

R44-series & R66 Cabin Interior Hardpoint Field Installation Kit Instructions

Kit installs safety harness attachment point installation in cabin left and right side locations. MT184-1 safety harness (pilot torso support for external load ops) may be used with G949 hardpoint installation (available for purchase from RHC).

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.

NOTE

Rivets included in kit contents are provided as a courtesy and at lengths most commonly used on production helicopters. Proper rivet length is determined by installer during installation.

ITEM	PART NUMBER	KIT CONTENTS	QTY
1	KI-293Instr.	Kit Instructions	1
2	D210-3	Nut	6
3	G654-2	Decal	2
4	G949-2	Ring	2
5	G949-3	Doubler	2
6	G949-4	Doubler	2
7	MS20426AD4-3.5+	Rivet (Note: "+" in part number indicates 50-qty pack)	1
8	MS20470AD4-3.5+	Rivet (Note: "+" in part number indicates 20-qty pack)	1
9	MS27039C1-06	Screw	3
10	NAS557-8A	Grommet	2
11	NAS1149F0332P+	Washer (Note: "+" in part number indicates 20-qty pack)	1
12	NAS9301B-5-05	Rivet	2

Special Tools

Refer to R66 Maintenance Manual (MM) § 20-70 or Refer to R44 MM § 23-70 for approved materials list.

- B270-8 Adhesive

Special Tools

- Drilling, deburring, and countersinking tool
- Cleco® (sheet metal fastener) in sizes #10 (copper), #30 (copper)
- Blind rivet installation tool

Kit Instructions

1. Refer to Figure 1. Using straight edge to maintain lateral alignment with existing holes layout (3) 0.127–0.133 inch diameter holes location along roof as shown. Using a drill stop, progressively drill (3) 0.127–0.133 inch diameter holes and remove (2) existing rivets at locations shown.

Kit Instructions (continued)

2. Carefully separate headliner from roof only as necessary to access frame. Position G949-4 doubler inside frame as shown. Cleco in place and match drill (3) 0.127–0.133 inch diameter holes along roof thru G494-4 doubler. Remove clecos and G494-4 doubler.
3. Refer to Figure 2. Remove existing rivet indicated in figure. Using doubler as drill guide, progressively drill specified holes and install clecos. Remove doubler.
4. Refer to Figure 3. Position G949-2 ring on frame and clamp to frame. Using ring as drill guide, progressively drill specified holes and install clecos. Remove ring.
5. Deburr all drilled holes as required and clean up debris. At installer's discretion, alodine and/or prime/paint hole(s) edges as described in NOTE below:

NOTE

After trimming or filing aluminum, finish edges as follows: Deburr trimmed edges with 220-grit or finer wet-or-dry aluminum oxide abrasive paper. Solvent-clean deburred edge and apply Bonderite M-CR 1132, or Bonderite M-CR 1201 Aero in accordance with manufacturer's instructions. Apply epoxy primer to dry edge. Touch up with helicopter paint color, where applicable, is optional.

6. Refer to Figure 1. Cleco G949-4 doubler in position and install using (5) MS20470AD4-3.5 rivets through (5) 0.127-0.133 inch diameter holes.
7. Refer to Figure 2. Cleco G949-3 doubler in position and install using NAS9301B-5-05 rivet, MS20470AD4-3.5 rivet, and (4) MS20426AD4-3.5 rivets as indicated in figure. Install G654-2 decal centered on G949-3 doubler.
8. Refer to Figure 3. Install G949-2 ring onto frame using hardware as shown.
9. Install NAS557-8A grommet and position gap as shown.
10. As required, install headliner to roof using B270-8 adhesive. Touch up external rivets with matching paint.
11. Perform steps 1 thru 10 on opposite, right hand side.
12. Make appropriate maintenance record entries. Weight and Balance change is negligible.

