Publication No. CSP-071

Illustrated Parts List and Maintenance Instructions with Initial Installation Instructions

FOR

LITTER INSTALLATION

Part No. 369D290170

USED ON HUGHES 500D (MODEL 369D) HELICOPTERS

Hughes Helicopters, Inc. Culver City, California 90230
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FOREWORD

F-1. PURPOSE AND CONTENT OF THIS MANUAL.

F-2. This manual supplements information contained in Handbook of Maintenance Instructions Vol 1 (HMI) and 369D - Illustrated Parts Catalog (IPC), and contains instructions for initial installation and continuing maintenance for the Litter Installations. Weight and balance data is included. This manual also contains parts lists for procuring replacement parts for the Litter Installations.

F-3. APPLICABILITY.

F-4. The Litter Installation is applicable for use on any Hughes 500D (Model 369D) helicopter.

F-5. COMPATIBILITY OF COMBINED OPTIONAL EQUIPMENT.

F-6. For compatibility information on which optional equipment may or may not be used in combination at the same time, refer to Section 21, HMI - Vol 1.

F-7. ORGANIZATION OF CONTENTS.

F-8. The contents of this manual is grouped into sections as outlined in the Table of Contents. Each section is organized to provide comprehensive coverage of entire systems, major equipment groupings, and major components that are similar or associated. (Procedures for each of these are presented in sequence as defined in Section 1, HMI - Vol 1).

F-9. USE OF THIS MANUAL.

F-10. This manual is for use by operators of the Model 369D helicopter equipped with a Litter Installation. Although this manual is a separate publication, it should be kept with HMI - Vol 1, HMI - Vol 2, 369D - IPC, and other handbooks listed in Section 1, HMI - Vol 1 that form the primary information file for the helicopter.

F-11. RELATED PUBLICATIONS.

F-12. Reference is made to applicable portions of HMI - Vol 1 and 369D - IPC as required to accomplish instructions contained herein.

F-13. LITERATURE CHANGES AND REVISIONS.

F-14. Changes and revisions to contents of this manual are made as defined in Section 1, HMI - Vol 1.

SECTION 1
ILLUSTRATED PARTS LIST

1-1. SCOPE AND CONTENTS.

1-2. This illustrated parts list provides, by means of text (parts lists) and companion illustrations, a complete parts definition of the PN 369D 290170 Litter Installation manufactured by Hughes Helicopters, Culver City, California.

NOTE

The illustrated parts list is organized and presented in the same manner as the 369D Series Illustrated Parts Catalog (369D -IPC). (For information on use, refer to 369D - IPC).

1-3. GROUP ASSEMBLY PARTS LIST.

1-4. The parts lists furnish information for procuring replacement parts for the Litter Installations and shall not be used for any other purpose. For information or procurement of replacement parts, refer to 369D - IPC.

1-5. ILLUSTRATIONS.

1-6. Isometric illustrations are provided for each group assembly parts list. Each illustration is exploded to the extent necessary to show parts relationship for the complete Litter Installation (fig. 1-1).

1-7. USABLE ON CODE.

1-8. The USABLE ON CODE column located at the right-hand side of the group assembly parts list pages indicates the effectivity of parts by aircraft serial number. In many cases two different parts are listed, one representing the original installation and another representing the improved replacement item. Alphabetic codes are used to indicate the aircraft serial number applications of a given part. When no USABLE ON CODE is listed, items are understood to have full effectivity. The alphabetic codes used in this manual are listed and explained below:

USABLE ON CODE LETTER	AIRCRAFT EFFECTIVITY
A	-0940 and subsequent
B	-0001 through -0939

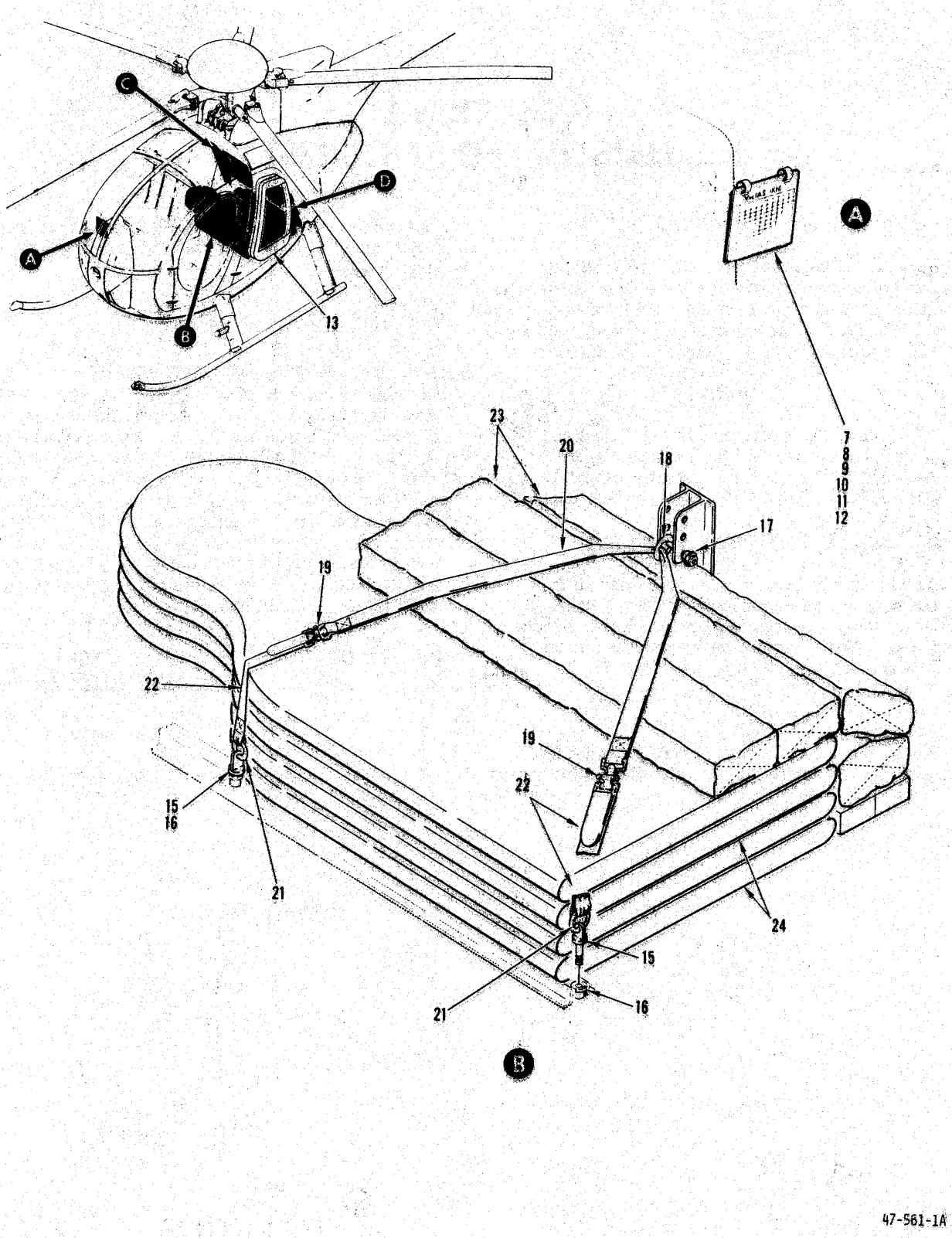

Figure 1-1. Litter kit installation (sheet 1 of 2)

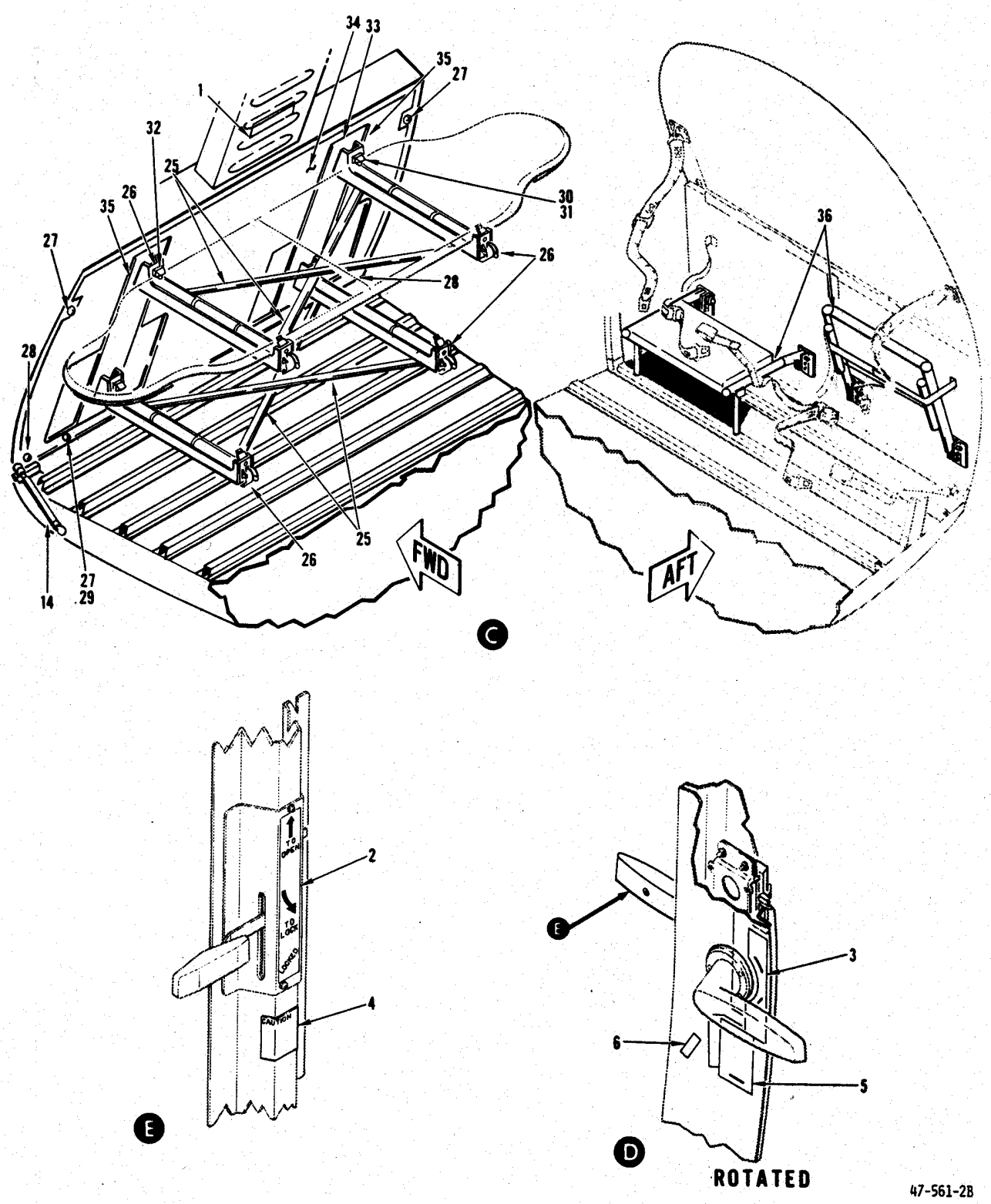

Figure 1-1. Litter kit installation (sheet 2 of 2)

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-1-	369D290170	LITTER KIT INSTL	1	
-1	369D290249	. DECAL	1	
-2	369H6615-167	. DECAL, LH	1	
	369H6615-168	. DECAL, RH	1	
-3	369H6615-169	. DECAL, LH (Utilized on aircraft with light color exterior)	1	
	369H6615-177	. DECAL, LH (Utilized on aircraft with dark color exterior)	1	
	369H6615-170	. DECAL, RH (Utilized on aircraft with light color exterior)	1	
	369H6615-178	. DECAL, RH (Utilized on aircraft with dark color exterior)	1	
-4	369H6615-171	. DECAL, LH	1	
	369H6615-172	. DECAL, RH	1	
-5	369H6615-173	. DECAL, LH	1	
	369H6615-174	. DECAL, RH	1	
-6	369H6615-175	. DECAL	2	
-7	369D292577-3	. CARD, VNE	1	
-8	369D292577-5	. CARD, VNE	1	
-9	369D292577-7	. CARD, VNE	1	
-10	369D292578-3	. CARD, VNE	1	
-11	369D292578-5	. CARD, VNE	1	
-12	369D292578-7	. CARD, VNE	1	
-13	369D290150-1	. DOOR INSTL, LH (See fig. 1-2 for bkdn)	1	
	369D290150-2	. DOOR INSTL, RH (See fig. 1-2 for bkdn)	1	
-14	369D290230-501	. PROP INSTL, REAR DOOR, LH (See fig. 1-5 for bkdn)	1	A
	369D290230-1	. PROP INSTL, REAR DOOR, LH (For replacement order 369D290230-501) (See fig. 1-5 for bkdn)	1	B
	369D290230-502	. PROP INSTL, REAR DOOR, RH (See fig. 1-5 for bkdn)	1	A
	369D290230-2	. PROP INSTL, REAR DOOR, RH (For replacement order 369D290230-502) (See fig. 1-5 for bkdn)	1	B
-15	AN42B-C3A	. BOLT	2	
-16	NAS1329H3-80L	. RIVNUT	2	
-17	NAS1333A3S10	. PIN	1	
	369D290170-11	. STRAP ASSY	1	
-18	SR18	. . RING	1	
-19	369D290170-9	. . BUCKLE	2	
-20	369D290170-3	. . STRAP	1	
	369D290170-13	. STRAP ASSY	1	
-21	SR18	. . RING	1	
-22	369D290170-5	. . STRAP	1	
-23	369D290227	. BAG, SUPPORT ARM STOWAGE	1	
-24	369D290200	. LITTER ASSY (See fig. 1-7 for bkdn)	2	
-25	369D290215	. BRACE, SUPPORT ARM	4	
-26	369D290190	. ARM ASSY, SUPPORT (See fig. 1-9 for bkdn)	4	
-27	SFSW10F10DS* 06BG	. SCREW	4	
-28	SFSW10F24DS* 06BG	. SCREW	2	

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-1-29	MS204070AD4	. RIVET	4	
	369H6524-801	. BRACKET ASSY	2	
-30	A10K-75	. . RIVNUT	1	
-31	369H6524-463	. . BRACKET	1	
	369D290226	. PANEL ASSY, FORWARD BULKHEAD AFT	1	
-32	369D290226-7	. . ANGLE	4	
-33	369D290226-5	. . TRIM	AR	
-34	369D290226-3	. . PANEL ASSY	1	
-35	369D290171	. SUPPORT INSTL, VERTICAL (See fig. 1-10 for bkdn)	1	
-36	369D290223	. SEAT INSTL, ATTENDANT (See fig. 1-6 for bkdn)	1	

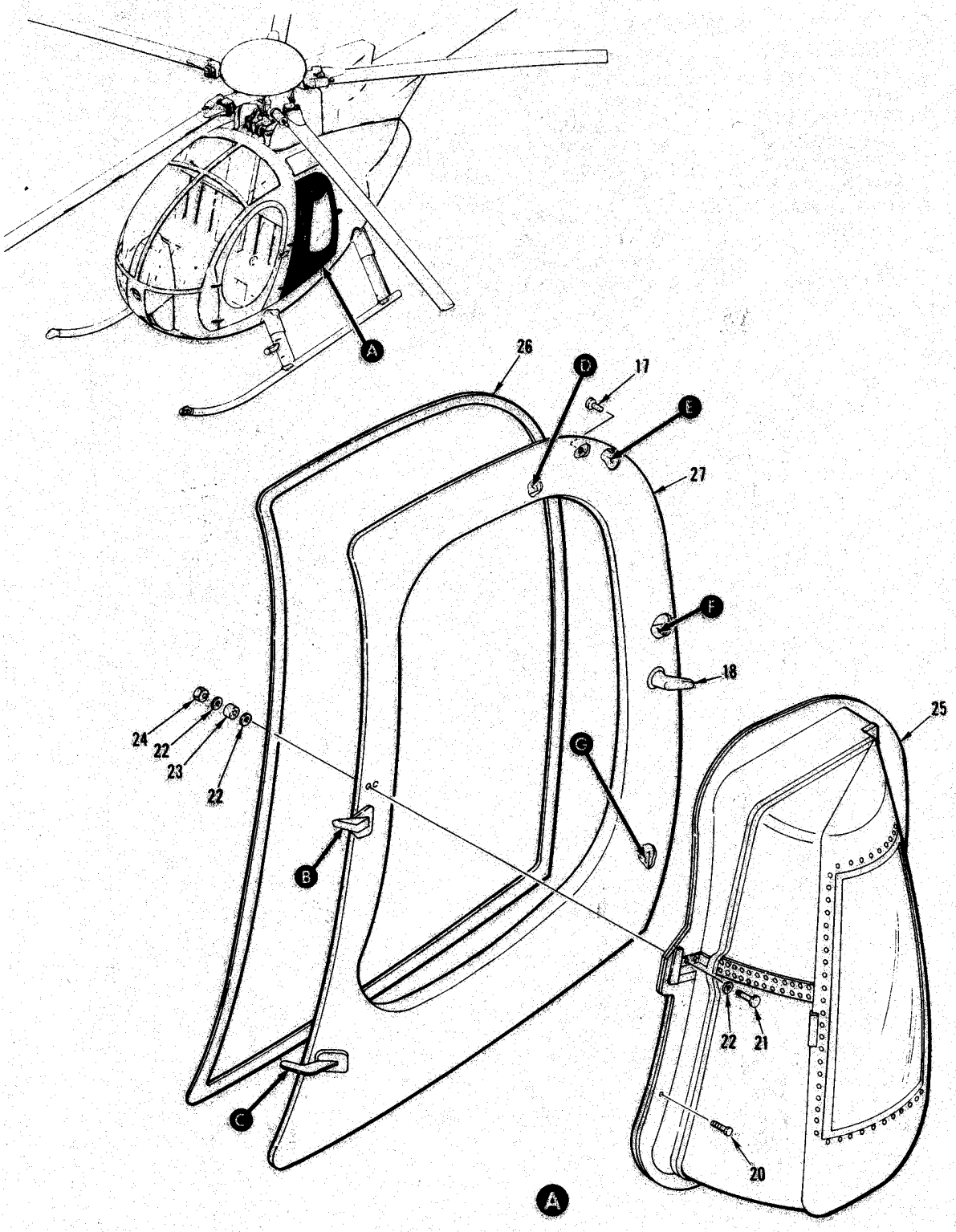

Figure 1-2. Litter high door installation (sheet 1 of 2)

