



SCHWEIZER SERVICE NOTICE

NOTICE NO. N-82.3*

DATE 19 Sept 1977

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*Supersedes Service Information
Notice No. N-82.2

dated 1 September 1976

MANDATORY

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SUBJECT: INSPECTION - TAILBOOM CENTER ATTACH FITTING (PN 269A2324),
AND CENTER FRAME AFT CLUSTER FITTINGS (PN 269A2234 AND
269A2235)

MODELS AFFECTED: All 269A, TH-55A, 269A-1 and 269B helicopters equipped
with subject fittings
269C helicopter Serial No. 0004 through 0569 equipped with
subject fittings

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

Step II - DYE PENETRANT INSPECTION shall be accom-
plished at next scheduled 200-Hour periodic
inspection, and at every 200-Hour periodic
inspection thereafter.

PREFACE: The information given in this Service Information Notice lists a procedure
for daily and periodic inspections to determine the structural integrity of
the subject 269A2324 tailboom center attach fitting, and 269A2234 (LH)
and 269A2235 (RH) center frame aft cluster fittings. Refer to Hughes
Service Information Notice No. N-109.2 for inspection and replacement of
269A2015 and 269A2015-5 tailboom support strut aluminum end fittings.

It is noted that the upgraded 269A2324-7 center attach fitting, and
269A2234-3 and 269A2235-3 aft cluster fittings are NOT subject to this
Notice. These fitting configurations are designed with lugs having increased
thickness, making them less susceptible to cracks and structural damage.
All 269C helicopters are factory equipped with the 269A2324-7 center attach
fitting. In addition, 269C helicopter Serial No. 0500 and subsequent are
factory equipped with the 269A2235-3 (RH) aft cluster fitting. 269C helicop-
ter Serial No. 0570 and subsequent will be equipped with the 269A2234-3 (LH)
aft cluster fitting. The upgraded center attach fitting and aft cluster fitting
configurations are to be field installed on all other 269 Series helicopters
when replacement of the Basic fitting configurations are required.

Step III of this Notice provides weld repair criteria for cracks in flange
area of aft cluster fittings.

An FAA Airworthiness Directive is to be issued in conjunction with this
Notice.

(I) Denotes portion of text added or revised.

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Reference

269 Series - Basic HMI, Issued 1 April 1973; Revision No. 4, 15 December 1976
269 Series - HMI Appendix B, Issued 1 July 1973; Revision No. 5, 1 August 1976
Hughes Service Information Notice No. N-109.2, dated 1 September 1976

TOOLS AND EQUIPMENT

Magnifying glass 10X	Commercial
Heliarc welding equipment	Commercial
Rotary file	Commercial

MATERIALS

Kit, dye penetrant: Spotcheck (MIL-I-25135)	Peabody Testing - Magnaflux Los Angeles, CA
Tracer-Tech (MIL-I-25135) or equivalent per MIL-I-25135	Uresco, Inc. Downey, CA
Solvent, methylethylketone (MEK) or equivalent grease-free solvent	Commercial
Paint stripper, acid fortified (for epoxy paint)	A202 - Cee Bee Chemical Co. or equivalent
Primer, zinc chromate	Commercial
Paint, epoxy enamel, color match (optional)	Commercial
Weld patch plate, 4130 sheet metal stock, condition "N", 2.00 x 1.50 x 0.093 (± 0.010) inches	Local fabrication

Step I - VISUAL INSPECTION (daily)

a. Without disassembly, visually inspect 269A2324 tailboom center attach fitting, and 269A2234 (LH) and 269A2235 (RH) center frame aft cluster fittings, for cracks, deformation or damage.

