



# TECHNICAL BULLETIN

DATE: 5 NOVEMBER 1976  
PAGE 1 OF 4

## MODIFICATION KIT PN M50445 - FAN ASSEMBLY, ENGINE OIL AND COMPARTMENT COOLING

### 1. PLANNING INFORMATION:

#### A. Models Affected:

Model 369HS Helicopter Serial No. 0201S and subs  
Model 369HM Helicopter Serial No 0201M and subs  
Model 369HE Helicopter Serial No. 0201E and subs

#### B. Time of Compliance:

At owners and operators discretion - recommended at next 900-hour replacement of oil cooler blower fan assembly upper and lower bearings, PN 369H5655-5 and 369H5655-3.

#### C. Preface:

The information given in this Service Information Notice lists a procedure for optional field modification of the oil cooler blower to provide improve grease sealing for the fan assembly bearings. Instructions are also provided for rework of the fan hub (housing) to facilitate greasing the bearing

The procedures for bearing installation and for assembly of the fan housing and shaft outlined in this Notice are to be considered a part of the HM and will be incorporated in the next scheduled revision to the below referenced Basic HMI.

#### D. Weight and Balance:

Weight and balance not affected.

#### E. Reference Publications:

Series - Basic HMI, Issued I October 1972; Revision No. 5, 15 June 1975  
500 Series - HMI Appendix B, Issued I October 1972; Revision No. 6, 1 August 1976

REPLACEMENT PARTS/SUPPLIES			
Nomenclature	Part No.	Qty.	Source
Bearing, Upper	369H5655-5	1	HH
Bearing, Lower	369H5655-3	1	HH
Screw	AN502-416-6	1	Commercial
Washer	AN960PD416L	1	Commercial
Lockwire	MS20995C32	A/R	Commercial

DATE: 5 NOVEMBER 1976  
PAGE 2 OF 4

# TECHNICAL BULLETIN

MATERIAL	
Nomenclature	Source
Grease (MIL-C-23827)	Shell Oil Co. (AeroShell 7) Bray Oil Co. (Braycote 627) Humble Oil Co. (Enco 5114EP)
Sealant (Silastic 140 or KTV732)	Dow Chemical Co.
Adhesive (Loctite Grade A or 271)	Loctite Inc.
Solvent (Methylethylketone, MEK) or aliphatic naptha	Commercial
Solvent, dry cleaning (P-D-680)	Commercial

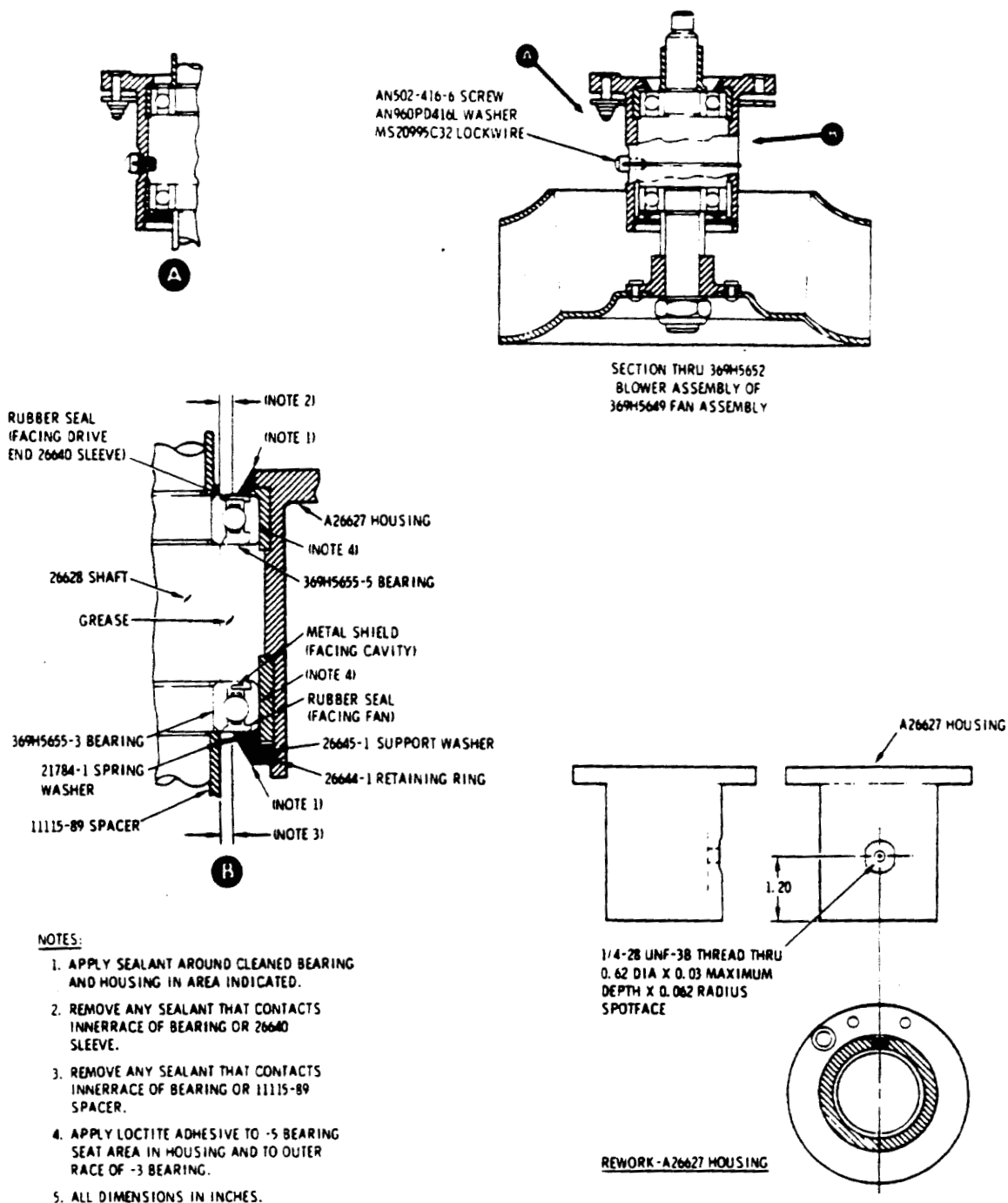
TOOLS AND EQUIPMENT	
Nomenclature	Source
Drill motor, portable	Commercial
Tap Drill - No. 3 (0.2130 die)	Commercial
Tap - 1/4-28UNF-3B thread	Commercial
Spotface - 0.62 die x 0.03 max deep x 0.062R	Commercial
Grease Fitting (PN MS15002-3/1/4-28 thread)	Commercial

