



SCHWEIZER SERVICE NOTICE

NOTICE NO. N-109.2*

DATE 1 Sep 1976

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*Supersedes Service Information
Notice No. N-109.1 dated
19 August 1974

MANDATORY

FAA APPROVED
MANDATORY

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SUBJECT: INSPECTION OF TAILBOOM SUPPORT STRUT ALUMINUM END FITTINGS, PN 269A2016-3 AND 269A2016-5; REPLACEMENT OF ALUMINUM END FITTINGS WITH STAINLESS STEEL END FITTINGS (MODIFICATION KIT NO. M10070)

MODELS AFFECTED: The following 269A, TH-55A, 269A-1 and 269B Helicopters equipped with 269A2015 Tailboom Support Strut Assembly; and 269C Helicopters equipped with 269A2015-5 Tailboom Support Strut Assembly:

269A Helicopter Serial No. 0011 thru 0314
TH-55A Helicopter Serial No. 0315 thru 1109
269A-1 Helicopter Serial No. 0001 thru 0041
269B Helicopter Serial No. 0001 thru 0462
269C Helicopter Serial No. 0004 thru 0219

TIME OF COMPLIANCE: Step I - VISUAL INSPECTION shall be accomplished at each and every daily inspection.

Step II - DYE PENETRANT INSPECTION shall be accomplished at each and every 50-Hour periodic inspection until compliance with Step III of this Notice is accomplished.

Step III - END FITTING REPLACEMENT shall be accomplished within next 500 hours of helicopter operation, or within 12 calendar months after date of this Notice, whichever is sooner, unless already accomplished per Hughes Notice N-109 or N-109.1.

PREFACE: The information given in this Service Information Notice lists a procedure for periodic inspections and mandatory replacement of existing aluminum end fittings on the tailboom support struts with stainless steel end fittings and attach bolts. The new corrosion resistant stainless steel fittings are designed for greater strength.

(|) Denotes portion of text added or revised.

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Installation of Modification Kit No. M10070 upgrades existing 269A2015 support strut assemblies to the new 269A2015-9 configuration for 269A/TH-55A/A-1/B helicopters; and upgrades existing 269A2015-5 support strut assemblies to the new 269A2015-11 configuration for 269C helicopters.

It is to be noted that the upgraded 269A2015-9 and -11 support strut configurations are NOT subject to the STEP II 50-hour periodic dye penetrant inspection. A dye check of these configurations is required only if cracks, deformation or damage is suspected during periodic inspections, or after a hard landing or tailboom strike, as specified in HMI Appendix B. The existing 200-hour torque inspection of the support strut end fitting attach nuts remains in effect.

The modification kit provides parts for replacement of upper and lower end fittings for ONE support strut only. Be sure to specify TWO of the M10070-1 kits to modify a ship set of support strut assemblies.

It is to be noted that an FAA Airworthiness Directive will be issued in conjunction with this Notice.

Reference

269 Series - Basic HMI, Issued 1 April 1973; Rev No. 3, 15 March 1975
269 Series - HMI Appendix B, Issued 1 July 1973; Rev No. 4, 1 Sep 1975
Hughes Service Information Notice No. N-108 dated 21 May 1973
Hughes Service Information Notice No. N-109 dated 31 July 1973
Hughes Service Information Notice No. N-109.1 dated 19 August 1974

PARTS LIST

For EACH support strut assembly to be reworked, specify ONE Modification Kit No. M10070-1 which consists of the following:

<u>Nomenclature</u>	<u>Part Number</u>	<u>Qty</u>	<u>Mfr</u>
End fitting, upper	269A2017-3	1	HH
End fitting, lower	269A2017-5	1	HH
Bolt	NAS1304-19	6	Commercial
Washer	AN960PD416	12	Commercial
Washer	AN960C416	6	Commercial
Nut	MS21042-4	6	Commercial

