



SERVICE BULLETIN

DATE: 8 DECEMBER 1978

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* Supersedes Service Information Notice No. DN-27, dated 1 September 1978

INSPECTION AND REWORK OF TAIL ROTOR HUB, PN 369A1725-5 AND 369A1725-501; INSPECTION OF TAIL ROTOR BLADE ATTACHMENT BOLTS; PN MS21250-06040

1. PLANNING INFORMATION

A. Models Affected:

Part I and Part II 500D Model 369D Helicopter Serial No. 0003D through 0355D

The following Tail Rotor Hub Assemblies (separate or installed as component of PN 369D21600 Serial Tail Rotor Assembly) in Spares Inventory at date of this Notice:

PN 369A1725-5 Tail Rotor Hub Assembly having Serial Numbers 001 through 862.

All PN 369A1725-501 Tail Rotor Hub Assemblies.

Part III All 500D Model 369D Series Helicopters

B. Time of Compliance

Shall be accomplished at next 100-Hour Periodic Inspection; or prior to installation of Spares assembly on helicopter; or within six months after date of this Notice, whichever is soonest.

C. Preface

Part I and Part II of this Service Information Notice provides instructions for inspection of the subject tail rotor hub assemblies, and application of a corrosion resistant coating at the radius area between the spindles and center portion of the hub.

Part III of this Notice provides instructions for inspection of the PN MS21250-06060 tail rotor blade attachment bolts to determine that the bolt heads are seated properly against the PN 369H5308 bushings.

D. Reference

500D Basic HMI-Vol I, Issued 15 September 1976; Revision No. 2, 27 November 1978

500D Component Overhaul Manual COM-369D, Issued 15 September 1976.

E. Weight and Balance

Weight and Balance not affected.

F. FAA Approved

(I) Denotes portion of text added or revised.

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TOOLS AND EQUIPMENT	
Nomenclature	Source
Magnetic Particle Inspection Kit, MIL-I-6868	
Magnifying Glass – 10X	
Oven, Baking or Heat Lamp	
Brush, Paint– 1/16”	
Torque Wrench – 0 to 1000 inch–pounds	

MATERIALS		
Nomenclature	Part Number/Specification	Source
Coating, Aluminum	Alumazite Z (4 oz. can)	HH
Methylethylketone (MEK)	TT-M261	Commercial
Emery Cloth, Medium		Commercial
Emery Cloth, Fine		Commercial
or		
Crocus Cloth, Fine	P-C-458	Commercial
Primer, Zinc Chromate		Commercial

NOTE: Authorized HH Service Centers may obtain one 4 oz. can of Alumazite Z without cost, if ordered prior to 30 November 1978. Owners/operators may purchase Alumazite Z through HH Service Centers.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Part I - Hub Identification

- (1). Identify tail rotor hub as follows:
 - (a). PN 369A1725-501 hub is identified by Part Number and Serial Number on one of two data plates on hub (see Figure 1) and is to be reworked per Part II of this Notice, unless identified with letter “Z” or letters “SP” following hub serial number.
 - (b). PN 369A1725-5 hub is identified by Part Number and Serial Number on one of two data plates on hub (see Figure 1) and is to be inspected and reworked per Part II of this Notice, except as noted below.

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NOTE:

- PN 369A172S-5 Tail Rotor Hubs having Serial No. 001 through 862 and identified with either Letter “Z” or letters “SP” following hub serial number do NOT require rework per Part II of this Notice.
 - PN 369A1725-5 Tail Rotor Hubs having Serial No. 863 and subsequent do NOT require rework per Part II of this Notice.
- (2). Record compliance with Part I of this Service Information Notice in Compliance Record of helicopter Log Book or tag Spares hub assembly and record compliance when assembly is installed on helicopter.

