



SERVICE BULLETIN

DATE: 8 DECEMBER 1969

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M30223 KIT INSTALLATION – MAIN ROTOR LOCKNUT AND RETAINING RING

1. PLANNING INFORMATION

A. MODELS AFFECTED:

369H Helicopter Serial Nos. 0001 through 0005
369HE Helicopter Serial Nos. 0101E through 0104E; and 0107E
369HS Helicopter Serial Nos. 0001S and 0002S; 0101S through 0106S; 0108S and 0114S
369HM Helicopter Serial Nos. 0001 through 0004; 0005M through 0054M

B. PREFACE:

The information given in this Service Information Notice lists a procedure for field modification of the main rotor mast, and installation of a new locknut and retaining ring to ensure positive retention of the main rotor mast nut.

C. TIME OF COMPLIANCE:

- (1) Shall be accomplished within next 100 hours or at next 300-hour inspection, which ever is sooner, for helicopters which have had a main rotor hub removal since delivery.
- (2) Shall be accomplished at next 300-hour inspection, for: helicopters which have not had a main rotor hub removal since delivery.

D. WEIGHT AND BALANCE:

Weight and balance not affected

E. REFERENCE:

500 Series - Basic Handbook of Maintenance Instructions, Revised 1 November 1969

Model 369HM Maintenance Manual Supplement to U.S. Army Model OH6A Maintenance Manuals TM55-1520-214-20 and TM55-1520-214-35, issued 1 April 1968

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F. TOOLS AND EQUIPMENT:

TOOLS AND EQUIPMENT Nut	
Nomenclature	Source
Wrench, torque (369A9934)	HTC –AD
Tool, slotting (369A9820)	HTC –AD
File, square (or equivalent) (9/32 inch)	Commercial
File, round pattern (1/16 inch)	Commercial

G. MATERIALS:

MATERIALS	
Nomenclature	Source
Cloth, crocus	Commercial
Primer, zinc chromate	Commercial
Safety wire (MS20995–N40)	Commercial

H. PARTS LIST:

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Rotor Installation	M30223	1	HTC –AD

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2. PROCEDURE

- a. Remove main rotor blades, main rotor drive shaft, main rotor hub assembly, and main rotor transmission, per reference.
- b. Screw slotting tool (P/N369A9820) on to main rotor mast until it bottoms.
- c. Using 9/32 in. square file. cut slots in mast tube to match slots in tool. See View B, Figure 1.

NOTE: Care should be taken to protect area from filings.

- d. Remove slotting tool and break top and bottom of slots; radius vertical side of slots to dimensions shown, and finish corner radius with 1/16 in. round pattern file or equivalent.
- e. Blend finish with crocus cloth; clean area and apply zinc chromate primer on reworked surfaces.
- f. Reinstall main rotor hub assembly, including new P/N 369A1022 locknut.

NOTE: Torque wrench P/N 369A9934 will have to be hand modified (filed) to increase tang slots symmetrically from 1/4-inch to 5/16-inch.

- g. Torque locknut to 200-foot-pounds.
- h. Install new P/N 369A1023 retaining ring; position keys of retainer in mast slots and check hole alignment.
- i. Increase nut torque, as required, to not more than 250 foot-pounds to obtain proper hole alignment for dual screw installation.

NOTE: If 200 to 250 foot-pound range fails to achieve required hole alignment, invert the retaining ring and repeat the process; also invert locknut, if necessary.

- j. Install two P/N MS35276-261 screws and safety wire.



Do not install washers under screw heads. Check that screw heads are free of burrs.

- k. Place straight edge across upper surface of main rotor hub; check that screw heads project no more than 0.050 inch above hub plane.
- l. Check main rotor mast rework and locknut installation for discrepancies.
- m. Reinstall main rotor drive shaft, main rotor blades and main rotor transmission.
- n. Perform operational check of main rotor drive system.
- o. Record compliance with this Notice in Compliance Record of helicopter Log Book.

