

# TECHNICAL BULLETIN

DATE: 23 AUGUST 1971

PAGE 1 OF 4

## PROVISIONS FOR DRAINAGE OF WATER ENTRAPMENT AREAS

### 1. PLANNING INFORMATION

#### A. MODELS AFFECTED:

All 369H Series Helicopters

#### B. PREFACE:

The information given in this Service Information Notice lists a procedure for incorporating drainage provisions in specified flight control components, to reduce the possibility of corrosion due to water entrapment.

#### C. TIME OF COMPLIANCE:

At Owners and Operators Discretion

#### D. REFERENCE:

500 Series - Basic Handbook of Maintenance Instructions, Revised 1 June 1971

DATE: 23 AUGUST 1971  
PAGE 2 OF 4

# TECHNICAL BULLETIN

## E. TOOLS AND EQUIPMENT:

TOOLS AND EQUIPMENT Nut	
Nomenclature	Source
Drill motor, portable	Commercial
Drill bit – (#1/8) 0.125 in. dia.	Commercial
Press ,arbor	Commercial

## F. MATERIALS:

MATERIALS	
Nomenclature	Source
Thinner Prepsol (DuPont 3919)	E. I. DuPont Co.
Chrome acid solution (pH 2.6 to 3.4) (Dow 19)	Dow Chemical Co.
Primer	Sherwin Wms. or equiv.
Paint, acrylic lacquer	Andrew Brown Co. or equiv.
Paper, abrasive – 400 grit	Commercial
Locquic Activator	Loctite Inc.
Loctite Solvent A	Loctite Inc.
Cleaner Trichloroethane	Commercial

## 2. PROCEDURE

**NOTE:** The following procedure is applicable to specified components installed on helicopters and in spares inventory, which have not been reworked to incorporate drainage provision.

### I Modification - Tail Rotor Bellcrank At Station 282, P/N 369A7514

- a. Remove Sta. 282 bellcrank, per Section 8 of Basic HMI
- b. Using arbor press and appropriate tool, press out 369A7951-25 pivot Do not apply pressure to bearing inner race.
- c. Using a rat tail file (1/4-inch diameter), file the slot to dimensions shown in Figure 1; remove any discernible file marks with 400 grit paper wrapped around a 1/4-inch diameter dowel.
- d. Provide magnesium surface touch up treatment, per Section 2 of the Basic HMI; and paint touch up, per applicable HMI Configuration Supplement.
- e. Replace the pivot bearing as follows:
  1. Clean faying surfaces of bearing and bellcrank with trichloroethane; do not allow trichloroethane to enter bearing face.

# TECHNICAL BULLETIN

DATE: 23 AUGUST 1971

PAGE 3 OF 4

2. Coat faying surfaces with Locquic Activator and air dry for 30 minutes minimum.
  3. Apply Loctite Sealant A sparingly to laying surfaces.
  4. Install bearing in bellcrank, using arbor press; install bearing straight and without pressure on inner race. Do not allow Loctite Sealant to enter race; remove excess sealant.
  5. Apply small fillet of sealant to faying edges of bearing and bellcrank assembly.
  6. Allow sealant to harden a minimum of 24 hours at ambient temperature, or by heating to 140-160° F for 1 hour.
- f. Reinstall Sta. 282 bellcrank, per Section 8 of Basic HMI.

## II Modification - Tail Rotor Bellcrank At Station 95, P/N 369A7516

- a. Remove Sta, 95 bellcrank, per Section 8 of Basic HMI.
- b. Drill two 0.125 inch diameter holes at dimensions shown in Figure 1; deburr holes and remove any shavings.
- c. Provide magnesium surface touch up treatment, per Section 2 of Basic HMI; and paint touch up per Section 2 of applicable HMI Configuration Supplement.
- d. Reinstall Sta. 95 bellcrank, per Section 8 of Basic HMI.

