

**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. HN-67

DATE 15 April 1974

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SUBJECT: CORROSION PREVENTION/INSPECTION - MAIN ROTOR BLADE
PN 369A1100-501 BLADE TIP WEIGHT AREA AND TIP CAP

MODELS AFFECTED: All 369H Series Helicopters equipped with subject part number main rotor blades; main rotor blades delivered as spares replacement.

Factory equipped helicopters and spare main rotor blades affected will have serial numbers prior to SN V-129. Please note prior blades may have all "Numeral" serial numbers or may be prefixed with a alpha character "A" through "V".

TIME OF COMPLIANCE: At owners/operators descretion.

PREFACE: This Service Information Notice lists a procedure to seal the tip weight to blade skin interface to prevent intrusion of corrosion causing substances at the blade to tip interface. Further a 100 hour inspection is recommended to detect corrosion causing conditions in their early stages and to verify integrity of sealant coating.

REFERENCE

369 Series - Basic HMI issued 1 October 1972 and Revised (Revision#3) 1 January 1974

MATERIALS

| | | |
|--|-----------|--|
| *Isopropyl Alcohol | | Commercial |
| **Paint Silicone | QR-4-3117 | Dow Corning Corp |
| **Primer | 1203 | Dow Corning Corp |
| **The following specific alternates may be used: | | |
| Paint Silicone | RTV615 | General Electric Corp |
| Primer | SS 4155 | General Electric Corp |
| <u>Release Agents</u> | | |
| *MS122 | | Miller Stephenson Chem Co Danbury, Conn |
| *GS-3 | | Ram Chemical Co Gardena, Ca |
| *Frecote-35 | | Frecote Inc Boca Raton, Fla |
| *WD-40 | | WD-40 Co San Diego, Ca |
| *Knockerloose | | K & W Products Santa Fe Springs, Ca |
| *Braycot 154 | | Bray Oil Co Los Angeles, Ca |

*Materials specified are primary selections; any equivalent material may be used as an alternate selection.

TOOLS AND EQUIPMENT

Paint application equipment brush or spray (at operators option).

PROCEDURE

Part I.

The main rotor blades may be removed from the helicopter if desired.

- Remove main rotor blade tip caps from four blades.
- Using penetrating oil, apply oil to blade tip weight area.

NOTE

Penetrating oil will arrest any corrosive products between blade skin and weight assembly.

- c. Using Isopropyl Alcohol, brush and clean cloth, thoroughly clean blade tip weight area and blade tip cap. Dry with clean cloth.

NOTE

Prevent contamination of cleaned parts.

- d. Using a release agent coat lightly inner surface of tip cap.
- e. Using brush or spray method apply a 1 mil coat of primer to blade tip weight area, making sure to treat joint between blade skin and tip weight housing; allow primer to air dry at least 1 hour.
- f. Apply thin film of paint to primed area.

NOTE

Mask as necessary when performing Steps e and f.
Allow at least 2 hours paint cure time for a tack free surface. Complete cure will be achieved in 18 to 24 hours.

- g. Install tip caps on blades.
- h. Perform Steps a through g on blade in spares inventory.
- i. Reinstall main rotor blades, if removed.
- j. Record compliance with this Service Information Notice in Compliance Record of Helicopter Log Book.

WEIGHT AND BALANCE DATA

Weight and balance not affected.

Part II.

- a. It is recommended that at each 100 hours of operation a visual inspection of the tip area of main rotor blades be performed. Inspect for evidence of corrosion, pay particular attention to mating area of blade skin to tip weight interface, verify integrity of sealant coating.