MANDATORY MANDATORY MANDATORY

FAA APPROVED

SUBJECT: INSPECTION - LATERAL CYCLIC TRIM CONTROL ASSEMBLY, PN 269A7316-3, -5, -7, -9 OR -11*

MODELS AFFECTED: Model 269C Helicopter Serial No. 0162 thru 0455; 0458 thru 0463; 0465 thru 0469; 0471 thru 0475

Any Model 269A, 269A-1, 269B, or 269C (Prior to Serial No. 0162) Helicopters Certificated in All Categories including the Military TH-55A and Equipped with Subject 269A7316-3, -5, -7, -9 or -11 Control Assembly*

All Subject 269A7316-3, -5, -7, -9 or -11 Control Assemblies in Spares Inventory*

TIME OF COMPLIANCE: Shall be accomplished within next 25 hours of operation. Shall be accomplished prior to installation on helicopter, if subject control assembly is in Spares Inventory.

PREFACE: The information given in this Service Information Notice lists a procedure for a one-time inspection to check the structural bond between the 269A7142 Tube and 269A7318-1 Housing of the subject lateral cyclic trim control assemblies. Instructions for rebonding the tube and the housing, if require are also provided. Refer to the below referenced handbook for removal and disassembly of the control assembly.

Reference

269 Series - Basic HMI, Issued 1 April 1973; Revision No. 3, 15 March 1975

*Subject control assemblies received from Hughes and identified by "C" Rev (or subsequent) after Part Number (for example, 269A269A7316-3-"C" Rev) have been proof-load tested and are NOT affected by this Notice.

MATERIALS

Bonding Compound	Scotch Weld EC1838 (Parts A and B)	3M Co
	or	
	A1177B	B. F. Goodrich
Cord, nylon or cotton -1/8 to 3/16 in. dia		Commercial
Solvent	MEK or M-114	Commercial
Abrasive Paper - 180 grit		Commercial

TOOLS AND EQUIPMENT

Fishscale - 0 to 100 pounds	Commercial

INSPECTION PROCEDURE

a. Remove lateral cyclic trim control assembly from helicopter, per Basic HMI.

NOTE

Reference in HMI to press fit and bonding tube with Loctite to housing is NOT applicable to 269A7316 control assemblies.

b. Remove bushing from end of guide; remove guide from spring and from tube in housing.

c. Perform the following bench inspection, to check bond between tube and housing:

1. Secure one end of cord to the tube next to the housing, using a rolling hitch, clove hitch, or prussik knot. Check that knot is secure and that NO slippage occurs when cord is pulled in direction away from housing. Secure other end of cord also to the tube, with the cord pulling along the opposite side of the tube; use the same knot and the same check for slippage.

2. Using fishscale and 75 to 80 pounds pull on cord loop in direction away from housing, check bond between tube and housing.

NOTE

If ANY slippage occurs between tube and housing, rebond the tube to the housing as follows; otherwise perform step d below.

3. Remove spring and pinion rack from housing, per Basic HMI.

4. Chip or file any loose bond residue from OD of tube and ID of housing; wipe clean with MEK or M-114 solvent.

5. Abrade faying surfaces of tube and housing, including any remaining bonding material, with 180 grit paper. Clean with MEK or M-114 solvent and air dry for 30 minutes minimum.

6. Apply bonding compound to faying surfaces of both the tube and housing; insert tube and rotate and seat in housing. Cure for 8 hours at room temperature (70° F) or 2 hours at 160° F.

7. Recheck bond between tube and housing, per substeps c.1. and c.2. above.

d. Identify control assembly after it has passed proof-load test, by painting a 1/4-inch white dot on the outside of the tube socket portion of the 269A7318-1 Housing.

NOTE

Control assemblies received from Hughes and identified by "C" Rev (or subsequent) after Part Number (for example, 269A269A7316-3-"C" Rev) have been proof-load tested and are NOT affected by this Notice.

e. Reassemble and reinstall lateral cyclic trim assembly, per Basic HMI.

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

WEIGHT AND BALANCE DATA

Weight and balance not affected.