



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. N-31.1*

ATE 23 APRIL 1973

AGE 1 OF 5

Supersedes Hughes Notice No.
N-31, dated 9 November 1967

**SUBJECT: FIELD INSTALLATION AND MODIFICATION - DUAL BOLT
TAIL SKID MOUNTING HARDWARE**

MODELS AFFECTED: All Model 269 Series Helicopters

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: Part I of this Notice lists a procedure for installing dual bolt tail skid mounting hardware on early model helicopters, to provide increased support for the tail skid assembly.

Part II of this Notice lists a procedure for modifying existing dual bolt tail skid mounting installations, as required, to eliminate looseness of the tail skid in the transmission housing or adapter.

Close tolerance bolts and specific bolt torque requirements are now utilized for both new and modified dual bolt mounting installations, to ensure positive attachment of the tail skid assembly.

It is noted that close tolerance dual bolt tail skid mounting hardware is factory installed on Model 269C Helicopters Serial No. 0200 and subsequent. If tail skid should loosen, perform Modification per Part II of this Notice.

Reference

269 Series - Basic HMI, Issued 1 April 1973

(■) Denotes portions of text added or revised.

Customer Service Department

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfr</u>
*Bolt	NAS1204-29	2	Commercial
*Nut	MS21045L4	2	Commercial
*Washer	NAS1197-416	4	Commercial
**Bolt	NAS1205-29	2	Commercial
**Nut	MS21045L5	2	Commercial
**Washer	NAS1197-516	4	Commercial

*Required for initial dual bolt installation

**Required for modification of existing dual bolt installation

MATERIALS

Primer Coating, Corrosion Preventive	MIL-M-3171	Zinc Chromate Dichromate Type III (Dow 7)
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TOOLS & EQUIPMENT

Portable drill
Torque wrench - 0 to 500 inch-pounds

*Drill bit - 0.2480 inch diameter

*Ream bit - 0.2498/0.2503 inch diameter

*Spotface tool - 0.620 inch diameter

**Drill bit - 0.3110 inch diameter

**Ream bit - 0.3123/0.3128 inch diameter

**Spotface tool - 0.690 inch diameter

*Required for initial dual bolt installation

**Required for modification of existing dual bolt installation

PART I - INITIAL DUAL BOLT INSTALLATION - TAIL SKID ATTACHMENT

Applicable to all 269A, 269A-1 and 269B helicopters equipped with single tail skid attachment bolt.

- a. With tail skid installed, line drill 0.2480 inch diameter hole through tail skid and tail rotor transmission adapter or housing below existing hardware at dimensions shown in Figure 1.
- b. Hand ream holes to 0.2498/0.2503 inch diameter; spotface 0.620 inch diameter to depth required to clean up to 0.500 inch wide surface, two places, on adapter or housing. Touch up reworked areas with corrosion preventive coating.
- c. Install new NAS1304-29 bolt, NAS1197-416 washers and MS21045L4 nut; apply wet zinc chromate primer before installation. Direction of bolt head is optional; washer required under bolt head and nut.
- d. Torque new NAS1304-29 bolt to 90 to 110 inch pounds.
- e. Remove original tail skid attachment bolt, washers and nut; repeat steps b thru d above for remaining tail skid attachment bolt.
- f. Check new dual bolt tail skid mounting installation for discrepancies.

PART II - DUAL BOLT MODIFICATION - TAIL SKID ATTACHMENT

Applicable to all 269A, 269A-1, 269B and 269C helicopters with dual tail skid attachment bolts installed.

- a. Remove one of the two existing tail skid attachment bolts, washers and nuts.
- b. Line drill through holes in tail skid assembly and tail rotor transmission adapter or housing, using 0.3110 inch diameter drill.
- c. Hand ream holes to 0.3123/0.3128 inch diameter; spotface to 0.690 inch diameter to depth required to clean up to 0.500 inch wide surface, two places, on adapter or housing.
- d. Touch up all reworked areas with corrosion preventive coating.
- e. Install new NAS1305-29 bolt, NAS1197-516 washers, and MS21045L5 nut. Apply wet zinc chromate primer before installation. Direction of bolt head is optional; washer required under bolt head and nut.