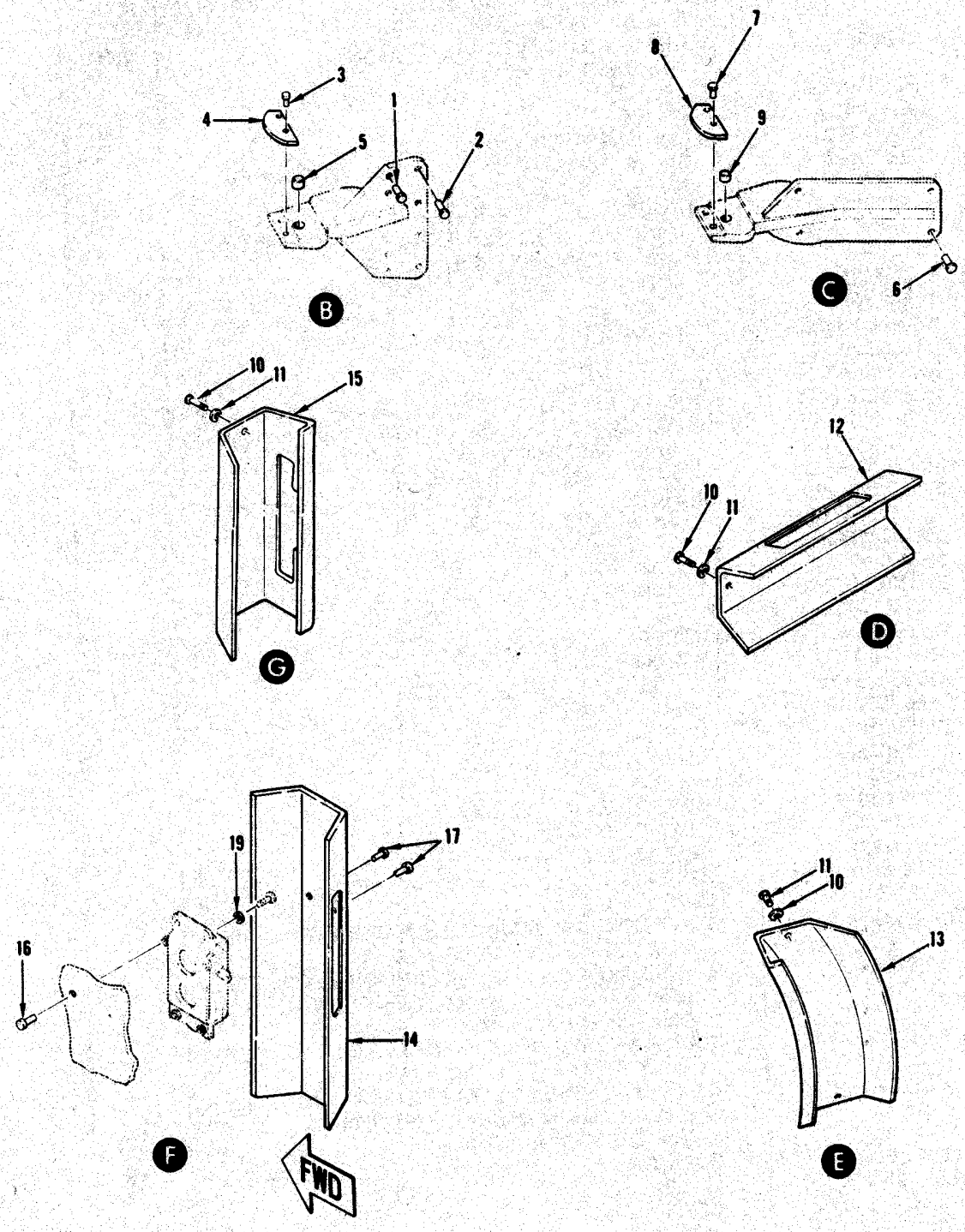

Figure 1-2. Litter high door installation (sheet 2 of 2)

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-2-	369D290150-1	DOOR INSTL, LITTER HIGH . . . . . (See fig. 1-1 for NHA)	REF	
	369D290150-2	DOOR INSTL, LITTER HIGH . . . . . (See fig. 1-1 for NHA)	REF	
-1	MS20470AD4	. RIVET	4	
-2	NAS1738B4	. RIVET	16	
	369H92747-11	. HINGE ASSY, UPPER, LH	1	
	369H92747-1	. HINGE ASSY, UPPER, LH (For replacement . . . order 369H92747-11)	1	
	369H92747-12	. HINGE ASSY, UPPER, RH	1	
	369H92747-2	. HINGE ASSY, UPPER, RH (For replacement . . . order 369H92747-12)	1	
-3	MS20427M3	. . RIVET	2	
-4	369A2060	. . CAM	1	
-5	HS610CP3132R* 190X190	. . BUSHING	1	
-6	NAS1738B5	. RIVET	4	
	369H92034-11	. HINGE ASSY, LOWER, LH	1	
	369H92034-1	. HINGE ASSY, LOWER, LH (For replacement. . . order 369H92034-11)	1	
	369H92034-12	. HINGE ASSY, LOWER, RH	1	
	369H92034-2	. HINGE ASSY, LOWER, RH (For replacement . . order 369H92034-12)	1	
-7	MS20427M3	. . RIVET	2	
-8	369A2060	. . CAM	1	
-9	HS610CP3132R* 190X190	. . BUSHING	1	
-10	AN515C6R5	. SCREW	30	
-11	AN960PD6L	. WASHER	30	
-12	369H2038-45	. COVER, LH	1	
	369H2038-46	. COVER, RH	1	
-13	369H2038-43	. COVER, LH	1	
	369H2038-44	. COVER, RH	1	
-14	369H2038-41	. COVER, LH	1	
	369H2038-42	. COVER, RH	1	
-15	369H92732-3	. COVER, LH	1	
	369H92732-4	. COVER, RH	1	
-16	MS20470AD4	. RIVET	14	
-17	MLSP-B4	. RIVET	8	
-18	369H2048-27	. LATCHING SYSTEM, PASSENGER DOOR, LH . . (See CSP-D-4 for bkdn)	1	
	369H2048-23	. LATCHING SYSTEM, PASSENGER DOOR, LH . . (For replacement order 369H2048-27) (See CSP-D-4 for bkdn)	1	
	369H2048-28	. LATCHING SYSTEM, PASSENGER DOOR, RH . . (See CSP-D-4 for bkdn)	1	
	369H2048-24	. LATCHING SYSTEM, PASSENGER DOOR, RH . . (For replacement order 369H2048-28) (See CSP-D-4 for bkdn)	1	
-19	AN960PD6	. WASHER	AR	
-20	NAS623-3-6	. BOLT	15	
-21	NAS623-3-22	. BOLT	2	
-22	AN960-10L	. WASHER	21	
-23	NAS43PD3-74	. SPACER	2	

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-2-24	MS21042-3	. NUT	2	
-25	369D290151-501	. ADAPTER ASSY, BUBBLE AND DOOR (See fig. 1-3 for bkdn)	1	
	369D290151-502	. ADAPTER ASSY, BUBBLE AND DOOR (See fig. 1-3 for bkdn)	1	
-26	MR4665	. EXTRUSION	AR	
	MR4669	. EXTRUSION (Intrch MR4665)	AR	
-27	4508	. SEAL	AR	
-28	369H92702-71	. STRUCTURE ASSY, LITTER DOOR, LH (See fig. 1-8 for bkdn)	1	
	369H92702-72	. STRUCTURE ASSY, LITTER DOOR, RH (See fig. 1-8 for bkdn)	1	

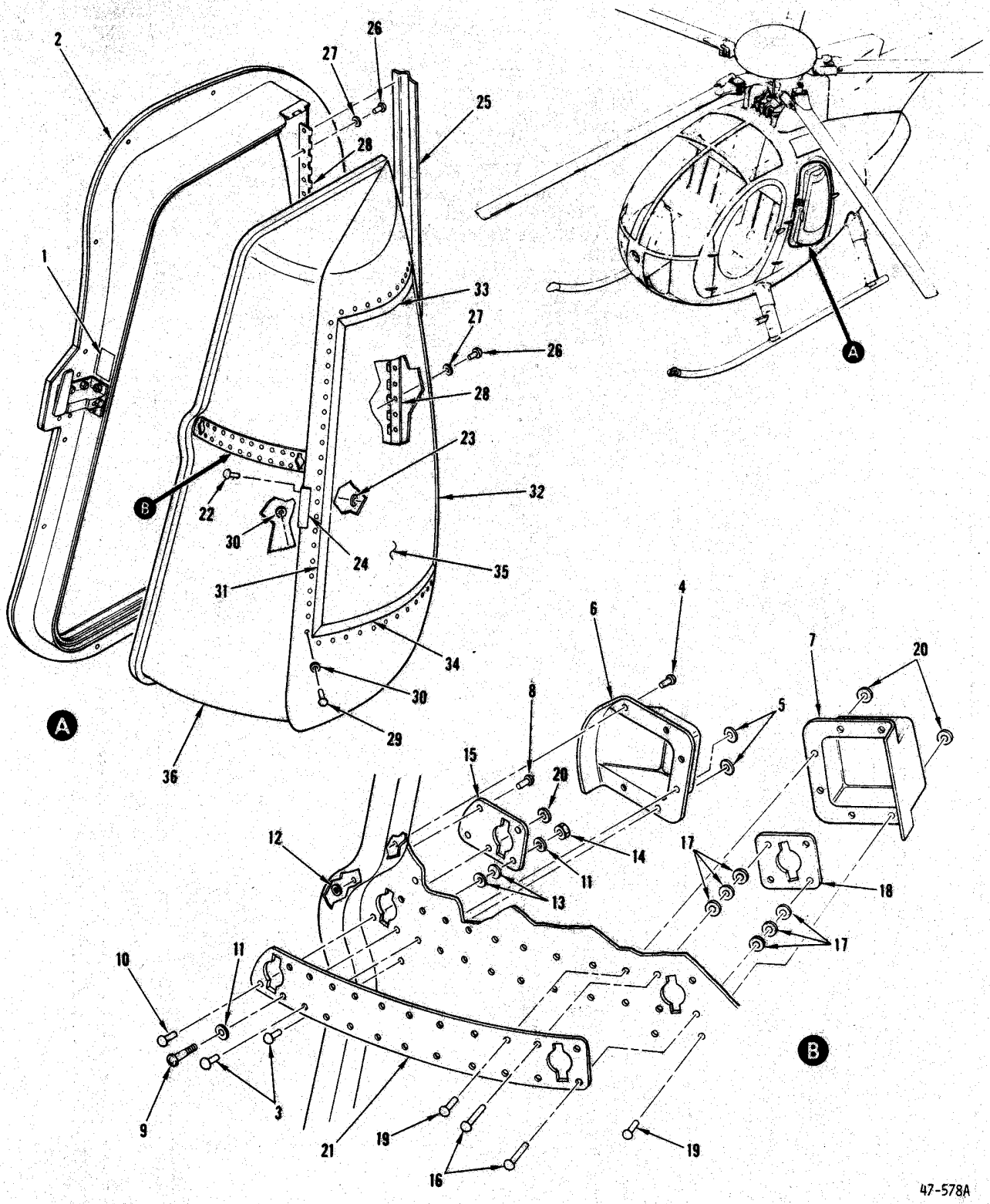

Figure 1-3. Bubble and door litter kit adapter assembly

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-3-	369D290151-501	ADAPTER ASSY, BUBBLE AND DOOR, LITTER.. KIT, LH (See fig. 1-2 for NHA)	REF	
	369D290151-502	ADAPTER ASSY, BUBBLE AND DOOR, LITTER.. KIT, RH (See fig. 1-2 for NHA)	REF	
-1	369D290267-3	. DECAL, INSTRUCTION, LH (Utilized on..... aircraft with light color exterior)	1	
	369D290267-5	. DECAL, INSTRUCTION, LH (Utilized on ..... aircraft with dark color exterior)	1	
	369D290267-4	. DECAL, INSTRUCTION, RH (Utilized on ..... aircraft with light color exterior)	1	
	369D290267-6	. DECAL, INSTRUCTION, RH (Utilized on ..... aircraft with dark color exterior)	1	
-2	369D290151-1	. ADAPTER ASSY, LH (See fig. 1-4 for bkdn) ...	1	
	369D290151-2	. ADAPTER ASSY, RH (See fig. 1-4 for bkdn) ...	1	
-3	MS20470B3	. RIVET	4	
-4	NAS1738B4	. RIVET	2	
-5	NAS620A3	. WASHER	4	
-6	369D290266-5	. CAP, BUBBLE DOOR LOCK, LH.....	1	
	369D290266-3	. CAP, BUBBLE DOOR LOCK, LH..... (For replacement order 369D290266-5)	1	
	369D290266-6	. CAP, BUBBLE DOOR LOCK, RH.....	1	
	369D290266-4	. CAP, BUBBLE DOOR LOCK, RH..... (For replacement order 369D290266-6)	1	
-7	369D290250-3	. CAP, BUBBLE DOOR LOCK, LH.....	1	
	369D290250-4	. CAP, BUBBLE DOOR LOCK, RH.....	1	
-8	NAS1398M-4	. RIVET	2	
-9	NAS601-10P	. SCREW	2	
-10	MS20470B3	. RIVET	1	
-11	AN960PD8	. WASHER	2	
-12	NAS620A5L	. WASHER	1	
-13	HS4105-13	. WASHER	AR	
-14	MS21042L06	. NUT	2	
-15	369D290265	. PLATE, LOCK, LH.....	1	
	369D290264	. PLATE, LOCK, RH.....	1	
-16	MS20470B4	. RIVET	4	
-17	NAS620A5L	. WASHER	AR	
-18	369D290263-1	. PLATE, LOCK, LH.....	1	
	369D290263-2	. PLATE, LOCK, RH.....	1	
-19	MS20470B3	. RIVET.....	6	
-20	NAS620A3	. WASHER	6	
-21	369D290169	. STRIP, RUB	1	
-22	MS20426AD4	. RIVET.....	4	
-23	NAS620A5	. WASHER	4	
-24	369D290164	. HANDLE, DOOR.....	1	
-25	369D290151-11	. SEAL	1	
-26	MS20470B4	. RIVET.....	48	
-27	NAS620A5	. WASHER	48	
-28	369D290157	. HINGE.....	1	
	369D290152-3	. WINDOW ASSY, LH.....	1	
	369D290152-4	. WINDOW ASSY, RH.....	1	
-29	MS20470B4	. . RIVET	71	
-30	NAS620A5	. . WASHER	142	
-31	369D290156-3	. . RETAINER, LH.....	1	
	369D290156-4	. . RETAINER, RH.....	1	

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-3-32	369D290156-5	. . RETAINER, LH	1	
	369D290156-6	. . RETAINER, RH	1	
-33	369D290156-7	. . RETAINER, LH	1	
	369D290156-8	. . RETAINER, RH	1	
-34	369D290156-9	. . RETAINER, LH	1	
	369D290156-10	. . RETAINER, RH	1	
-35	369D290155-3	. . WINDOW, LH	1	
	369D290155-4	. . WINDOW, RH	1	
-36	369D290154-3	. . BUBBLE, LH	1	
	369D290154-4	. . BUBBLE, RH	1	

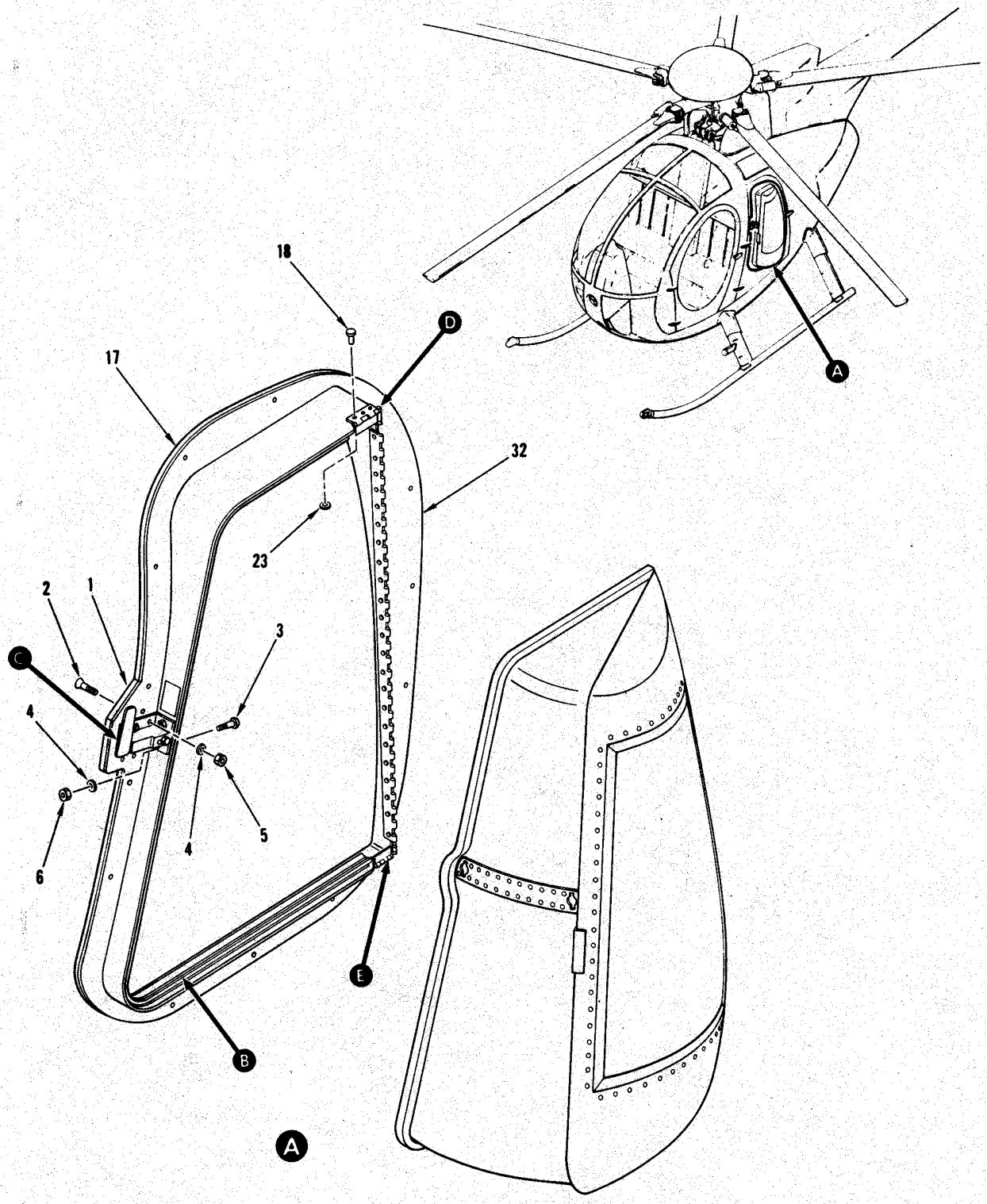

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Figure 1-4. Bubble and door adapter assembly (sheet 1 of 2)

