



**HUGHES
SERVICE INFORMATION
LETTER**

LETTER NO. HL-6.1*

DATE May 3, 1971

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*Supersedes Service
Information Letter No. HL-6
Dated March 5, 1971

TO—All owners and operators of Hughes Helicopters

SUBJECT: SPECIAL WRENCHES FOR FIELD REPLACEMENT
OF MAIN ROTOR PITCH BEARING STUDS

MODELS AFFECTED: 369H Helicopter Serial Nos. 0001H thru 0005H
369HS Helicopter Serial Nos. 0001S thru 0300S
369HE Helicopter Serial Nos. 0101E thru 0215E
369HM Helicopter Serial Nos. 0001 thru 0004;
0005M thru 0200M; 0204M

Reference

500 Series - Basic Handbook of Maintenance Instructions, Revised 1 May 1970

Hughes Service Information Notice No. HN-21.1, dated November 4, 1970

Special wrenches are now available to permit replacement of pitch bearing studs in the field without disassembly of the main rotor hub, thus eliminating the need for returning the hub to HTC-AD.

A 369A9825 stud wrench is used to remove and install the pitch bearing studs, in conjunction with a 369A9826 stud nut holding wrench which engages and holds the stud attach nuts.

Due to the tolerance build-ups in forging and casting of individual main rotor hubs, insertion of the 369A9826 stud nut holding wrench may not be possible with some hubs. If the holding wrench cannot be inserted properly to engage the stud attach nuts, the hub assembly must be returned to HTC-AD for stud replacement.

It is emphasized that disassembly of the main rotor hub should not be attempted in the field. To disassemble the hub, tension on the retention straps must be released.

(|) Denotes portions of text added or revised.

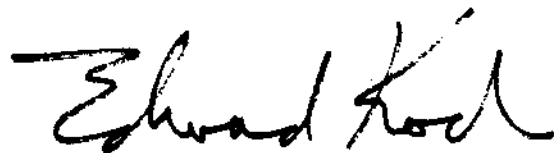
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Preloading of the straps for hub reassembly requires special equipment available only at HTC-AD overhaul facilities.

All main rotor hubs returned to HTC-AD for stud replacement or for overhaul will be updated to the new 369A1200-501 configuration which incorporates holding brackets to restrain the stud attach nuts. Stud replacement for the -501 hub configuration does not require use of the stud nut holding wrench.

Unit prices for the special wrenches and for pitch bearing studs are as follows:

<u>Nomenclature</u>	<u>Part Number</u>	<u>Unit Price</u>
Wrench, stud - pitch bearing, main rotor	369A9825	\$10.12
Wrench, stud nut - pitch bearing, main rotor	369A9826	15.12
Stud - pitch bearing, main rotor	369A1248	26.57



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