B. Part II - Hub Inspection and Rework

- (1). As applicable, remove tail rotor assembly from helicopter and remove tail rotor blade assemblies, per Basic HMI-Vol I. Disassemble hub and drive fork assembly, per Component Overhaul Manual (COM-369D).
- (2). Clean hub with MEK.
- (3). Using 10X glass, inspect hub for cracks and corrosion or other damage. Pay particular attention to area of 0.13 radii between the spindles and center portion of the hub. (See Figure 1.)
 - (a). Indications of cracking are cause for hub rejection, except as noted below.
 - 1). Minor surface imperfections or discontinuities in the unmachined center of the hub may appear to indicate cracking. This area may be dressed with medium grade emery cloth for minimum material removal to remove the imperfections.
 - (b). If corrosion or pitting is noted, clean hub surface with fine emery cloth or crocus cloth.
 - (c). If surface repair was performed in a. or b. above, clean hub with MEK and reinspect hub with 10X glass. Pay particular attention to 0.13 radius areas on both sides of the hub.
 - (d). If hub is rejected, contact HH Customer Service Department for disposition.
- (4). Magnetic particle inspect hub for cracks, per MIL-I-6868. Pay particular attention to 0.13 radius areas on both sides of the hub. If hub is rejected, contact HH Customer Service Department for disposition.
- (5). Rework hub as follows using Alumazite Z:
 - (a). Shake contents of container thoroughly.
 - (b). Brush a thin (0. 0002 to 0. 0005 inch) even coat onto cleaned surface of 0.13 radius areas on both sides of the hub. (See Figure 1.) Limit width of aluminum coating to 0.25 inch, to prevent contact with feathering bearings.
 - (c). Allow a flash-off (drying) time of 8 to 10 minutes.
 - (d). Bake hub for 1 hour at 375° to 425° F in oven or use heat lamp.
 - (e). Air cool hub.
- (6). Add letter “Z” following serial number on hub data plate, to denote rework of 369A1725-5 or 369A1725-501 hub. (See Figure 1.)

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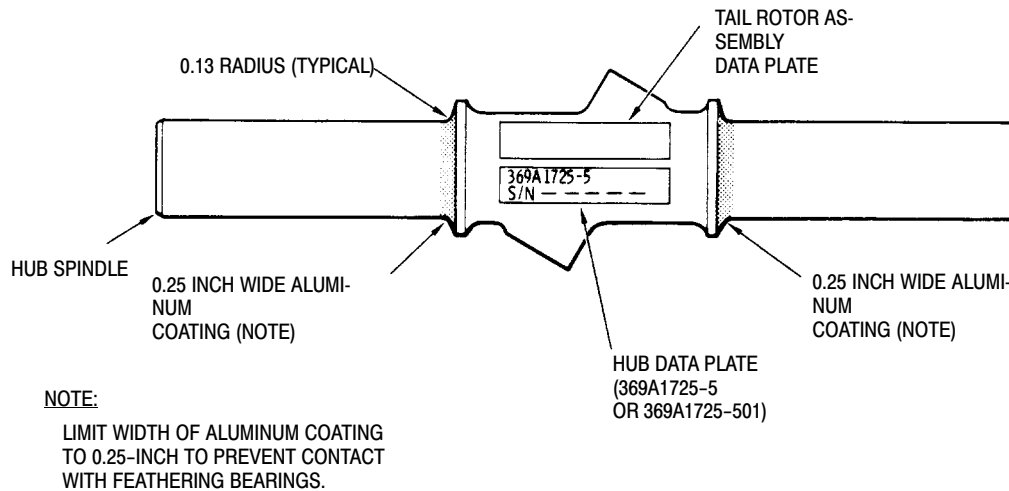
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- (7). Reassemble tail rotor hub and drive fork assembly, per Component Overhaul Manual (COM-369D). Reinstall tail rotor blade assemblies, per Basic HMI-Vol I.
- (8). Perform Part III of this Notice.
- (9). As applicable, reinstall tail rotor assembly on helicopter, per Basic HMI-Vol I.
- (10). Record compliance with Part II and Part III of this Service Information Notice in Compliance Record of helicopter Log Book; or tag Spares assembly and record compliance when assembly is installed on helicopter.



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Figure 1. Rework of Tail Rotor Hub Assembly

C. Part III - Inspection of Tail Rotor Blade Attachment Bolt

- (1). Inspect the two PN MS21250-06040 tail rotor blade attachment bolts for gap between bolt head and bushing. No gap is permitted; bolt head must sit flush against PN 369H5308 bushing.

NOTE: If gap is noted between bolt head and bushing, replace with serviceable PN MS21250-06040 bolt and PN 369H5308 bushing, per Section 8 of basic HMI-Vol I. Coat bolt, bushing and washers with unthinned zinc chromate primer at installation. Install nut and torque to 600 to 650 inch-pounds while zinc chromate primer is wet.

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