



HUGHES SERVICE INFORMATION NOTICE

NOTICE NO. N-27

DATE February 22, 1967

PAGE 1 OF 6

SUBJECT: KIT INSTALLATION - EXHAUST HEATER SUPPORT

MODELS AFFECTED: All 269A/A-1 Helicopters.

TIME OF COMPLIANCE: At owners and operators discretion.

PURPOSE: To provide increased support and stability for exhaust heater muffler jacket.

Reference

269A/A-1 Handbook of Maintenance Instructions
269A/A-1 Exhaust Heater Installation Instructions

Parts List

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty.</u>
Kit, Exhaust Heater Support Installation	M10019	1

Materials

Paint

Zinc Chromate

Tools and Equipment

Gage - Spring Tension

Lbs. calibrated

- a. Loosen 4209 clamps and remove 4210-5 tube and 4210-7 tube from muffler jacket assembly. (See Figure 1)
- b. Pull back wiring terminal nipple covers to generator output wiring and disconnect wires.

NOTE

Identify each wire as it is disconnected for reinstallation purposes.

- c. Remove wires attached to diagonal joint A-B' strut assembly, noting routing. (See Figure 9-9, Handbook of Maintenance Instructions)
- d. Remove diagonal joint A-B' strut assembly at B' attachment point.
- e. Remove diagonal joint A-B' strut assembly at A' attachment point.
- f. Remove engine exhaust assemblies at tab assembly attachment to exhaust adapters on engine.

NOTE

If AN960C416L washers were used to eliminate deformation in tabs, make notation for reinstallation purposes.

- g. Remove attaching hardware from muffler jacket assembly.
- h. Drill two 0.198/0.204 inch diameter holes in -3 reinforcement and upper heater jacket, per dimensions shown in Figure 2.
- i. Enlarge holes in 4229 angle to 0.198/0.204 inch diameter; install angle to jacket and reinforcement with AN3H4A bolts, AN960C10L washers and MS21042-3 nuts.

- j. Install heater muffler jacket assembly around engine exhaust assembly with flange gaskets and seals.
- k. Install AN520-10R8 screws, AN960-10 washers and NAS679A3 nuts, through heater muffler jacket flanges, finger tight.

NOTE

When installing screws through heater muffler jacket flange, screw heads will be on top half of muffler jacket and the nuts will face the ground.

- l. To insure correct positioning of engine exhaust assembly, reinstall on engine adapters and tighten all accessible nuts on heater muffler jacket flanges.
- m. Remove engine exhaust assembly and tighten remaining nuts on heater muffler jacket.
- n. In recessed area of heater muffler jacket assembly; install two each AN520-10R28 screws, one AN520-10R30 screw; three each AN960-10 washers and NAS679A3 nuts.

NOTE

In recessed area hole nearest centerline location, install the AN520-10R30 screw. Allow 1 to 3 thread protrusion beyond nut on all screws.

- o. Install engine exhaust assembly with heater muffler, utilizing existing hardware.

CAUTION

To eliminate possibility of tabs cracking, reinstall AN960C416L washers in original position. When tightening installation nuts, do not allow deformation of tabs; disassemble connecting hardware and insert additional AN960C416L washers.

- p. Install 4230 clamps to #1 and # 3 cylinder manifold and to 4229 angle with four each AN3C4A bolts, NAS1021C3 nuts, and AN960C10L washers. Clamps and angle to be clamped solid two places.
- q. Attach spring scale to aft exhaust manifold tab or exhaust manifold opening.
- r. Attain 10-14 lb. reading by raising exhaust manifold from lowest deflected position to highest position.

NOTE

It will be necessary to increase or decrease torque on adapter tab nuts, in order to achieve the above mentioned spring scale reading.

- s. Reinstall diagonal joint A-B' strut assembly and zinc chromate bolt shafts.
- t. Reroute wires to diagonal joint A-B' strut assembly and install identified wires to generator or alternator output terminals.
- u. Install wire nipple covers over terminals.
- v. Slide cuffed end of 4210-5 tube and 4210-7 tube approximately 1" over muffler jacket openings; secure in place with 4209 clamps.
- w. Perform inspection of heater muffler jacket installation for discrepancies.

