



**HUGHES  
SERVICE INFORMATION  
NOTICE**

NOTICE NO. N-17

DATE November 17, 1966

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FAA Approved

**SUBJECT:** FIELD MODIFICATION - FUEL INJECTION SYSTEM  
ROSETTE FITTING

**MODELS AFFECTED:** 269A (TH55A) Helicopter Serial No's. 0315 through 0667,  
269A-1 Helicopter Serial No's. 0001 through 0018, and  
269B Helicopter Serial No's. 0123 through 0173.

**TIME OF COMPLIANCE:** Within the next 25 hours of rotorcraft operation.

**PURPOSE:** To minimize the effect of the fuel flow gage installation  
on engine operation.

Procedure 1. given in this notice defines the proper method of altering the orifice of the rosette fitting, which does not affect the gage calibration. Slower fuel flow gage response will be noted after this alteration.

Procedure 2. may be utilized at the owners/operators option, but will make the fuel flow portion of the instrument inoperative.

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<u>Nomenclature</u>	<u>P/N</u>	<u>Qty.</u>	<u>Manufacturer</u>
Wire, Music	3/0 (0.007 in. dia.)	12 in.	Comm.
Drill bit, pivot	.18 mm dia. (jewelers drill)	1	Comm.
Solder, activated core	40-60 or 50-50 tin/lead	-	Comm.
Solvent	Naptha or acetone	-	Comm.

#### Reference

269A/A-1 Handbook of Maintenance Instructions  
TH55A HMI Addendum  
269B Handbook of Maintenance Instructions

#### Procedure 1

- a. Determine that all electrical power on the rotorcraft is shut down.
- b. Determine that fuel shut off valve and mixture control are closed.
- c. Disconnect five fuel lines from rosette fitting.
- d. Remove rosette fitting from servo control.
- e. Using solvent, thoroughly clean and degrease interior and exterior of fitting and allow to dry.
- f. Secure fitting in vise or other suitable holder with hole to be resized pointing down.
- g. Add solder to inside of fitting, heat with soldering iron or torch at low flame.

NOTE

Solder wetting and flow will be evident at lower extremity of hole opening.

- h. Insert deburred music wire through molten solder.
- i. Remove heat, allow solder to harden and fitting to cool.

CAUTION

If wire is excessively heat hardened it may break off. Do not allow open flame, if used, to contact and over-heat the wire below the extremity of hole.

- j. Carefully remove music wire from rosette fitting.
- k. Remove fitting from vise; using solvent thoroughly clean fitting and allow to dry.
- l. Inspect fitting; determine that there are no obstructions blocking injection line ports or ports into injector.

NOTE

An alternate method of modification is to fill orifice with solder as noted, then drill new passage using 18 mm jewelers bit.

- m. Reinstall rosette fitting in reverse order of removal.
- n. Pressurize fuel system, check installation for leaks.

Procedure 2

- a. Disconnect fuel flow line from rosette fitting and fuel flow instrument.
- b. Remove or secure fuel flow line from rotorcraft.
- c. Install cap on rosette fitting and instrument.
- d. Pressurize fuel system, check capped opening of rosette fitting for leakage.

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Weight and Balance Data

No appreciable change.

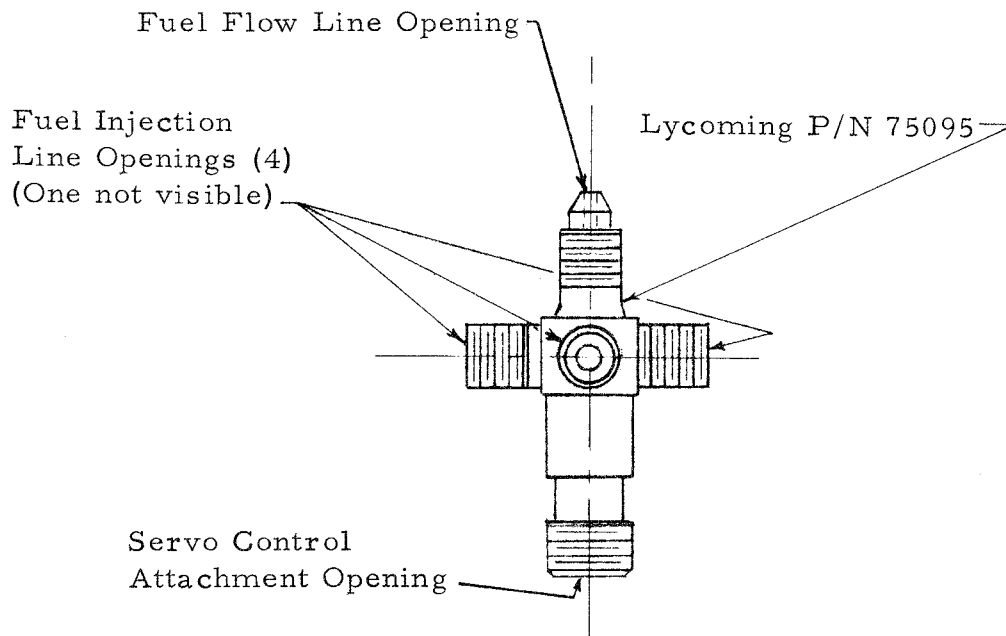


Figure 1.  
Rosette Fitting