



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. N-68

DATE March 10, 1969

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SUBJECT: CONTROL COVERS - BONDING, UPPER AND LOWER

MODELS AFFECTED: Model 269B Helicopter Serial Nos. 0001 through 0454

TIME OF COMPLIANCE: Shall be accomplished within next 100 hours of helicopter operation, unless already accomplished.

PREFACE:

The information given in this Service Information Notice lists a procedure for bonding P/N269A4027 upper control cover to P/N269A4880 lower control cover to obtain a one-piece control cover assembly. The new one-piece configuration is designed to (1) facilitate proper installation of cover, and (2) maintain proper position of cover when center seat is occupied, ensuring adequate clearance and freedom between cover and throttle controls during flight.

Reference

269B Handbook of Maintenance Instruction, Revised 1 July 1968

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfgr.</u>
Kit-Control Covers, Bonding, Upper and Lower	M10033-1	1	HTC-AD

Tools & Equipment

Gun, rivet	Commercial
Drill motor, portable	Commercial
Bit, drill - #41 (0.096/0.100 dia.)	Commercial
Bit, drill - (0.217/0.229 dia.)	Commercial
Clamp - C-clamp or equivalent	Commercial

Materials

Solvent - methylethylketone or equivalent	Commercial
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PROCEDURE

- a. Remove center seat cushion and seat back cushion, if installed.
- b. Remove upper and lower control covers.
- c. Using solvent, clean bonding surfaces of upper and lower control covers.
(See Figure 1.)
- d. Position and bond -3 and -5 spacers to inside front edge of lower control cover as shown.
- e. Position and bond lower cover and spacers to upper cover; maintain 5 to 15 psi pressure with C-clamps; air dry at 80°F or higher for 24 hours.
- f. Drill four #41 (0.096/0.100 in.) diameter holes through sides of upper and lower covers, as shown.
- g. Install pop rivets and washers.

NOTE

Pop rivet with washers on inside and outside are used for clamping and added strength.

- h. Drill 0.217/0.229 in. diameter hole in lower RH side of upper cover assembly, per dimensions shown.
- i. Position cover assembly on aircraft; drill 0.217/0.229 in. diameter hole in P/N269A2105-3 angle in line with hole in upper cover, per step h.; remove cover assembly.
- j. Notch out edge of upper cover assembly to dimensions shown; install nut clip on cover.
- k. Reinstall control cover assembly, using existing hardware.
- l. Install upper cover to -3 angle, using screw, -7 spacer and washer.
- m. Check control cover rework for discrepancies.
- n. Reinstall center seat cushion and seat back cushion, where previously installed.
- o. Perform operational check of flight controls per HML.

WEIGHT AND BALANCE DATA

Weight and balance not affected.