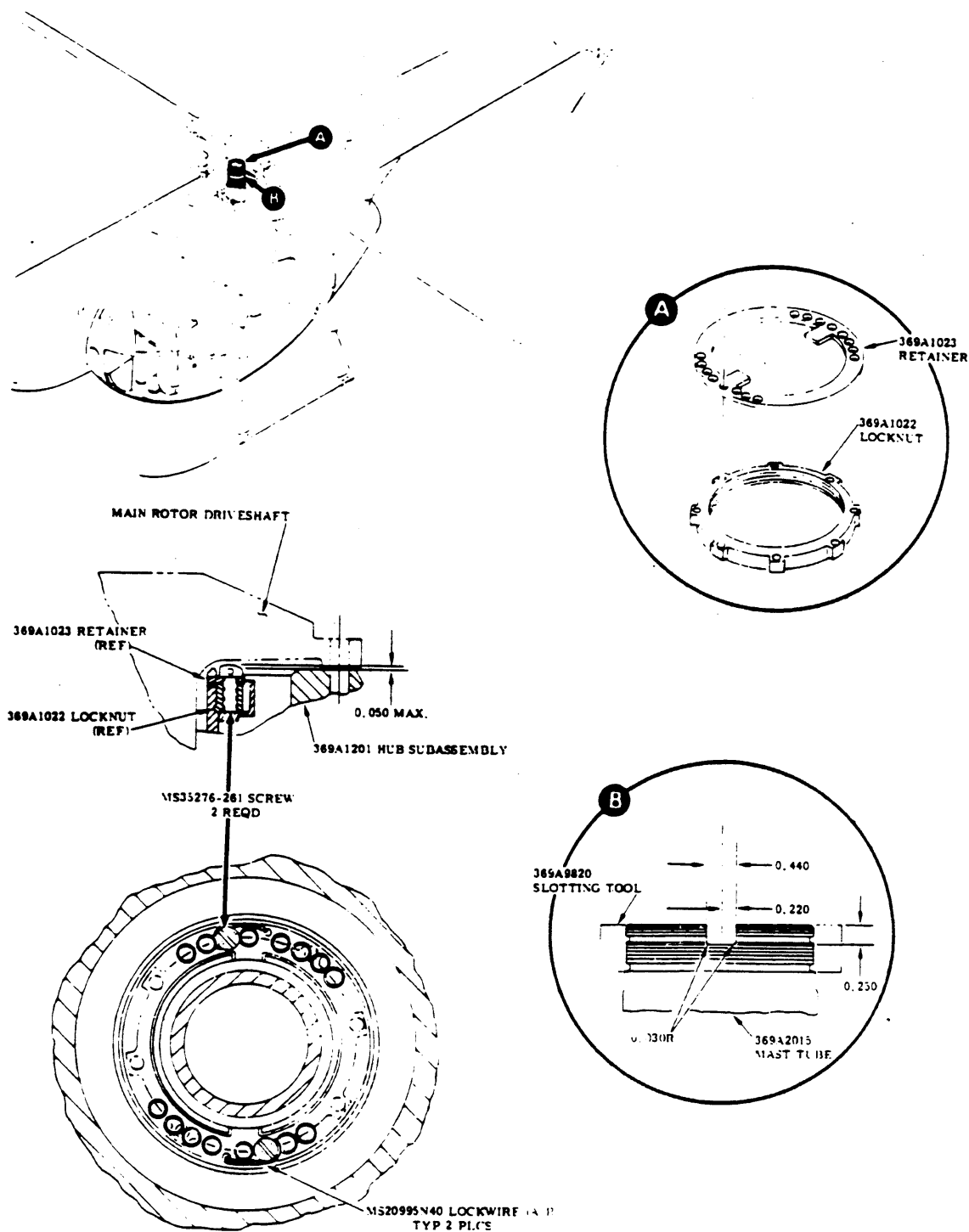
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Figure 1. M30223 Kit Installation - Main Rotor Hub Locknut and Retainer Ring.

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