

# TECHNICAL BULLETIN

DATE: 21 APRIL 1970

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## INSTALLATION – DUAL BOLT, LOWER VERTICAL STABILIZER

### 1. PLANNING INFORMATION

#### A. MODELS AFFECTED:

All 369H Series Helicopters with single attach bolt securing lower vertical stabilizer to gearbox mounting frame.

#### B. PREFACE:

The information given in this Service Information Notice lists a procedure for installation of a second bolt to ensure positive attachment of the lower vertical stabilizer to the Gearbox mounting frame. Special alignment tools will be provided on a loan basis by HTC-AD to help accomplish field retrofit.

#### C. TIME OF COMPLIANCE:

At owners and operators discretion

#### D. REFERENCE:

500 Series – Basic Handbook of Maintenance Instruction, Revised 1 November 1969

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## E. TOOLS AND EQUIPMENT:

TOOLS AND EQUIPMENT		
Nomenclature		Source
Tool, alignment	M30210-80901	HTC -AD
Tool, alignment	M30210-80902	HTC -AD
Drill motor - portable		Commercial
Drill bit - #9/32 (0.2812 in. dia.)		Commercial
Tool, spotface - 0.750 in. dia. with 0.2812 in. pilot		Commercial
Wrench, torque - 0 to 500 in. lb. range		Commercial

## F. MATERIALS:

MATERIALS		
Nomenclature		Source
Primer, zinc chromate		W.P. Fuller or equivalent
Paste - zinc cromate		W.P. Fuller or equivalent

## G. PARTS LIST:

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Bolt	NAS1304-34	2	Commercial
Nut	MS21045L4	2	Commercial
Washer	AN960-416L	4	Commercial
Spacer	369A2202	2	HTC-AD

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## 2. ACCOMPLISHMENT INSTRUCTIONS

- a. Remove lower vertical stabilizer, per HMI
- b. Attach hole alignment tool (M30210-80902) to gearbox mounting frame post; secure tool with pin in existing attachment holes. (See figure 1)
- c. Drill 0.2812 in. dia. holes in post; remove alignment tool.
- d. Attach hole alignment tool (M30210-80901) to stabilizer firing; secure tool with pin in existing attachment holes.
- e. Drill 0.2812 in. dia. holes through stabilizer skin (LH and RH sides) and skid tube; remove alignment tool.
- f. Using spotface tool or equivalent, carefully enlarge pilot holes in stabilizer skin to 0.750 in. dia. (LH and RH sides) to provide clearance for new attachment bolt and nut. Apply zinc chromate primer to raw edges.



Do not allow spotface tool to contact surface of attach fitting (tube) inside skin.

- g. Apply coating of zinc chromate paste on gear box mounting frame post.
- h. Position lower vertical stabilizer on post; check alignment of upper and lower attachment holes.
- i. Install NAS1304-34 bolt, AN960-416L washers and MS21045L4 nut at upper attachment holes. Direction of bolt head is optional. Torque nut to 90 to 110 inch-pounds.
- j. Install NAS1304-34 bolt, AN960-416L washers, 369A2202 spacers and MS21045L4 nut at lower attachment holes. Direction of bolt head is optional; nut facing aft, however, makes torquing easier. Torque nut to 90 to 100 inch-pounds.

