



SERVICE BULLETIN

DATE: 18 JUNE 1976

PAGE 1 OF 2

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INSPECTION - TAIL ROTOR PITCH CONTROL LINK ASSEMBLIES, PN 369A1807 BASIC AND 369A1807-5

1. PLANNING INFORMATION:

A. Models Affected:

Part I - All 500 Model 369H Series Helicopters

Part II - The following helicopters equipped with PN 369A1807 Basic Tail Rotor Pitch Control Link Assemblies:

369H Helicopter Serial No. 0001H thru 0005H

369HE Helicopter Serial No. 0101E thru 0215E

369HM Helicopter Serial No. 000 1 thru 0004; 0005M thru 0281M

369HS Helicopter Serial No. 0001S thru 0752S; 0754S; 0758S; 0761S thru 0764S; 0770S thru 0772S; 0775S; 0776S; 0785S; 0788S

B. Time of Compliance:

Part I - Shall be accomplished at each scheduled 300-Hour Periodic Inspection Interval

Part II - Shall be accomplished, as applicable, within next 25 hours of helicopter operation, or at next 100-Hour Periodic Inspection, whichever is sooner.

C. Preface:

Part I of this Service Information Notice lists a procedure for a 300-Hour Periodic Inspection of the subject tail rotor pitch control link assemblies, to check for condition and wear.

Part II of this Notice provides instructions for a one-time check of the bearings installed in the subject PN 369A1807 Basic pitch control link assemblies only, to determine if replacement of the pitch link assemblies is required. PN 369A1807-5 pitch link assemblies are NOT applicable to Part II of this Notice.

The periodic inspection data listed in Part I of this Notice is to be considered a part of the HMI and will be incorporated in the next scheduled revision to the below referenced Basic HMI and HMI Appendix B.

D. Reference Publications:

500 Series Basic HMI, Issued 1 October 1972; Revision No. 5, 15 June 1975

500 Series - HMI Appendix B, Issued 1 October 1972; Revision No. 5, 15 June 1975

500 Series - HMI Appendix C, Issued 1 April 1976

2. PART I - 300 HOUR PERIODIC INSPECTION

(1). Remove tail rotor pitch control link assemblies, per Basic HMI and inspect as follows:

(a). Carefully inspect area of link around staked bearings cracks. Scrap link assembly, if any cracks are found.

/// MANDATORY ////////////////////////////////// MANDATORY ////////////////////////////////// MANDATORY ///



DATE: 18 JUNE 1976

PAGE 2 OF 2

SERVICE BULLETIN

/// MANDATORY ////////////////////////////////// MANDATORY ////////////////////////////////// MANDATORY ///

- (b). Inspect for excessive wear at both ends of pitch links (see Figure 1 for wear criteria). Check that wear area is smooth and does not extend into outer race of bearing. Touch up wear area with primer and matching paint finish.
- (c). Inspect staked groove in outer race of bearings for evidence of cracking. No cracks are allowed.
- (d). Record compliance with this Service Information Notice in Compliance Record of helicopter Log Book.

NOTE: Repeated recording of compliance with this Notice in helicopter Log Book will not be required following incorporation of above periodic inspection procedure in HMI Appendix B.

3. PART II - BEARING CHECK AND POSSIBLE PITCH I/LINK REPLACEMENT, PN 369A1807 BASIC ONLY

NOTE: Early type 369A1807 Basic pitch links are equipped with bearings secured by the pressed-lip staking method, which displaces the aluminum link material around the link bore over the edges of the bearing outer race. Bearings staked by this method are NOT replaceable. Current type 369A1807 Basic pitch links are equipped with replaceable bearings secured by staking of the grooved bearing outer race. This method retains the bearing by upsetting (flaring) the edges of the bearing outer race over the chamfered edges of the link bore.

- (1). Visually determine if pitch control links are equipped with replaceable type bearings.

NOTE: Performance of step 2 below not required, if non-replaceable type bearings are installed.

- (2). Remove pitch control link assemblies per Basic HMI; rotate bearing and measure OD of bearing ball. {See figure 1. }

NOTE: If OD of bearing ball is 0. 500 inch, reinstall pitch control link assembly and perform step 3.

If OD of bearing ball is 0. 540 inch, contact HH Customer Service Department. Install new 369A1807-5 pitch control link assemblies provided by HH as replacement for existing link assemblies.

For interim use, existing pitch link assemblies may be reinstalled, if inspection reveals no evidence of cracking of the staked groove in the outer race of bearings. Use bright light and 40X magnifying glass for inspection. If cracking is noted, bearings may be replaced with 269A5050-75 or Kahr KSBG-4N3 bearings, per HMI Appendix C; or spares 269A6091-5 pitch link assemblies may be installed, if available.

- (3). Record compliance with Part II of this Service Information Notice in Compliance Record of helicopter Log Book.

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