Weight & Balance Data

Weight	Arm
0.3	92.0

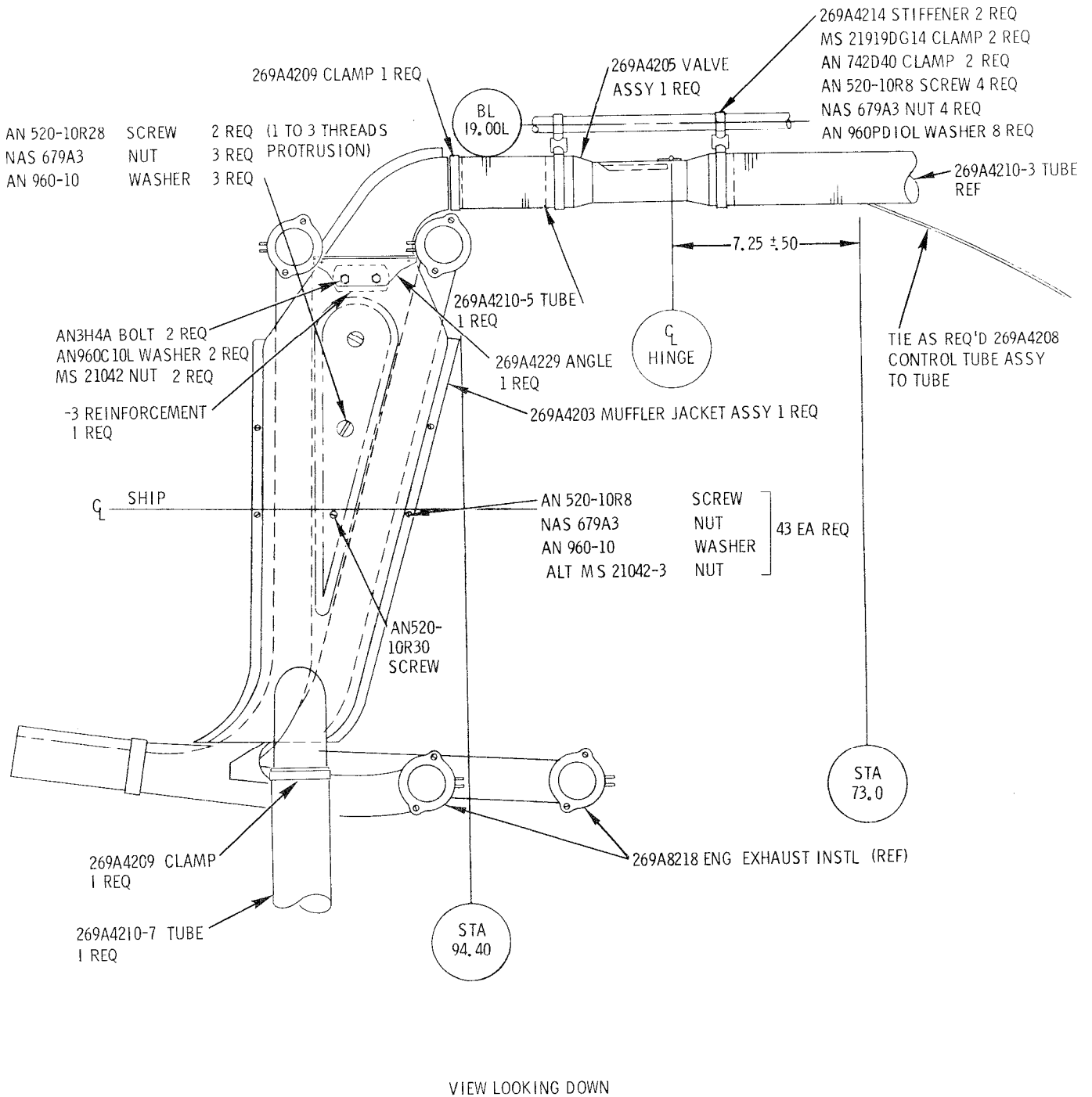


Figure 1. Heater Muffler Jacket Installation

NOTICE NO. N-27