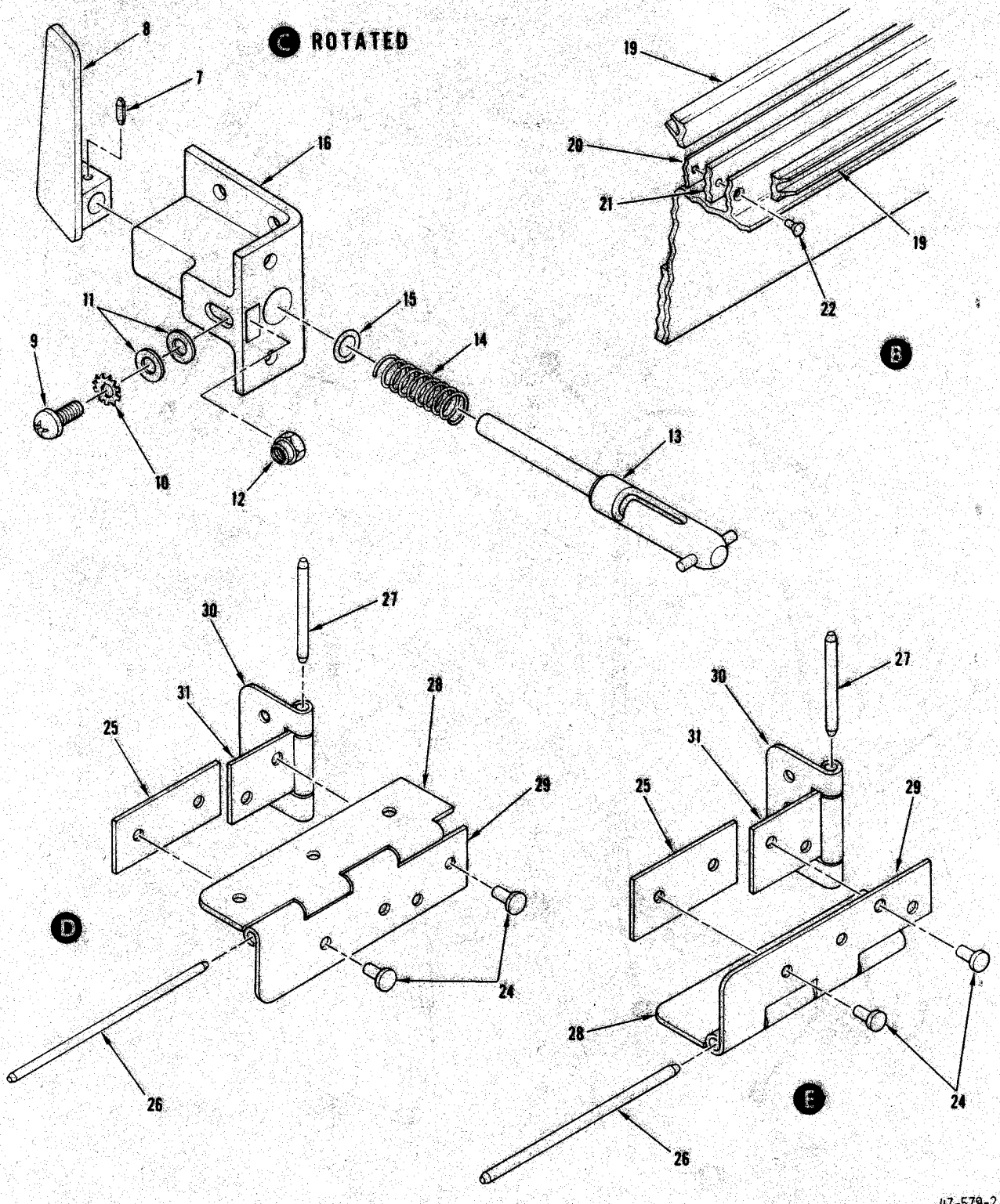


Figure 1-4. Bubble and door adapter assembly (sheet 2 of 2)

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-4-	369D290151-1	ADAPTER ASSY, BUBBLE AND DOOR, LH (See fig. 1-3 for NHA)	1	
	369D290151-2	ADAPTER ASSY, BUBBLE AND DOOR, RH (See fig. 1-3 for NHA)	1	
-1	369D290151-9	. SEAL	2	
-2	HS4727-3-3	. SCREW	4	
-3	NAS1403-4	. SCREW	2	
-4	AN960-10	. WASHER	6	
-5	22K1-02	. NUT	4	
-6	MS21042-3	. NUT	2	
	369D290260-1	. LOCK ASSY, DOOR, LH	1	
	369D290260-2	. LOCK ASSY, DOOR, RH	1	
-7	MS163562-34	. . PIN	2	
-8	369D290258-1	. . HANDLE, LH	1	
	369D290258-2	. . HANDLE, RH	1	
-9	369D290254	. . SCREW	2	
-10	MS35335-67	. . LOCKWASHER	2	
-11	AN960C516L	. . WASHER	AR	
-12	MS21045L5	. . LOCKNUT	2	
-13	369D290255-3	. . BOLT, LH	1	
	369D290255-4	. . BOLT, RH	1	
-14	C0480-051-15005	. . SPRING	2	
	C0480-051-1500M	. . SPRING (Intrch C04801-051-15005)	2	
-15	MS28775-011	. . O-RING	2	
-16	369D290259	. . HOUSING	2	
-17	369D290151-5	. SEAL	1	
-18	MS20426B3	. RIVET	10	
-19	369D290151-7	. SEAL	1	
-20	369D290165	. STRIP, DOOR ADAPTER	1	
-21	369D290166	. GUIDE	1	
-22	MS20470B3	. RIVET	28	
-23	NAS620A3	. WASHER	10	
	369D290168-1	. COVER ASSY, LH	1	
	369D290168-2	. COVER ASSY, RH	1	
-24	MS20426AD3	. . RIVET	AR	
-25	369D290168-11	. . FILLER	1	
-26	369D290168-13	. . PIN	1	
-27	369D290168-15	. . PIN	1	
-28	369D290168-3	. . HINGE, HALF, LH	1	
	369D290168-4	. . HINGE, HALF, RH	1	
-29	369D290168-5	. . HINGE, HALF, LH	1	
	369D290168-6	. . HINGE, HALF, RH	1	
-30	369D290168-7	. . HINGE, HALF, LH	1	
	369D290168-8	. . HINGE, HALF, RH	1	
-31	369D290168-9	. . HINGE, HALF	1	
-32	369D290153-3	. ADAPTER, DOOR, LH	1	
	369D290153-4	. ADAPTER, DOOR, RH	1	

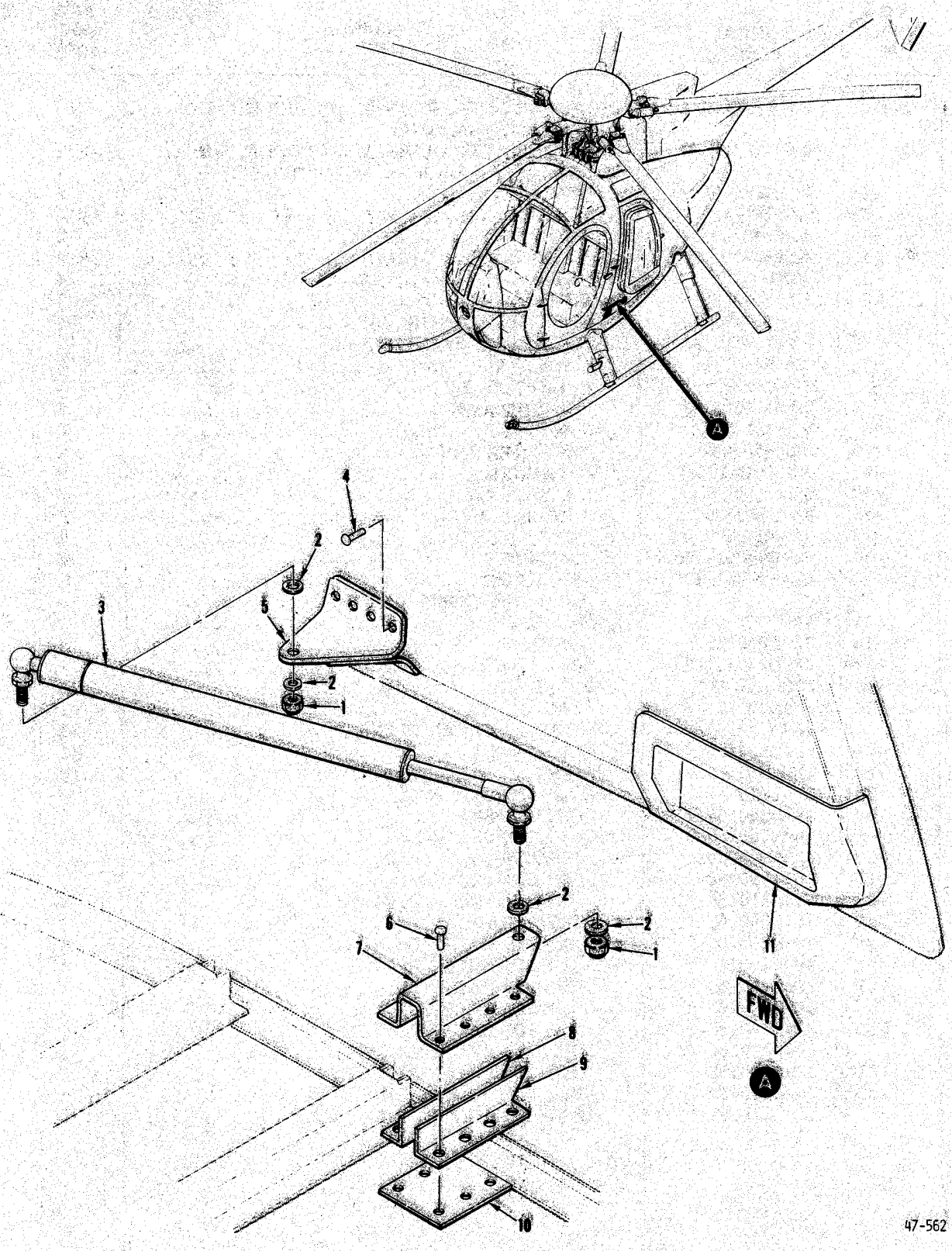


Figure 1-5. Prop installation

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-5-	369D290230-501	PROP INSTL, REAR DOOR, LITTER KIT, LH . . . (See fig. 1-1 for NHA)	REF	A
	369D290230-1	PROP INSTL, REAR DOOR, LITTER KIT, LH . . . (For replacement order 369D02301-501) (See fig. 1-1 for NHA)	REF	B
	369D290230-502	PROP INSTL, REAR DOOR, LITTER KIT, RH . . . (See fig. 1-1 for NHA)	REF	A
	369D290230-2	PROP INSTL, REAR DOOR, LITTER KIT, RH . . . (For replacement order 369D290230-502) (See fig. 1-1 for NHA)	REF	B
-1	MS16228-5C	. NUT	2	
-2	AN960PD516L	. WASHER	4	
-3	369D290247	. SPRING ASSY, GAS	1	B
-4	MS90354-0502	. RIVET	7	
-5	369D290231-3	. BRACKET ASSY	1	
-6	MS90354-0502	. RIVET	8	
-7	369D290231-9	. STIFFENER, LH	1	
	369D290231-10	. STIFFENER, RH	1	
-8	369D290231-12	. CLIP	1	
-9	369D290231-11	. CLIP	1	
-10	369D290231-13	. DOUBLER	1	
-11	369D290245-3	. COVER, LH	1	
	369D290245-4	. COVER, RH	1	

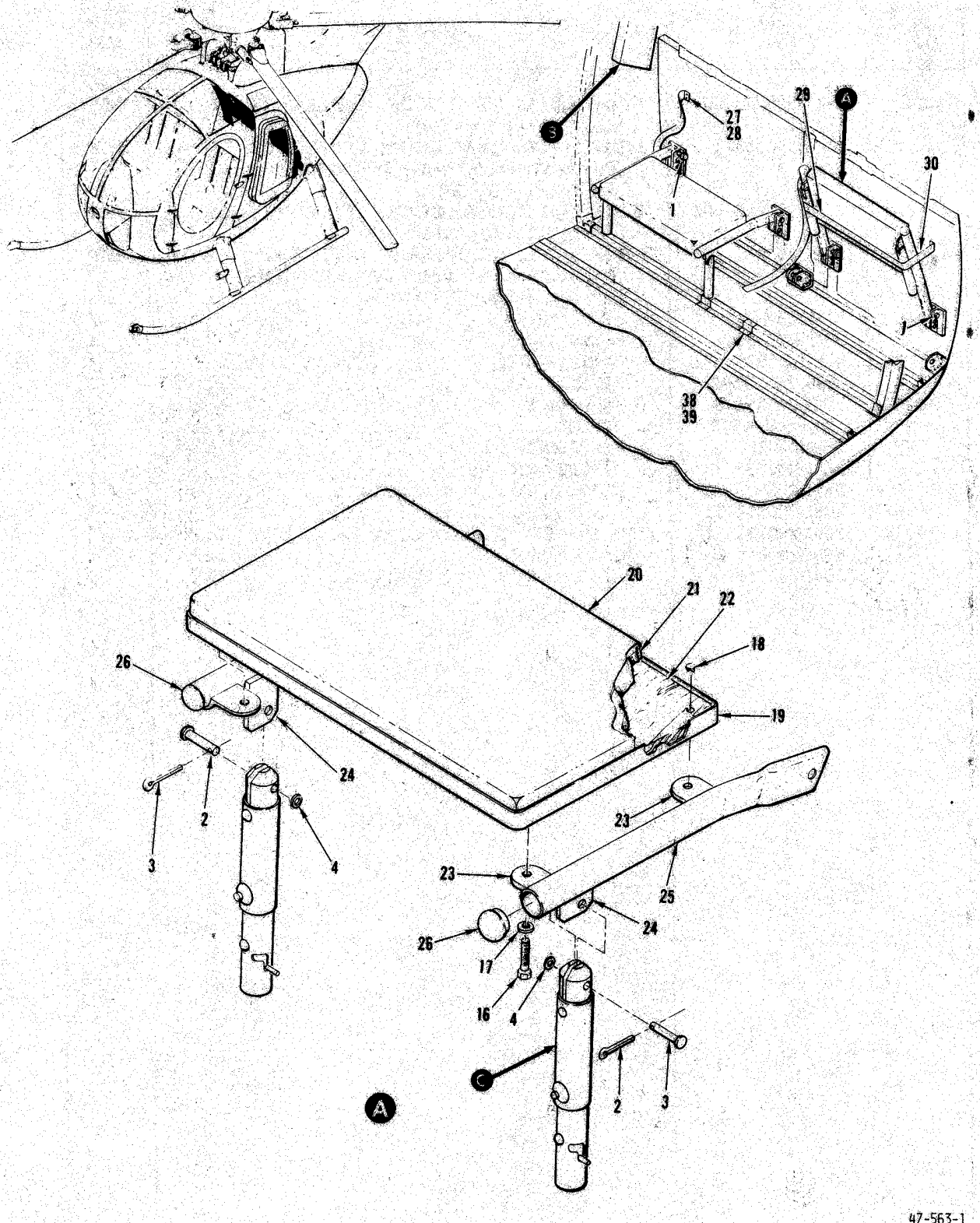


Figure 1-6. Attendant seat installation (sheet 1 of 2)

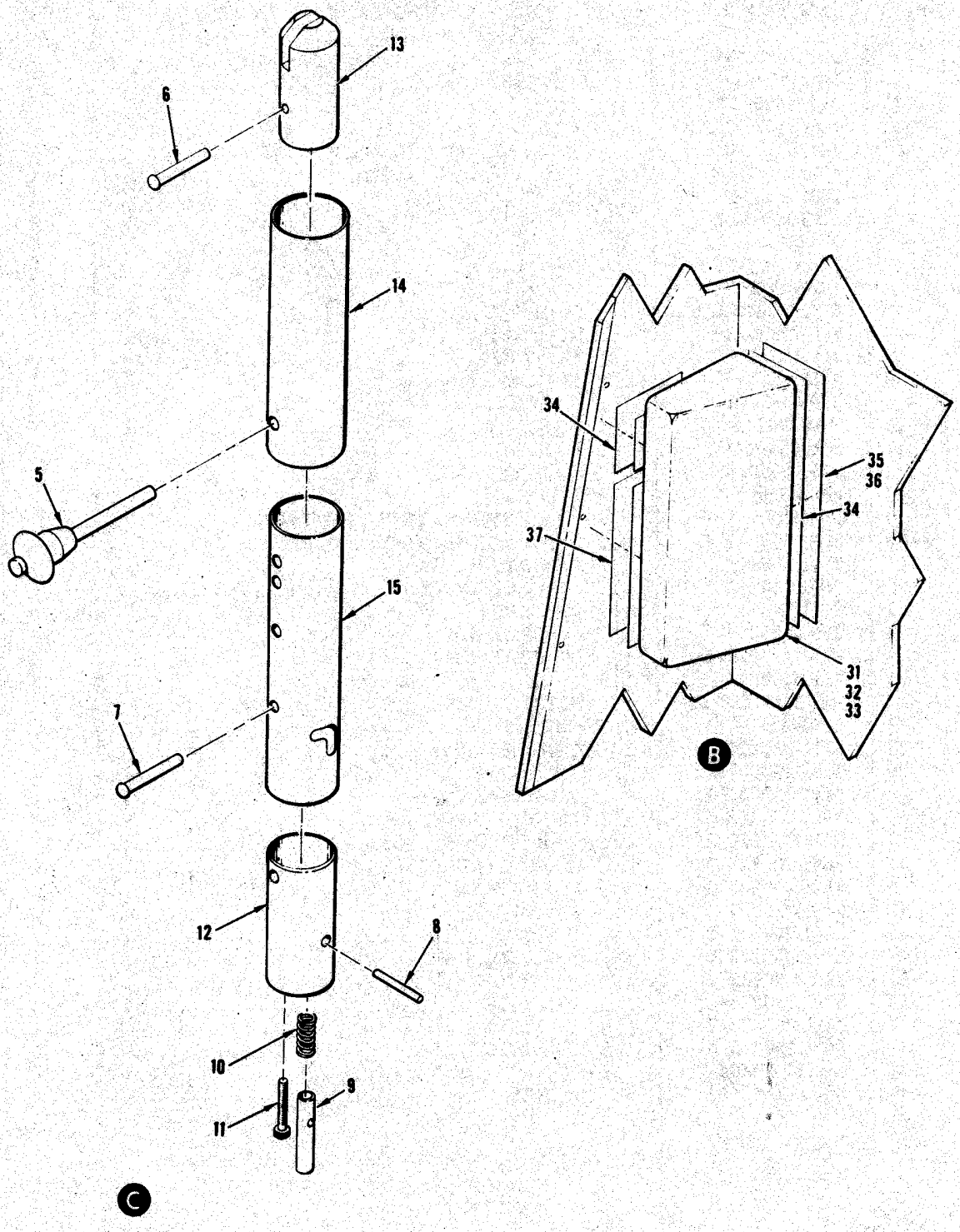


Figure 1-6. Attendant seat installation (sheet 2 of 2)