## 2. MODIFICATION PROCEDURE

- (1). Remove and disassemble oil cooler blower assembly, per Basic HMI.
- (2). Disassemble hub (housing) and shaft assembly; remove 369H5655-5 tipper bearing and 369H5655-3 lower bearing from she/t, per basic HMI.
- (3). Rework housing by adding 1/4-26 threaded hole for screw. (See Figure 1)

# TECHNICAL BULLETIN

DATE: 5 NOVEMBER 1976  
PAGE 3 OF 4



**Figure 1. Modification - Oil Cooler Blower Hub and Shaft Assembly, Kit M50445**

DATE: 5 NOVEMBER 1976  
PAGE 4 OF 4

# TECHNICAL BULLETIN

- (4). Clean housing and shaft with dry cleaning solvent; install screw with washer in housing; do not lockwire screw.
- (5). Reassemble housing and shaft as follows:
  - (a). Lightly grease the drive end bearing journal of shaft, and bore of inner end bearing, 369H5655-5. Press bearing on shaft using suitable sleeve on bearing inner race, with rubber seal of bearing facing splined end of shaft.
  - (b). Lightly grease bore of inner race of fan end bearing, 369H5655-3. Press bearing on shaft, with shield (metal disc) facing splined end of shaft and seal (rubber disc) side facing fan end of shaft.
  - (c). Clean outer races of bearings and bearing seats in housing with MEK or aliphatic naphtha.
  - (d). Apply Loctite adhesive to 369H5655-5 bearing seat area in housing, and to outer race of 369H5655-3 bearing. Install assembled shaft and bearings in housing.
  - (e). Clean retaining ring, support washer, spring washer and exposed surfaces of 369H5655-3 bearing and housing with MEK or aliphatic naphtha.

## **NOTE**

Ensure that spring washer is installed next to 369H5655-3 bearing. Also check that OD of washer is completely seated against outer race of bearing.

- (f). Apply thin coat of sealant around the -3 bearing and housing. Install spring washer, support washer and retaining ring. Apply sealant to exposed edges of these items, as shown in View A. It. move any sealant that contacts inner race of -3 bearing and 11115-89 spacer.
  - (g). Clean exposed end of 369H655-5 bearing and housing with MEK or aliphatic naphtha.
  - (h). Apply sealant around cleaned bearing and housing in area shown in View A. Remove any sealant that contacts inner race of -5 bearing and 26640 sleeve.
  - (i). Allow sealant to cure per manufacturer's instructions.
  - (j). Remove screw and washer; install grease fitting (PN MS15002-3-1/4-28 thread) in threaded hole in housing; fill housing cavity with grease until grease seeps out around edges of seal in -5 bearing.
- (6). Rotate shaft by hand to check smoothness of operation..
  - (7). Reassemble and install oil cooler blower assembly, per Basic HMI.