



SERVICE BULLETIN

DATE: 8 DECEMBER 1978

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MANDATORY

INSPECTION AND REWORK OF TAIL ROTOR HUB, PN 369A1725 AND 369A1725-5; INSPECTION OF TAIL ROTOR BLADE ATTACHMENT BOLTS, PN MS21250-06040

1. PLANNING INFORMATION:

A. Models Affected:

Part I and Part II:

All 500 Model 369H Series Helicopters.

The following Tail Rotor Hub Assemblies (separate or installed as component of PN 369A1600 Series or PN 369A1620 Series Tail Rotor Assembly) in Spares Inventory at date of this Notice:

All PN 369A1725 Tail Rotor Hub Assemblies

PN 369A1725-5 Tail Rotor Hub Assembly, having Serial Numbers 001 through 862.

PART III:

All 369H Series Helicopters equipped with PN 369A1613-501 or -503 tail rotor blade assemblies.

B. Time of Compliance:

Shall be accomplished at next 100-Hour Periodic Inspection or prior to installation of Spares Assembly on helicopter; or within six months after date of this notice, whichever is soonest.

C. Preface:

Field reports indicate that corrosion pitting in the root radii of the PN 369A1725 and 369A1725-5 rotor hub has occurred in service. Part I and Part II of this Service Information Notice provide instructions for identification and inspection of the hubs affected, and application of a corrosion resistant coating at the radius area between the spindles and center portion of the hub.

Part III of this Notice provides instructions for inspection of PN MS21250-06040 tail rotor blade attachment bolts to determine that the bolt heads are seated properly against the PN 369H5308 bushings.

It is to be noted that PN 369A1700 tail rotor hub made from chrome plated steel is NOT affected by this Notice.

D. Weight and Balance:

Weight and balance not affected.

E. Reference Publications:

500 Series * Basic HMI, Issued I October 1972, Revision No. 7, 15 October 1976

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TOOLS AND EQUIPMENT	
Nomenclature	Source
Magnetic Particle Inspection Kit (MIL-I-6868)	Commercial
Magnifying Glass – 10X	Commercial
Oven, Baking or Heat Lamp	Commercial
Brush, Paint – 1/16 in.	Commercial
Torque Wrench (0–1000 in. lbs.)	Commercial

MATERIAL	
Nomenclature	Source
Coating, Aluminum (Alumazite Z)	HH
Methylethylketone (MEK, TT-M261)	Commercial
Emery Cloth – Medium	Commercial
Emery Cloth – Fine	Commercial
Crocus Cloth – Fine (P-C-458)	Commercial
Primer, Zinc Chromate	Commercial

NOTE: Authorized HH Service Centers may obtain one 4 oz. can of Alumazite Z without costs, if ordered prior to 30 November 1978. Owners/operators may purchase Alumazite Z through HH Service Centers.

2. PART I – HUB IDENTIFICATION

(1). Identify tail rotor hub as follows:

- (a). PN 369A1725-5 hub is identified by part number and serial number on one of two data plates on hub (see Figure 1) and is to be inspected and reworked per Par: II of this Notice, except as noted below.

NOTE: (a) PN 369A1725-5 Tail Rotor Hubs having Serial No. 001 through 862 and identified with either letter "Z" or letters "SP" following hub serial number do NOT require rework for Part II of this Notice.

NOTE: (b) PN 369A1725-5 Tail Rotor Hubs having Serial No. 863 and subsequent do NOT require rework per Part II of this Notice.

- (b). PN 369A1725 hub has silver appearance of stainless steel and is to be inspected and reworked per Part II of this Notice.

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(c). PN 369A1700 hub has gold tint from cadmium plating and is NOT affected by this Notice.

NOTE: (a) If part number and color distinction cannot be determined, remove tail rotor assembly from helicopter, as applicable, and remove tail rotor blade per Basic HMI. Check ID of hub spindles for color as above.

(b) If color of hub and color of ID of hub spindles cannot be determined, inspect and rework the hub per Part II of this Notice.

(2). Record compliance with Part I of this Service Information Notice in Compliance Record of helicopter Log Book; or tag Spares hub assembly and record compliance when assembly is installed on helicopter.

3. PART II – HUB INSPECTION AND REWORK

(1). As applicable, remove tail rotor assembly from helicopter and remove tail rotor blade assemblies, per Basic HMI. Disassemble hub and drive fork assembly, per Component Overhaul Manual (HMI Appendix C).