TOOLS AND EQUIPMENT

Drill press	Commercial
Drill bit - #3/16	Commercial
Drill bit - #2	Commercial
Drill bit - #E (0.250/0.254 inch dia)	Commercial
Torque wrench	Commercial
Magnifying glass 10X	Commercial

MATERIALS

Kit - dye penetrant	Commercial
Solvent - methylethylketone (MEK) or equivalent grease-free solvent	Commercial
Paint stripper - acid fortified (for epoxy paint)	A202 - CeeBee Chemical Co or equivalent
Primer - zinc chromate	Commercial
Paint - epoxy enamel - color match (optional)	Commercial

Step I - VISUAL INSPECTION (daily)

a. Without disassembly, visually inspect 269A2016-3 and 269A2016-5 aluminum tailboom support strut end fittings for cracks, deformation or damage.

CAUTION

If cracking is suspected, dye penetrant inspect fittings per STEP II of this Notice.

Step II - DYE PENETRANT INSPECTION (50 hours)

CAUTION

Support tailboom at aft end prior to removal of strut, per step a below.

NOTE

On Model 269B helicopter, it will be necessary to detach the battery cable from the strut prior to removal of the strut.

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a. Remove bolts, washers and nuts securing upper and lower tailboom support strut fittings to the tailboom center attach fitting and the center frame aft cluster fittings, left and right hand sides. Remove struts from helicopter.

WARNING

Paint stripper can cause burns. Wear protective clothing and a face mask when handling stripper.

b. Using acid fortified paint stripper, remove finish paint coat from the tailboom support strut end fittings.

c. Apply dye penetrant solution to upper and lower surfaces of tailboom strut end fittings (see figure 1). Using 10X magnifying glass, inspect for cracks and other structural damage.

d. Visually inspect remainder of support strut shafts, fittings, rivets, etc for deformation or other physical damage.

e. Immediately retire from service and tag as unserviceable any tailboom support strut end fitting found to have cracks or other unrepairable structural damage. Replace end fittings with stainless steel end fittings, per Step III of this Notice.

NOTE

Notify HH of any discrepant parts found during inspection. Address correspondence to:

Hughes Helicopters
Customer Service Department
Centinela & Teale Streets
Culver City, CA 90230

f. Remove dye penetrant solution from tailboom support strut end fittings. Wipe stripped area with MEK solvent.

g. Apply wash coat of zinc chromate primer; apply a finish coat using locally procurable epoxy enamel. Color match as close as possible. Apply finish coat in accordance with paint manufacturer's instructions.

h. Install tailboom support struts in reverse order of removal.

i. Remove support (see NOTE, step a) from tailboom.

j. Record compliance with Step II of this Notice in Compliance Record of helicopter Log Book.

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Step III - FITTING REPLACEMENT

- a. Remove existing aluminum end fittings and install replacement stainless steel end fittings. (Refer to Basic HMI.)
- b. Following installation of upper and lower stainless steel end fittings, record new support strut assembly configuration 269A2015-9 for 269A/TH-55A/A-1/B helicopters, or 269A2015-11 support strut assembly configuration for 269C helicopters, in Components Record of helicopter Log Book.
- c. Record compliance with Step III of this Notice in Compliance Record of helicopter Log Book.

NOTE

(269C Helicopters only) Serialization of the tailboom support strut assembly is required in order to identify and ensure replacement of the struts at the specified limited life interval of 10,700 hours. If not already accomplished, install new 269A4583-3 Serial Number ID Plate on tailboom support strut, per referenced Service Notice No. N-108.

Record the strut Serial Number with the 269A2015-11 configuration entry in the helicopter Log Book, per step b above.

When new fittings are installed, replacement of the 269A2015-11 support strut assembly shall be accomplished when 10,700 hours total time in service is accrued by the existing strut tube.

WEIGHT AND BALANCE DATA

Weight and balance not affected.