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-6-	369D290223	SEAT INSTL, ATTENDANT LITTER KIT (See fig. 1-1 for NHA)	REF	
-1	NAS1333AS10	. PIN	4	
	369D290221	. SEAT ASSY	2	
-2	MS24665-170	. . PIN	2	
-3	MS20392-3C31	. . PIN	2	
-4	AN960-416C	. . WASHER	2	
-5	NAS133A3S10	. . PIN	2	
-6	MS20615-4M	. . RIVET	4	
-7	MS20470AD4	. . RIVET	2	
-8	NAS561-4-14	. . PIN	2	
-9	369H6557-35	. . PIN, LOCK	2	
-10	LC022C9	. . SPRING	2	
-11	NAS1351C08LN12	. . SCREW	2	
-12	369H6557-33	. . HOUSING	2	
-13	369H6557-37	. . FITTING	2	
-14	369H6557-17	. . TUBING	2	
-15	369H6557-19	. . TUBING	2	
-16	NAS1304-4	. . BOLT	4	
-17	NAS620-416L	. . WASHER	4	
	369D290219	. . CUSHION ASSY	1	
-18	SS-58698	. . . TEENUT	4	
-19	369D290219-9	. . . COVERING, VINYL (BOTTOM)	AR	
-20	369D290219-7	. . . COVERING, VINYL (TOP)	AR	
-21	369D290219-5	. . . CUSHION	1	
-22	369D290219-3	. . . PLATFORM	1	
-23	369D290218	. . FITTING	4	
-24	369D290217-3	. . FITTING, LH	1	
	369D290217-4	. . FITTING, RH	1	
-25	369D290216	. . TUBE	2	
-26	HS51248-K1110	. . PLUG	2	
-27	MS20426A4	. RIVET	6	
-28	369D290223-3	. DOUBLER	6	
-29	369D290220-13	. BELT ASSY	1	
-30	369D290220-11	. BELT ASSY	2	
	369D290222-1	. BACKREST ASSY, LH	1	
	369D290222-2	. BACKREST ASSY, RH	1	
-31	369D290222-7	. . TAPE, HOOK, LH	1	
	369D290222-9	. . TAPE, HOOK, RH	1	
-32	369D290222-5	. . COVERING, VINYL	AR	
-33	369D290222-3	. . CUSHION, LH	1	
	369D290222-4	. . CUSHION, RH	1	
-34	369D290233-9	. TAPE, PILE	2	
-35	369D290233-8	. TAPE, PILE	1	
-36	369D290233-7	. TAPE, PILE	1	
-37	369D290223-5	. TAPE, PILE	2	
-38	NAS1919M04-2	. RIVET	12	
-39	369A2508-191	. BRACKET	2	

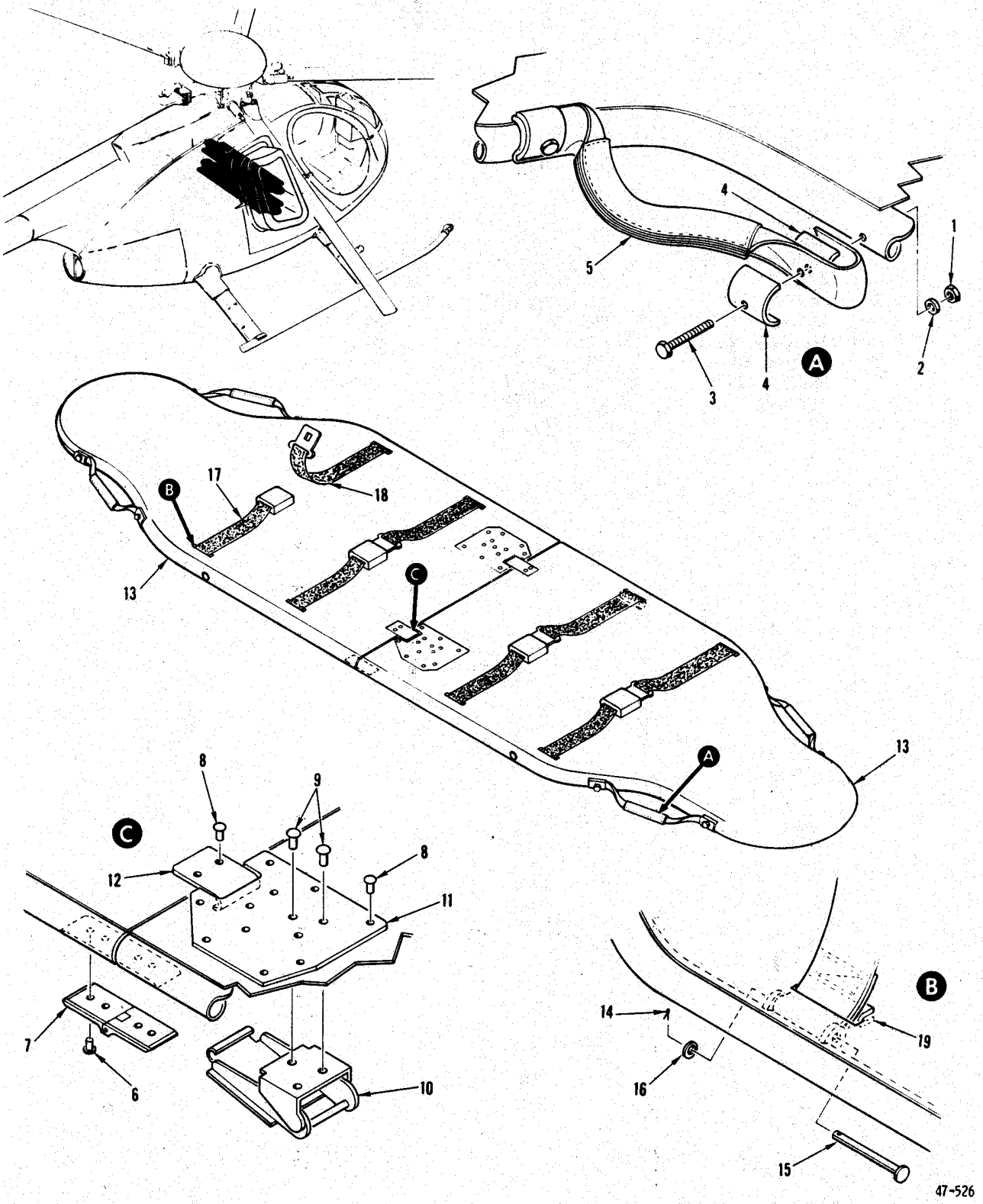


Figure 1-7. Litter kit assembly

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-7-	369D290200	LITTER KIT ASSY (See fig. 1-1 for NHA)	REF	
-1	MS21083N4	. NUT	8	
-2	AN960C416	. WASHER	8	
-3	NAS1304-25	. BOLT	8	
-4	369D290228	. WASHER	16	
-5	369D290209	. HANDLE	4	
-6	MS90353-06	. RIVET.	8	
-7	369D290207	. HINGE.	2	
-8	MS20470AD6	. RIVET.	6	
-9	MS20470AD4	. RIVET.	26	
-10	H462-3	. LATCH	2	
-11	369D290229-3	. BRACKET	2	
-12	369D290229-5	. BRACKET	2	
-13	369D290201	. LITTER, HALF	2	
-14	MS24665-153	. PIN, COTTER	8	
-15	MS20392-2C79	. PIN.	8	
-16	AN960-10L	. WASHER	8	
-17	369H92723-5	. BELT ASSY	4	
-18	369H92723-3	. BELT ASSY	4	
-19	896	. EXTRUSION	8	

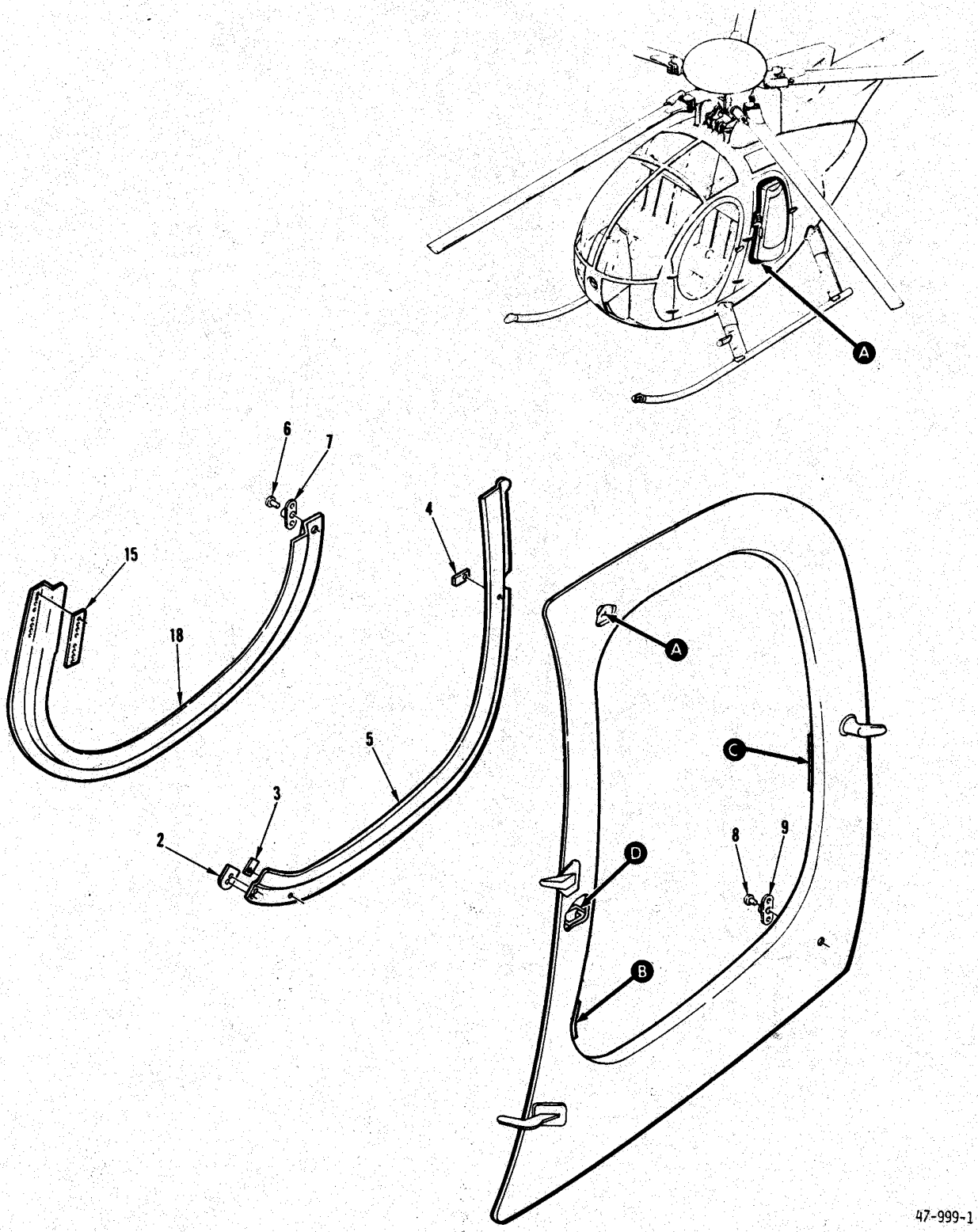


Figure 1-8. Litter door structural installation (sheet 1 of 2)

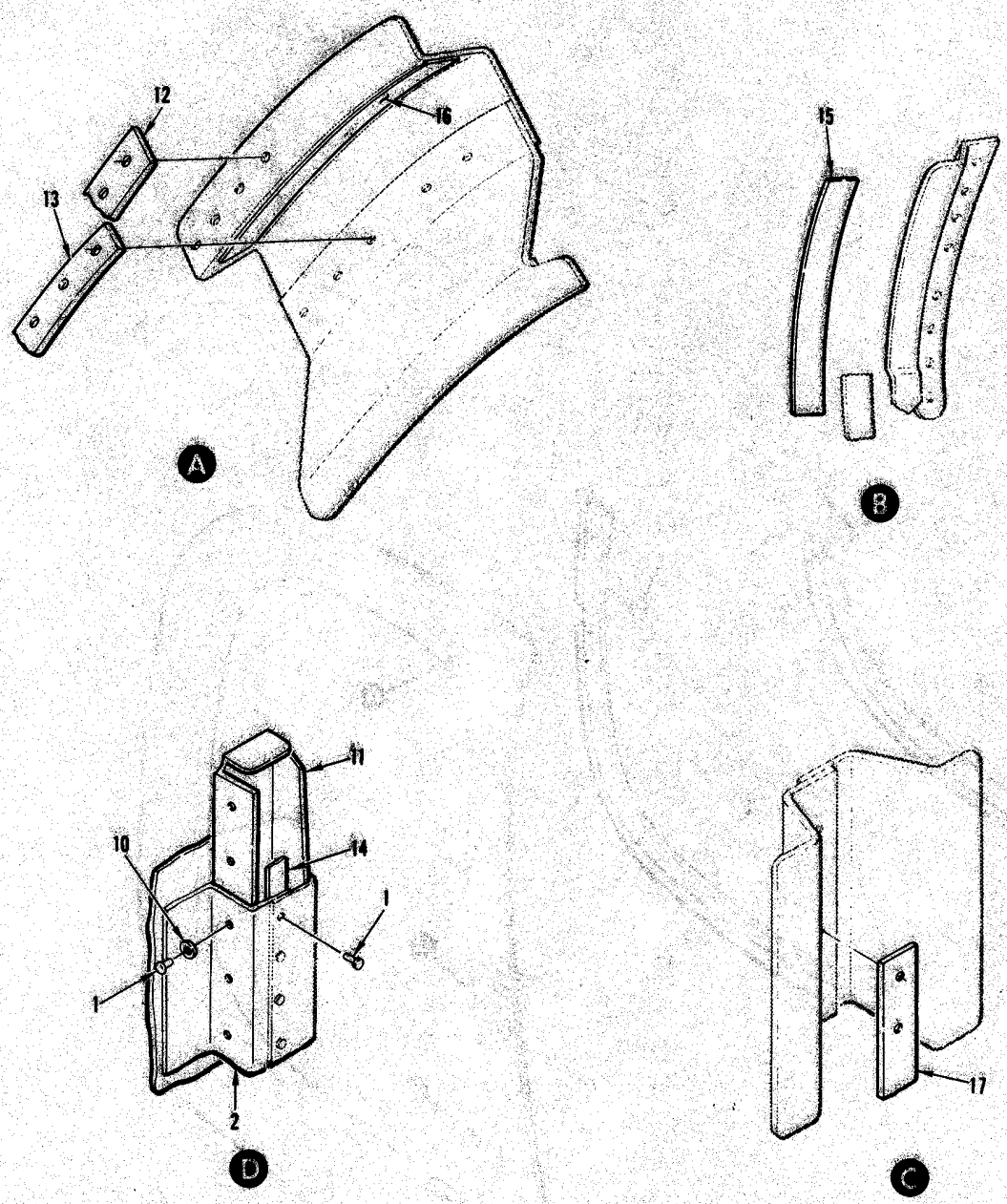


Figure 1-8. Litter door structural installation (sheet 2 of 2)

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-8-	369H92702-71	STRUCTURE INSTL, LITTER DOOR, LH. . . . . (See fig. 1-2 for NHA)	REF	
	369H92702-72	STRUCTURE INSTL, LITTER DOOR, RH. . . . . (See fig. 1-2 for NHA)	REF	
-1	MLSPB4	. RIVET.	AR	
	369H92702-23	. RETAINER ASSY, WINDOW, LH	1	
	369H92702-24	. RETAINER ASSY, WINDOW, RH	1	
-2	369H92702-27	. . CLIP	2	
-3	369H92702-29	. . CLIP	24	
-4	369H92702-55	. . CLIP	2	
-5	369H92702-25	. . RETAINER	1	
-6	MS20426AD3	. RIVET.	AR	
-7	MS21059-3	. NUTPLATE	15	
-8	MS20426AD2	. RIVET.	AR	
-9	NAS697C06M	. NUTPLATE	3	
-10	AN960PD4L	. WASHER	5	
-11	369H92702-15	. CHANNEL, LH.	1	
	369H92702-16	. CHANNEL, RH.	1	
	369H92702-31	. ZEE ASSY, LH.	1	
	369H92702-32	. ZEE ASSY, RH.	1	
-12	369H92702-49	. . STRIP, BACKUP, LH.	1	
	369H92702-50	. . STRIP, BACKUP, RH.	1	
-13	369H92702-59	. . ZEE, LH	1	
	369H92702-60	. . ZEE, RH	1	
-14	369H92702-41	. . STRIP, BACKUP, LH.	1	
	369H92702-42	. . STRIP, BACKUP, RH.	1	
-15	369H92702-47	. . STRIP, BACKUP	2	
-16	369H92702-51	. . STRIP, BACKUP, LH.	1	
	369H92702-52	. . STRIP, BACKUP, RH.	1	
	369H92702-11	. ZEE ASSY, LH.	1	
	369H92702-12	. ZEE ASSY, RH.	1	
-17	369H92702-43	. . STRIP, BACKUP, LH.	1	
	369H92702-44	. . STRIP, BACKUP, RH.	1	
-18	369H92702-13	. . ZEE, LH	1	
	369H92702-14	. . ZEE, RH	1	

