



# SERVICE BULLETIN

DATE: 26 NOVEMBER 1979

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**SUBJECT:** PN 369A1800 SERIES AND PN 369H1800 TAIL ROTOR PITCH CONTROL ASSEMBLY - SEATING OF BEARING INNER RACE; TORQUE INCREASE FOR PN 369A1817 LOCKNUT

**MODELS AFFECTED:** All 500 Model 369H Series Helicopters

All subject PN 369A1800 Series and 369H1800 Pitch Control Assemblies, separate or component of Tail Rotor Assemblies in Spares Inventory at date of this Notice

**TIME OF COMPLIANCE:** Shall be accomplished within next 100 hours of helicopter operation

**PREFACE:** The information given in this Service Information Notice lists a procedure for seating the double row ball bearing of the tail rotor pitch control assembly, to ensure that the bearing inner race is firmly in contact with the shoulder of the swashplate. At reassembly of the pitch control assembly, the locknut is torqued to 400 to 450 inch-pounds. Reseating of the bearing inner race and increasing the torque for the locknut is designed to prevent loosening of the locknut and premature wear of the bearing during tail rotor operations.

It is to be noted that PN 369A1800 Series and 369H1800 Pitch Control Assemblies identified with a white dot on the locknut (See Figure 1) are not affected by this Notice.

**REFERENCE PUBLICATIONS:**

500 Series – Basic HMI, Issued 1 October 1972; Revision No. 7, 15 December 197

500 Series – HMI Appendix C, Overhaul Manual, Issued 1 April 1976; Revision No. 1 August 1976.

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- d. Place housing and swashplate assembly on arbor press bed with swashplate end down. Apply 2000 pounds of pressure to press inner race of bearing firmly in contact with shoulder of swashplate. Use suitable tube or sleeve to press INNER race of bearing only. Remove assembly from arbor press.
- e. Install new 369A1816 tang washer; reinstall locknut and torque locknut to 400 to 450 inch-pounds. Use wrench adapter and torque wrench while assembly is held in holding block, to tighten locknut.
- f. Check for sufficient clearance (0.015 inch minimum) between swashplate and housing (see Figure 1 ).
- g. Check for smooth easy and free rotation without binding.
- h. Bend a tang of the tang washer into bottom of any aligned slot on locknut.
- i. Paint a 0.12 to 0.18 inch white dot on locknut, as shown in Figure 1, to denote reseating of bearing and locknut torqued to 400 to 450 inch-pounds.
- j. As applicable, reinstall pitch control and tail rotor assembly, per Basic HMI. Use new HS1551S290 tang washer. Tag spares assembly to denote compliance with this notice.
- k. Following installation of pitch control/tail rotor assembly, record compliance with this Service Information Notice in Compliance Record of helicopter Log Book.

**WEIGHT AND BALANCE:** Weight and balance not affected.

FAA APPROVED

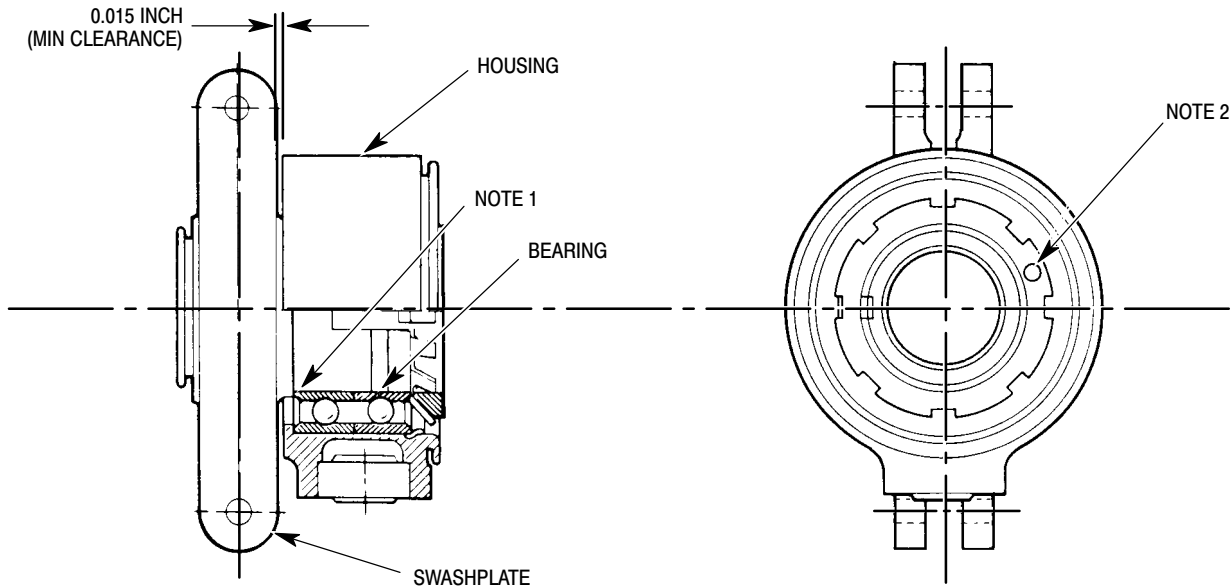
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**NOTES:**

- 1. INNER RACE FIRMLY SEATED AGAINST SHOULDER OF SWASHPLATE
- 2. AFTER TORQUE, COLOR CODE WITH WHITE DOT (0.12 - 0.18 IN. DIA.)

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Figure 1. Tail Rotor Pitch Control Assembly - Seating of Bearing and Increased Torque for Locknut

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