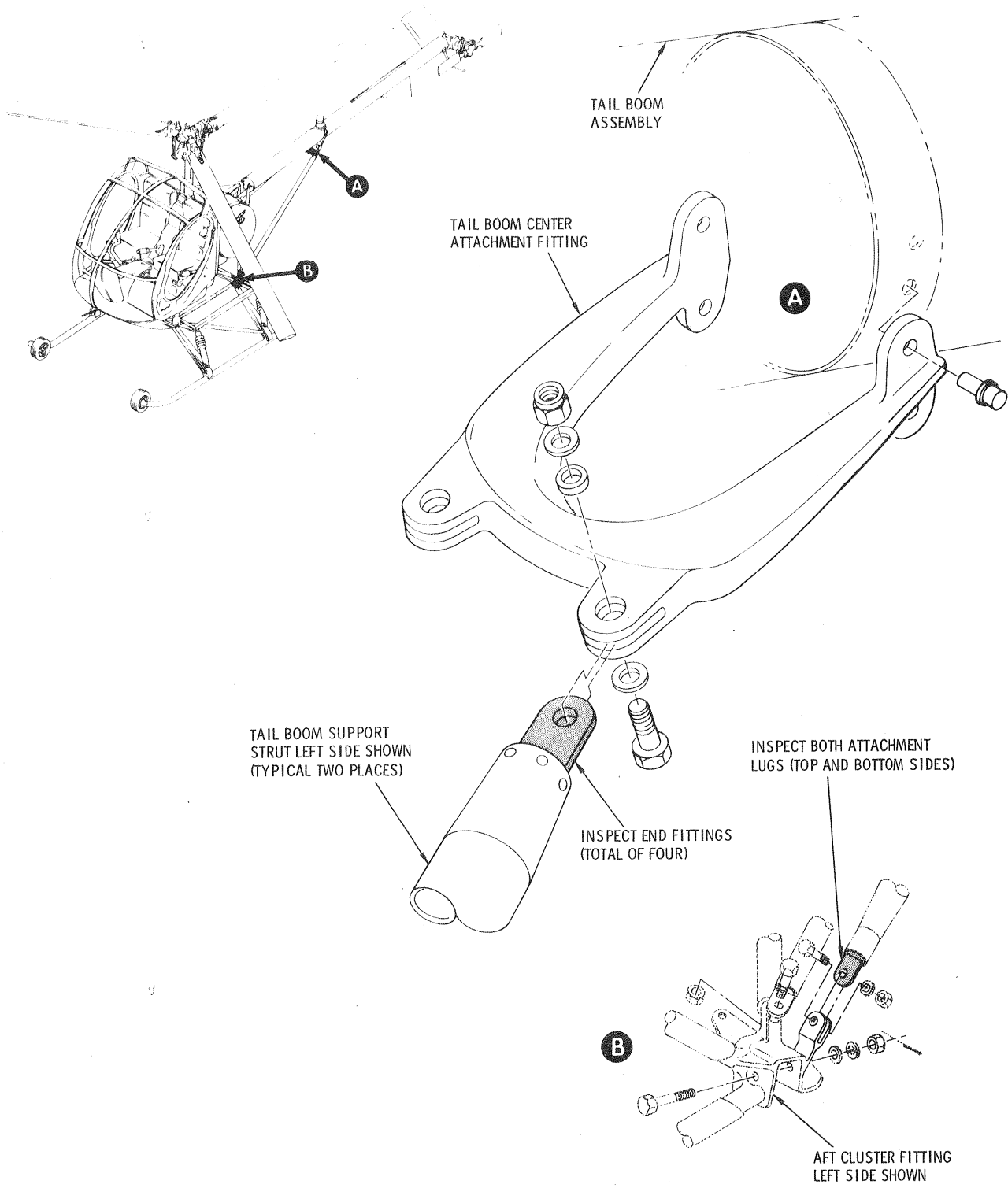


Figure 1. Inspection - tailboom support struts