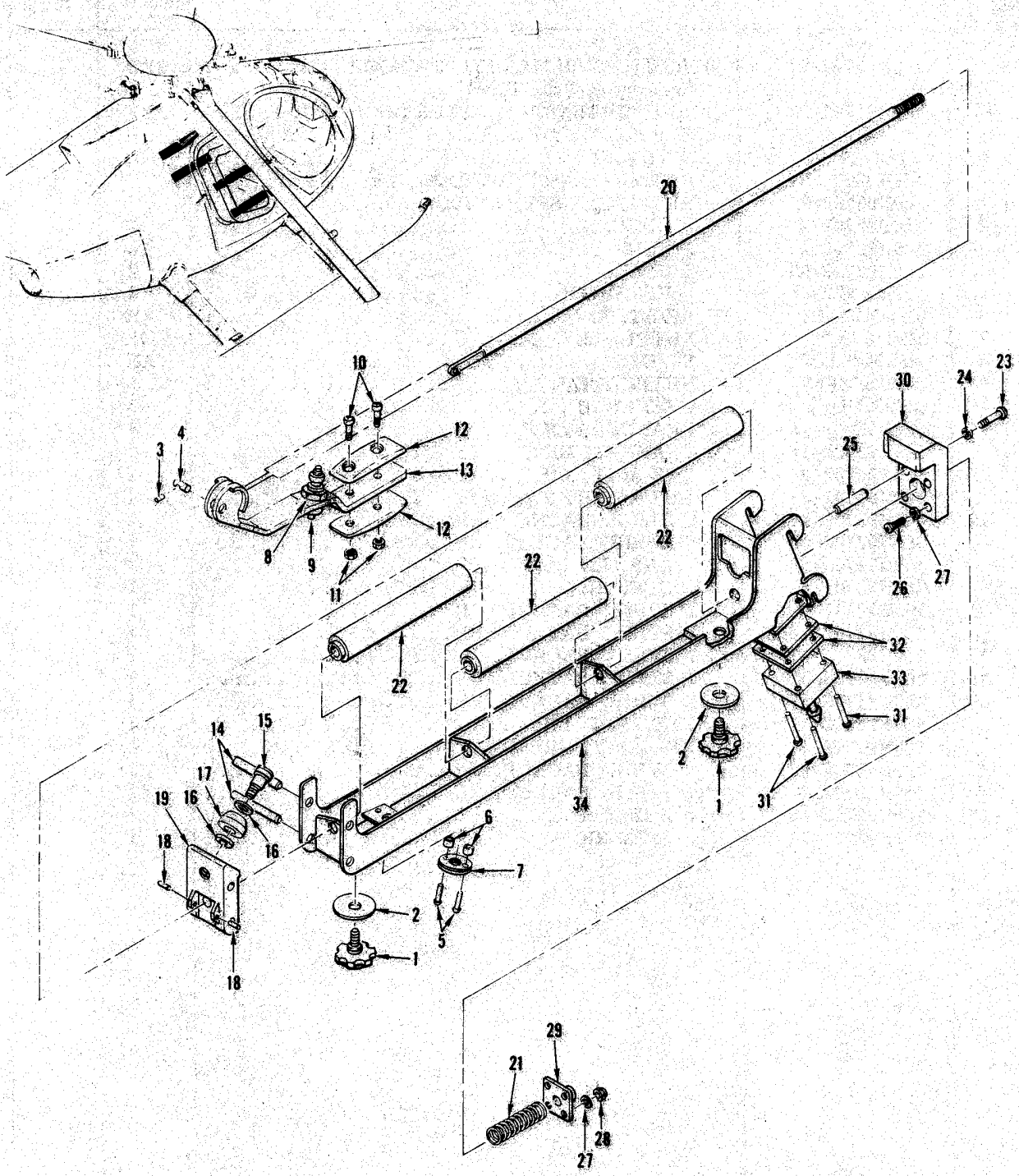


Figure 1-9. Litter kit support arm assembly

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-9-	369D290190	ARM ASSY, LITTER KIT SUPPORT ..... (See fig. 1-1 for NHA)	REF	
-1	4054	. THUMBSCREW	2	
-2	AN960C416L	. WASHER	2	
-3	MS9048-007	. PIN, SPRING	1	
-4	369D290198	. PIN	1	
-5	MS20470AD3	. RIVET	2	
-6	NAS42HT3-8	. SPACER	2	
-7	53433-1	. RECEPTACLE	1	
	369D290243	. HANDLE ASSY	1	
-8	AN316C-10	. . NUT	1	
-9	53433	. . PIN	1	
-10	NAS1190-04P8	. . SCREW	2	
-11	NAS671C4	. . NUT	2	
-12	369D290244	. . GRIP, HANDLE	2	
-13	369D290184	. . HANDLE	1	
-14	MS9048-178	. PIN, SPRING	2	
	369D290211	. BRACKET ASSY, ROLLER	1	
-15	MS51975-17	. . SCREW	1	
-16	AN960C616L	. . WASHER	2	
-17	369D290212	. . ROLLER	1	
-18	MS9390-160	. . PIN	2	
-19	369D290213	. . BRACKET, ROLLER	1	
-20	369D290194-11	. ROD	1	
-21	C0720-081-1250	. SPRING	1	
-22	369D290193	. ROLLER	3	
	369D290228	. LUG ASSY	1	
-23	NAS623-2-2	. . SCREW	1	
-24	AN960C8	. . WASHER	1	
-25	369D290210	. . PLUNGER	1	
-26	NAS602-12P	. . SCREW	4	
-27	NAS620C8	. . WASHER	8	
-28	MS210B3C08	. . NUT	4	
-29	369D290242	. . FITTING	1	
-30	369D290195	. . LUG	1	
-31	MS20470AD3	. RIVET	4	
-32	369D290197	. SPACER	2	
-33	9245	. CATCH	1	
-34	369D290189	. ARM, SUPPORT	1	

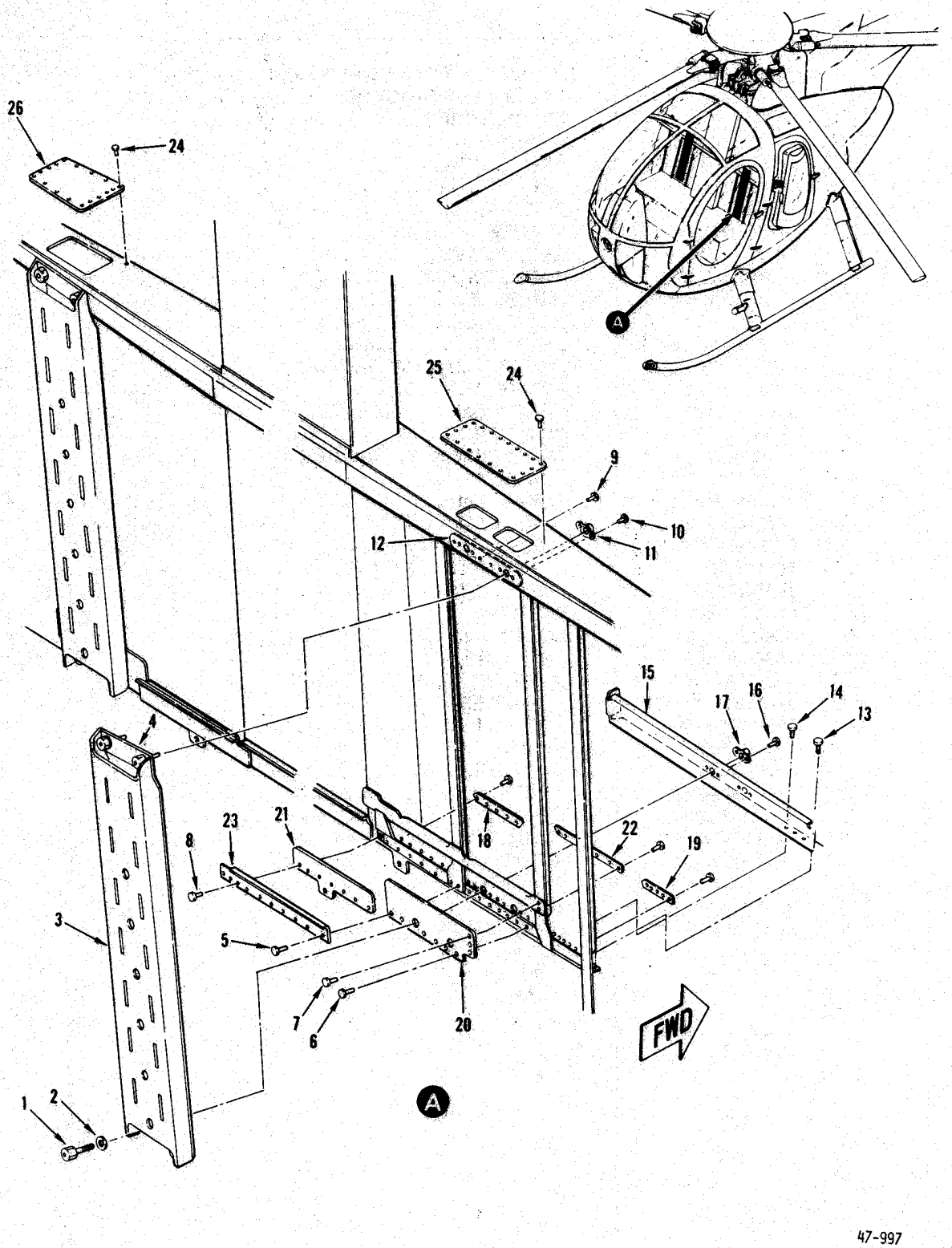


Figure 1-10. Vertical canted station 78.50 litter kit support installation

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
1-10-	369D290171	SUPPORT INSTL, VERTICAL, CANTED STA. . . . 78.50 LITTER KIT (See fig. 1-1 for NHA)	REF	
-1	HS734-19	. BOLT	8	
-2	AN960-416L	. WASHER	8	
	369D290180-1	. SUPPORT ASSY, LH	1	
	369D290180-2	. SUPPORT ASSY, RH	1	
-3	369D290180-3	. . CHANNEL, LH	1	
	369D290180-4	. . CHANNEL, RH	1	
-4	369D290180-5	. . PLATE, LH	1	
	369D290180-6	. . PLATE, RH	1	
-5	MS20470AD4	. RIVET	AR	
	NAS1398D4	. RIVET (Intrch MS20470AD4)	AR	
-6	MS20426AD3	. RIVET	AR	
	NAS1399D3	. RIVET (Intrch MS20470AD4)	AR	
-7	MS20470AD3	. RIVET	AR	
	NAS1398D3	. RIVET (Intrch MS20426AD3)	AR	
-8	MS20615M3	. RIVET	AR	
	NAS1738M3	. RIVET (Intrch MS20615M3)	AR	
-9	MS20426AD4	. RIVET	AR	
	NAS1399D4	. RIVET (Intrch MS20426AD4)	AR	
	369D290182	. DOUBLER ASSY	2	
-10	MSR0426AD3	. . RIVET	8	
-11	MS21077-4	. . NUTPLATE	4	
-12	369D290182-3	. . DOUBLER	1	
-13	MS20615M4	. RIVET	AR	
	NAS1738M4	. RIVET (Intrch MS20615M4)	AR	
-14	MS20470AD3	. RIVET	AR	
	NAS1739M3	. RIVET (Intch MS20470AD3)	AR	
-15	369D290181-1	. CHANNEL ASSY, LH	1	
	369D290181-2	. CHANNEL ASSY, RH	1	
-16	MS20426AD3	. . RIVET	8	
-17	MS21077-4	. . NUTPLATE	4	
-18	369D290177	. SPACER	2	
-19	369D290178	. SPACER	2	
-20	369D290175	. SPACER	2	
-21	369D290176	. SPACER	2	
-22	369D290179	. SPACER	2	
-23	369D290174-1	. ANGLE, LH	1	
	369D290174-2	. ANGLE, RH	1	
-24	NAS1398D4	. RIVET	AR	
	NAS1738E4	. RIVET (Intrch NAS1398D4)	AR	
-25	369D290173	. COVER, LH	1	
-26	369D298172	. COVER, RH	1	

SECTION 2
MAINTENANCE INSTRUCTIONS

2-1. GENERAL INFORMATION.

2-2. SCOPE.

2-3. This section provides description and maintenance information for the litter kit installation. This information is intended for user-level (field) service and repair.

2-4. REFERENCE DATA.

2-5. Information pertaining to helicopter structural components which interface with the litter kit installation is in the Structural Repair Manual (369D - SRM). Information pertaining to standard helicopter equipment is in HMI - Vol 1 and 369D - IPC.

2-6. DESCRIPTION.

2-7. The litter kit installation consists of two litters, two support assemblies and four special arm supports. The support assemblies are mounted on the aft side of canted bulkhead station 78.50. The arm support assemblies slide into notches provided in the support assemblies. The litters slide across rollers provided in the arm supports and are secured in place with locking mechanisms. Additional equipment includes two bubble doors and prop assemblies for opening bubble doors. Two attendant seats which mount to the aft cargo compartment floor and bulkhead are also provided.

2-8. LITTER INSTALLATION.

2-9. REPLACEMENT OF LITTER INSTALLATION COMPONENTS.

2-10. See figure 1-1 and remove or install sufficient attaching hardware for individual component replacement or repair.

2-11. INSPECTION OF LITTER INSTALLATION.

a. Inspect litters and supporting framework for cracks, corrosion, deformation, and other visible damage.

b. Inspect pivot points and attaching hardware for wear and positive locking.

c. Inspect litter safety belts for worn or frayed condition and loose stitching. If any doubt exists as to belt strength, pull test with a 1500-pound test load as specified in HMI - Vol 1. Replace unserviceable belts.

2-12. REPAIR OF LITTER INSTALLATION.

2-13. Perform tubular weld repairs and repair damaged sheet metal according to instructions in FAA AC 43.13-1, Aircraft Inspection and Repair.

2-14. BUBBLE DOOR INSTALLATION.

2-15. GENERAL.

2-16. The bubble door installation consists of a door frame complete with hinges, door latching mechanism, and a "bubble" window configuration. The bubble window, used with litters installed, is installed on the door frame with an adapter assembly.

2-17. BUBBLE DOOR FRAME.

2-18. The bubble door frame consists of a complete door frame assembly with automatic latching mechanism. Refer to HMI - Vol 1 for inspection and maintenance of the door frame, hinges, and automatic latching mechanism.

2-19. BUBBLE DOOR TROUBLESHOOTING. (Refer to table 2-1.)

2-20. ATTENDANT SEAT INSTALLATION. (Refer to figure 1-6.)

a. Inspect seat and support assemblies and attaching hardware for security of installation, distortion, cracks, breaks, corrosion, or other damage.

b. Inspect backrest assembly, pile tape, cushion assembly, belt assemblies, doublers, and attaching hardware for excessive wear, damage, and security of installation.

2-21. LOCK ASSEMBLY. (Refer to figure 1-4.)

a. Inspect housing (15), lock handles (7), sliding bolt (12), and associated hardware and attach parts for security of installation, cracks, breaks, corrosion, or other damage.

b. Inspect lock assembly for proper function.

Table 2-1. Bubble door troubleshooting

Symptom	Probable Trouble	Corrective Action
Door will not open	Improperly operating (stuck) latching mechanism	Clean and lubricate latching mechanism. If this does not correct, check part functioning; disassemble mechanism and replace any damaged parts. Refer to figure 1-7.
	Defective door prop	Replace door prop. (Refer to figure 1-2.)
Door will not close	Defective door prop	Replace door prop.
	Defective hinge assembly	Clean and lubricate. If this does not correct, disassemble and replace defective parts.
Door is difficult to open and close	Misaligned door and adapter assembly	Adjust.
Door will not open/close	Jammed latching mechanism	Check component functioning; clean and lubricate mechanism; replace defective parts.

2-22. STOWAGE AND USE OF LITTER KIT COMPONENTS.

2-23. STOWAGE OF LITTER KIT COMPONENTS.

2-24. The following operations are required for proper stowage of litter kit components.

a. Stow litters by disengaging latches located on underside of litter.

b. Place all buckle and strap assemblies inside first litter and fold litter in half.

c. Second litter is stowed by placing buckle and strap assemblies outboard of litter.

d. Fold second litter in half and place first litter on top of second litter. (Refer to figure 2-1.)

e. Secure buckle and strap assemblies as shown in figure 2-2.

f. Place stowage bag (23, fig. 1-1) on flat surface. Slide support arm assemblies (26) and support braces (25) into individual compartments of stowage bag. Refer to figure 2-3. Secure flaps on stowage bag.

g. Stow attendant seat assemblies (36, fig. 1-1) by releasing locking pins (9, fig. 1-6) located at bottom of seat supports.

h. Fold attendant seats against aft bulkhead and secure using straps (20 and 22, fig. 1-1) mounted on bulkhead.

i. For stowage of litters and stowage bag, refer to figure 2-4 and perform the following:

(1) Position litters aft of eyebolts on cargo floor.

(2) Place stowage bag on top of litters with support brack compartment aft of litters.

(3) Place two support arm compartments on top of litters.

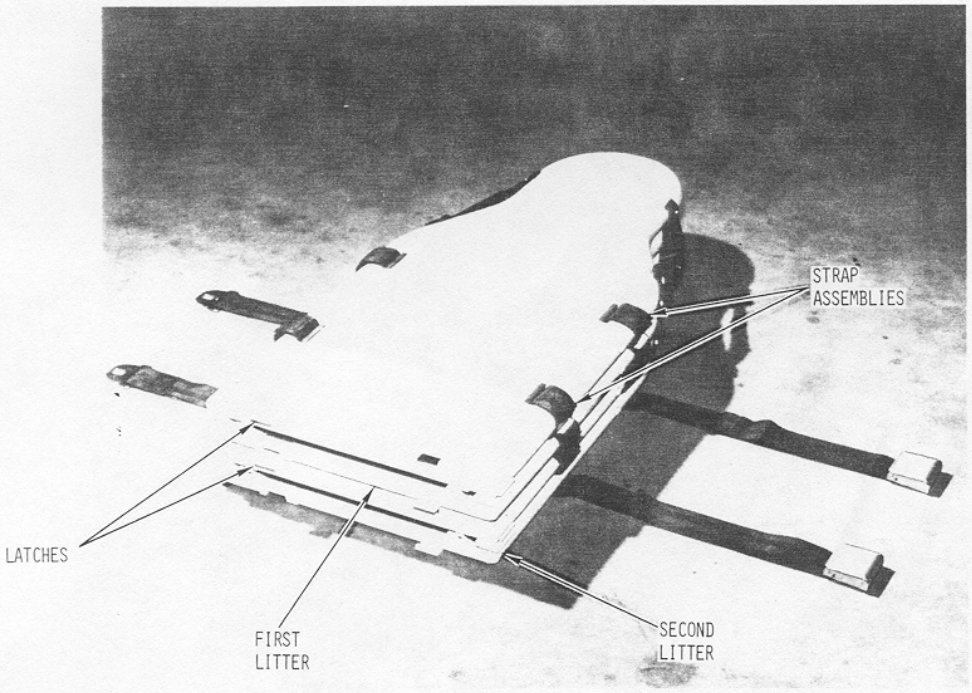
(4) Ensure proper placement of litters and stowage bag and secure components using strap assemblies mounted on bulkhead and cargo floor.

2-25. USE OF LITTER KIT COMPONENTS.

2-26. The following operations are required for proper use of litter kit components. (Refer to figure 2-5 and perform the following):

CAUTION

Litter doors are spring-loaded. Stand clear when opening to avoid contact from the door-opening action.



