



SERVICE BULLETIN

DATE: 12 SEPTEMBER 1977

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INSPECTION OF PN 369A3511 – 15 AND 369A3511 – 17 TAILBOOM BRACKET ASSEMBLIES, TAIL ROTOR TRANSMISSION ATTACHMENT

1. PLANNING INFORMATION:

A. Models Affected:

All Model 369H Series. Helicopters equipped with 369A3500- 505 Tailboom Assembly having Serial Number listed below. *

All 369A3500-505 Tailboom Assemblies in Spares Inventory having Serial Number listed below.

PN 369A3500-505 Tailboom Assembly Serial No.

44-791 thru 44-798, 25-979 thru 25-999, 54-799 thru 54-803, 35-1000 thru 35-1014, 64- 804 thru 64- 842, 45-1015 thru 45-1036, 84-843 thru 84-866, 65-1037 thru 65-1066, 94-867 thru 94-886, 75-1067 thru 75-1081, 104-887 thru 104-946, 125-1082 thru 125-1101, 114-947 thru 114-968, 16-1102 thru 16-1108, 15-969 thru 15-978

B. Time of Compliance:

Shall be accomplished within next 100 hours of helicopter operation.

C. Preface:

The information given in this Service Information Notice lists a procedure for field inspection and replacement, as required, of the subject brackets installed on the aft end of the tailboom. Field reports indicate that cracks have occurred in the anchor nut incorporated in the bracket assembly, resulting in loss of torque on the tail rotor transmission attach bolt.

The affected tailboom assemblies, installed or in Spares Inventory, are identified by Serial Numbers listed above, and are to be reworked, if required, to install new tailboom brackets.

Order the required parts from your Service Center or Distributor, listing the Serial Number of the helicopter and/or tailboom assembly, and this Service Notice No. HN-111.1. HH will furnish the replacement brackets and attaching hardware.

* The Serial Number of the installed 369A3500-S05 Tailboom Assembly is recorded in the Component Record of the helicopter Log Book.

D. FAA Approval:

FAA APPROVED

E. Weight and Balance:

Weight and balance not affected

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F. Reference Publications:

500 Series – Basic HMI, Issued 1 October 1972 Revision 7, 15 December 1976

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Tailboom bracket assembly	369A3511-15	2	HH
Tailboom bracket assembly	369A3511-17	2	HH
Lockbolt or Visu-Lok Fastener	MS90354-0506 PL7214-5-6	4 4	Commercial
Rivet	MS20470AD4-5	3	Commercial
Rivet	MS20470AD5-5	1	Commercial

TOOLS AND EQUIPMENT	
Nomenclature	Source
Drill motor, portable	Commercial
Drill bit – #30	Commercial
Drill bit – #25	Commercial
Drill bit – #21	Commercial
Ream bit – 0.164/0.163 in. dia.	Commercial
Rivet gun, nose assembly, pulling gun (for lock bolt installation)	Commercial
Nose adapter and wrench adaptor (for Visu-Lok installation)	Commercial
Dental mirror	Commercial
High intensity light source	Commercial

MATERIAL	
Nomenclature	Source
Zinc chromate primer	Commercial

2. PROCEDURE – BRACKET INSPECTION AND REPLACEMENT

- (1). (For installed tailboom assembly only) Remove tail rotor, tail rotor transmission and tail rotor drive shaft assemblies, per-Basic HMI.

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- (2). Using dental mirror and high intensity light, inspect each of the four tail-boom brackets for an identification mark "R" impression stamped on one of the NAS1068A4 nut plate retaining tabs. Check all tabs on each nut plate. (See Figure 1.)



1. If an identification mark "R" is noted on nutplate of any tailboom bracket, replace bracket as follows:

NOTE: Do not confuse scratches, riveting marks, etc. as identification mark. If any doubt exists, replace tailboom bracket.

- (a) Locate and identify existing lockbolt and rivet securing B69A3511-15 or 369A3511-17 bracket to tailboom. (See Figure 1.)

NOTE: MS90354-0506 lockbolts (or Visu- Loks PLT21 4- 5-6) are used to install brackets to 369A3503-5 tailboom frame and 369A3500-23 doublet. An MS20470AD5 rivet is used to install the 369A3511-17 bracket to the -?-3 doublet at the 7 o' clock position, looking forward. MS20470AD4 rivets are used at the other three bracket locations.

- (b) Remove existing lockbolts and rivets securing the tailboom bracket; remove and discard bracket.

- (c) Mate replacement bracket with existing holes in frame and doublet, and install with lockbolts (or Visu-Loks) and rivets as shown with zinc chromate primer.

