

**KI-234 R66 Cabin Bulkhead Doubler Installation Kit Instructions**

*To repair a crack in F259-2 cabin bulkhead panel near right side F020-1 upper frame assembly attachment*

**CAUTION**

Visit [www.robinsonheli.com](http://www.robinsonheli.com) to verify kit instructions are current revision. Review instructions before installation; contact [RHC Technical Support](#) with questions. Verify kit contents match list; contact [RHC Customer Service](#) if parts are missing or damaged.

ITEM NUMBER	PART NUMBER	DESCRIPTION	QTY PER KI-234
<b>KIT CONTENTS</b>			
1	KI-234 Instr.	Kit Instructions .....	1
2	F003-22	Insulation – RH .....	1
3	G803-2	Doubler (Revision B or subsequent) .....	1
4	NAS9301B-4-02	Rivet .....	3

**Special Tools**

- Blind rivet installation tool and clecos (sheet metal fasteners)

**Consumables**

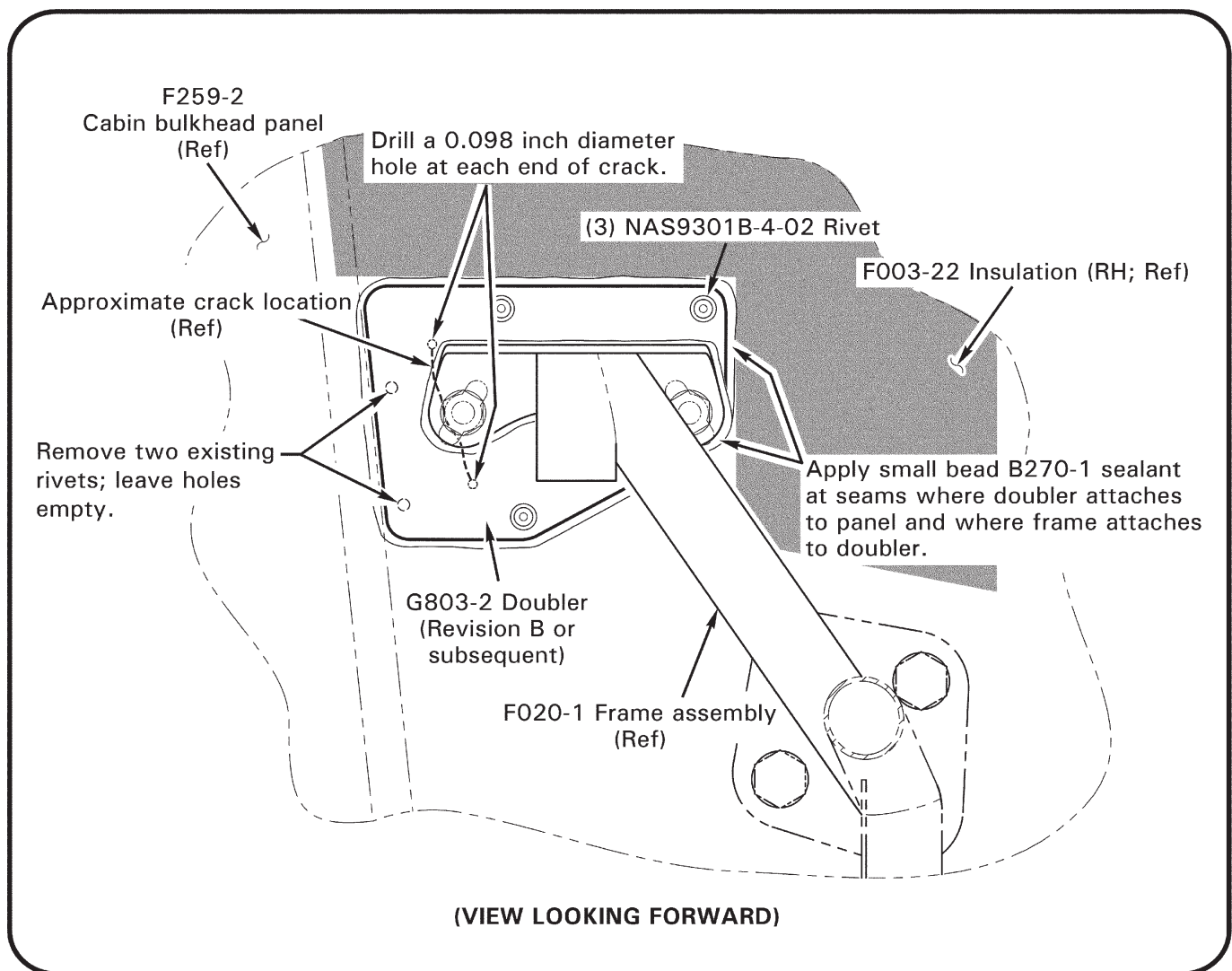
- B270-1 & B270-8 sealant

**KI-234 Kit Instructions**

1. Refer to Figure 1. If installed, remove F003-22 (RH) insulation (located on aft side of F259-2 cabin bulkhead panel) per R66 Maintenance Manual (MM) § 25-40.
2. If crack can be stop-drilled at each end without removing F020-1 upper frame assembly, remove F006-1 main rotor gearbox assembly per MM § 63-20. If crack cannot be stop-drilled at each end, remove upper frame per MM § 53-33.
3. Drill a 0.098 inch diameter hole at each end of crack in cabin bulkhead panel. Deburr holes.
4. Remove two existing rivets shown; leave holes empty.
5. Using G803-2 doubler as template, match drill (3) 0.130 inch diameter holes thru panel. Deburr holes and clean up debris.
6. Cleco (sheet metal fastener) doubler to panel. Progressively remove clecos and install (3) NAS9301B-4-02 rivets. Verify rivet and doubler security.
7. Install upper frame per MM § 53-33, step 1, if removed. Apply small bead B270-1 sealant at seams where doubler attaches to panel and where frame attaches to doubler.

**KI-234 Kit Instructions (continued)**

8. If removed, install supplied insulation per MM § 25-40 and Figure 1, and seal along top edge using B270-1 sealant.
9. Install upper frame per MM § 53-33, steps 2 thru 16, if removed, or install main rotor gearbox per MM § 63-20.
10. Make appropriate maintenance record entries. No change to helicopter weight and balance.



**FIGURE 1**