47-989

Figure 2-1. Litters in position

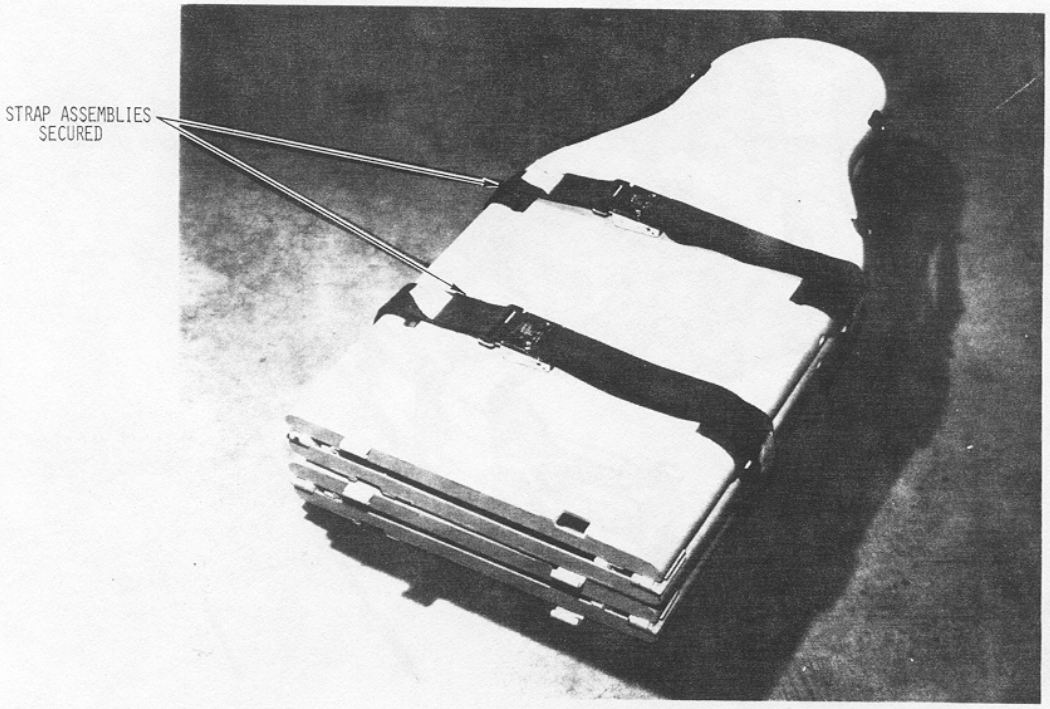


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Figure 2-2. Litters secured

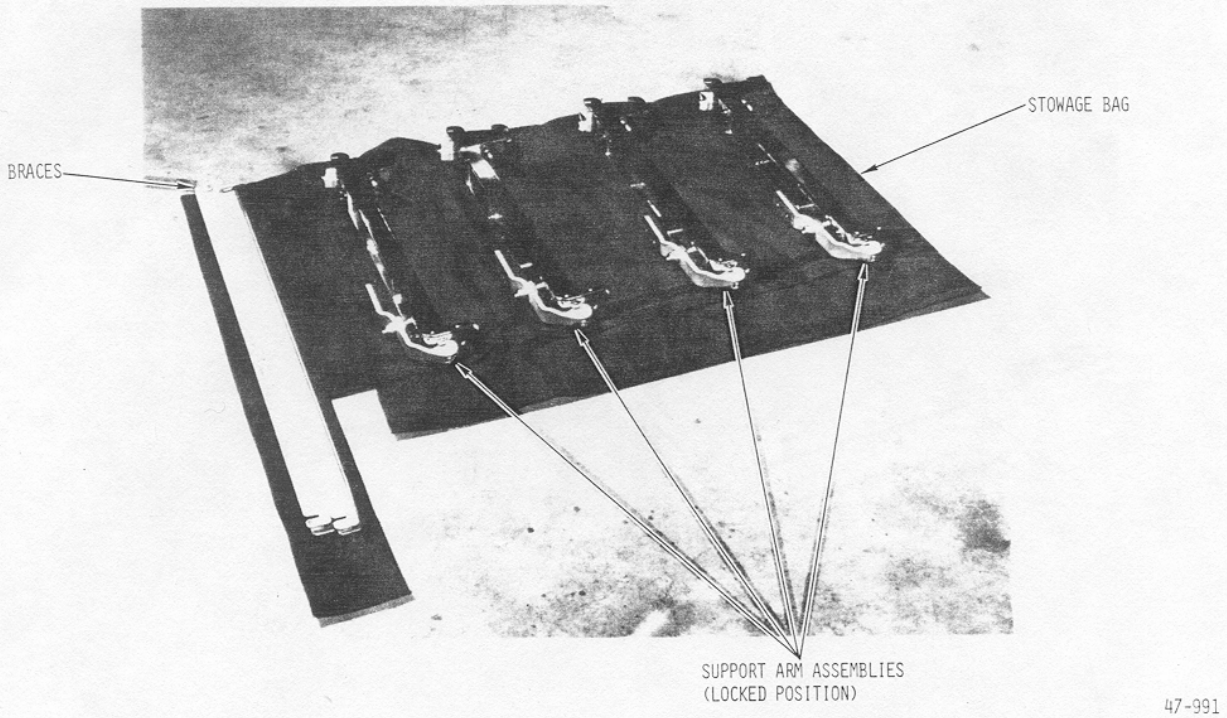


Figure 2-3. Stowage bags and components

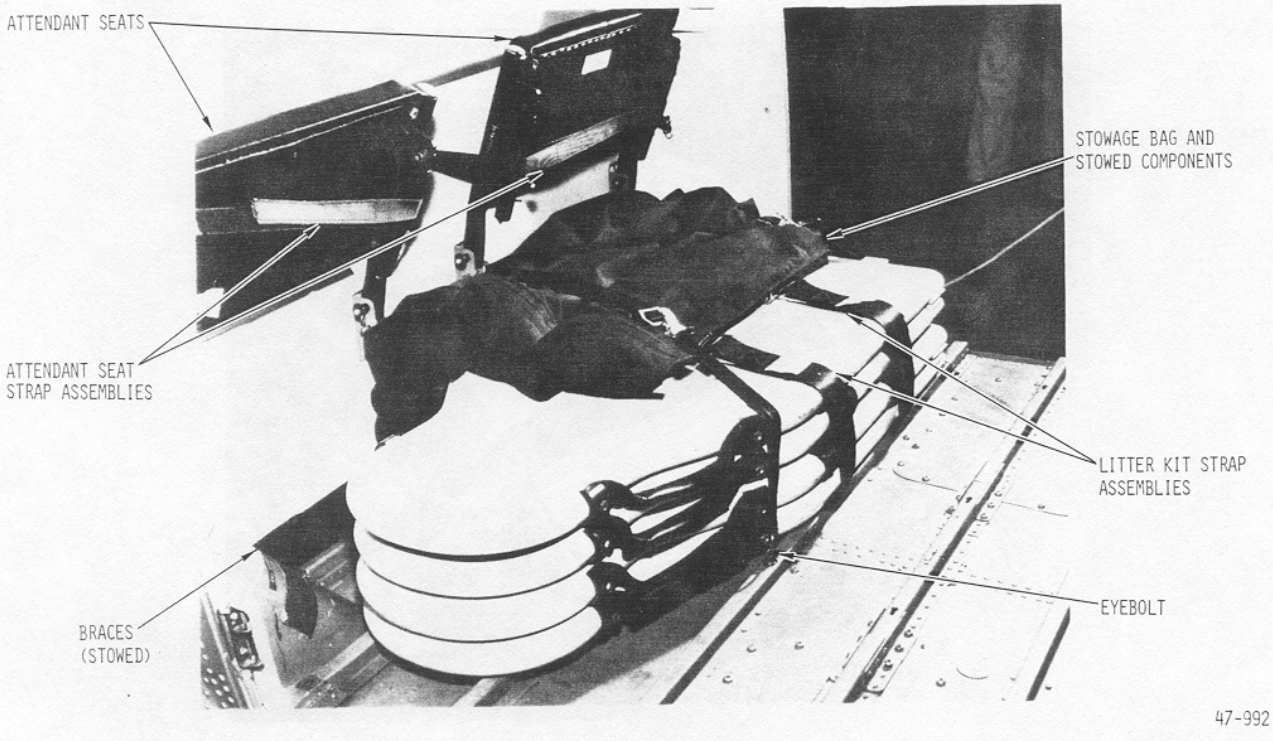


Figure 2-4. Litter components stowed

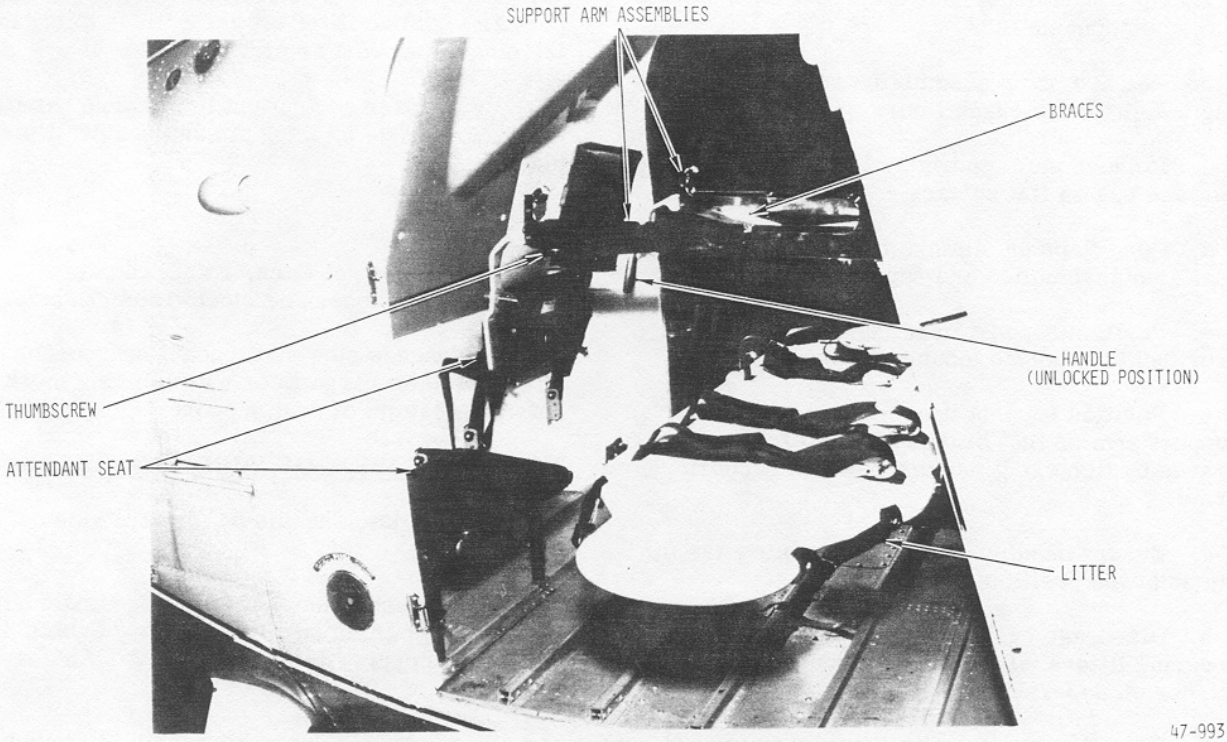


Figure 2-5. Litter kit components installed

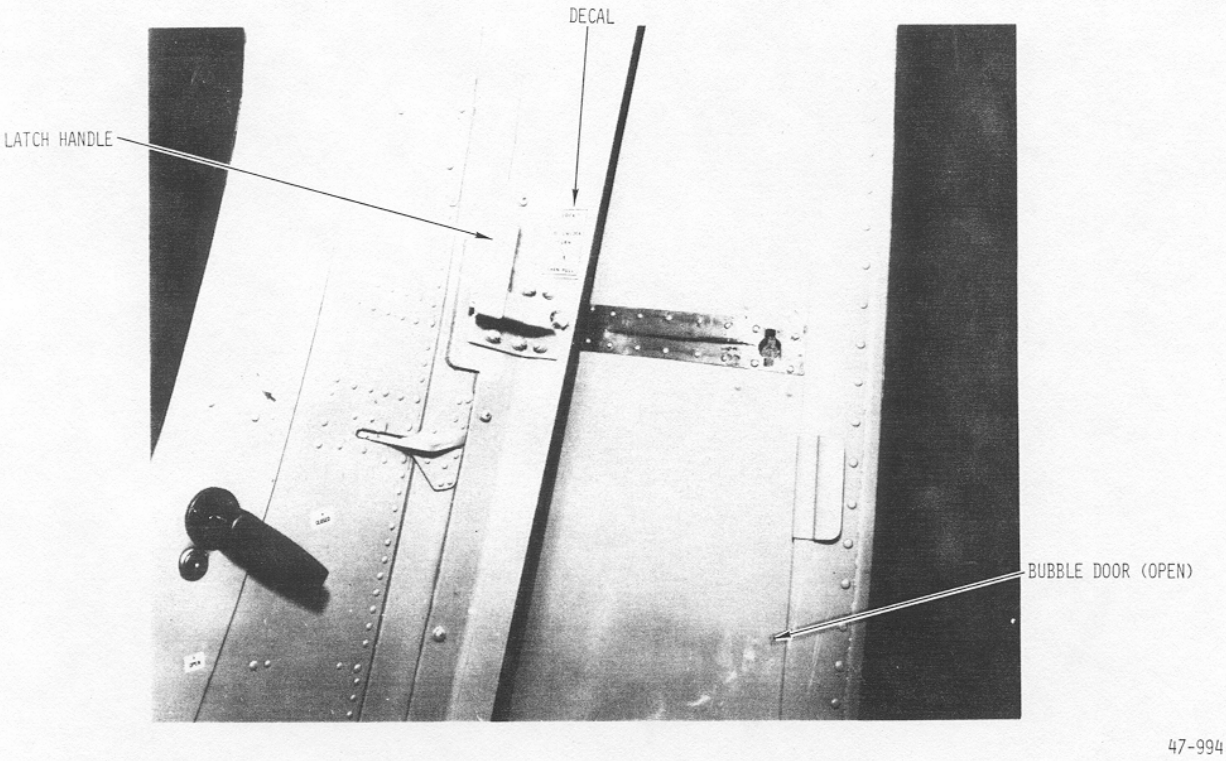


Figure 2-6. Bubble door latch decal

a. Open bubble doors to gain access to stowed litter components.

b. Release strap assemblies securing stowage bag and litters to cargo floor.

c. Remove stowage bag and litters. Place stowage bag on flat surface.

d. Open flaps on stowage bag and remove support arm assemblies and support braces.

e. Position support arm assemblies in slots provided in bulkhead mounted support.

f. Position support braces on underside of support arm so that braces form a cross. Secure braces by tightening thumbscrews on support arms.

g. Ensure handles on arm assemblies are in the unlocked position.

h. Disengage buckle and strap assemblies securing litters. Unfold litters and engage latches on underside of litters.

i. Place litter patient on litter and secure buckle and strap assemblies.

j. Lift litter and patient and position on support arm. Slide litter across rollers to engage latching on support arm.

k. With litter and patient in position, rotate handle to engage latching pin and secure litter in place.

NOTE

If handle does not latch, rotate counterclockwise to loosen or clockwise to tighten.

l. Disengage stowed attendant seat straps and attach seats to cargo floor with latching mechanism on bottom of seat support.

2-27. OPERATION OF BUBBLE DOORS.

a. Locate latch handle on forward side of litter doors.

b. Open bubble doors by rotating handle outboard, then pulling handle forward. Bubble door will swing open. (Refer to figure 2-6 for location of decal.)

c. Close bubble doors by pushing on bubble, thus engaging the latching mechanism.

SECTION 3
INSTALLATION INSTRUCTIONS

3-1. GENERAL INFORMATION.

3-2. SCOPE.

3-3. Procedures in this section may be performed at the operator's discretion and provide complete instructions for initial installation of the litter kit. These procedures are additional to those for maintenance of the litter kit components. Reference is made in the Instructions to Applicable Data in the HMI - Vol 1 to accomplish installation of litter components.

3-4. REFERENCE DATA.

3-5. Table 3-1 lists consumable materials and expendable items required for installation. Items listed in the consumable materials and expendable items table are recommended items and are of a commercial nature that should be procurable locally. Alternate, but equivalent, items are acceptable.

3-6. PREPARATION FOR INSTALLATION.

3-7. Preparation for installation of the litter kit includes the following:

a. Identify all components of litter kit including attaching hardware and components removed to gain access to work areas. Protect all components from damage and foreign matter.

b. Check all electrical switches for OFF position and turn BATT-OFF-EXT switch to OFF.

3-8. REMOVAL OF HELICOPTER EQUIPMENT.

3-9. Before litter kit components are installed, a limited number of existing items must be removed from the helicopter. Refer to HMI - Vol 1 and perform the following:

a. Remove crew and passenger compartment seats.

Table 3-1. Consumable materials and expendable items

Item No.	Material	Specification No. (1)	Commercial Product (2)	
			Name/No.	Manufacturer
1.	Adhesive, epoxy, non-structural	MIL-A-52194	Scotch-Weld EC 1838 (Parts A & B)	3M Co., St. Paul, Minn.
		MIL-A-8623	A 1177B	B. F. Goodrich
2.	Grease	-	130A	Lubriplate Mfg.
3.	Solvent, dry cleaning	P-D-680	(3)	-
4.	Sealant, polymer, non-structural	-	PR 1221, Class B-2	Products Research and Chemical Corp., Burbank, CA

NOTES: (1) Numbers are U. S. A. specifications and standards. The prefix symbols are defined as follows: AMS - American Material Standard; MS - Military Standard; MIL - military specifications; single, double or triple alpha prefix of the same letter - federal specification; AN - Air Force-Navy aeronautical standard; NAS - National Aerospace Standard.

(2) Primary selection. Any equivalent material may be used as an alternate selection.

(3) Use the best comparable grade material when the conformity of available materials of the same type with the listed specification number cannot be determined.

b. Remove the following crew compartment trim panels as required:

(1) Controls tunnel cover

(2) Shoulder beam

(3) Left and right bulkhead panels

(4) Left and right lower aft panels.

c. Remove the following passenger compartment trim panels as required:

(1) Forward bulkhead panel

(2) Left and right door panels

(3) Floor carpeting and floor pan.

d. Remove passenger compartment doors.

3-10. INSTALLATION OF LITTER KIT COMPONENTS.

3-11. The litter kit is shipped with as many parts assembled as possible; however, certain items require assembly at installation. Figures 1-1 thru 1-10 show major components of the litter kit. Detail items listed in these figures are to be used for ordering replacement parts as required. Detailed instructions, along with illustrations, follow for components that require assembly or installation to complete litter kit installation.

a. Position decals (6, fig. 1-1). Clean mounting surface, remove protective backing from decals and install.

b. Position decals (3) as required. Clean mounting surface, remove protective backing from decals, and install.

c. Position decals, 1, 4, and 5). Clean mounting surface, remove protective backing from decals, and install.

d. Locate brackets (31) and mark rivet holes as shown in figure 3-1, view A.

e. Drill rivet holes as required. Deburr rivet holes and clean up drill chips.

f. Position brackets (31, fig. 1-1) and install using rivets (29).

g. Locate and install panel (34) using screws (27 and 28).

h. Locate and drill holes in cargo floor as shown in figure 3-1, view A.

i. Deburr drill holes and clean up drill chips. Install eyebolts (15, fig. 1-1) using rivnuts (16).

j. Locate strap assemblies and secure to eye bolts.

k. Locate strap assembly and existing bracket on aft bulkhead (BL 3.99 approximately). Slide metal ring into position and secure using pin (17).

l. Locate shoulder straps (20, 22) and seat belts (19). Secure straps and belts to existing brackets.

m. Locate stowage bag (23), braces (25), and arm assemblies (26). Place stowage bag on flat surface and slide braces and arm assemblies into compartments provided in stowage bag. Secure flaps on stowage bag.

n. Install V_{ne} cards as required.

3-12. LITTER ASSEMBLIES.

3-13. The litter kit contains two litter assemblies. The litter assemblies consist of two latches, four belt assemblies, and four handles. The individual litters are hinged in the center to accomplish stowage. The two latches are located on the right and left hand side of the litters, and are used to secure the litter in a flat position. The four seat belts, located two on each litter half, are used to secure the litter patient in place on the litter. The four handles, located on the outboard sides of the litter, are used to lift and transport the litter to the helicopter.

3-14. The following operations are required to install the litter assemblies. (Refer to the figures call for in the below operations.)

a. Remove litter assemblies (24, fig. 1-1) from stowed position.

b. Disconnect belt assemblies (17 and 18, fig. 1-7).

c. Remove one litter and place on flat surface.

d. Open litter and secure in flat position using latches (18, fig. 1-2).

e. Place litter patient on litter assembly and fasten belt assemblies (17 and 18, fig. 1-7) to secure patient in place.

f. Using handles (5), lift litter, and slide across arm assemblies (26, fig. 1-1).

g. Rotate handle (5, fig. 1-7) on arm assembly and lock litter in position.

h. Perform steps c. through g. for second litter.

