



**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. N-96

DATE October 8, 1971

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FAA APPROVED

SUBJECT: MODIFICATION - CENTER BACK CUSHION
ASSEMBLY, P/N 269A4042

MODELS AFFECTED: Model 269C Helicopter Serial Nos. 0004 thru 0050

TIME OF COMPLIANCE: Shall be accomplished within next 100 hours of
helicopter operation

PREFACE: The information given in this Service Information Notice
lists a procedure for modifying the subject center back
cushion assembly to preclude any possible interference
between the cushion back support and the bolt attaching
the lower collective control rod to the collective pitch
mixer ballecrank.

Reference

269 Series - Basic Handbook of Maintenance Instructions, Revised 1 August 1971

269 Series - Configuration Supplement C, Revised 1 August 1971

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

MATERIALS

| | | |
|-----------------|---|--|
| Fabric Material | Woven Glass, Finished | Commercial Type 181; MIL-C-9084 Type VIII |
| Cement | Resin, Polyester - Low Pressure Laminating | Commercial: MIL-R-9300 Type I |
| Solvent | Naptha or MEK | Commercial |
| Abrasive Paper | Fine | Commercial |
| Wax Paper | | Commercial |

TOOLS & EQUIPMENT

| | |
|--|------------|
| Brush | Commercial |
| Spatula | Commercial |
| Gloves - Lint-Free; Cloth, Rubber or Nylon | Commercial |

PROCEDURE

- a. Remove center back seat cushion assembly.
- b. Modify existing -27 back support on center back cushion by cutting out area, per dimensions shown in Figure 1.
- c. Fabricate and install four-ply reinforcement doubler to center back support as follows:
 1. Using solvent and clean cloth, remove dirt and other foreign materials from faying surface of back support.
 2. Lightly abrade faying surface of back support; wipe dust from back support.
 3. Cut four layers of fiberglass material to shape as a doubler to cover cutout in back support; allow sufficient material to form depression or pocket as shown.

NOTE

When handling glass cloth, wear lint-free gloves.

4. Using brush or equivalent, apply cement (resin mixed with catalyst, as required) to faying surface of back support.
5. Position fiberglass layer to cover cutout in back support as shown. Press firmly into place, using wood block wrapped in wax paper or equivalent to help form depression or pocket in doubler. Continue adding fiberglass layers and cement until a four-ply doubler is fabricated.
6. Slowly wipe air and excess cement out of laminates, using spatula or hand. Continue wiping process until all entrapped air has moved past edges of laminates and impregnated plies are firmly pressed together.

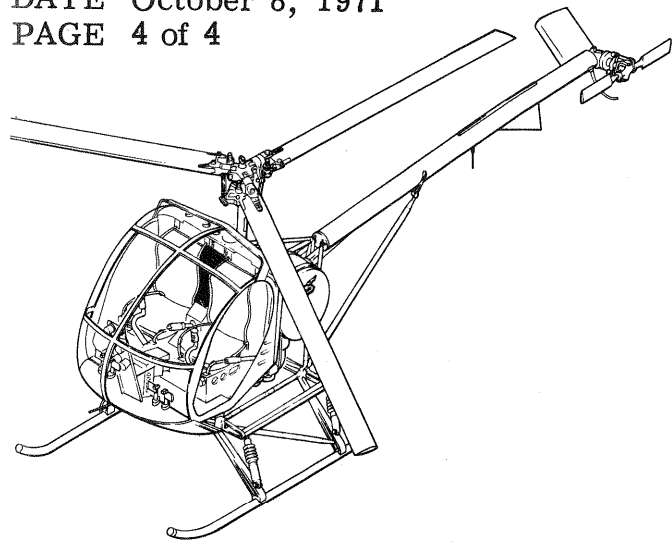
NOTE

Wiping should not be carried out to point of cement (resin) starvation.

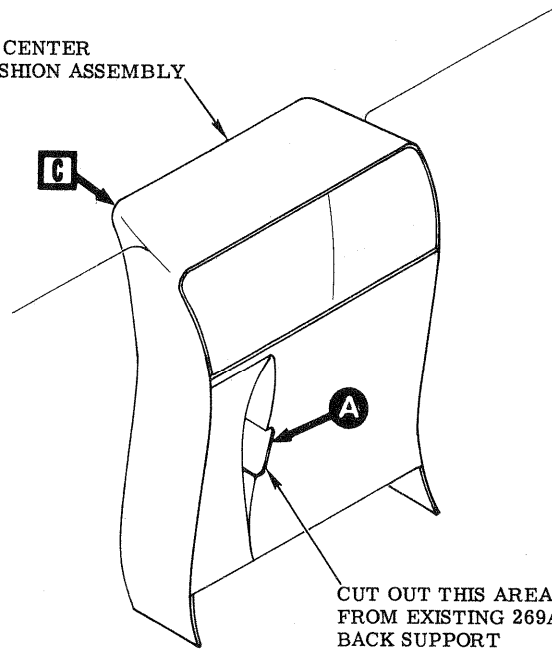
- d. Install center back cushion assembly; check for adequate clearance between fiberglass doubler on back support and collective control rod attaching hardware.
- e. Record compliance with Service Information Notice in Compliance Record of Helicopter Log Book.

