ref to Service Information Summary, 269 Basic HMI, page i.)