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KI-111 R22 LOWER SCROLL HALF ACCESS HOLE INSTALLATION KIT

KIT CONTENTS:

1 ea	D229-4	Cover
2 ea	MS21069L06	Nutplate
4 ea	MS20426AD3-4	Rivet
2 ea	MS35206-227	Screw
1 ea	KI-111Instr	Kit Instructions

INSTRUCTIONS:

1. Verify contents of kit conforms to parts list. Contact RHC if any parts are missing or damaged.
2. Remove screws and two bolts attaching lower scroll half to lower actuator bearing block. Remove lower scroll half.
3. Refer to Figure 2. Determine if B174-1 fanwheel is Revision J & subsequent or Revision I & prior.
4. Using dimensions appropriate to fanwheel revision, locate and drill 1.50 inch diameter hole per Figure 1.
5. Locate and drill two 0.141 inch diameter holes per Figure 1.
6. Locate and orient MS21069L06 nutplates on 0.141 inch diameter holes per Figure 1. Note 30 degree orientation of nutplates. Using nutplates as templates, drill four 0.098 inch diameter holes. Countersink four 0.098 inch diameter holes on outside of scroll as required and attach nutplates to inside of scroll using MS20426AD3-4 rivets.
7. Install D229-4 cover using MS35206-227 screws.
8. Touch up paint as necessary.
9. Install lower scroll half. Torque fasteners per R22 Maintenance Manual Section 1.320.
10. Make appropriate maintenance record entries.

NOTE

In future, when replacing Revision I & prior fanwheels with Revision J & subsequent fanwheels, relocate D229-4 cover to coincide with different fanwheel bolt pattern using KI-124 kit.