DRILL #41 HOLE (.096-.100 DIA) AD32AES POP RIVET
 AN960PD3 WASHER 2 REQD 3 PLACES

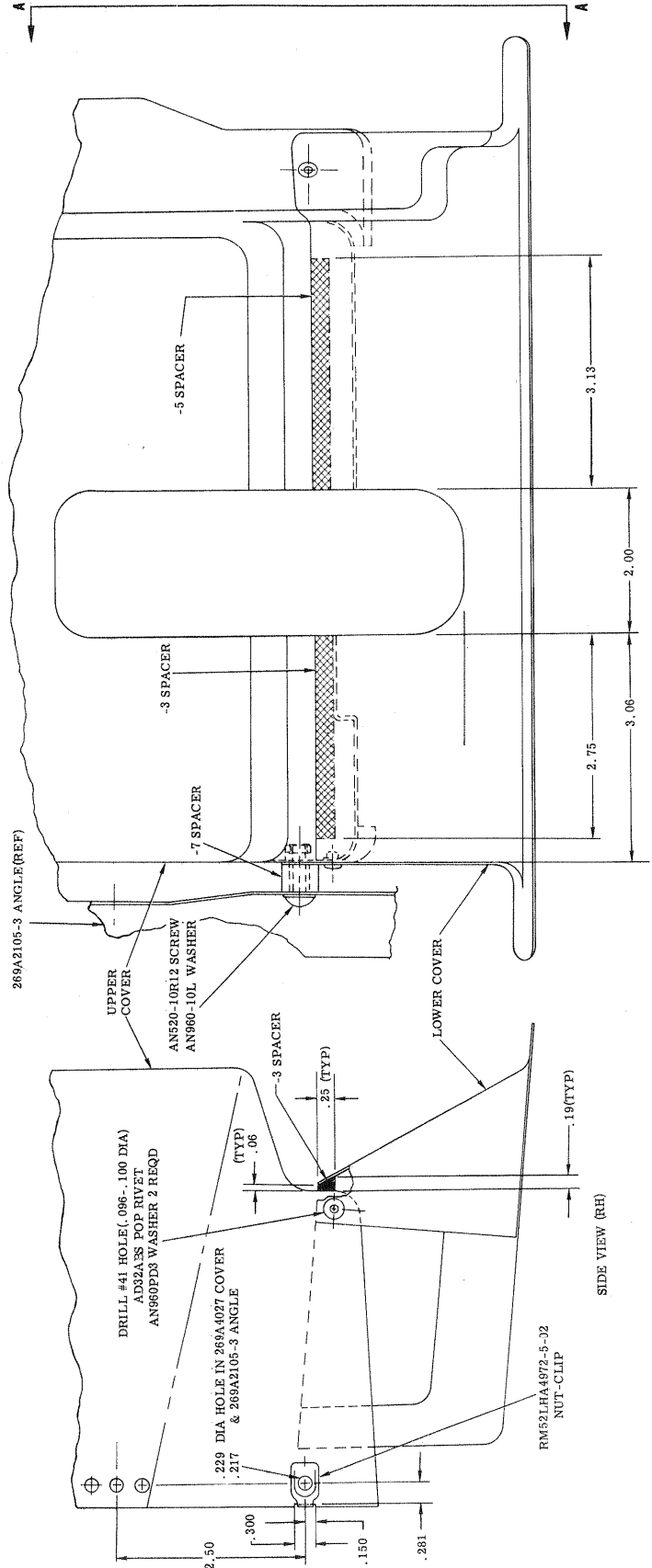
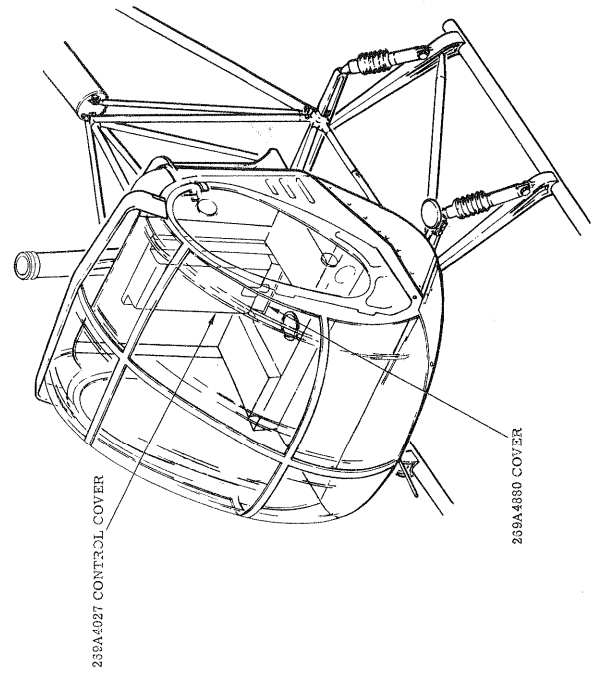
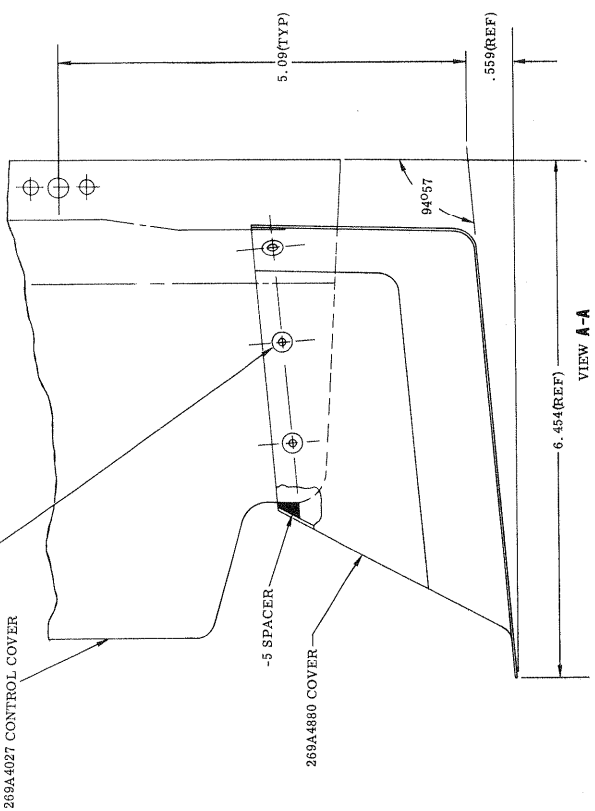


FIGURE 1. CONTROL COVERS-BONDING, UPPER AND LOWER