

# ROBINSON HELICOPTER COMPANY

2901 Airport Drive, Torrance, California 90505

Phone (310) 539-0508 Fax (310) 539-5198

## INSTALLATION INSTRUCTIONS FOR KI-73

28 February 1992

TITLE: Tailcone Doubler Installation for T.R. Visual  
Warning Guard (Required by SB-68)

---

### Kit Contents:

1. 1 ea. B805-1 Doubler
2. 8 ea. NAS1919B04S02 Rivet
3. 2 ea. MS27039C1-07 Screw
4. 2 ea. AN960-10L Washer

**NOTE: READ THROUGH ALL INSTRUCTIONS CAREFULLY PRIOR  
TO INSTALLING DOUBLER**

### INSTRUCTIONS:

- Step 1) Loosen the A121-17 P/P tube's forward rod end jam nut by no more than 1/4 turn. Prevent the jam nut from further turning by securing it in place with the adjacent palnut. Torque stripe the jam nut, palnut and rod end. Mark the A121-17 P/P tube aft rod end to indicate which side faces up. Do NOT loosen the aft rod end. Disconnect the A121-17 P/P tube at the aft A120-1 bellcrank. Unscrew the P/P tube from the forward rod end and record the number of turns necessary to disengage the P/P tube from the forward end. Remove the P/P tube from the tail cone.
- Step 2) Remove B312-1 T.R. Guard. Inspect tailcone skin for cracks using a 10X magnifying glass.
- Step 3) Install B805-1 Doubler between tailcone and T.R. Guard using the two MS27039C1-07 screws and AN960-10L washers on the tailcone seam and two of the original screws in the other two holes. (ref Fig. 1)
- Step 4) Using a .128 inch diameter drill (#30) with drill stop attachment and clecos, drill six holes thru doubler and tailcone. Use caution and a drill stop attachment to avoid damaging the tail rotor drive shaft when drilling. Remove drill chips from inside tailcone. Remove the T.R. Guard and the Doubler. Deburr the Doubler. Reinstall the Doubler and the T.R. Guard.

(OVER)

# ROBINSON HELICOPTER COMPANY

2901 Airport Drive, Torrance, California 90505

Phone (310) 539-0508 Fax (310) 539-5198

- Step 5) Install six NAS1919B04S02 rivets. Using clecos make sure there is no gap between doubler and tailcone when riveting. (Loosening screws slightly may be required)
- Step 6) Re-install the A121-17 P/P tube. Screw the P/P tube onto the forward rod end the same number of turns recorded in Step 1. Ensure the mark applied in Step 1 is at its original position. The forward rod end jam nut must require no more than 1/4 turn prior to locking against P/P tube. If more than 1/4 turn is necessary the tail rotor rigging must be checked per section 10.140 of the R22 Maintenance Manual.
- Step 7) Touch-up paint (ref R22 Maintenance Manual Section 1.400).
- Step 8) Enter SB-68 completed in aircraft logbook/maintenance record.

**CAUTION:** Installation of this kit does not satisfy the additional requirements of Service Bulletin SB-67.

# ROBINSON HELICOPTER COMPANY

2901 Airport Drive, Torrance, California 90505

Phone (310) 539-0508 Fax (310) 539-5198

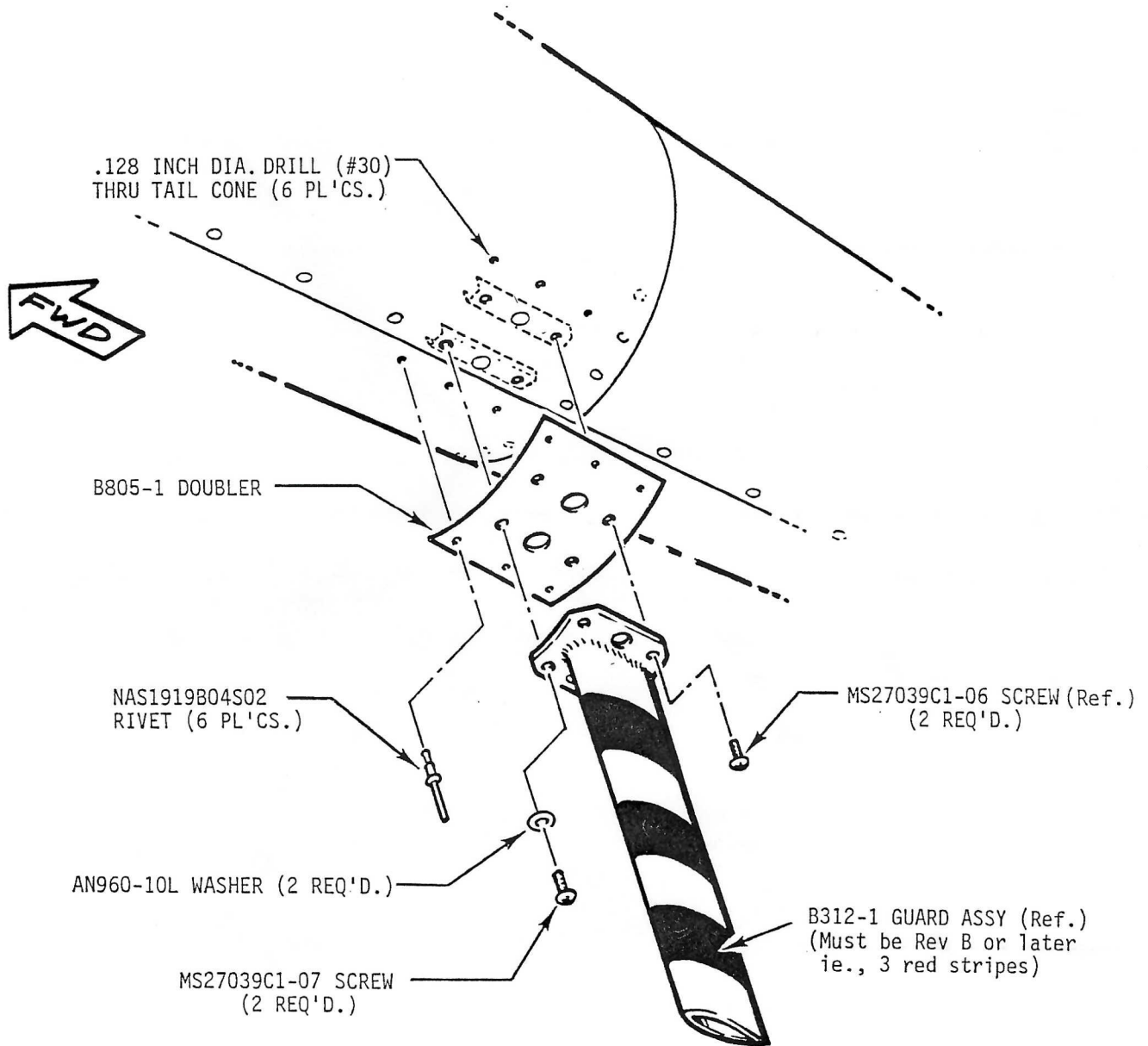


FIGURE 1 B805-1 TAIL CONE DOUBLER INSTALLATION