



# SERVICE BULLETIN

DATE: 28 AUGUST 1981

PAGE 1 OF 4

**/// MANDATORY ////////////////////////////////// MANDATORY ////////////////////////////////// MANDATORY ///**

## MAIN ROTOR BRAKE SYSTEM, PN 369H90123 SERIES— INSTALLATION OF MASTER CYLINDER STOP, PN 369D292585

### 1. PLANNING INFORMATION

#### A. Models Affected:

All Model 369H Helicopters equipped with subject Main Rotor Brake System incorporating 369H92584-501 or -502 Master Cylinder Linkage Assembly

#### B. Preface:

The information given in this Service Information Notice lists a procedure for fabricating and installing a stop device on the rotor brake master cylinder and the actuating lever, to limit the stroke of the cylinder plunger spring, and prevent possible dislocation of a rubber cup inside the cylinder. Field reports indicate that constant bottoming of the spring can dislocate rubber cup causing blockage of the hydraulic fluid feed holes and preventing brake pucks from disengaging from the brake disc. The resultant friction can in turn create heat build up and possible damage to the brake disc caliper assembly.

Dimensions and specifications are provided for field fabrication of the 369D292585 Rotor Brake Lever Stop.

#### C. Time of Compliance:

Shall be accomplished within next 100 hours of helicopter operation, or within 180 days after receipt of this notice, whichever is sooner. Order parts from your authorized HHI Service Center or Distributor upon receipt of this Note.

#### D. Reference:

Model 500 Basic HMI, Issued 15 June 1975; Revision No. 8, 1 December 1980.

Model 500 HMI Appendix A, Revision No. 4, 15 December 1974.

#### E. Weight and Balance Data:

Weight and balance not affected.

#### F. FAA Approval:

FAA/DER Approved.

#### G. Parts/Supplies:

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Stop	369D292585	1	Field Fabricate*
Washer	AN960-516L	6	Commercial
Nut	MS21042-3	1	Commercial

**/// MANDATORY ////////////////////////////////// MANDATORY ////////////////////////////////// MANDATORY ///**

DATE: 28 AUGUST 1981

PAGE 2 OF 4

# SERVICE BULLETIN

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

REPLACEMENT PARTS/SUPPLIES (Cont.)			
Nomenclature	Part No.	Qty.	Source
Pin, cotter	MS24665-170	1	Commercial
Spacer	NAS1057T3-075	1	Commercial
Bolt	NAS1303-16	1	Commercial
*See Figure 2 for dimensions and specifications.			

## H. Tools and Equipment:

TOOLS AND EQUIPMENT	
Nomenclature	Source
Drill motor, portable	
Drill bit – No. 10 (0.190/0.194 in. dia)	

## I. Materials:

MATERIAL	
Nomenclature	Source
Primer, zinc chromate	Commerce

## 2. MODIFICATION PROCEDURE

- (1). Remove linkage cover (Refer to HMI Appendix A).
- (2). Remove master cylinder assembly and 369H92829 actuating lever (Refer to HMI Appendix A).
- (3). Rework actuating lever by drilling 0.190/0.194 inch diameter hole in lever at dimensions shown in Figure 1. Apply zinc chromate primer to reworked area of lever.
- (4). Reinstall master cylinder assembly, with new 369D292585 stop, using new AN960-516L washers and existing nuts and bolts as shown.
- (5). Install NAS1057T3-075 spacer on actuating lever as shown, using NAS1303-16 bolt and MS21042-3 nut.
- (6). Reinstall lever assembly on pin, using existing spring, washer and nut. Secure with new cotter pin.
- (7). Position rotor brake handle at down position; check for contact between new stop and spacer; also check for proper engagement of brake pucks and brake disc.
- (8). Perform inspection and operational check of main rotor brake system per HMI Appendix A.
- (9). Reinstall linkage cover.