**NOTE:** Install 369A2202 spacers so that concave end of spacers is flush against convex side of stabilizer skid tube.

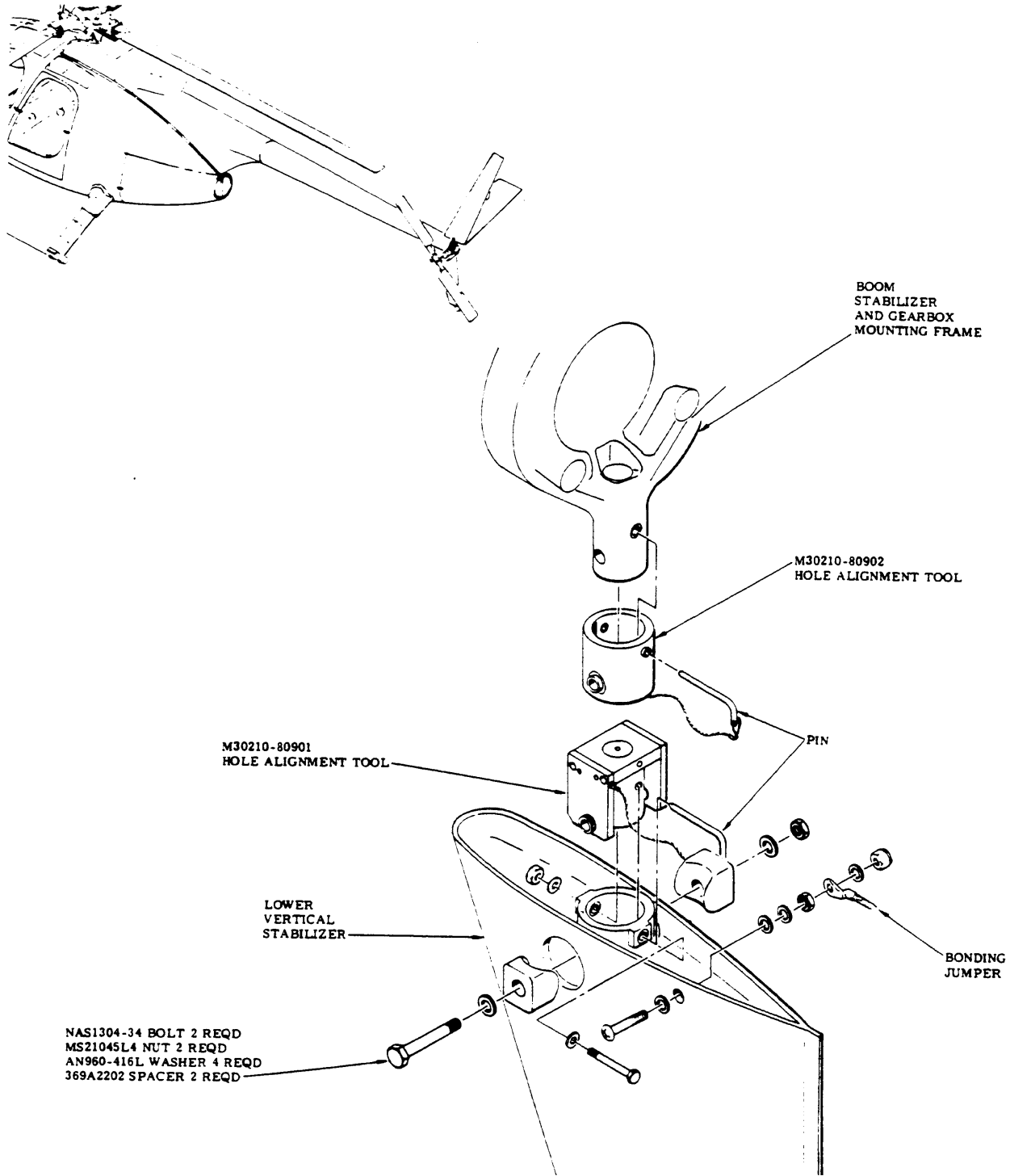
- k. Install bonding jumper
- l. Check dual bolt installation for discrepancies.

### NOTE:

1. When replacing the lower vertical stabilizer assembly, order part number 369A3650-605. This stabilizer configuration incorporates the P/N 369A3655-601 skid tube assembly which is predrilled to accommodate the dual bolt installation.
2. When replacing the fuselage structure boom assembly, order part number 369A3500-505. This boom configuration incorporates the P/N 369A3503-9 stabilizer and gearbox mounting frame which is predrilled to accommodate the dual bolt installation.

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**Figure 1. Installation - Dual Bolt, Lower Vertical Stabilizer**