



**HUGHES  
SERVICE INFORMATION  
NOTICE**

NOTICE NO. N-173

DATE 30 January 1981

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**MANDATORY**

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**SUBJECT: SEALING OF INTERFACES OF ABRASION STRIP AND MAIN ROTOR  
BLADE SKIN**

**MODELS AFFECTED:** Model 269A, 269A-1 and 269B Helicopters equipped with PN 269A1190 Main Rotor Blade Assemblies with Serial Nos. below 1125.  
Model 269C Helicopters equipped with PN 269A1185 Main Blade Abrasion Strip Installations with Serial Nos. below 2706

**TIME OF COMPLIANCE:** When main rotor blade(s) show visual signs of adhesive erosion at interface with abrasion strip.

**PREFACE:** The information given in this Service Information Notice lists a procedure for sealing of interfaces of abrasion strip and main rotor blade skin to inhibit corrosion and/or adhesive erosion.

Customer Service Department



## TOOLS AND EQUIPMENT

Sealant applicator gun or spatula

## MATERIALS

Solvent - M-114M, J. B. Moore Company, 1605 Ventura Blvd., Encino,  
CA 91436 or Methyl Ethyl Ketone (MEK), TT-M-261

Adhesive - EC2216 B/A, 3M Company, 6411 Randolph, Los Angeles,  
CA 90049

Sealant - PR1436G, Class B-2 or  
PR1422G, Class B  
Products Research and Chemical Corporation, 2919 Empire Avenue,  
Burbank, CA 91504

Release agent - TC-527, EPD Industries, 2055 E. 223 Street, Long Beach,  
CA 90810 or 225, Ram Chemical Company, Gadena, CA

Primer, zinc chromate

## PROCEDURE

- a. Remove screw and tip cap from main rotor blade.
- b. Remove any loose or cracked sealant or adhesive from areas of main rotor blade shown in Figure 1.

## WARNING

MEK is flammable. Use in well ventilated area and  
away from smoke and flame.

- c. Clean areas to be sealed with clean cloth moistened with M-114M solvent. For hard to clean problem areas MEK solvent may be used. Wipe surface dry before solvent evaporates.
- d. Prepare EC2216 B/A adhesive per manufacturer's instructions.
- e. Apply bead of adhesive to interface of abrasion strip and blade skin as shown in Figure 1. Ensure that there are no gaps or bridges in bead. Cure adhesive per manufacturer's instructions.

f. Seal tip cap as follows: (See Figure 1)

1. Apply release agent to inside of tip cap per manufacturer's instructions.
2. Prepare and apply a 0.010 to 0.020 inch coating of PR1436G Class B-2 or PR1422G Class B sealant to faying surfaces per manufacturer's instructions.
3. Attach tip cap to blade and install screw with zinc chromate primer.
4. Wipe off squeezed out sealant flush with surface.

NOTE

To inhibit moisture entering bond joint of abrasion strip after initial application, reapply sealant, when sealant is worn away or becomes cracked.

g. Record compliance with this Service Information Notice in Compliance Record of helicopter Log Book

