



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. N-119

DATE 23 May 1974

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FAA APPROVED

MANDATORY

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SUBJECT: INSPECTION-REPLACEMENT MAIN ROTOR BLADE ROOT FITTING BOLTS; MAIN ROTOR BLADE DAMPER BOLTS.

MODELS AFFECTED: All 269 Series Helicopters having Main Rotor Blades P/N 269B1145, and or Main Rotor Blade Dampers P/N 269A1222 or 269A1927 Installed.
All Main Rotor Blades and Main Rotor Blade Dampers in Spares Inventory.

TIME OF COMPLIANCE: Part I. Inspection - shall be performed on a one time basis within the next 50 hours of helicopter operation following receipt of this Notice.

Part II. Replacement - shall be performed within next 50 hours following and contingent upon the results of Part I, and receipt of parts.

PREFACE: Part I of this Service Information Notice outlines an inspection to determine whether the correct bolts are installed in the blade root fittings and Main Rotor Blade Dampers.

Installation of NAS1304 bolts in place of NAS464's may produce an unsatisfactory installation.


Part II outlines the part necessary and the procedure for replacement if, and as required. Required hardware may be procured at no charge from Hughes Parts Department if ordered within six months from the date of this notice.

Reference

269 Series Basic Handbook of Maintenance Instructions issued April 1, 1973, Revision #1. October 1, 1973 and Revision #2, April 1, 1974.
269 Series Illustrated Parts Catalog issued March 1, 1974.

Customer Service Department

PARTS LIST FOR 269B1145
 MAIN ROTOR BLADE ROOT FITTING
 (Top & Bottom)

Nomenclature	Part Number	Qty.	Source
Hole 1. Bolt	NAS464P4A23	1	HH or Commercial 
Washer	AN960PD416L	1	
Washer	AN960PD416	1	
Nut	MS20364-428	1	
Hole 2. Bolt	NAS464P4A9	2	
Washer	AN960PD416	2	
Hole 3. Bolt	NAS464P4A7	2	
Washer	AN960PD416L	2	
Hole 4. Bolt	NAS464P4A5	2	
Washer	AN960PD416	2	
Hole 5. Bolt	NAS464P4A4	2	HH or Commercial
Washer	AN960PD416L	4	
Hole 6. Bolt	NAS464P4A4	2	HH or Commercial
Washer	AN960PD416	2	

Hole 1. Inboard hole, AN960PD416L is used under head of bolt.
 Hole 2., 3., 4., and 6. Top and bottom.
 Hole 5. Two washers required under bolt head, top and bottom.

PARTS LIST MAIN ROTOR BLADED DAMPERS

1. Model 269A, 269A-1, TH55-A, 269B and 269C helicopters may be found equipped with the following dampers.

- 269A1222
- 269A1222-3
- 269A1222-5
- 269A1927-5

2. Hardware used to attach the damper arm to the damper body is the same for all the above part numbered dampers and all part numbered arms and is as follows:

Bolt	NAS464P4-13	1 ea
Washer	AN960-416	2 ea
Nut	AN320-4	1 ea
Pin Cotter	AN381-2-7	1 ea

NOTE

Parts listed are required only if the inspection reveals incorrect parts installed.

TOOLS AND EQUIPMENT

Wrench, Torque	0 to 100 in. pounds
Glass Magnifying	10 X
Ball-Hole Gage	

MATERIALS

Dye Penetrant Kit	AR
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Part I. INSPECTION.

a. Visually inspect to determine that NAS1304 bolts are not installed in the following locations:

NOTE

NAS1304 Bolts may be identified by a spherical indentation in the head of the bolt; in addition the part number itself may be stamped on the bolt head.

NAS464 Bolts may be identified by the part number on the head and a delta (triangle) imprint.

1. Eleven (11) bolts securing root fitting top and bottom to Main Rotor Blade.
 2. Bolt securing Main Rotor Damper Arm to damper body.
- b. Remove any NAS1304 bolt found in locations specified in a. 1 and 2.
(Refer to HMI)

CAUTION

Do not remove all bolts at one time securing root fitting, nut plate will drop into blade interior.

NOTE

If no NAS 1304 bolts are found installed, no further action need be taken.

c. Inspect any hole from which an NAS1304 bolt has been removed per the following:

- (1) Evidence of corrosion.
- (2) Evidence of cracks. (Use 10X magnifying glass)
- (3) Evidence of galling, fretting and other damage.
- (4) Evidence of thread imprint and out of round holes. (Use ball gage).

NOTE

If cracks are found or suspected, use dye penetrant to confirm; no cracks allowed. Minor damage may be reworked per standard procedures. (Refer to HMI.) Thread imprint in excess of 0.002 inch, or hole out-of-round in excess of 0.005 inch are cause for rejection of part.

Part II. REPLACEMENT

a. Replace discrepant parts and hardware found per Part I. Inspection.

NOTE

Refer to Illustrated Parts Catalog for replacement part numbers. Consult parts list in this Service Information Notice to determine hardware combinations required for specific hole locations. Torque Blade Root Fittings bolts 50 to 60 inch-pounds.

Refer to HMI for other torques and procedures. If all Root Fitting bolts are to be replaced, fabricate retaining screws to prevent loss of nut plate in interior of Blade.

To prevent any possible interference of the inboard bolt in the root fitting, with the pitch bearing case; insure that the end of the NAS464P4A23 Bolt does not stick out beyond the outside face of the mounting bushing in the root fitting. One additional AN960PD416L Washer may be added under the head of the bolt to preclude this condition.

b. Record Compliance with this Service Information Notice in Compliance Section of Helicopter Log Book.

WEIGHT AND BALANCE DATA

Weight and Balance not Affected.