## III Modification - Main Rotor Stationary Swashplate, P/N 369A7612

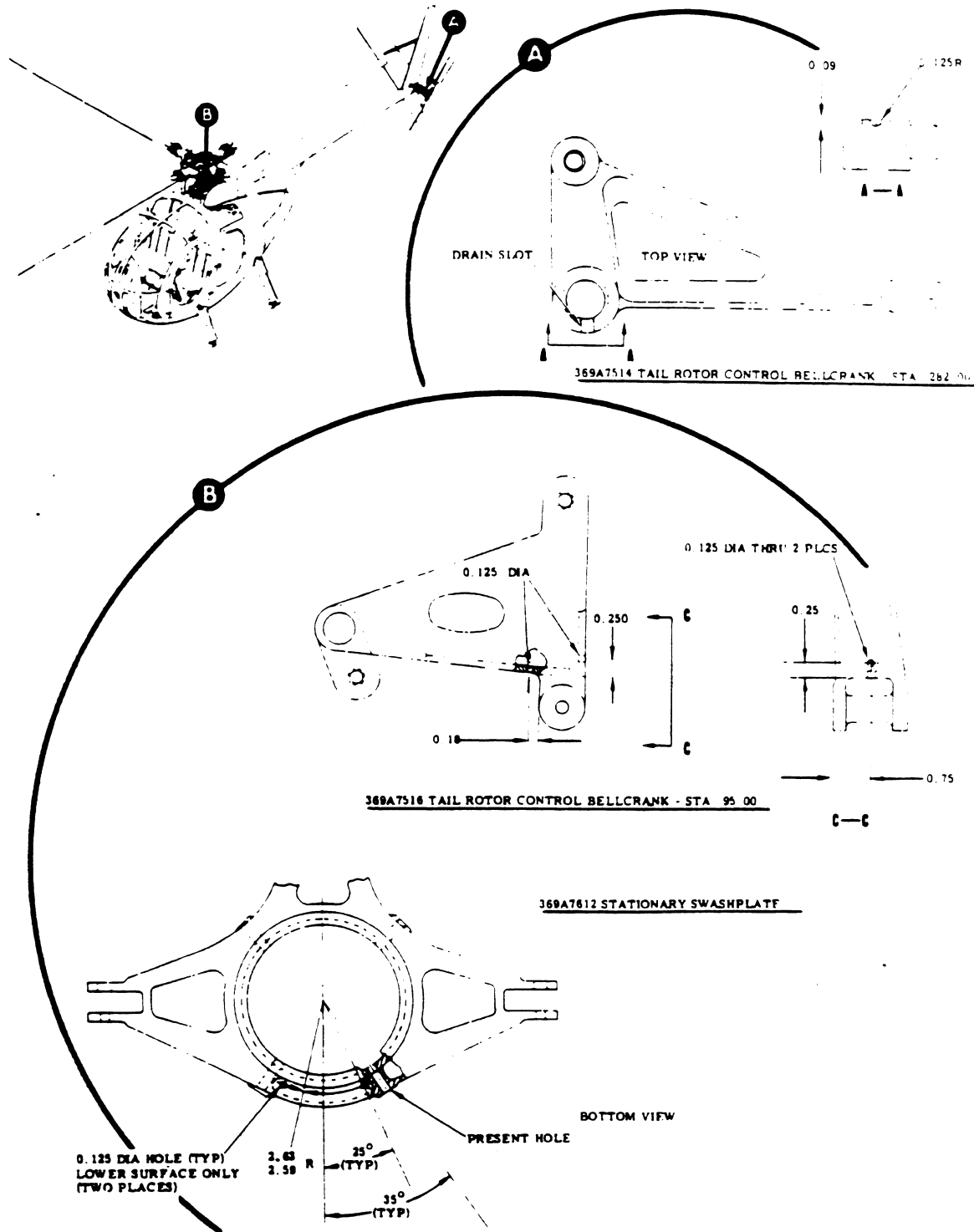
- a. Remove stationary swashplate, per Section 7 of Basic HMI.
- b. Drill two 0.125 inch diameter holes at dimensions shown in Figure 1; deburr roles and remove any shavings.
- c. Provide magnesium surface touch up treatment, per Section 2 of Basic HMI; and paint touch up, per Section 2 of applicable HMI Configuration Supplement.
- d. Reinstall stationary swashplate, per Section 7 of Basic HMI.

## IV Compliance

- a. Record compliance with Parts I, II and III in Compliance Record of helicopter Log Book.

DATE: 23 AUGUST 1971  
PAGE 4 OF 4

# TECHNICAL BULLETIN



88-718

**Figure 1. Drainage Provisions - Water Entrapment Areas**