(2). Clean hub with MEK.

(3). Using 10X glass, inspect hub for cracks, corrosion or other damage. Pay particular attention to area of 0.13 radii between the spindles and center portion of the hub. (See Figure 1.)

NOTE: (1) Indications of cracking are cause for hub rejection, except as noted below.

(a) Minor surface imperfections or discontinuities in the unmachined center of the hub may appear to indicate cracking. This area may be dressed with medium grade emery cloth for minimum material removal to remove the imperfections.

(2) If corrosion or pitting is noted, clean hub surface with fine emery cloth or crocus cloth.

(3) If surface repair was performed in (1)(a) or (2) above clean hub with MEK and reinspect hub with 10X glass. Pay particular attention to 0.13 radius areas on both sides of the hub.

(4) If hub is rejected, contact HH Customer Service Department for disposition.

(4). Magnetic particle inspect hub for cracks per MIL-I-6868. Pay particular attention to 0.13 radius areas on both sides of the hub. If hub is rejected, contact HH Customer Service Department for disposition.

(5). Rework hub as follows, using Alumazite Z:

(a). Shake contents of container thoroughly.

(b). Brush a thin (0.0002 to 0.0005 inch) even coat onto cleaned surface of 0.13 radius areas on both sides of hub. (See Figure 1.) Limit width of aluminum coating to 0.25 inch to prevent contact with feathering bearings.

(c). Allow a flash-off (drying) time of 8 to 10 minutes.

(d). Bake hub for 1 hour at 375' to 425' F in oven or use heat lamps.

(e). Air cool hub.

(6). To denote rework of 369A1725-5 hub, add letter "Z" following serial number on hub data plate; to denote rework of 369A1725 hub, add letter "Z" following part number on tail rotor assembly data plate. (See Figure 1.)

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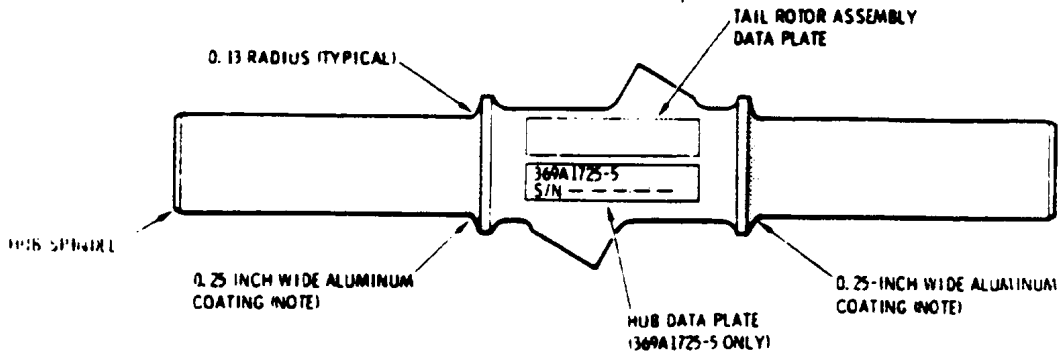
- (7). Reassemble tail rotor hub and drive fork assembly, per Component Overhaul Manual (HMI-Appendix C). Reinstall tail rotor blade assemblies, per Basic HMI.
- (8). Perform Part III of this Notice, if PN 369A1613-501 or -503 Left rotor blade assemblies are installed.
- (9). As applicable, reinstall tail rotor assembly on helicopter per Basic HMI.
- (10). Record compliance with Part II and Part III of this Notice, as applicable, in Compliance Record of helicopter Log Book; or bag Spares hub assembly and record compliance when assembly is installed in helicopter.

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NOTE:
LIMIT WIDTH OF ALUMINUM COATING
TO 0.25-INCH TO PREVENT CONTACT
WITH FEATHERING BEARINGS.

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Figure 1. Rework of Tail Rotor Hub Assembly

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4. PART III – INSPECTION OF TAIL ROTOR BLADE ATTACHMENT BOLTS

- (1). Inspect the two PN MS21250-06040 tail rotor blade attachment bolts for gap between bolt head and PN 369H5308 bushing. No gap is permitted: bolt head must flush against bushing.

NOTE: If gap is noted between bolt head and bushing, replace bolt and bushing. At installation, coat bolt, bushing and washers with unthinned zinc chromate primer. Bolt should have easy snug fit through assembled blade. Install nut and torque to 600 to 650 inch-pounds while zinc chromate primer is still wet.

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