

R66 Float Stabilizer Installation Upgrade Kit Instructions
(upgrades G950-2 float stabilizer Revision C to Revision E)
(to comply with R66 Service Bulletin SB-33)

NOTE

Visit 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 | PART NUMBER | KIT CONTENTS | QTY |
|------|-----------------|---|-----|
| 1 | KI-267-1Instr. | Kit Instructions | 1 |
| 2 | D210-4 | Nut | 2 |
| 3 | G953-15 | Spacer | 2 |
| 4 | NAS1097AD3-3.5+ | Rivet (Note: "+" in part number indicates 50-qty pack) | 1 |
| 5 | NAS1097AD3-4+ | Rivet (Note: "+" in part number indicates 50-qty pack) | 1 |
| 6 | NAS1149F0432P+ | Washer (Note: "+" in part number indicates 20-qty pack) | 1 |
| 7 | NAS1351-4-40P | Screw | 1 |
| 8 | NAS1351-4-56P | Screw | 1 |

Consumables

Refer to R66 Maintenance Manual (MM) § 20-70.

- Bonderite M-CR 1201 Aero (Alodine 1201) or similar product.
- Epoxy primer.
- B270-1 Sealant.
- R8260 Touch-up paint kit (refer to helicopter Maintenance Record for paint codes).

Special Tools

- Drilling, deburring, and countersinking tools.

Kit Instructions

1. Remove G950-2 stabilizer assembly Revision C (refer to stabilizer data plate) per MM § 53-52 Part C and discard hardware.
2. Refer to Figure 1. Using G953-15 spacers as template (on outboard faces), match drill two 0.097–0.102 inch diameter (rivet) holes on G953-7 & G957-8 plates. Remove spacers and deburr holes.

NOTE

Use of hardware to temporarily & lightly clamp G954-7 & G954-8 plates in place prior to drilling rivet holes is at installer’s discretion. Do not overtighten hardware.

Kit Instructions (continued)

3. **On outboard face of G953-7 plate only:** create 0.250 inch diameter, 100° countersinks in newly drilled rivet holes.

NOTE

Proper rivet length is determined by installer. Application of chemical film (following manufacturer's instructions) and/or prime/paint to drilled hole(s) edges is at installer's discretion.

4. Position (1) G953-15 spacer on inboard side of G953-7 plate, countersunk holes facing inboard. Install spacer using (2) NAS1097AD3-3.5 rivets with factory heads on inboard-side of plate. Ensure bucked end is 0.110 inch (minimum) diameter and is flush with, or recessed in, plate.

CAUTION

Bucked end of rivets must be flush on outboard-side of G953-7 plate to allow D081-4 block to clamp properly.

5. Position remaining G953-15 spacer on inboard side of G953-8 plate, countersunk holes facing inboard. Install spacer using (2) NAS1097AD3-4 rivets with heads on inboard-side of plate.
6. Apply a yellow paint dot adjacent to part number on data plate to indicate G953-14 & G953-15 spacers have been installed and stabilizer is at Revision E.
7. Verify dimension between lower screw holes is 1.625 ± 0.015 inches. Using hardware provided in kit, install G950-2 stabilizer assembly per MM § 53-52 Part D, replacing NAS1351-4-53P with NAS1351-4-56P screw, and replacing NAS1351-4-38P with NAS1351-4-40P screw. Up to six exposed threads beyond nut is acceptable. Touch-up paint as necessary.
8. Make appropriate maintenance record entries. Weight and Balance change is negligible.

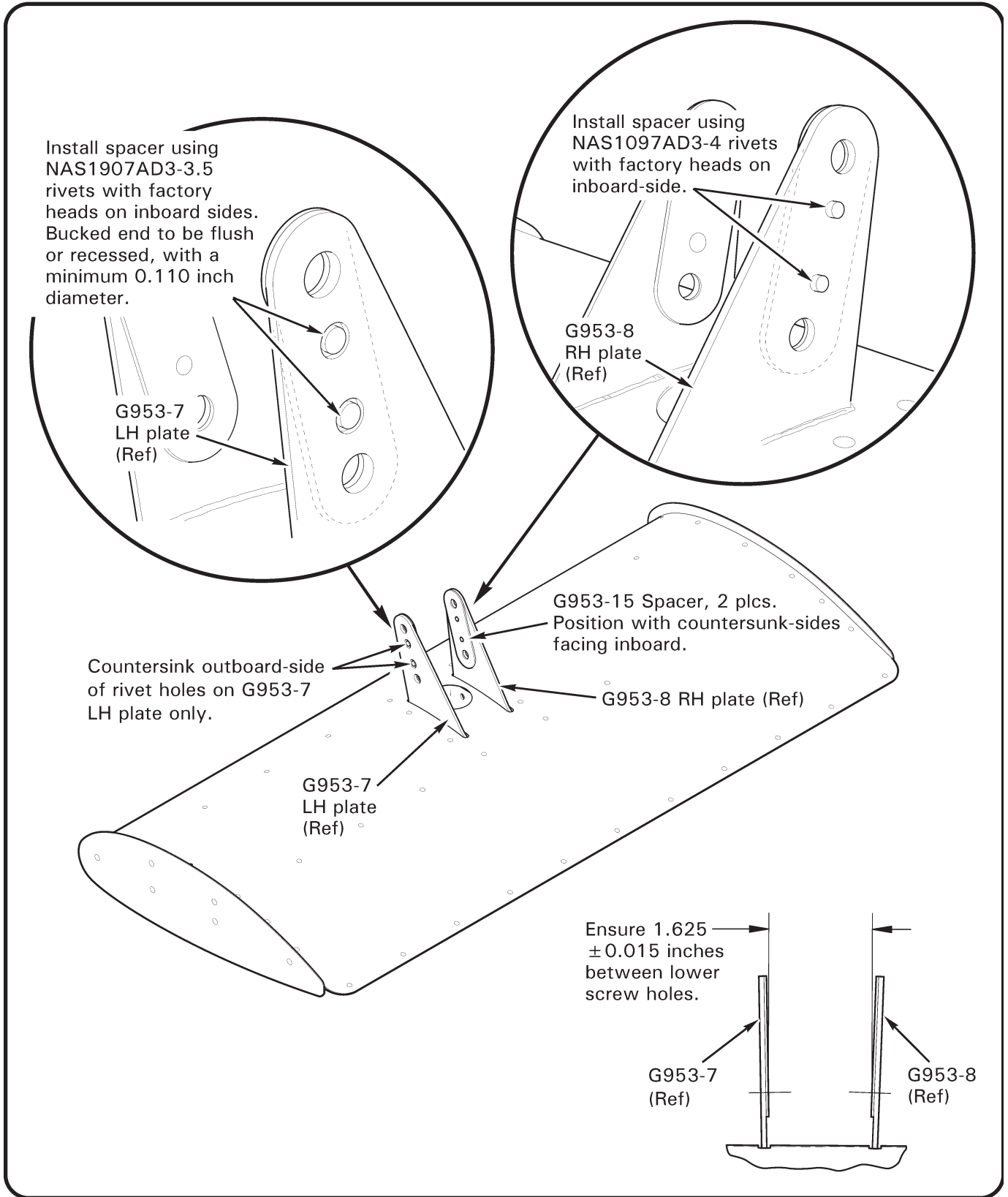


FIGURE 1 Installation of G953-13 spacers
(G950-2 Rev D and prior)