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

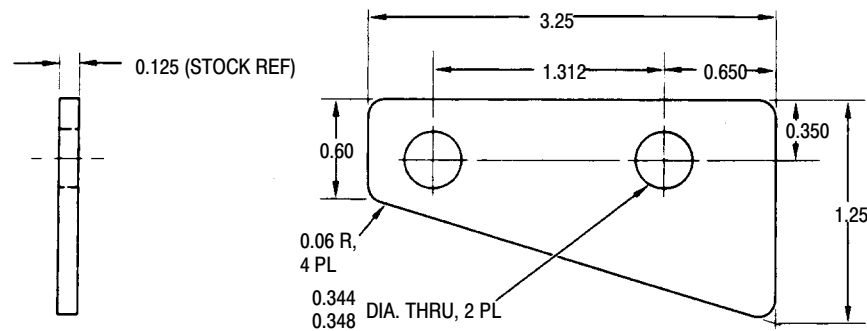
# SERVICE BULLETIN

DATE: 28 AUGUST 1981

PAGE 3 OF 4

MANDATORY MANDATORY MANDATORY

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



## NOTES:

1. MATERIAL 0.125 THICK 7075-T6 OR T651 AL ALLOY SHEET PER QQ-A-250/12.
2. ALTERNATE MATERIAL: 0.125 THICK 2024-T6, T4 OR T3 AL ALLOY SHEET PER QQ-A-250/4.
3. ALL DIMENSIONS IN INCHES.

88-521

**Figure 1. Installation of Rotor Brake Master Cylinder Stop Mechanism**

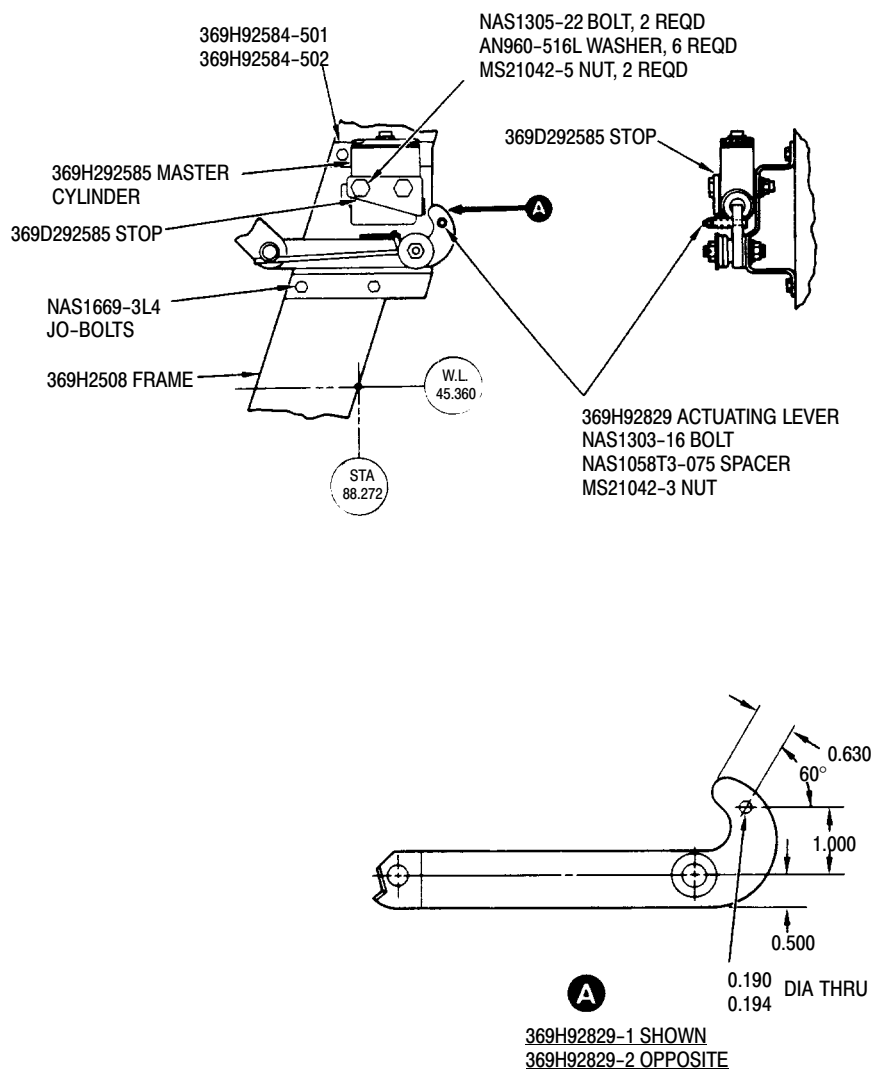
MANDATORY MANDATORY MANDATORY

DATE: 28 AUGUST 1981

PAGE 4 OF 4

# SERVICE BULLETIN

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

**NOTES:**

1. ALL DIMENSIONS IN INCHES.
2. COAT REWORKED AREA WITH ZINC CHOMATE PRIMER.

88-522

**Figure 2. Field Fabrication - 369D292585 Rotor Brake Lever Stop**

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