



HUGHES SERVICE INFORMATION NOTICE

NOTICE NO. N-39.2*

DATE August 14, 1968

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*Supersedes Service Information Notice
No. N-39.1 dated 7 May 1968

SUBJECT: INSTALLATION - STIFFENER, CANOPY SLAT

MODELS AFFECTED: All 269 Series Helicopters equipped with P/N 269A2299 basic canopy slat installation.

TIME OF COMPLIANCE: Shall be accomplished with the next 100 hours of aircraft operation.

PREFACE:

The information given in this Service Information Notice Lists a procedure for installation of fiberglass stiffeners on the basic P/N 269A2297 canopy slat to create a new P/N 269A2297-7 canopy slat assembly. Installation of stiffeners to both sides of center bracket provides increased structural support to center section of canopy slat and additional protection against abrasion and wear.

It is to be noted that incorporation of the new -7 canopy slat assembly changes the P/N 269A2299 basic canopy slat installation to a new P/N 269A2299-3 configuration.

Reference

269A/A-1/TH-55A Handbook of Maintenance Instructions, Revised 1 June 1968
269B Handbook of Maintenance Instructions, Reissued 1 April 1968

(■) Bar denotes portion of text superseded

CUSTOMER SERVICE DEPARTMENT • HUGHES TOOL COMPANY • AIRCRAFT DIVISION • CULVER CITY, CALIFORNIA

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty.</u>	<u>Description</u>	<u>Mfgr.</u>
Stiffener-canopy slat	269A2297-5	2	2.50 x 11.0 in., two laminations	Fabricate - fiberglass cloth 181 or equiv.
Rivet	MS20470A4	2		Commercial

Materials

Fabric Material, woven glass	Commercial Type 181, Type VIII; MIL-C-9084 or equiv.
Adhesive - resin, epoxy	Narmco 3135
Catalyst, polyamide	Narmco 7111
Solvent - Aliphatic Naptha	TT-N-95; Standard Oil #200
Sandpaper - 220 grit, wet or dry	Commercial
Tape, masking	Commercial
Alum. Al. Sheet-3.50 x 0.75 x thickness A/R	2024T3;QQ-A-250/5 Temp T3

Tools & Equipment

Gloves - lint free (cloth, nylon or rubber)	Commercial
Brush (alternate:squeegee)	Commercial
Spatula (alternate:roller)	Commercial
Gun - rivet	Commercial
Drill - portable	Commercial
Bit - drill, 0.127/0.135 dia.	Commercial
Tool, spotface - 0.292/0.342 dia. (with 0.127/0.135 pilot)	Commercial
Cup, disposable - unwaxed	Commercial
Depressor, tongue - wood	Commercial
File, hand - fine	Commercial

PROCEDURE

- a. Remove canopy slat from aircraft.

NOTE

If position lights are installed on canopy slat, disconnect electrical wiring before removing attaching hardware.

- b. Place canopy slat on bench; drill out two rivets securing P/N 269A2255 brace to canopy slat. (Refer to Figure 1)

- c. Clean faying surface of canopy slat with solvent.

NOTE

Faying surfaces are denoted by shaded areas in Figure 1.

- d. Lightly abrade faying surface (top and bottom) of canopy slat. Wipe slat clean with solvent and air dry a minimum of 30 minutes at room temperature.

NOTE

Apply masking tape to isolate faying surfaces and to protect non-faying surfaces of slat when sandpapering.

- e. Thoroughly mix 50 parts by weight of Narmco 3135 resin, and 50 parts by weight of Narmco 7111 catalyst in an unwaxed disposable cup; use wooden tongue depressor for mixing.

NOTE

Pot life of mixed adhesive is 1 hour at room temperature.

- f. Cut four fiberglass strips to 2.50 x 11.0 inch dimensions.
- g. Spread thin layer of adhesive on abraded faying surfaces of canopy slat.
- h. Position initial fiberglass strips on canopy slat with overlap as shown in Figure 1. Press firmly into place.
- i. Add second layer of adhesive and fiberglass strips and overlap as above.
- j. Slowly wipe air and excess resin out of laminates; use spatula, roller or hand. Continue wiping process until all entrapped air has moved past edges of laminates and impregnated plies are pressed firmly together.
- k. Air dry for 24 hours at room temperature.
- l. Drill 0.127/0.135 diameter holes through fiberglass stiffeners and existing rivet holes in canopy slat. Existing rivet holes are visible through stiffener material.
- m. Spotface rivet holes through stiffener material, on top of surface of canopy slat only.

CAUTION

Do not spotface beyond old spotface in existing rivet holes in canopy slat.

