

SERVICE BULLETIN #51

DATE: 2 July 1986

TO: R22 Owners And Operators

SUBJECT: Main Rotor Elastic Teeter Stops.

ROTORCRAFT AFFECTED: R22 Helicopters S/N 501 through 554 having elastic teeter stops installed with ty-raps.

TIME OF COMPLIANCE: Within the next 50 flight hours or by 15 September 1986 whichever occurs first.

BACKGROUND: Elastic teeter stops installed with ty-raps have been observed to move or creep slightly in service causing a misalignment of the stops and the spindle. An improved metal mounting bracket for the elastic stop has been developed to prevent creeping.

INSTALLATION INSTRUCTIONS

1. The installation procedure will require four people and four ladders or work stands.
2. Rotate the main rotor blades so they are in the 11:00 and the 5:00 position.
3. Place a ladder or work stand under each blade approximately at the 3/4 blade radius.
4. Place a ladder or work stand on either side of the helicopter cabin.
5. Cone both of the main rotor blades upward until the spindle tusks move off the droop stops.
6. Remove the NAS1305-44 bolt from the droop stops. Inspect the droop stops for wear. Replace any droop stops worn more than .030 inches.
7. Place an AN960-516L washer on the new NAS1305-46 bolt.
8. Place the B151-2 teeter stops 90 degrees to the droop stop bolt on the main rotor shaft.
9. Place the A150-1 droop stops in their respective positions.

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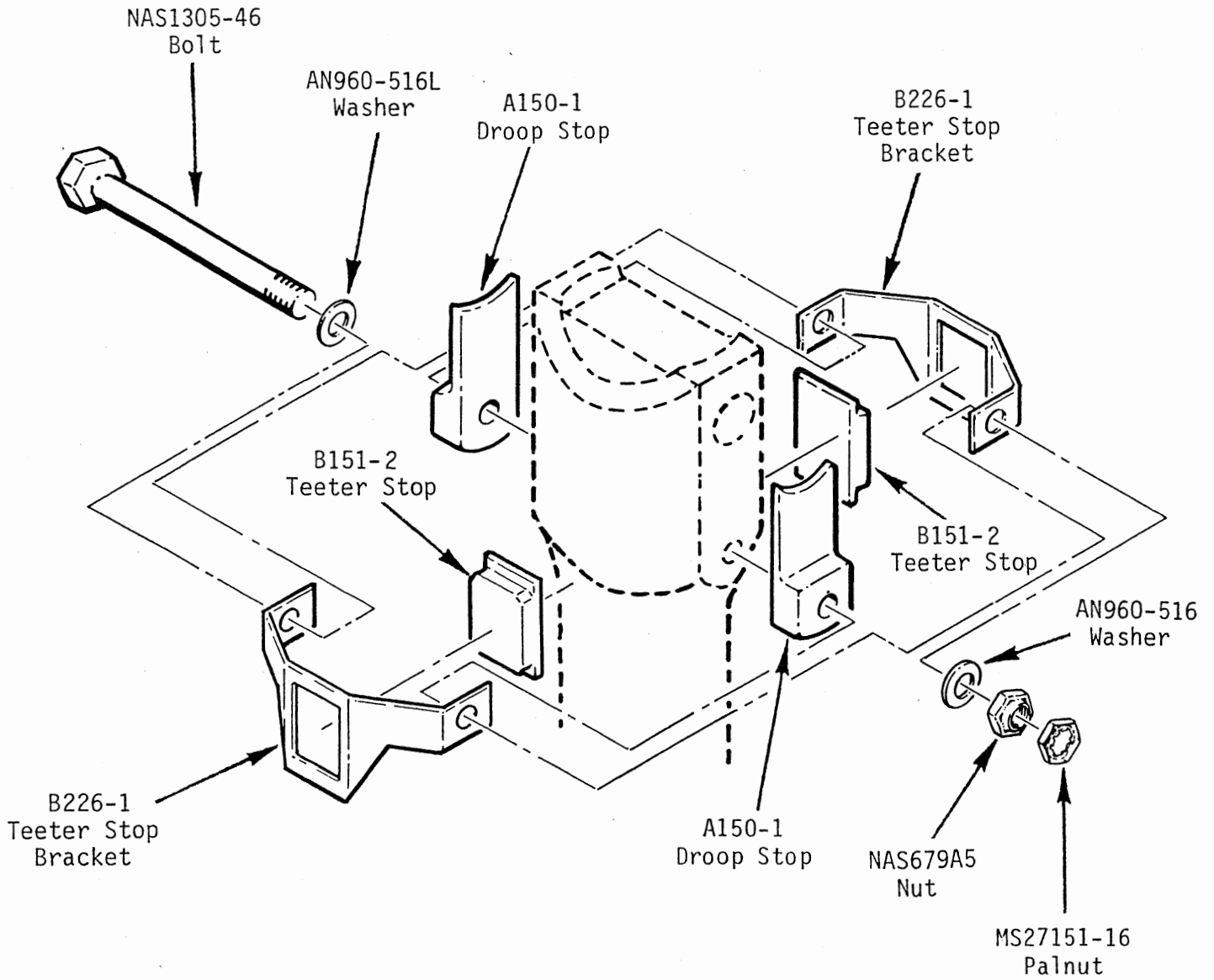
10. Place the B226-1 teeter stop bracket over the B151-2 teeter stops and align the bolt holes in the bracket with the hole in the droop stops and the main rotor shaft.
11. Insert the NAS1305-46 bolt through the teeter stop brackets and droop stops. Verify the teeter stops are positioned correctly in their brackets. Verify the droop stop cut-outs are positioned correctly over the main rotor hub teeter bolt journals.
12. Install an AN960-516 washer and a NAS679A5 nut on the NAS1305-46 bolt. Torque the nut to 220 inch/pounds. Install the MS27151-16 Pal Nut and torque to 20-40 inch/pounds. Torque stripe the nut and bolt installation.
13. Gently lower the main rotor blades.

KIT CONTENTS KI-51

<u>Quantity</u>	<u>Part #</u>	<u>Description</u>
2 ea.	B151-2	Teeter Stop
2 ea.	B226-1	Teeter Stop Bracket
1 ea.	NAS1305-46	Bolt
1 ea.	AN960-516	Washer
1 ea.	AN960-516L	Washer
1 ea.	NAS679A5	Nut
1 ea.	MS27151-16	Palnut

APPROXIMATE COST:

Materials: No charge if ordered by 1 Sept. 86
Labor: 15 minutes for four people equals
one man hour.



TEETER STOP INSTALLATION