 DATE February 22, 1967
 PAGE 6 OF 6

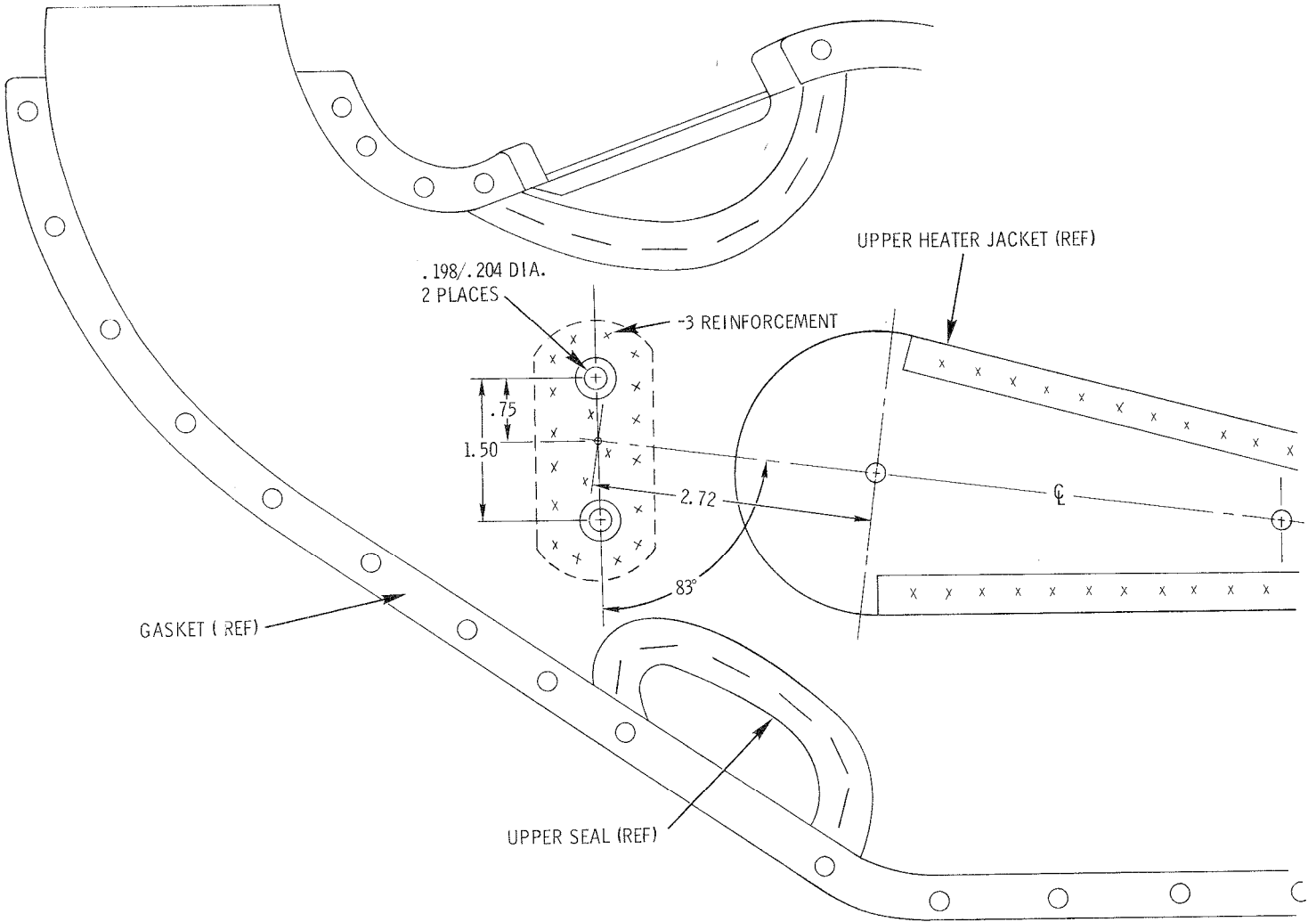
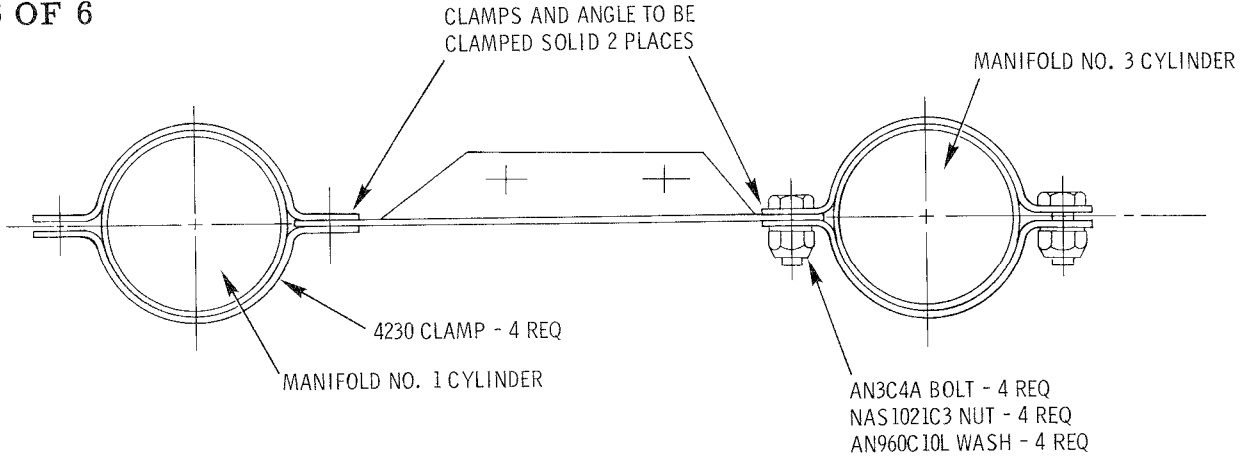


Figure 2. Heater Muffler Jacket Installation