CAUTION

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

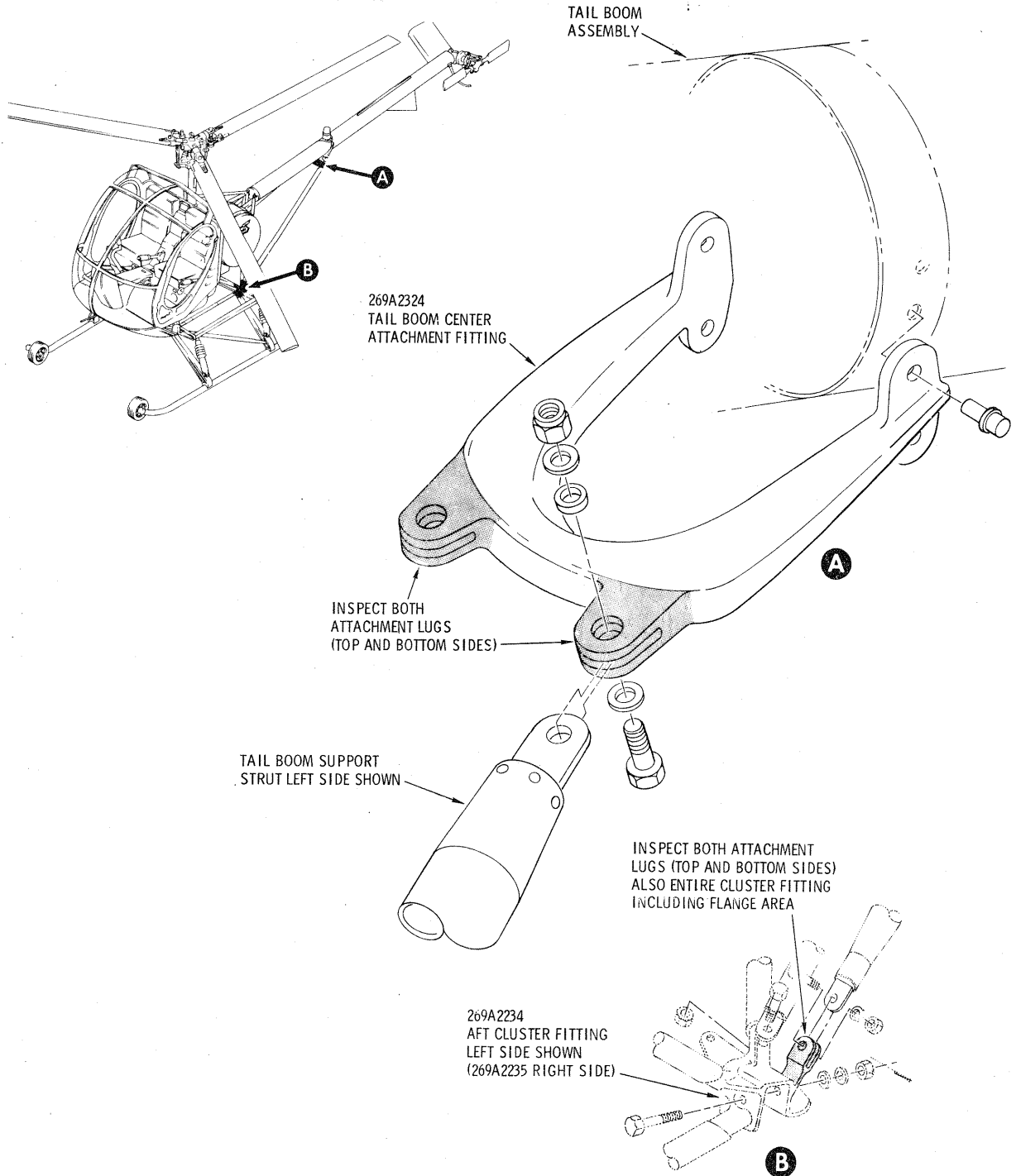


Figure 1. Inspection - tailboom center attach fitting, and center frame section aft cluster fittings

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Step II - DYE PENETRANT INSPECTION (200 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.

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 face mask when handling stripper.

NOTE

Where installed (see Preface), the tailboom center attach fitting (269A2324-7) and aft cluster fittings (269A2234-3 and 269A2235-3) do NOT require paint removal and dye check, unless cracking, deformation or damage is suspected.

b. Using acid fortified paint stripper, remove finish paint coat from attachment lugs of the 269A2324 tailboom center attach fitting, and from the 269A2234 (LH) and 269A2235 (RH) center frame aft cluster fittings. Wash with water and dry.

c. Apply dye penetrant solution to attach lugs of tailboom center attach fitting, and to center frame aft cluster fittings. Using 10X magnifying glass, inspect for cracks and other structural damage. (See Figure 1.)

d. Immediately retire from service and tag as unserviceable any tailboom center attach fitting found to have cracks or other structural damage. The 269A2324-7 center attach fitting MUST be used for replacement.