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- n. Reinstall brace to canopy slats with rivets.
- o. Reinstall canopy slat to LH and RH sides of canopy; reconnect position lights, if installed, and check lights for proper operation.
- p. Position brace and 2248 filler on canopy; measure gap between brace and center support; fabricate and insert new spacer under center support; mark and drill three 0.171/0.177 in. dia. holes in spacer.

NOTE

Fabricate spacer per dimensions shown in Figure 1.

- q. Install center support, new spacer, brace and filler, using existing attaching hardware.
- r. Check canopy slat stiffener installation for discrepancies.

WEIGHT & BALANCE DATA

Weight and balance not affected.

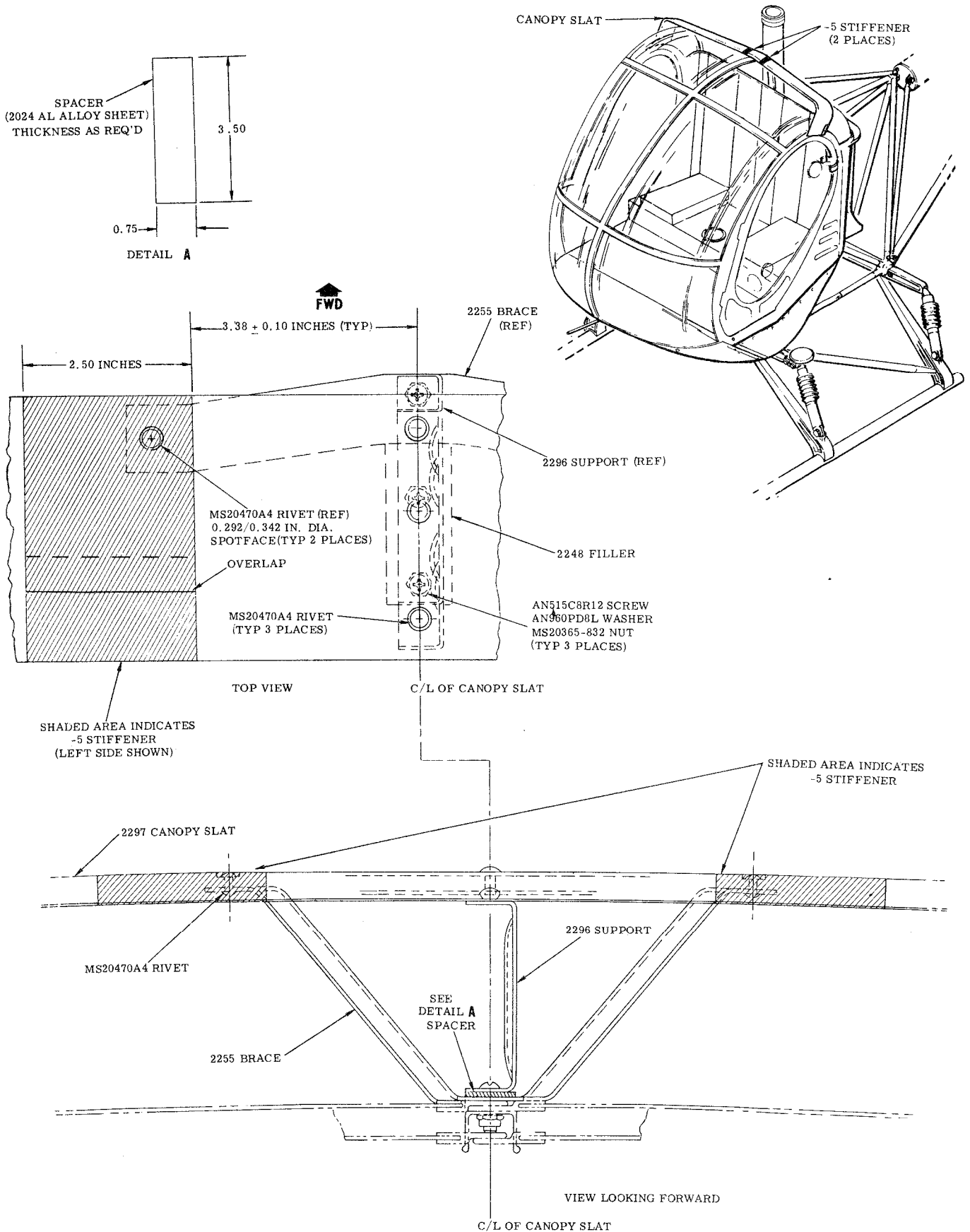


FIGURE 1. INSTALLATION - STIFFENER, CANOPY SLAT

