

**HUGHES
SERVICE INFORMATION
NOTICE**

SUBJECT: REMOVAL OF INBOARD TAB - MAIN ROTOR BLADE, PN 369A1100-501*

MODELS AFFECTED: All 500 Model 369H Series Helicopters

*Subject Main Rotor Blade Serial No. W671 and subsequent not affected - inboard tab removed at factory.

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: The information given in this Service Information Notice lists a procedure for removal of the inboard tab on the trailing edge of the main rotor blade, to minimize possible blade handling damage. As noted in the below reference Hughes Service Information Letter No. HL-40, removal of the inboard tab has no affect on blade tracking or weight and balance. In addition, tabbed and untabbed blades are 100 percent interchangeable, individually or in ship sets.

Reference

500 Series - Basic HMI, Issued 1 October 1972; Revision No. 5, 15 June 1975

500 Series - HMI Configuration Supplement S/E, Issued 1 May 1972; Revision No. 2, 1 October 1973

500 Series - HMI Configuration Supplement M, Issued 1 September 1971; Revised 15 March 1975

Hughes Service Information Letter No. HL-40, dated 21 July 1975

Hughes Helicopters

NOTICE NO. HN-94

DATE 1 April 1976

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MATERIALS

Exterior Surface Touchup Treatment	Iridite	Eichardson Co. Allied-Kelite Div. Des Plaines, Ill.
Paint - Flat Black		ADVANCE COATING, So. EDWARDS CA Andrew Brown Co. LA
Primer - Yellow	MIL-P-23377B	Andrew Brown Co. LA
Solvent - Aliphatic Naphtha	TT-N-95	Commercial
Solvent - Dry Cleaning	P-D-680	Commercial
Tape	#850	3M Co. St. Paul, Minn.

TOOLS AND EQUIPMENT

Metal Cutting Saw - Portable, Power
Grinder or File

PROCEDURE

- a. Remove main rotor blades, per Basic HMI.
- b. Wipe away dirt on and around inboard tab area with clean cloth dampened with dry cleaning solvent.

CAUTION: Provide protective surface and/or covering to prevent scratching, nicking or other damage to blade during rework.

- c. Mask edges of blade area around inboard tab with tape; do NOT cut tape after it has been applied to blade. Position blade on work bench or equivalent so that a firm straight edge is provided for cutting or filing off inboard tab.

CAUTION: Cutting, grinding or filing to remove inboard tab, and deburring of reworked blade trailing edge, are to be performed in a SPANWISE direction only. Do NOT use shears or clippers to remove inboard tab.

- d. Use metal cutting saw or equivalent to remove the 6.00 x 0.38 inch inboard tab per dimensions shown in Figure 1. Deburr edges in a spanwise direction only.

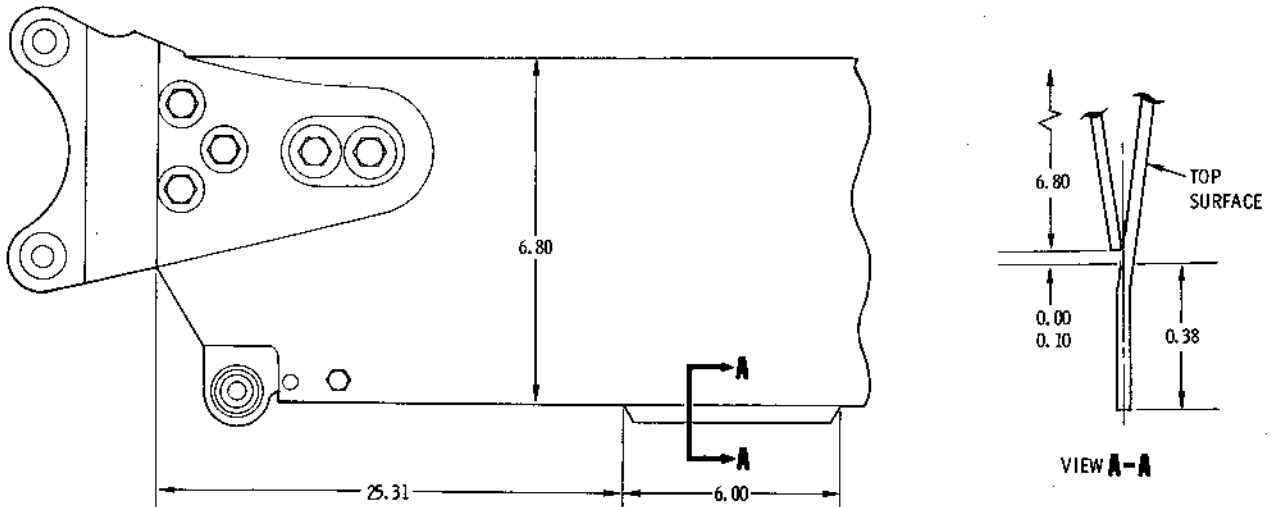
- e. ^{feeler} Remove tape and inspect area around repair; refer to Basic HMI for blade inspection and damage criteria. Clean repaired area with cloth dampened in solvent (aliphatic naphtha).

f. Apply chemical film treatment (Iridite) to reworked area of blade trailing edge; apply a thin film of primer and paint lightly. (Refer to Basic HMI and applicable HMI Supplement.)

g. Reinstall main rotor blade per Basic HMI.

WEIGHT AND BALANCE DATA

Weight and balance not affected.



NOTE:
ALL DIMENSIONS IN INCHES.

Figure 1. Removal of Inboard Tab - Main Rotor Blade, PN 369A1100-501