WEIGHT AND BALANCE DATA

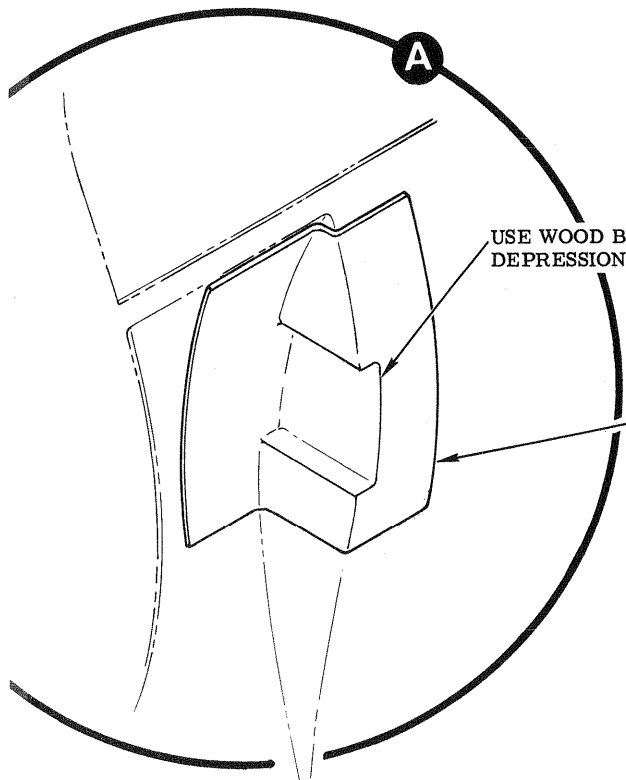
Weight and balance not affected.



269A4042 CENTER
 BACK CUSHION ASSEMBLY

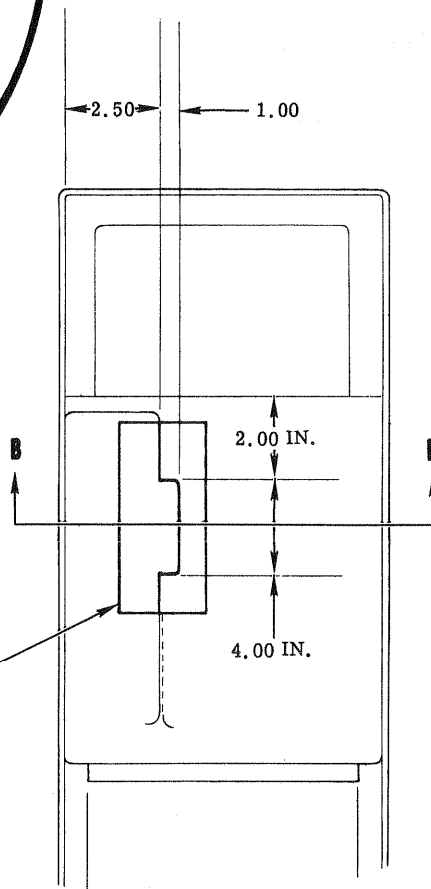


CUT OUT THIS AREA
 FROM EXISTING 269A4042-27
 BACK SUPPORT



USE WOOD BLOCK TO HELP FORM
 DEPRESSION OR POCKET IN DOUBLER

MAKE REINFORCING DOUBLER FROM
 FIBERGLASS LAMINATES



REINFORCING DOUBLER

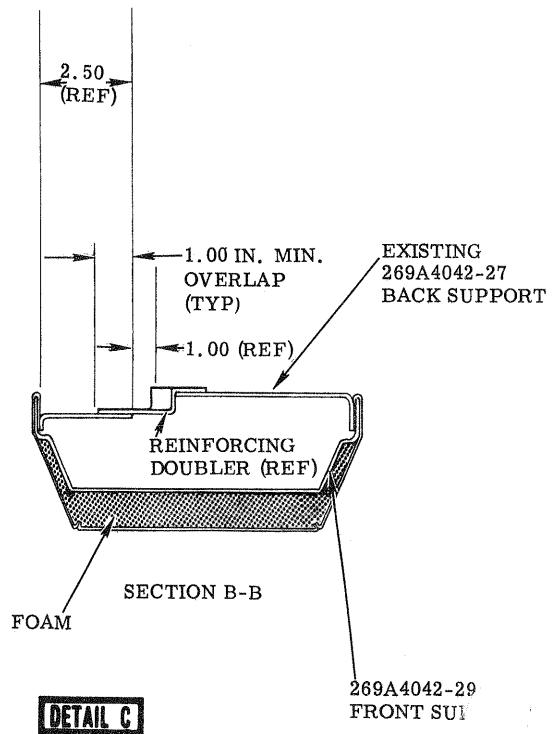


FIGURE 1. MODIFICATION OF CENTER BACK CUSHION ASSEMBLY, P/N 269A4042