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

e. Immediately retire from service and tag as unserviceable any aft center frame cluster fitting found to have unrepairable cracks or other structural damage. The 269A2234-3 and/or 269A2235-3 aft cluster fittings MUST be used for replacement where required.

NOTE

Refer to Step III of this Notice for weld repair criteria for cracks occurring in flange area of aft center frame cluster fittings. Only cracks in the flange area on outboard side of fitting may be repaired. Cracks in any other area require fitting replacement per Step II. (See Figure 1.)

f. Remove dye penetrant solution from attach lugs of tailboom center attach fitting and from aft cluster 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 closely 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.

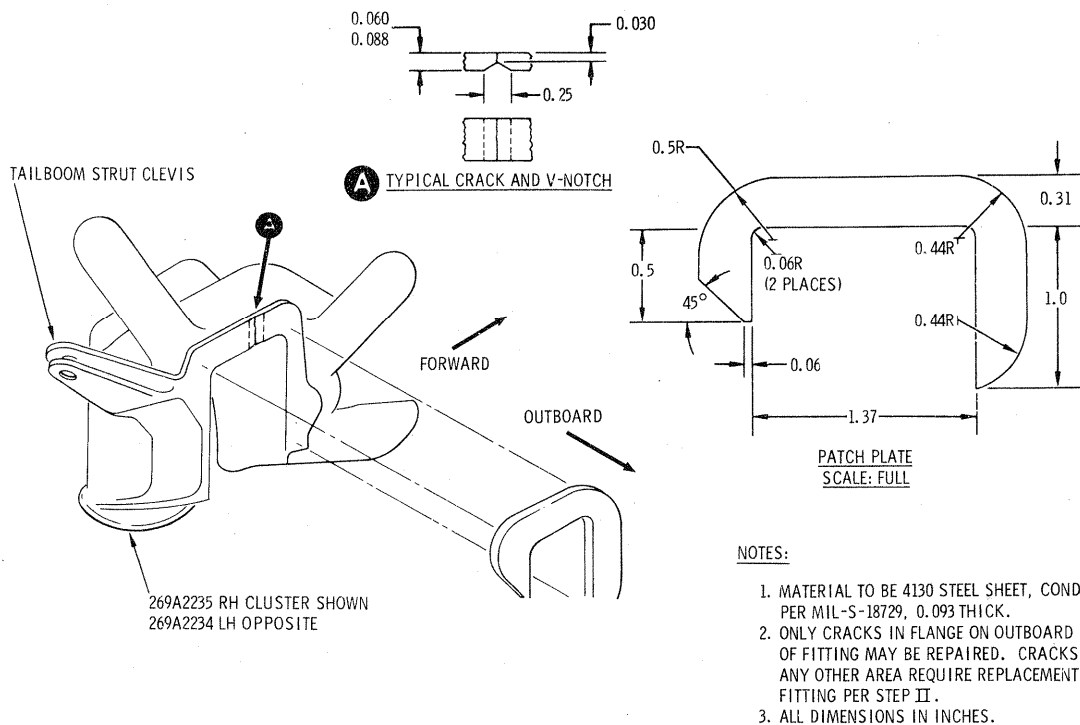
j. Record compliance with this Notice in Compliance Record of helicopter Log Book.

Step III - WELD REPAIR, AFT CENTER FRAME CLUSTER FITTINGS

CAUTION

1. Weld repair or fitting replacement must be accomplished prior to next flight.
2. Prior to weld repair, remove fuel tank, battery and starter relay; also disconnect aft cross beam from cluster fitting. (Refer to Basic HMI.)

a. Remove dye penetrant solution from cluster fitting and wipe fitting with MEK solution.



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Figure 2. Weld repair of aft center frame cluster fittings

b. Rotary file a "V" notch in crack area as shown in Figure 2; locally fabricate a "cluster" patch plate per dimensions shown in Figure 2, and weld in accordance with FAA AC 43.13-1A, Section 2 and MIL-W-8611. The patch plate weld must be airtight to prevent accumulation of moisture.

c. Zinc chromate and repaint cluster fitting and repaired area. Color match as close as possible; apply finish coat in accordance with paint manufacturer's instructions.

d. Reassemble and reinstall removed components per Basic HMI.

e. Continue daily and periodic inspections of cluster fittings per Step I and Step II of this Notice.

WEIGHT AND BALANCE DATA

Weight and balance not affected.

FAA APPROVED