



SERVICE LETTER

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PREVENTION OF WATER LEAKAGE THROUGH CANOPY GEON STRIPS

TO: All owners end operators of Hughes Helicopters

MODELS AFFECTED: All 500 Model 369HE, 369HM and 369HS Series helicopters.

REFERENCE:

Model 500. Basic HMI (CSP-H-2), Reissued 15 September 1981. Model 500 HMI Appendix D, Issued 1 October 1973.

Should water leakage through the geon strips of the forward canopy occur, seal all faying surfaces of the geon strip(s) where the leakage occurs with PR1221 sealant (Product Research, Glendale, CA). Remove any existing sealant bead in the area of the leak using a plastic or other non-metallic scraper which will not scratch the canopy glass. Apply a 0.06-inch bead of sealant (refer to manufacturers instructions) along faying surfaces in the affected area.

When replacement of components mating with the geon strips and removal of the canopy glass is required, apply a 0.010-to 0.020-inch coating of PR1221 sealant to all faying surfaces of the geon strip and to the adjoining components prior to reinstallation. Carefully align and join mating surfaces with as few movements as possible. Do not reposition or shift the faying surfaces once they are joined. Install any attaching hardware necessary during the working life of the sealant (refer to manufacturers instructions). Remove any sealant squeeze-out in excess of 0.125-inch using a non-metallic spatula or scraper.

The information given in this Service Information Letter is to be considered as a part of the HMI, and will be incorporated in the next scheduled revision to the above referenced manuals.

Edward Koch, Manager,
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Product Support Department

REFERENCE SHEET
SERVICE INFORMATION NOTICES AND LETTERS

ACTION REFERENCE: When installing or repairing forward canopy windows refer to Service Information Letter No. HL-85.

HMI REFERENCE : Insert this sheet in 500 Series - HMI, Appendix D, Section 2, Page 2-45.

This reference sheet shall be kept as a part of the manual until the data is incorporated at the next revision to 500 Series -HMI Appendix D. (See Service Information Summary, HMI Appendix D, page i.)