- (d) For Visu-Lok installation only, predrill holes with #25 drill and ream holes to 0.164/0.163 inch diameter. Torque check (CCW) to 4 inch-pounds maximum; do not over torque.

- (3). As applicable, reinstall tail rotor drive shaft, tail rotor transmission and tail rotor assemblies, per Basic HMI.

- (4). Record compliance with this Service Notice in Compliance Record of helicopter Log Book. Record rework per this Notice of affected serial numbered tailboom assembly in Component Record of helicopter Log Book.

NOTE: For spares tailboom assembly, identify and tag tailboom as reworked per this Notice. At installation of tailboom on helicopter, record compliance with this Notice in helicopter Log Book; and record rework of serial numbered tailboom assembly in Component Record of helicopter Log Book.

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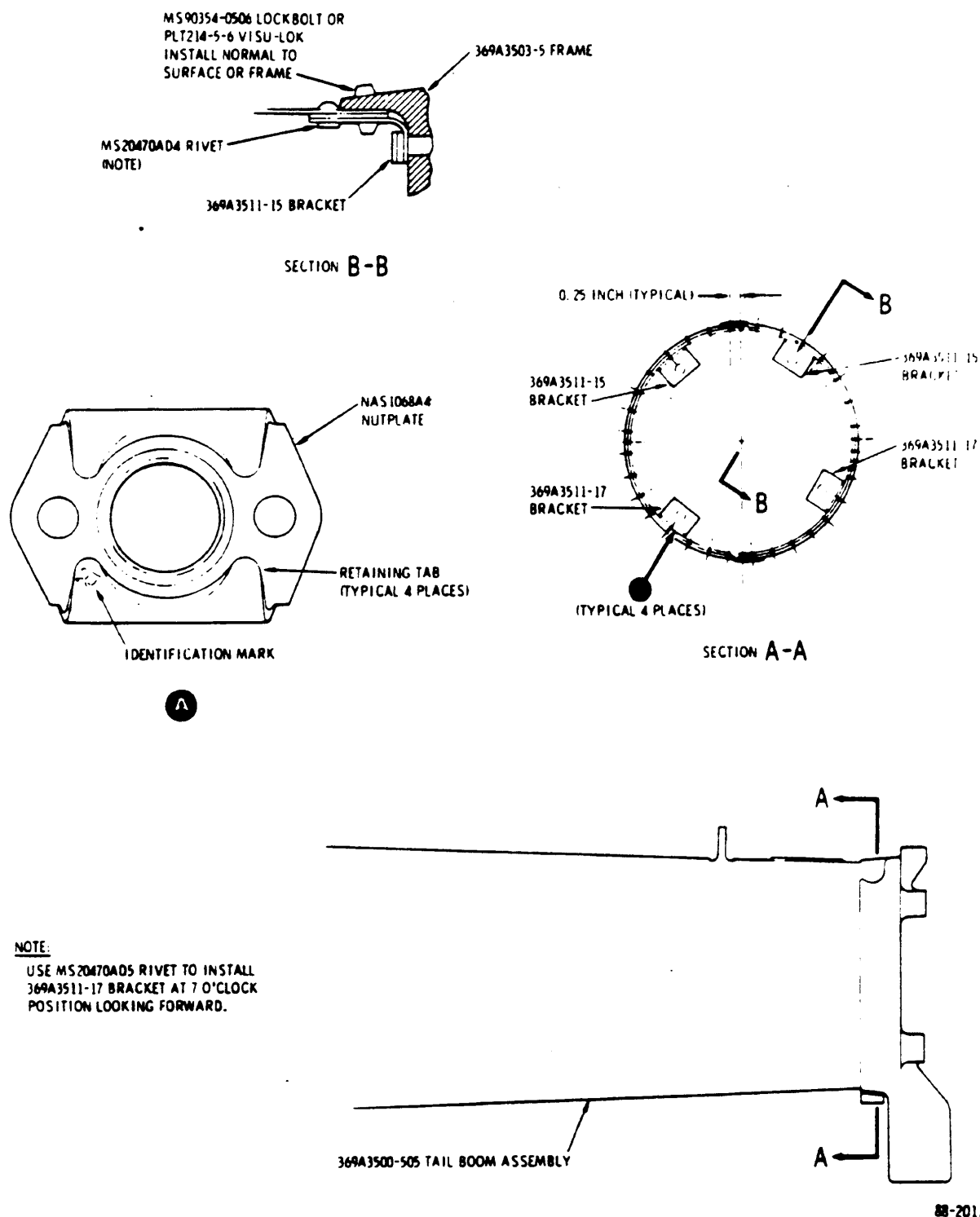


Figure 1. Rework of Tailboom - Replacement of 369A3511-15 and 369A3511-17 Brackets.

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