



HUGHES SERVICE INFORMATION NOTICE

NOTICE NO. N-30

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SUBJECT: EXHAUST MANIFOLD ASSEMBLY - FIELD
MODIFICATION TO ACCOMMODATE NEW
EXHAUST ADAPTER FLANGE

MODELS AFFECTED: All 269 Series Helicopters

TIME OF COMPLIANCE: When installing new P/N 8203-3 or 8207-3 exhaust
adapter flanges on aircraft equipped with basic P/N
8205/8206 or 8214/8214 exhaust manifold assemblies

PREFACE:

The following lists a procedure for field modification of basic exhaust manifold assemblies to accommodate installation of new P/N 8203-3 or 8207-3 exhaust adapter flanges. The new -3 flange configuration features a larger and stronger lug to provide greater security of attachment to exhaust manifold tab assemblies. Increased lug size requires that exhaust manifold tubes be reworked to permit proper seating of adapter flanges and mating of attach bolt holes.

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty.</u>	<u>Mfgr.</u>
Flange, Exhaust Adapter	269A8203-3	4	HTC-AD
	or 269A8207-3	4	HTC-AD
Washer	AN960C416L	A/R	Commercial

CUSTOMER SERVICE DEPARTMENT • HUGHES TOOL COMPANY • AIRCRAFT DIVISION • CULVER CITY, CALIFORNIA

Tools & Equipment

Scale, spring - 0 to 20 lbs. range	Commercial
Wrench, torque - 0 to 200 in. lbs. range	Commercial

PROCEDURE

- a. Remove hardware and clamp securing upper and lower exhaust manifolds.
- b. Remove hardware securing exhaust manifold tab assemblies to lugs of four exhaust adapter flanges on aircraft engine; remove upper and lower manifolds.
- c. Remove hardware securing exhaust adapter flanges to aircraft engine.
- d. Notch out area on all four exhaust manifold tab assemblies to dimensions shown. (See Figure 1)
- e. Check new -3 adapter flanges for proper seating and mating of attach bolt holes on reworked tab assemblies.
- f. Install -3 adapter flanges to aircraft engine; use existing hardware. Torque nuts to 160-180 in. lbs.
- g. Install upper and lower exhaust manifold tab assemblies to -3 adapter flanges; use existing hardware.
- h. Reinstall clamp to secure upper and lower exhaust manifolds.
- i. Attach spring scale at aft exhaust manifold tab or aft exhaust manifold opening.
- j. Attain a 10-14 lb. reading by raising exhaust manifolds from lowest deflected position to highest position.

NOTE

It may be necessary to increase or decrease torque on nuts securing exhaust manifold tab assemblies to -3 adapter flanges, in order to attain the 10-14 lb. spring scale reading.

CAUTION

When tightening nuts, do not allow deformation of exhaust manifold tabs. Shim between lug and manifold tabs to center the lug; use P/N AN960C416L washers as required.

- k. Check adapter flange installation for discrepancies.
- l. Perform operational check of aircraft engine; inspect engine exhaust system for leaks.

Weight and Balance Data

Weight and balance not affected.

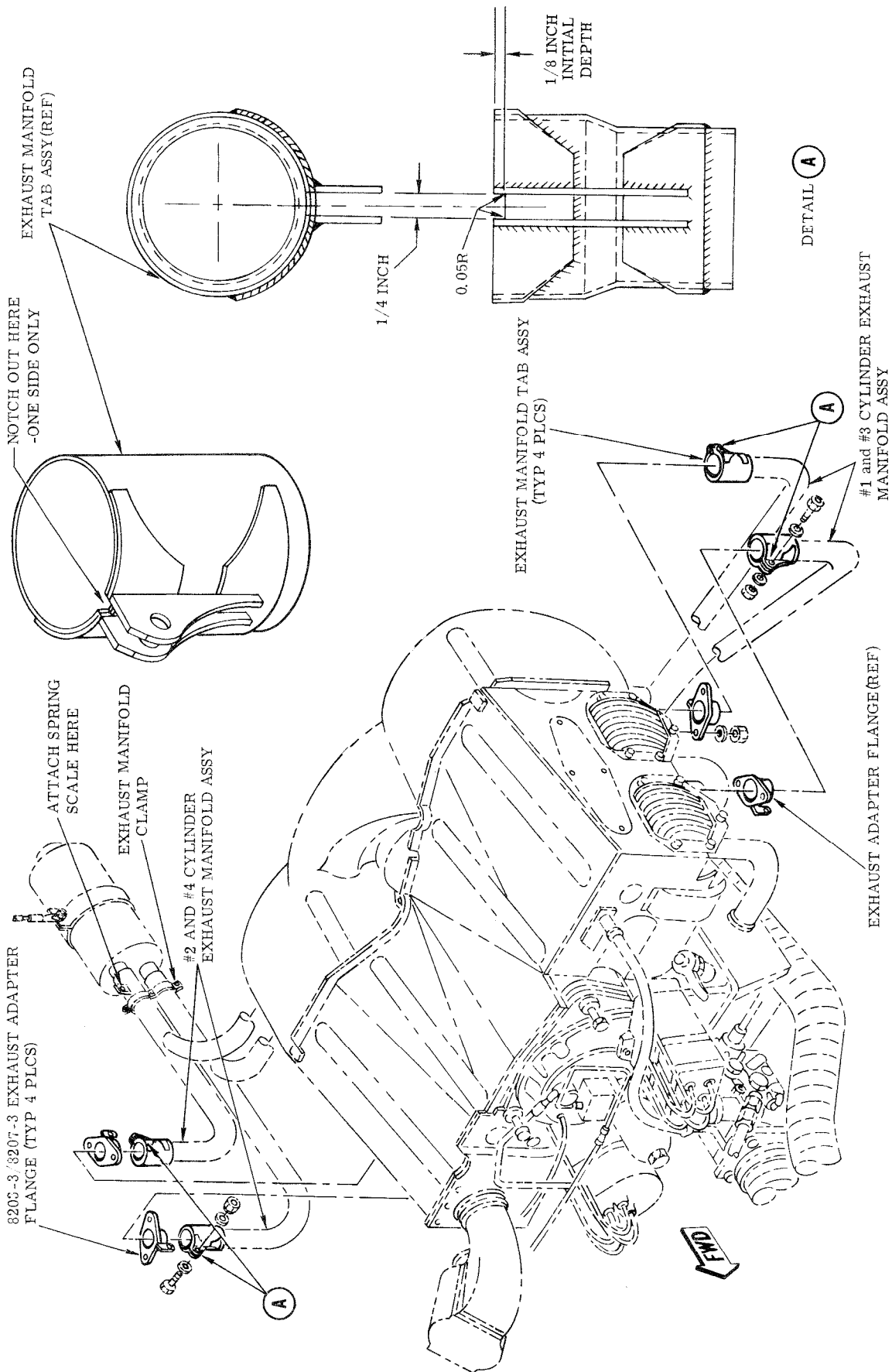


FIGURE 1. EXHAUST MANIFOLD ASSEMBLY - FIELD MODIFICATION