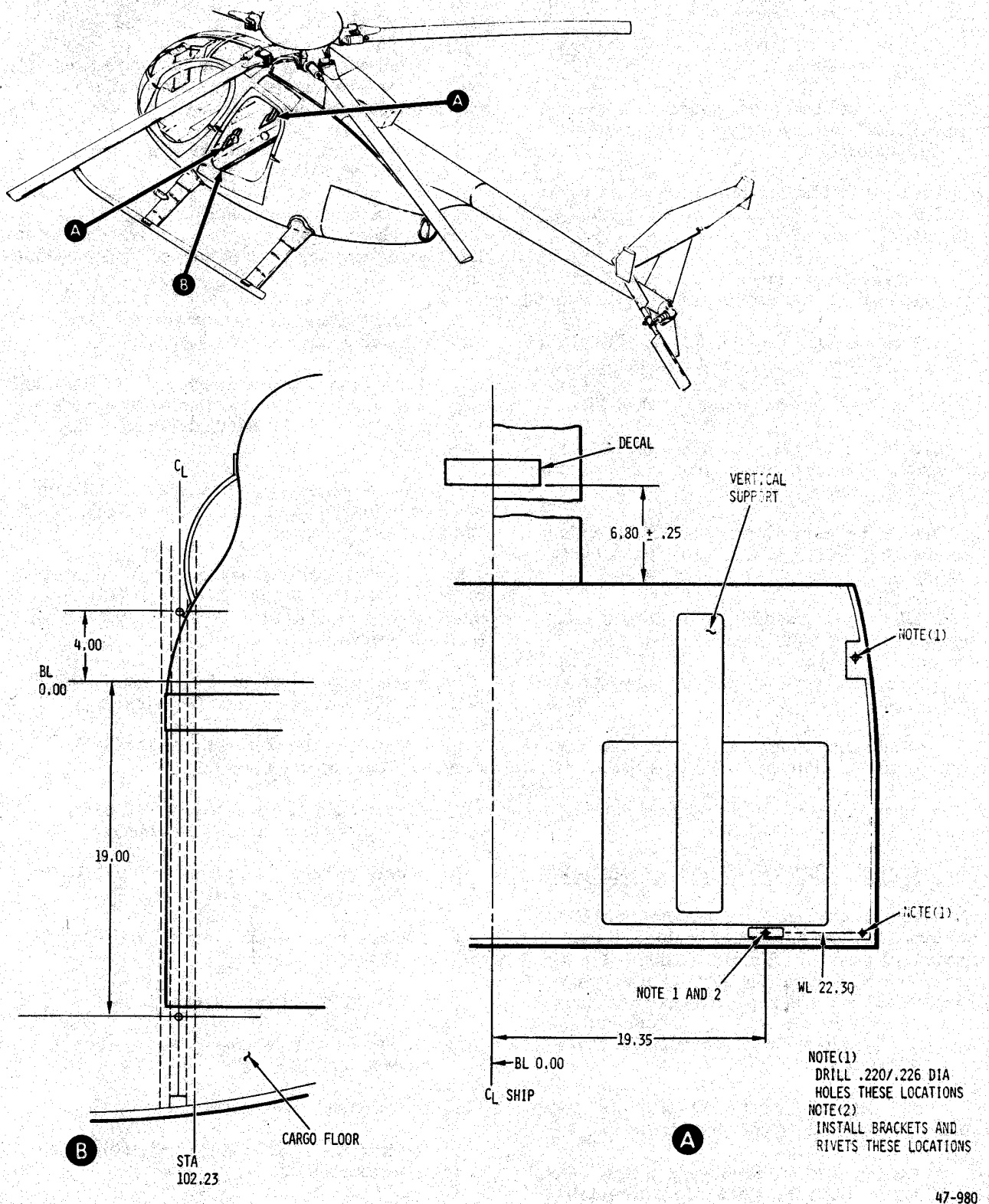


Figure 3-1. Litter kit installation

3-15. ATTENDANT SEATS.

CAUTION

Use care in drilling through cargo floor: do not puncture fuel cells.

a. Remove fuel cell access panels, and temporarily install backing material to protect fuel cells when drilling.

b. Locate existing supports as shown in figure 3-2, view A. Using supports (14 and 15, fig. 1-6) as templates, mark rivet holes.

c. Drill and deburr rivet holes. Install anti-chafing tape on rivets inside fuel cell compartment.

d. Locate pile tape (34, 35, 36, and 37). Refer to figure 3-2, view B and install tape as shown.

e. Install back rest assembly (31 thru 33).

f. Locate doubler (28, fig. 1-6). Using doublers as templates, mark rivet holes as shown in figure 3-2, view C.

g. Drill and deburr rivet holes. Position belt assembly (29 and 30) and doublers. Install with rivets (27).

h. Position seat assembly on existing support fittings and secure using pins (1).

i. Attach seat assembly to floor supports with locking pin (3).

j. Clean all drill chips and foreign material from work area, particularly the tops of fuel cells.

k. Remove temporary backing; close access panels.

3-16. INSTALLATION OF VERTICAL SUPPORT.

3-17. The vertical support installation consists of two supports, the necessary doublers, spacers, and attaching hardware for installation. The two supports are mounted to the aft side of canted bulkhead 78.50 and are used to support the four arm assemblies for the litters. Accomplish these operations in order to permit installation of the vertical supports:

a. Identify all components and attaching hardware for the vertical support installation.

b. Verify removal of all necessary equipment, components, and attaching hardware from helicopter to provide access to work area.

c. Predetermine and mark all existing rivets that require removal. (Refer to figure 3-3.)

d. Using a drill motor and proper drill sizes, drill out all existing rivets as required.

e. A portion of the existing structure must be modified before installation of supports can be accomplished. (Refer to figure 3-3, view D.)

f. Verify removal of all existing rivets and modification of structure.

g. Locate channel assembly (3, fig. 1-10). Position channel assembly in place and drill pilot holes using existing rivet patterns. Cleco channel in place.

h. Locate spacer (21) and position in place. Drill pilot holes as required and cleco in place.

i. Locate angle (23) and spacer (21). Position angle and spacer in place and drill pilot holes through angle, spacer and channel assembly. Cleco in place.

j. Locate spacer (18, 19, and 22). Position spacers in place and drill pilot holes as required. Cleco spacer in place.

k. Verify proper positioning of all components: channel assembly, spacer (21), angle (23), and spacers (18, 19, 20, 22). Drill remaining rivet holes as required.

l. Install channel assembly (15) using rivets (13, 14, 16). Remove clecos as required.

m. Install spacers (20) using rivets (5, 6, 7). Remove clecos as required.

n. Install angle (23) and spacer (21) using rivets (5, 8). Remove clecos as required.

o. Install spacers (18, 19, and 23) using rivets (8, 14). Remove clecos as required.

p. Position doubler (12); mark and drill attachment holes as required.

q. Install doubler using rivets (9, 10).

r. Position cover (26); mark and drill attachment holes as required.

s. Install cover using rivet (24).

t. Position cover (25); mark and drill attachment holes as required.

u. Install cover using rivets (24).

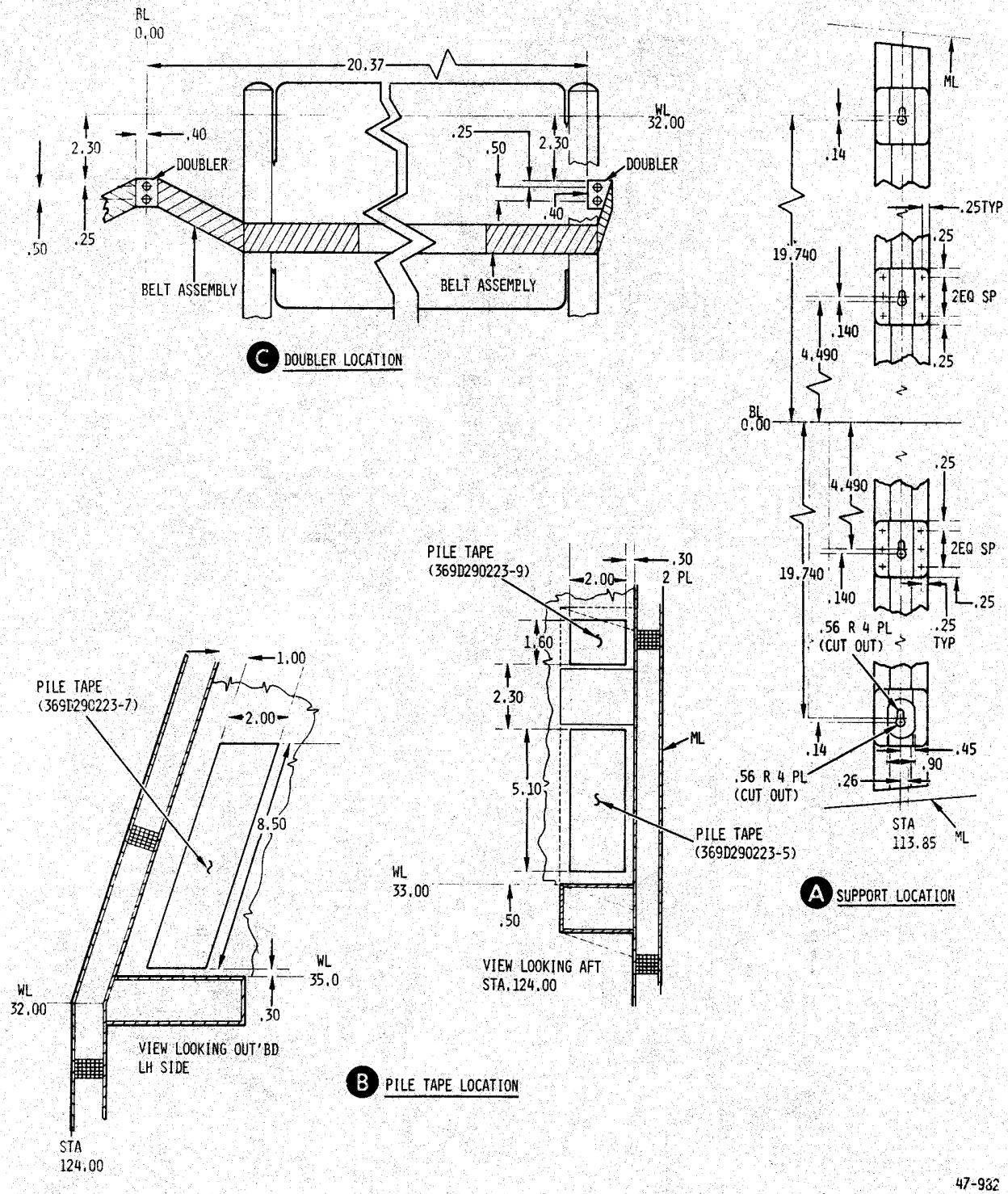


Figure 3-2. Attendant seat installation

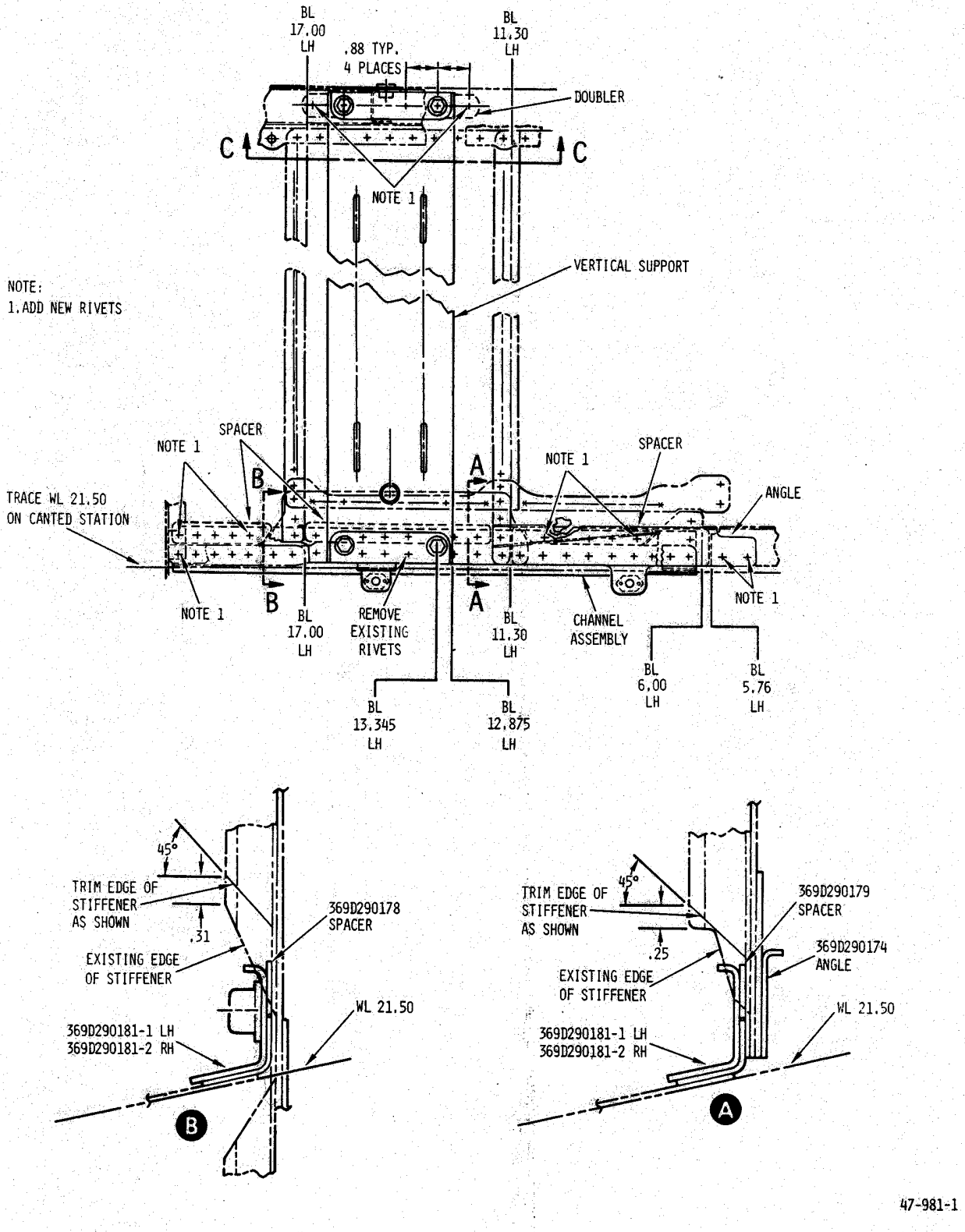


Figure 3-3. Structure modification for vertical support installation (sheet 1 of 2)

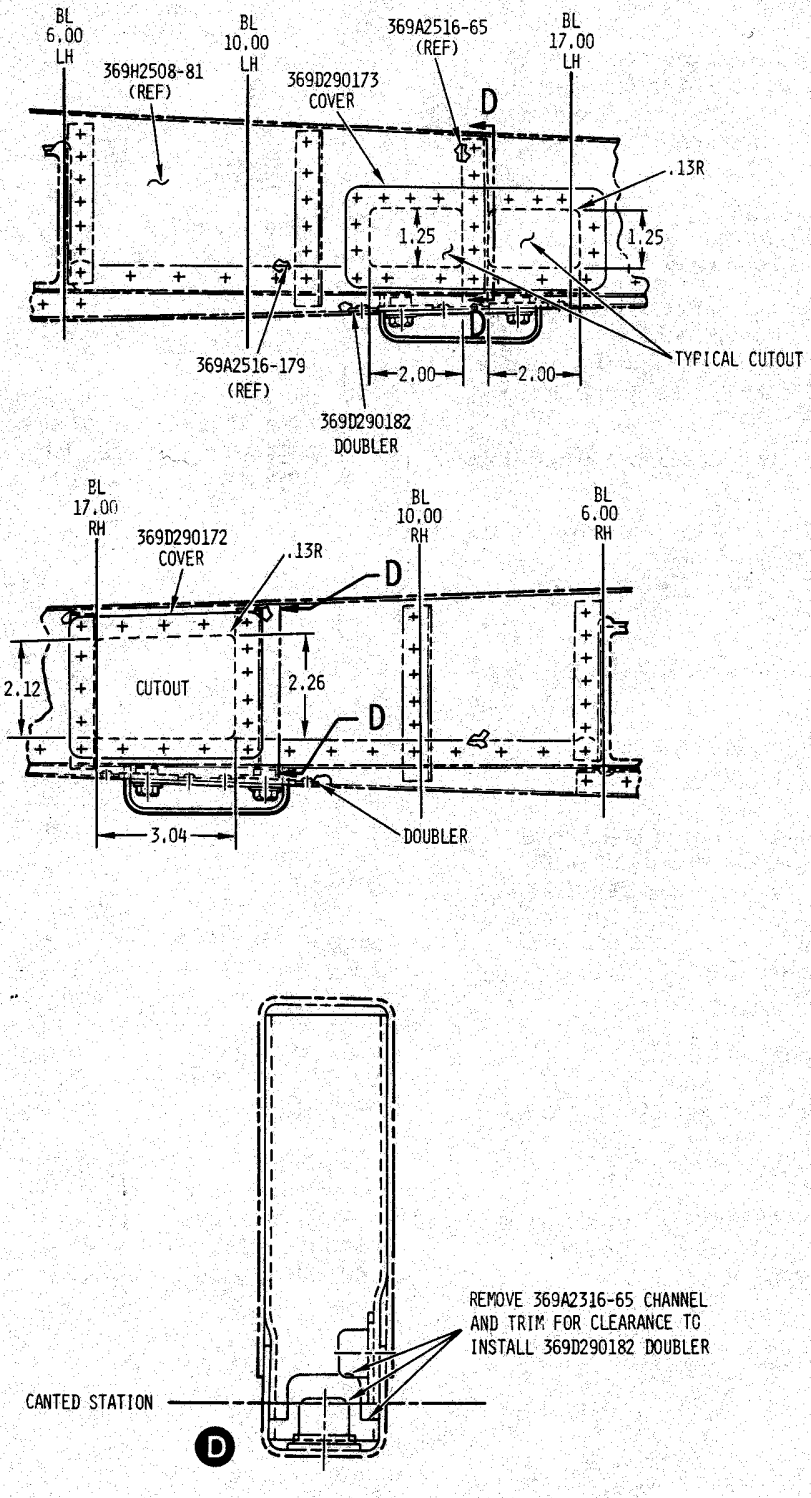


Figure 3-3. Structure modification for vertical support installation (sheet 2 of 2)

v. Position supports (3) and secure in place using bolts (1) and washers (2). Secure bolts with lockwire.

3-18. BUBBLE DOORS.

3-19. The rear doors installation consists of two litter high doors with upper and lower right and left hand hinge assemblies, two bubble and door adapter assemblies, prop assembly, covers, and necessary attaching hardware.

CAUTION

Do not attempt to install bubble doors with hook latching-type strikers on helicopters with serial numbers earlier than 0795. Doors will be damaged beyond repair. Refer to paragraph 3-21.

