HUGHES SERVICE INFORMATION NOTICE

NOTICE NO. N-24
DATE Sept. 19, 1967
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SUBJECT: MAIN ROTOR BLADES, P/N 269B1145 - SINGLE CONFIGURATION, PAINTED

MODELS AFFECTED: All 269 Series Helicopters equipped with 269B1145 main rotor blades.

TIME OF COMPLIANCE: Mandatory when mixing painted and unpainted blades in a ship set.

PREFACE:

Effective immediately, all 269B1145 main rotor blades will be painted at the factory to provide a single blade configuration for both commercial and military helicopters.

The information given in this Service Information Notice lists a procedure for painting main rotor blades in the field to (1) obtain a single all-painted blade configuration, and (2) eliminate the problem of "flicker vertigo" experienced by pilots operating aircraft equipped with a mixed set of main rotor blades.

All main rotor blades are balanced to the same master blade at the factory and thus weigh the same, whether painted or unpainted. To maintain a balanced rotor system it is therefore necessary that all blades of a mixed set be painted equally and at the same time.

Materials

Thinner	#200 Oil or No. 3919	Standard Oil Co. Dupont (Prepsol)
Primer, wash	P406C1	Sherwin Williams Co. or equiv.
Catalyst	V66VC48	Sherwin Williams Co. or equiv.
Reducer	R6K27	Sherwin Williams Co. or equiv.
Primer	E42GP15	Aero Cati Coat, Sherwin Williams
Catalyst	V66KP15	Sherwin Williams Co. or equiv.
Enamel, epoxy-black	F55PB16	Aero Cati Coat, Sherwin Williams Co. or equiv.
Catalyst	V66KP11	Sherwin Williams Co. or equiv.
Reducer	R7KP36	Sherwin Williams Co. or equiv.
Tape, masking - 1/2 inch width		Commercial

Tools & Equipment

Gun, paint-spray	Commercial
Bench, work - 12 ft. length or sawhorse (2)	Commercial
Sponge or brush-soft	Commercial
Cloth-soft, lint-free	Commercial

Reference

269A/A-1 Handbook of Maintenance Instructions
269B Handbook of Maintenance Instructions

a. Remove main rotor blades from aircraft, per HMI.

b. Inspect main rotor blades, per HMI.

c. Position blades with lower surface facing upwards on work bench, saw-horses or equivalent; provide protective covering or padding to prevent damaging or scratching of blades.

d. Wipe blades with thinner; use sponge, soft brush or lint-free cloth; wipe dry immediately with dry cloth.

NOTE

Clean blades thoroughly. It is essential that blade surfaces to be painted are absolutely clean and dry.

e. Mask all root fittings and all blades upward from centerline of leading edge and blade tip; leave masking on during all painting.

NOTE

Covering one-half inch area around each root fitting provides unpainted area for subsequent inspection of blade root fitting area.

f. Mix four parts wash primer with one part V66VC48 catalyst, and three parts R6K27 reducer (Typical: 16 ounces primer, 4 ounces catalyst, and 12 ounces reducer).

NOTE

Strict adherence to mixtures, procedures and materials, including paint manufacturer's instructions, is absolutely essential.

g. Using a single spray pass, apply coating of primer in thin but wet film so that a continuous film is obtained on lower surface of blades.

NOTE

Do not attempt to obtain a full hiding spray coating as this indicates excessively thick coat and improper application technique.

CAUTION

Prime and paint all three rotor blades together. Do not prime or paint one blade or portion of blade without spraying all blades an equal amount at the same time. Single or partial spraying may produce blade out-of-balance condition resulting in lateral vibration.

h. Mix epoxy primer 1 to 1 with V66KP15 catalyst reducer. Spray one coat of primer on lower surface of blades; air dry for one hour minimum before applying coat of black epoxy enamel.

i. Mix epoxy enamel 1 to 1 with V66KP11 catalyst; spray two coats of epoxy enamel on lower surface of blades; air dry for ten minutes minimum between each coat.

j. Remove masking tape; allow to air dry for 24 hours.

k. Check newly painted areas of main rotor blades for discrepancies.

l. Install and track main rotor blades, per HMI.

m. Test fly aircraft.

NOTE

If out of balance blade condition exists (lateral vibration) return all three blades in set to factory for rebalancing.

Weight and Balance Data

Weight and balance not affected.