

**HUGHES
SERVICE INFORMATION
NOTICE**

NOTICE NO. HN-81

DATE 2 Jan 1975

PAGE 1 OF 4

**SUBJECT: MODIFICATION - FUEL CELL VENT SYSTEM INSTALLATION
(MODIFICATION KIT NO. M50042)**

**MODELS AFFECTED: 369HS Helicopter Serial No. 0101S thru 0671S
369HM Helicopter Serial No. 0201M thru 0264M
369HE Helicopter Serial No. 0101E thru 0215E**

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: The information given in this Service Information Notice lists a procedure for modifying the fuel vent system on the above affected helicopters by installing an additional vent tube and fairing assembly to provide alternative venting.

Reference

500 Series - Basic HMI, Issued 1 October 1972; Revision No. 3, 1 January 1974

NOTICE NO. HN-81
DATE: 2 Jan 1975
PAGE: 2 of 4

M50042 PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfr</u>
Doubler	M50042-3	1	Hughes
Tube	M50042-5	1	Hughes
Tee Assembly	369H92110	1	Hughes
Fairing Assembly	369A8128	1	Hughes
Lockwire	MS20995N32	A/R	Commercial
Rivet	MS20426AD3	7	Commercial
Rivet	MS20426AD4	3	Commercial
Tubing, Tygon	F4040	42.0 in.	Norton Plastics & Synthetics Division Akron, Ohio

TOOLS & EQUIPMENT

Drill, portable
Gun, rivet
Drill bit - No. 30
Drill bit - No. 41
Drill bit - No. 13/16 (0.81 in. dia)
Saw, metal cutting

MATERIALS

Adhesive (epoxy), nonstructural	EA9309 or EA9314 (A & B)	HySol Div., Dexter Corp. Pittsburg, PA
Adhesive (alternate)	EC1828	3M Company

MODIFICATION PROCEDURE

- a. Drain sufficient fuel to prevent spillage when fuel vent is removed; remove forward fuel vent system, per Basic HMI.
- b. Cut off 2.5 inches from lower end of existing 3698131-3 vent tube.
(See Figure 1.)
- c. Install new 369H92110 tee assembly into flared tube of existing fairing assembly.