3-20. To install when hook latching-type striker is on the door frame:

a. Hang door as a unit, using masking tape or equivalent to secure door and matching striker plates on fuselage with latches (18, fig. 1-2) on doors. (Refer to figure 3-4.)

b. Trim door skin (both doors) to match fuselage cutout.

c. Locate and drill hinges. Rivet hinges to door assemblies.

d. Cut out a rectangular hole in door frame (both doors) and trim to ensure snug fit of the 369D290245-3 (and -4) cover to the door frame. Install cover with sealant (table 3-1, item 4).

e. Install fuselage mount for gas spring (door prop) mount. (Refer to figure 3-5.)

f. Install gas spring mount on door.

g. Install gas spring between door and fuselage.

h. Rig door latch mechanisms:

(1) Shim latch blocks and adjust strikers inboard and outboard to achieve proper hook latch/striker engagement.

(2) Place neoprene shim under door seal as required to accomplish water-tight capability.

3-21. Helicopters equipped with the older door bolting system require rework of the rear door frames to accommodate the bubble hook latching striker. (Refer to figure 3-6 for rework procedure.)

3-22. REPLACEMENT OF HELICOPTER EQUIPMENT.

3-23. Replace helicopter equipment removed to permit litter kit installation. (Refer to HMI - Vol 1.)

3-24. WEIGHT AND BALANCE.

2-25. Weight and balance changes resulting from installation of the litter kit are listed in table 3-2. After installation of litter kit, incorporate changes in helicopter weight and balance records as instructed in HMI - Vol 2.

Table 3-2. Weight and balance data*

	Weight (lb)	Longitudinal Arm (in.)	Horizontal Moment (in.-lb/100)
	In use load condition		
Added	117.7	97.4	114.6
Removed	0	0	0
Changed	+117.7	97.4	+114.6
	Stowed condition		
Added	117.7	107.2	126.2
Removed	0	0	0
Changed	+117.7	107.2	+126.2

*SN-0940 and subsequent: door assembly becomes standard; subtract 22 lb at Sta 82.7 aft passenger doors (door prop assembly included).

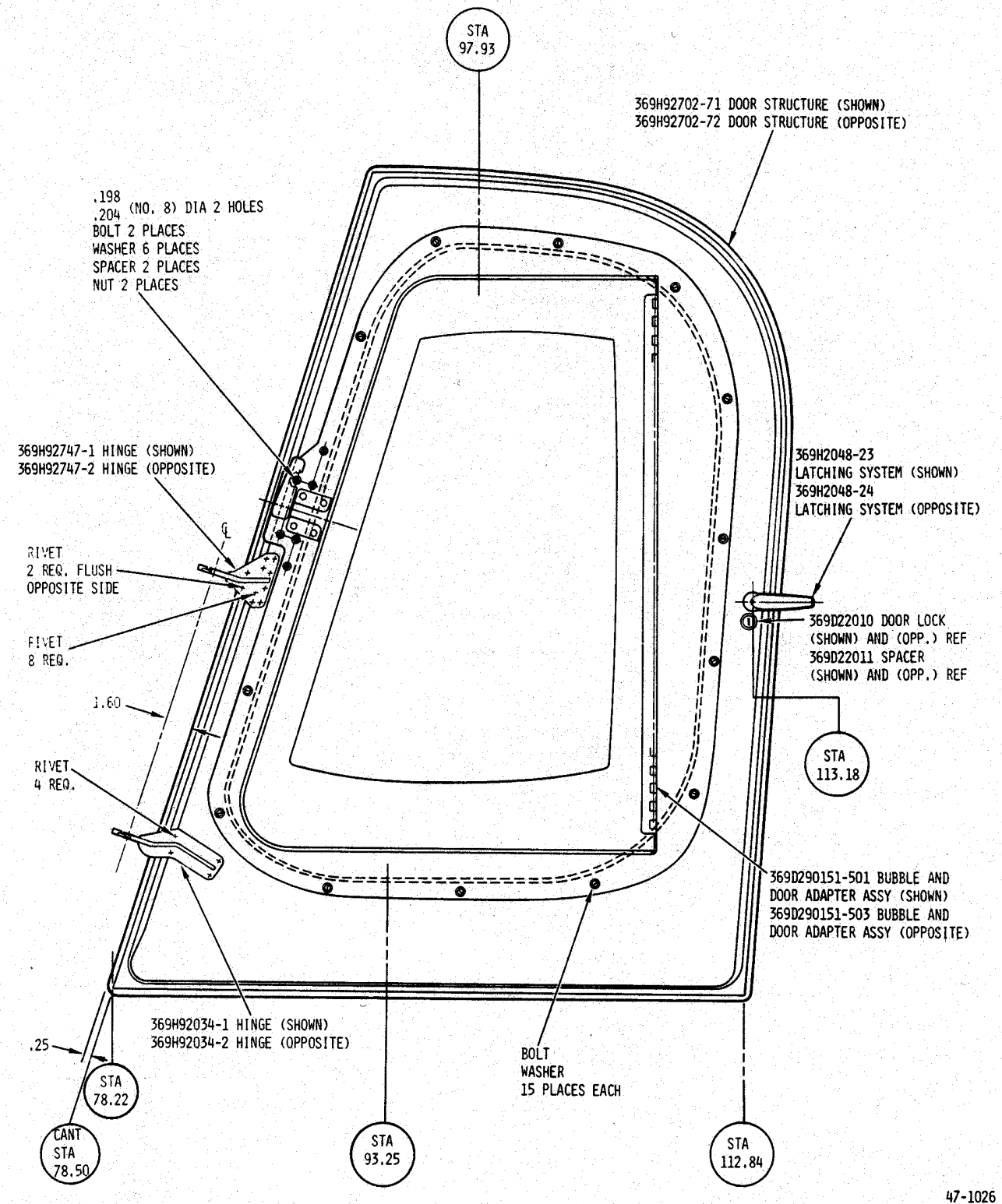
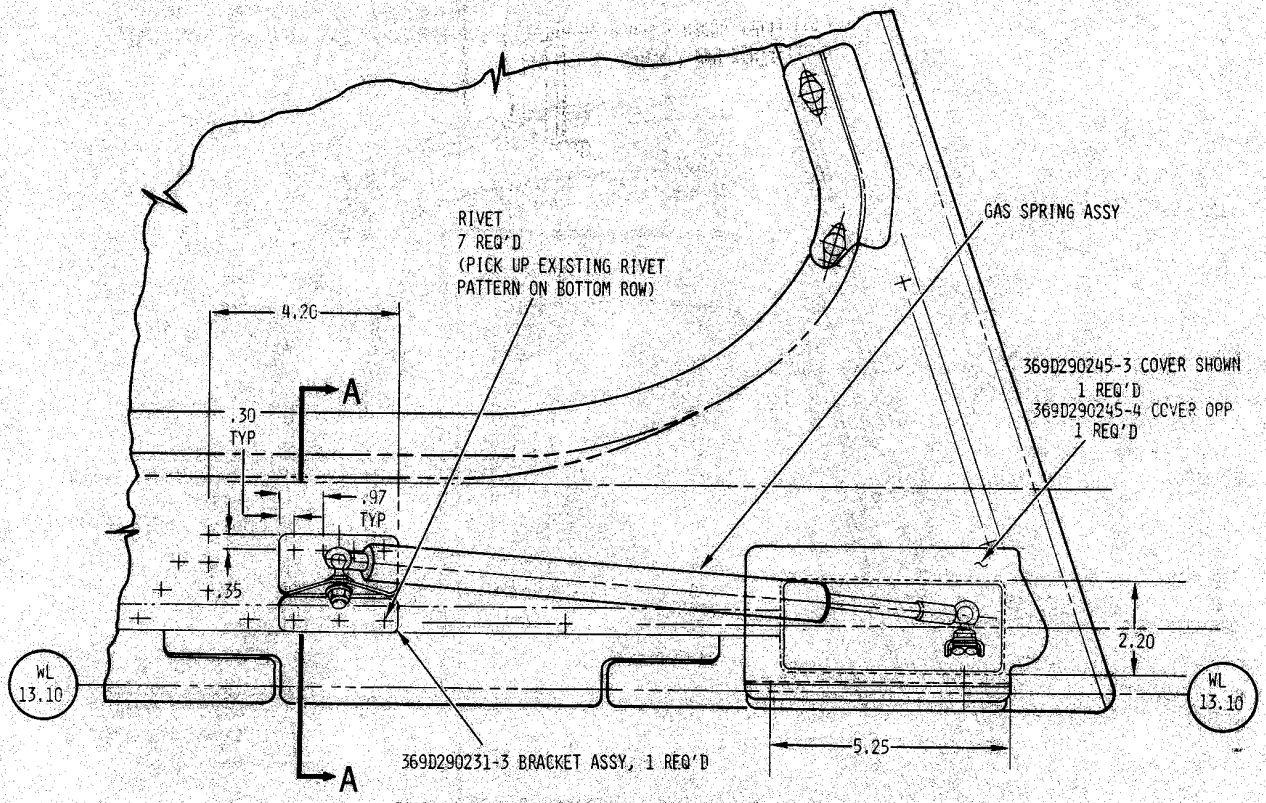


Figure 3-4. Litter high door installation



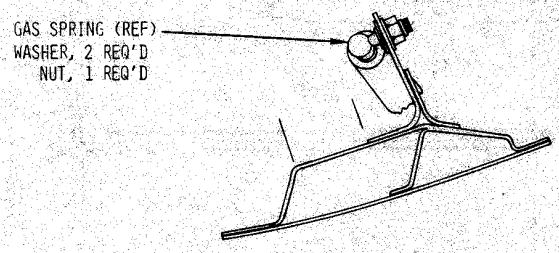


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Figure 3-5. Door prop (sheet 1 of 2)

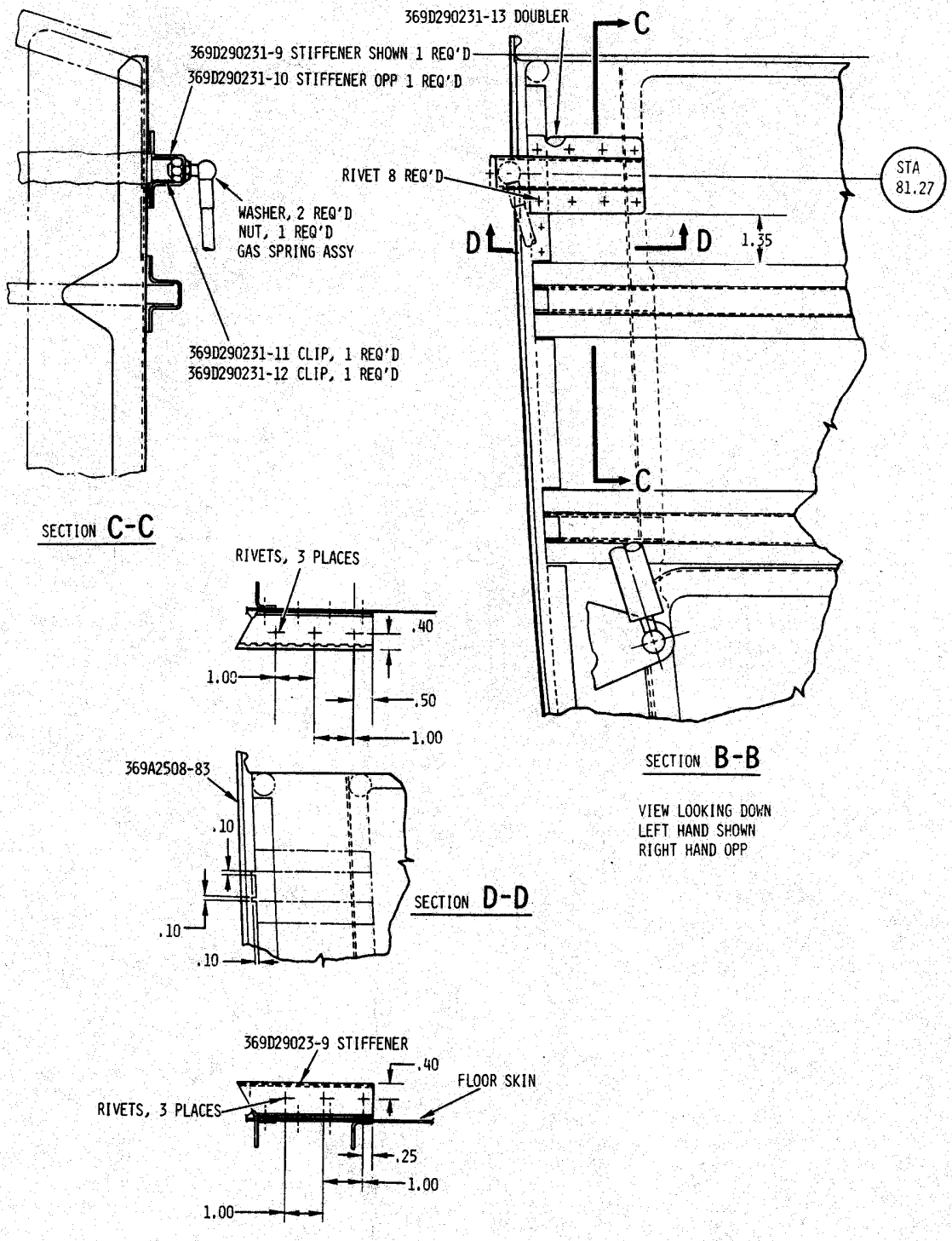
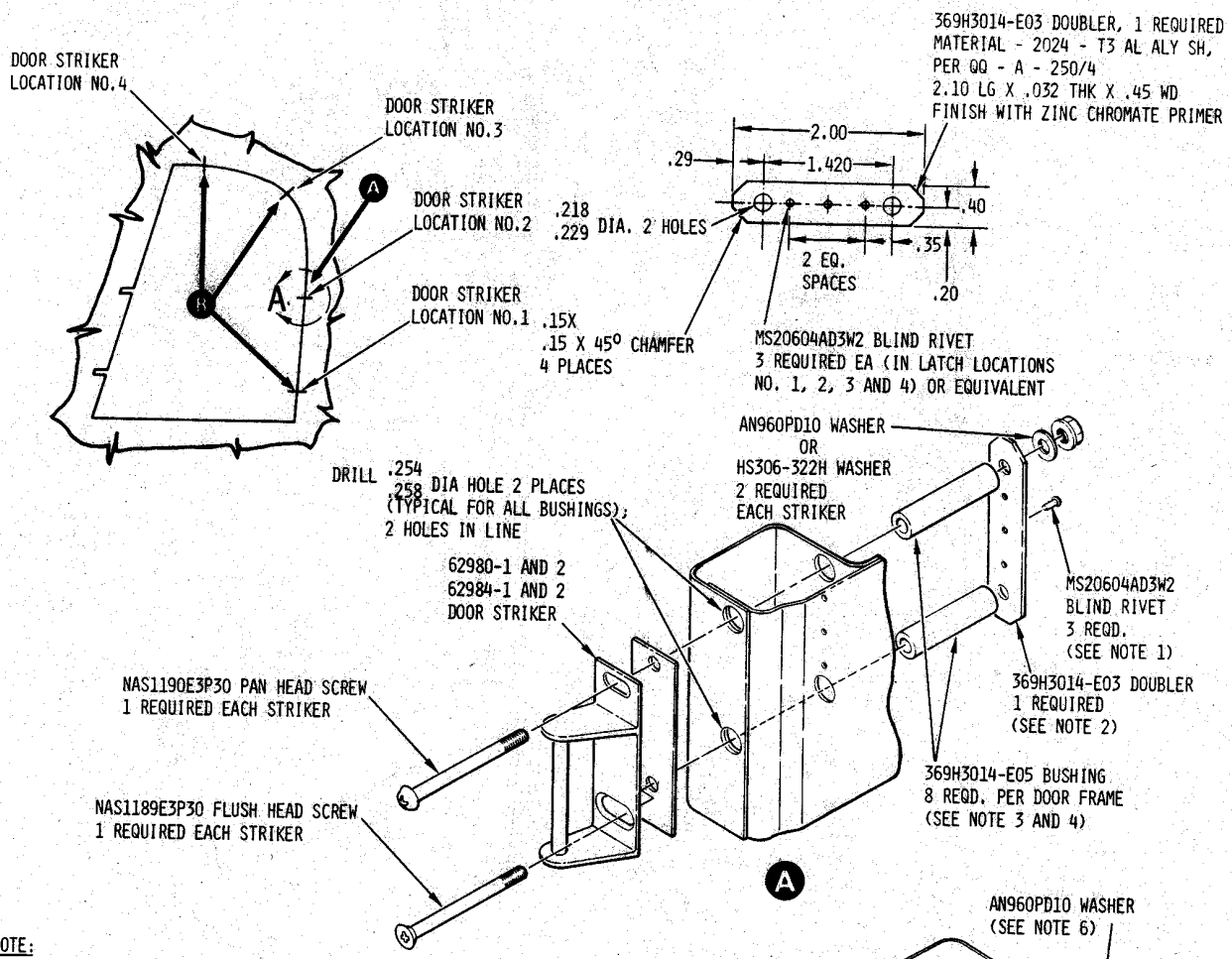


Figure 3-5. Door prop (sheet 2 of 2)



NOTE:

1. LOCATION NO. 1, 2, 3,4. AS AN ALTERNATE METHOD TO RIVETING, -3 DOUBLER MAY BE BONDED TO DOOR FRAME.
2. MAKE FROM 2024-T3 AL. ALLOY SHEET PER QQ-A-250/4, 2.10 LG. X .032 THK. X .45 WD. FINISH WITH ZINC CHROMATE PRIMER.
3. MAKE FROM 0.25 OD X 0.028 WALL TUBING. 304 CRES STEEL 1/8 HARD PER MIL. T-6845, SEAMLESS, TYPE I. I.D. TO BE REAMED TO $^{0.190}_{0.194}$ (ALTERNATE MATERIAL: 0.25 OD. X 0.028 WALL TUBING. 304 CRES STEEL 1/8 HARD PER MIL. T-6845, SEAMLESS TYPE I) LENGTH = 1.30. FINISH WITH ZINC CHROMATE PRIMER.
4. DRILL $^{.254}_{.258}$ DIA. HOLES IN DOOR FRAME ON SAME AS NAS1329C06-75 RIVNUTS DRILLED OUT TO PERMIT BUSHING INSTALLATION. INSTALL BUSHING. BOND INTO PLACE WITH EC1838 SCOTCHWELD. TRIM BOTH FACES OF BUSHING FLUSH TO $^{+.000}_{-.010}$ OF SURFACE.
5. SHIM ALL STRIKERS USING 369H2401-83 SHIM AS REQUIRED TO MAXIMUM SHIM THICKNESS OF 0.20 FOR LATCH LOCATIONS NO. 1 THRU 4.
6. AN960PD10 OR HS306-322H WASHER MAY BE USED WITH NUT AS ALTERNATE TO 369H3014-E03 DOUBLER AT NO. 4 LOCATION ONLY. TRIM WASHER AS REQUIRED TO ACCOMMODATE SURROUNDING STRUCTURE. REMOVE ANY INTERFERING RIVETS.

47-1020

Figure 3-6. Door frame rework procedure