WEIGHT AND BALANCE DATA

Weight and balance not affected

FAA/DER APPROVED 2 February 1981

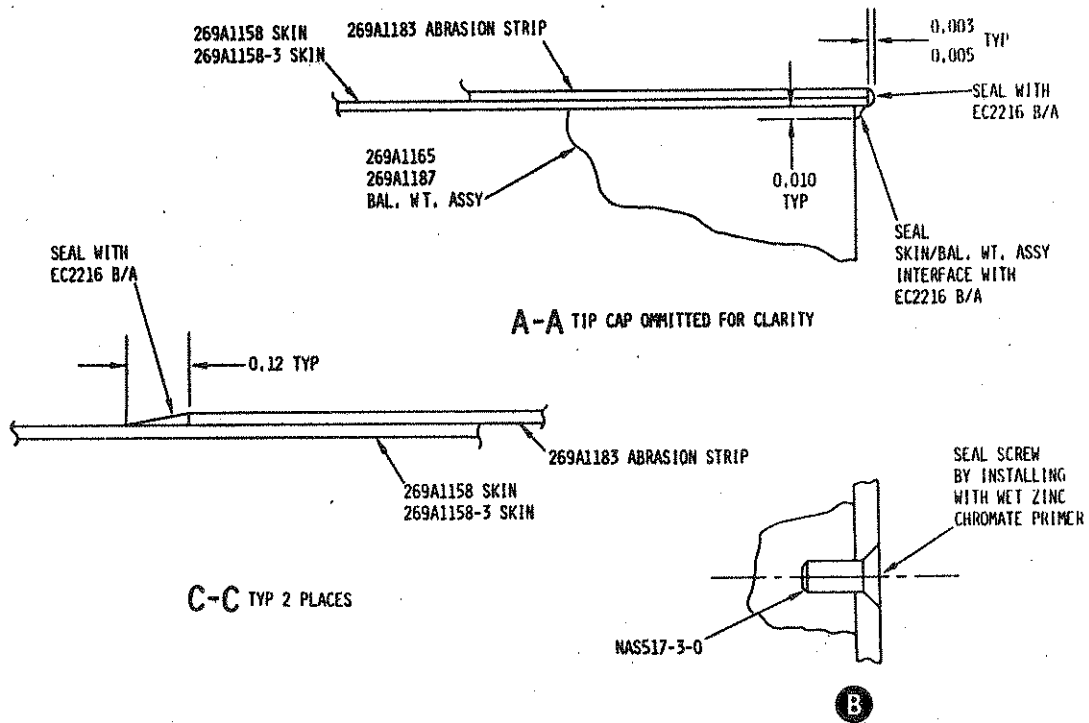
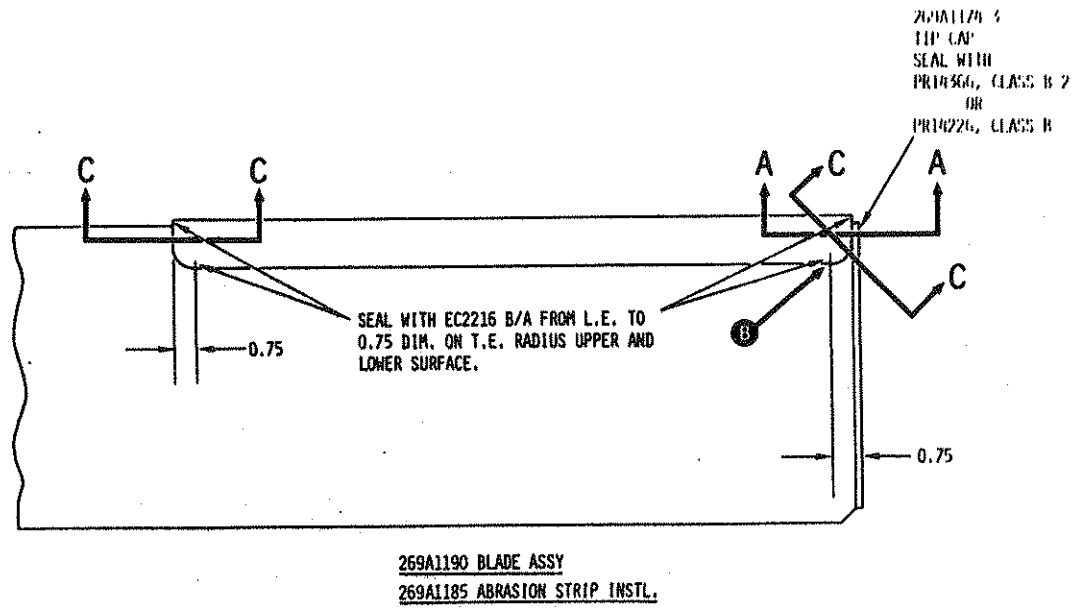


Figure 1. Sealing of Abrasion Strip and Tip Cap