

McDonnell Douglas
Helicopter Company
SERVICE INFORMATION NOTICE

HN-55

DATE 1 Mar 1973

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SUBJECT VALVE HOUSING MODIFICATION - HEAT CONTROL
VALVE ASSEMBLY, CABIN HEATING SYSTEM KIT
INSTALLATION

MODELS AFFECTED: The following helicopters with 369H90020 Series Cabin Heating System Kit installed at date of this Notice:

369HE Helicopter Serial No. 0101E thru 0215E
369HE Helicopter Serial No. 0001S thru 0328S;
0330S thru 0353S; 0355S;
0357S thru 0360S
369HM Helicopter Serial No. 0001 thru 0004;
0005M thru 0213M

TIME OF COMPLIANCE: At owners and operators discretion

PREFACE: The information given in this Service Information Notice lists a procedure for modifying the valve housing assembly incorporated in the 369H90020 Series Cabin Heating System Kits currently installed on the above affected helicopters. The modification consists of riveting a support block to the inside bore of the inlet valve body, to help seat the ball valve and prevent the ball valve from shifting in service.

It is noted that Hughes Notice No. HN-30 defines a procedure for modifying and shimming the heater control valve assembly to prevent binding within the mechanism. Valve housings modified per HN-30 are identified by a green paint dot or M50023 ink stamped on the valve housing. Also, Hughes Notice No. HN-50 lists a mandatory one-time inspection of the heat control valve assembly to ensure that proper torque is maintained and the ball valve operates freely without binding.

Product Support Department

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PREFACE (Cont.)

If applicable and not already accomplished, compliance with Hughes Notice No. HN-30 and HN-50 may be performed in conjunction with the modification outlined in this Notice.

Reference

500 Series - Basic HMI. Issued 1 October 1972
500 Series - HMI Appendix A. Issued 1 October 1972
Hughes Notice No. HN-30. dated 21 December 1970
Hughes Notice No. HN-50. dated 31 May 1972

PARTS LIST

<u>Nomenclature</u>	<u>Part No.</u>	<u>Qty</u>	<u>Mfr</u>
Support	369A8014-9	1	Hughes
Rivet. Blind	NAS1398B5-4	1	Commercial

TOOLS & EQUIPMENT

Gun. rivet	Commercial
Drill motor. portable	Commercial
Drill bit - #20 (0.161 in. dia)	Commercial
Spotface tool (0.380 dia x 0.040 in. depth max)	Commercial

MATERIALS

Alodine 1200 * Alcoa

* Primary Selection - any equivalent material may be used as an alternate selection.

PROCEDURE

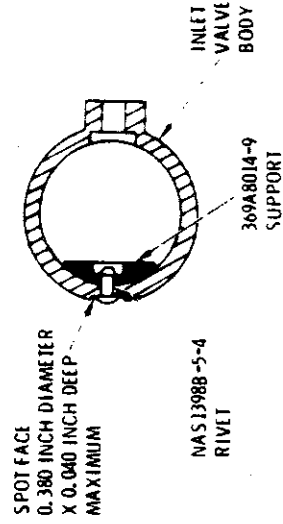
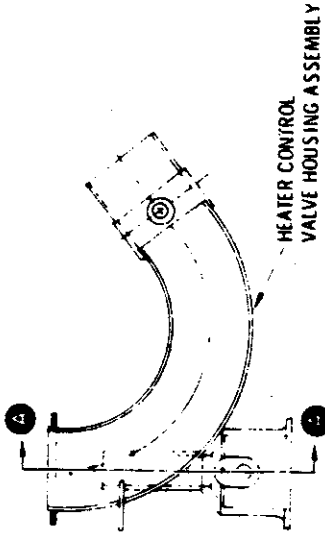
a. Carefully remove heat control valve assembly from helicopter. (Refer to Group 6 of referenced HMI Appendix A.)

b. Disassemble and inspect valve assembly. per HMI Appendix A: removal of cold air valve vane. shaft and pulley not required.

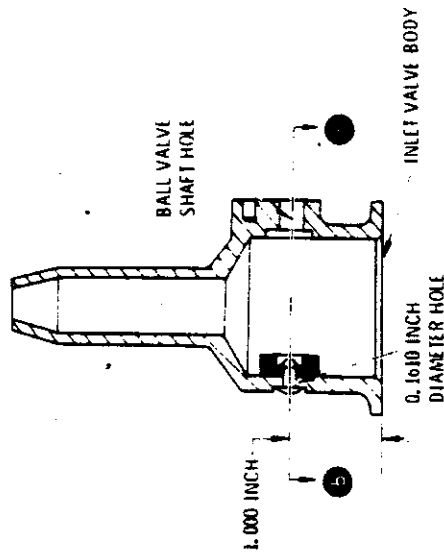
- c. Using #20 drill bit, drill rivet hole in the inlet valve body in line with existing hole for ball valve shaft, as shown in Figure 1.
- d. Using spotface tool, spotface outer diameter of inlet valve body as shown.
- e. Coat reworked area with Alodine or equivalent.
- f. Install 369A8014-9 support to inner bore of inlet valve body with NAS1398B5-4 rivet.
- g. Reassemble, reinstall and adjust rigging of heat control valve assembly, per HMI Appendix A.
- h. Perform operational check of heat valve and controls, per HMI Appendix A.
- i. Record modification of heat control valve housing assembly per this Notice in Component Record of helicopter Log Book.

WEIGHT & BALANCE DATA

Weight and balance not affected



SECTION B-B



SECTION A-A

Figure 1. Modification of Valve Housing Assembly - Cabin Heat System Kit