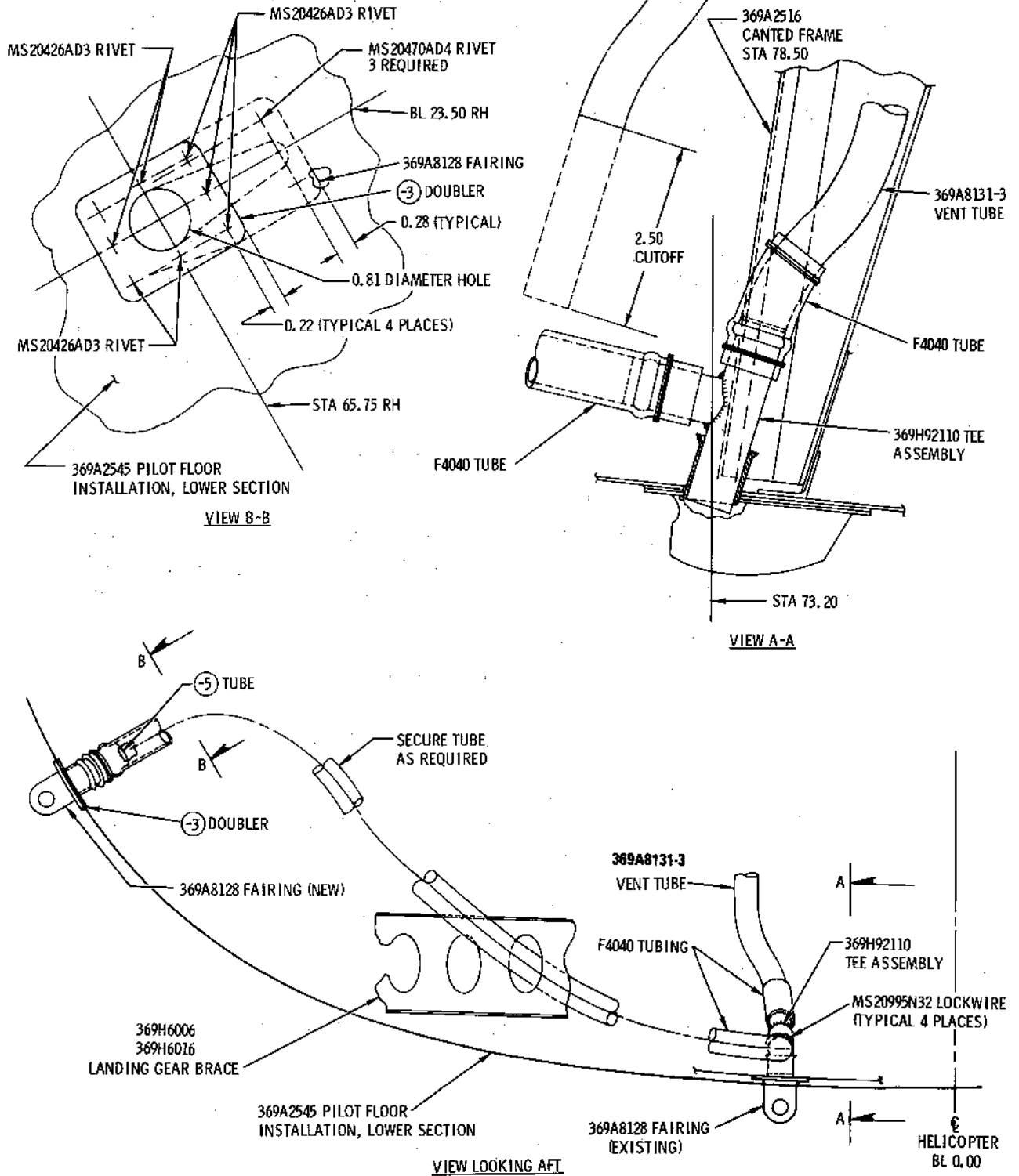


Figure 1. Modification - Fuel Cell Vent System Installation (M50042)

- d. Connect shortened 369A8131-3 vent tube and new tee assembly with appropriate length of F4040 tubing. Secure plastic tubing two places with lockwire as shown, using double wrap of lockwire that ends with at least five full twists.
- e. Drill 0.81 inch diameter hole thru RH lower section of pilot's floor installation at location shown; deburr edges.
- f. Install M50042-5 tube into flared tube of new 369A8128 fairing assembly, using adhesive.
- g. Install new fairing assembly with adhesive to outboard side of fuselage structure, with fairing tube inserted inboard thru 0.81 inch diameter hole.
- h. Position M50042-3 doubler in place on inboard side and over fairing tube; install doubler to fuselage structure and fairing assembly with seven (7) MS20426AD3 rivets as shown.
- i. Install three (3) MS20426AD4 rivets as shown to secure fairing assembly to fuselage structure.
- j. Route appropriate length of F4040 tubing from tee assembly under landing gear brace to new fairing assembly; secure tubing at both ends with double wrap of lockwire that ends with at least five full twists. Secure tubing to helicopter structure, as required, with tie straps.

CAUTION

Sharp bends may collapse the tube, make all bends with smooth radiions. Landing gear flexing can pinch or damage tube, allow sufficient clearance to compensate. Route tube to prevent straps in system.

- k. Reinstall remaining components of fuel vent system, per Basic HMI.
- l. Check installation for discrepancies.
- m. Secure controls access cover, right foot support fairing, and fuel vent cover.
- n. Top fuel cells if required.
- o. Reconnect battery and external power.

WEIGHT AND BALANCE DATA

Weight and balance not affected.