



NOTE

Procedural steps as given apply to both left and right hand float/skid assemblies.

- a. Raise rotorcraft clear of ground using jacking or hoisting method defined in applicable Handbook of Maintenance Instructions.
- b. Deflate float chambers.
- c. Disconnect drag struts from fore and aft cross beams.
- d. Remove bolts, nuts and washers securing floats to skids and skid extensions.
- e. Remove drag struts from floats.
- f. Loosen float retaining straps; remove floats from rotorcraft.
- g. Using drill bit remove center pin in (6) jo-bolts securing skid extensions to skid tube.
- h. Using drift and mallet, remove remaining portion of jo-bolt.

CAUTION

Damage to skid and skid extension can result if excess force is used when removing jo-bolts.

- i. Remove skid extensions from skids.
- j. Clean interior of skid tubes of debris.
- k. Using drill motor and "F" (0.257 in. dia.) drill bit, enlarge four existing holes in skid shoes, deburr holes.
- l. Using same drill bit, enlarge (10) existing holes in each skid float, extension and standard skid sleeve.
- m. Using 0.562 in. dia. spotface tool; spotface 0.010 to 0.020 in. deep upper six of ten holes in skid float extensions and standard skid sleeve.
- n. Using "F" drill bit, enlarge existing ten holes in standard skid extension.

- o. Using 0.445 to 0.455 in. dia. countersink, countersink 0.391 to 0.397 in. deep ten holes in standard skid extension.
- p. Touch up reworked holes and spotface with zinc chromate primer.
- q. Using Hi-Shear special tool; install ten Hi-Shear nuts on inside diameter of standard skid extensions.
- r. Inspect installed nuts for security and freedom from burrs.
- s. Using contact cement, install skid extension caps in skid extensions.

NOTE

Use: PR 1221, (Products Research Co. Los Angeles)  
Grip, (Royal Aluminum Incorporated, Los Angeles)  
Stabond, E154 (American Latex Products, Corp.  
Hawthorne, Calif.) or equivalent in accordance with  
manufacturer's instructions to install caps.

- t. Reassemble standard skid extension, sleeve, shoe and drag strut in accordance with the applicable Handbook of Maintenance Instructions using bolts and washers.
- u. Reinstall float retaining bolt nuts and washers using sealant along entire length of skids.
- v. Visually inspect installation.

SPECIAL TOOLS

Hi-Shear Installation tool P/N BH 220-428-M2\*

PARTS REQUIRED

Bolt	AN 174-6A	20	
Washer	AN 960-416	12	
Blind Nut	BN 360-428-9*	20	(Hi-Shear)

\*Hi-Shear tools and materials may be purchased from Hi-Shear Corporation, 2600 W. 247th Street, Torrance, California. 90509 - Phone (213) 326-8110.