- f. Torque bolt to 200 to 225 inch pounds.
- g. Repeat steps a thru f above for remaining tail skid attachment bolt.
- h. Check modification of dual bolt tail skid mounting installation for discrepancies.

WEIGHT & BALANCE DATA

Weight and balance not affected

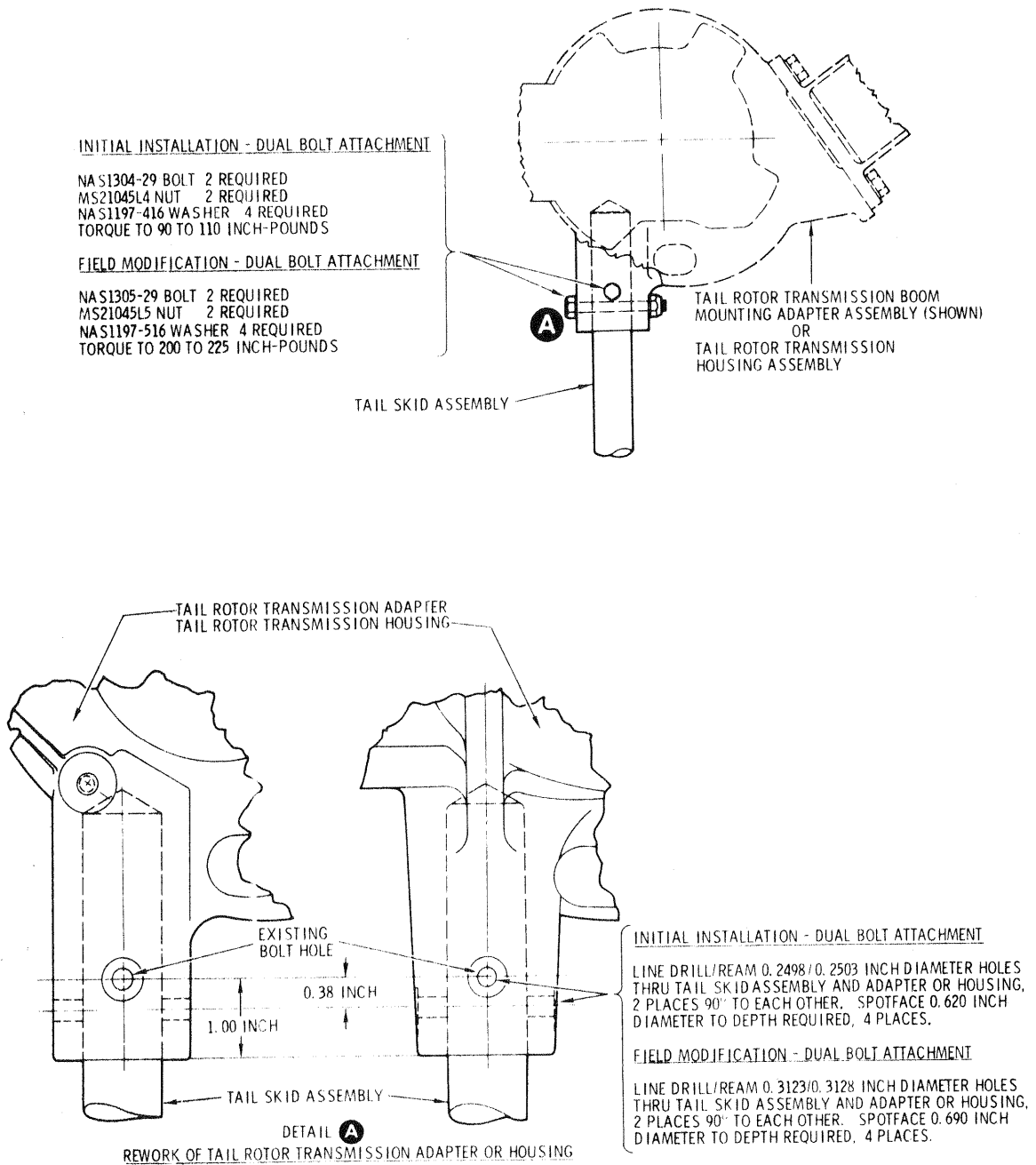


Figure 1. Field Installation and Modification - Dual Bolt Tail Skid Mounting Hardware