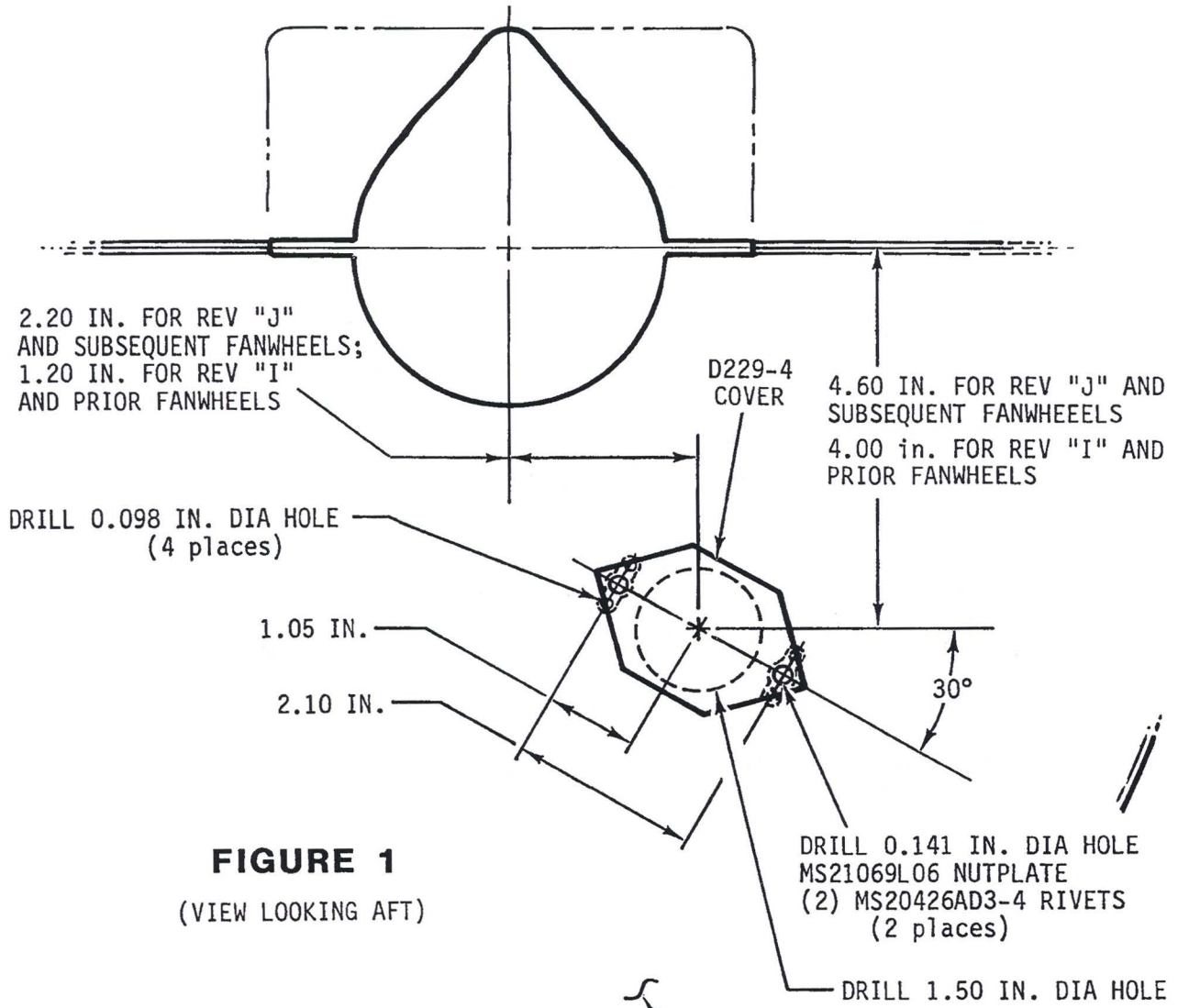


FIGURE 1
(VIEW LOOKING AFT)

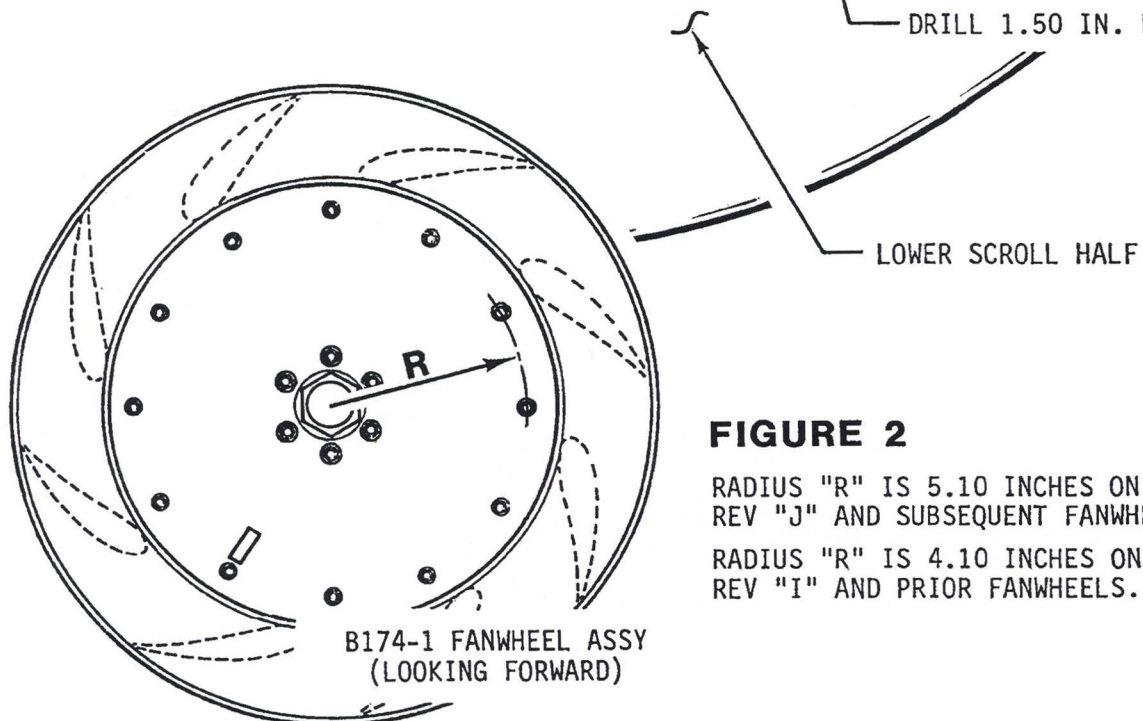


FIGURE 2

RADIUS "R" IS 5.10 INCHES ON B174-1 REV "J" AND SUBSEQUENT FANWHEELS;
RADIUS "R" IS 4.10 INCHES ON B174-1 REV "I" AND PRIOR FANWHEELS.