



FOR TRAINING
HUGHES
SERVICE INFORMATION
LETTER

LETTER NO. L-29
DATE Sept. 22, 1967
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TO—All owners and operators of Hughes Helicopters

SUBJECT: INTERIM REVISION (HMI) RE: LOWER COUPLING DRIVE
SHAFT (P/N269A5504 BASIC and 269A5504-5 SHAFT ASSY) -
WEAR TOLERANCES

MODELS AFFECTED: All 269 Series Helicopters

Reference

269A/A-1 Handbook of Maintenance Instructions, Rev. 1 March 1967
TH55A HMI Addendum
269B Handbook of Maintenance Instructions, Reissued: 15 August 1967

The information given in this Service Information Letter defines inspection procedures and wear tolerances for the spline teeth on the ends of the lower coupling drive shaft. This data revises that given in the current HMI's. The data is to be considered a part of the HMI until formal incorporation is accomplished at the next revision cycle.

269A/A-1 HMI, Page 4-37, Paragraph 4-96, Tools and Equipment
269B HMI, Page 4-46, Paragraph 4-97, Tools and Equipment

ADD: Micrometer - 1 to 2 inch range Commercial
Wire, Measuring - 0.0890 + 0.0002
in. dia. or Blank, drill or drill
shank - #43 (0.0890 + 0.0002) Commercial

269A/A-1 HMI, Page 4-43, Paragraph 4-103, step g.
269B HMI, Page 4-54, Paragraph 4-106, step i.

DELETE: Existing substep (3)

ADD: New substeps (3) and (4)

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- (3) Check splines (2) teeth wear pattern.

NOTE

Contact starts with a short pattern centered on tooth.
As wear increases, the wear pattern length increases.

- (4) Check teeth of fore and aft splines for excessive wear. Insert two measuring wires 180° apart in root areas between teeth; position micrometer on center-line of tooth crowns to obtain measurement over wires. (See Figure 1)

NOTE

Tooth wear is acceptable when dimensions are 1.902 inches or above. When measurements are below the 1.902 inch minimum dimension, the shaft shall be retired from service due to excessive wear.

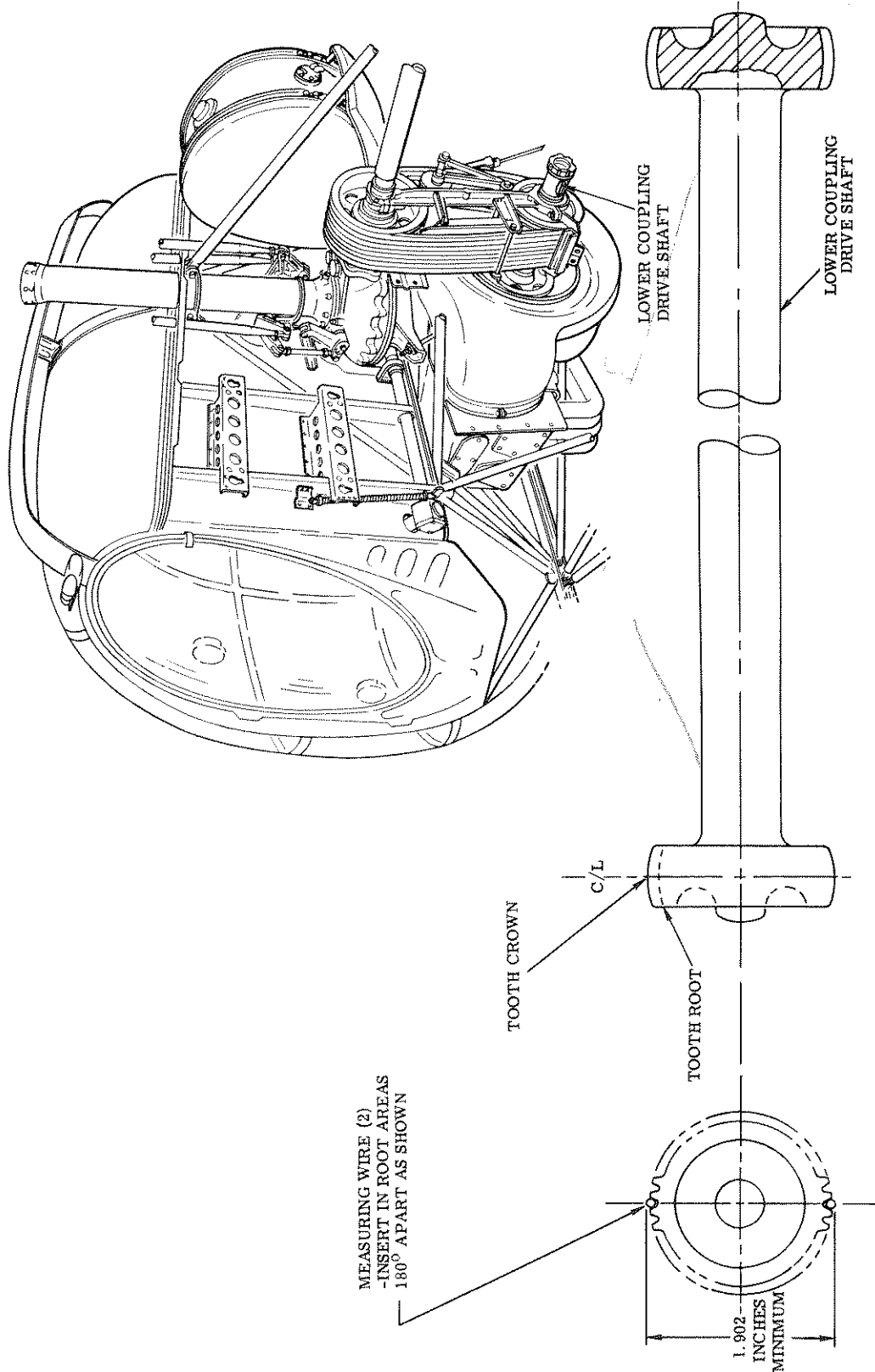


FIGURE 1. WEAR TOLERANCES - LOWER COUPLING DRIVE SHAFT, GEAR TEETH