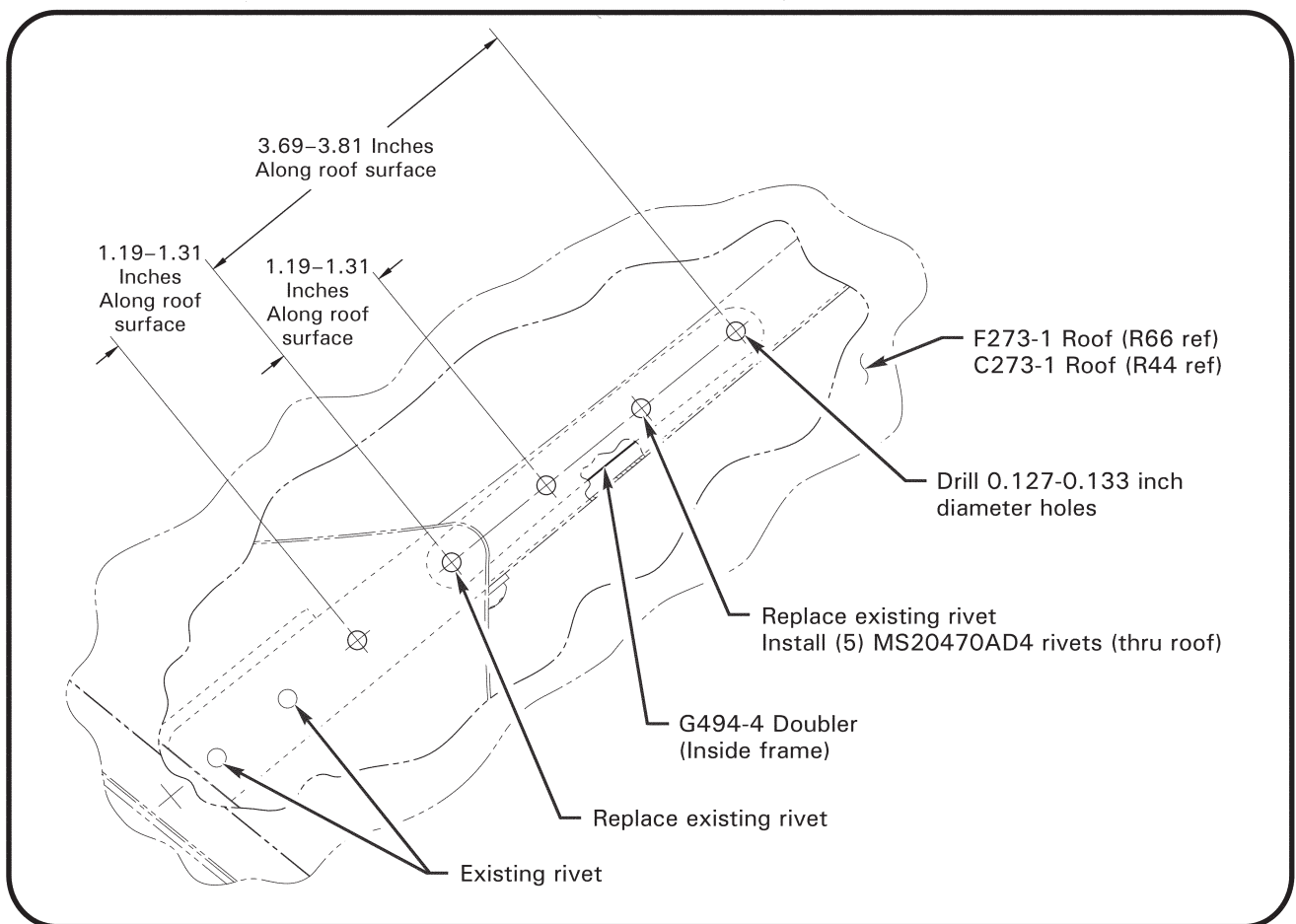
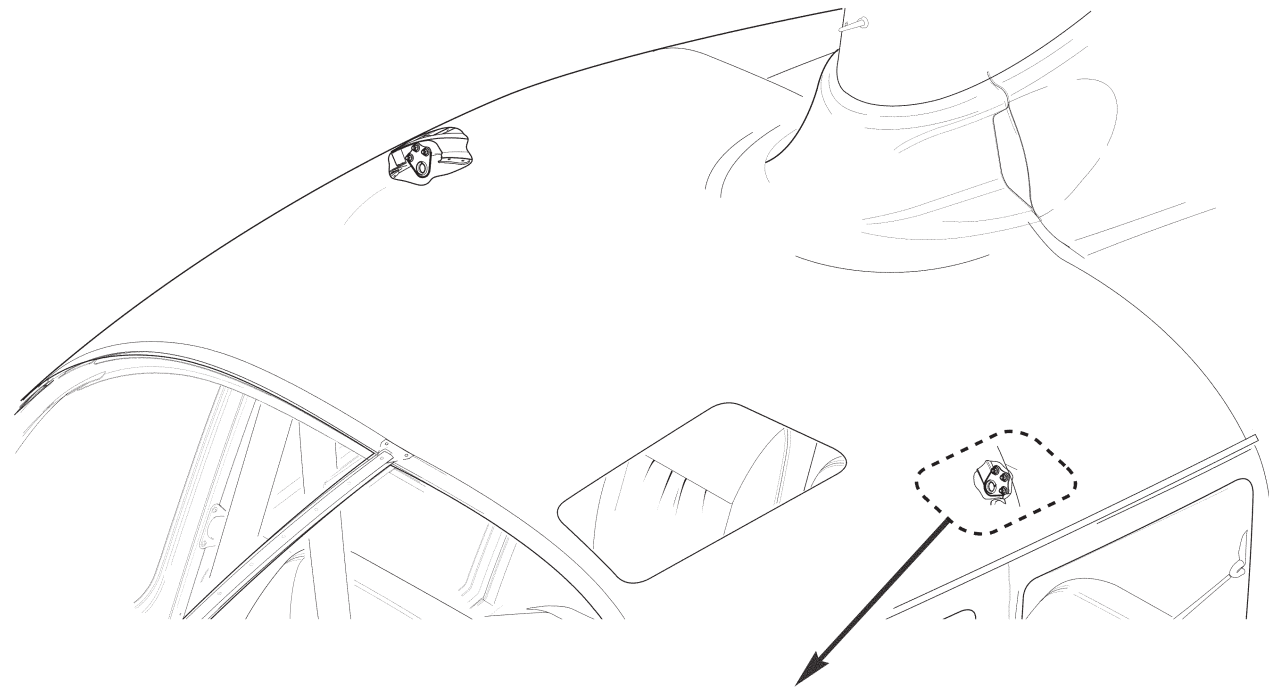


FIGURE 1 LH G494-4 Doubler
(LH installation shown; RH installation similar)

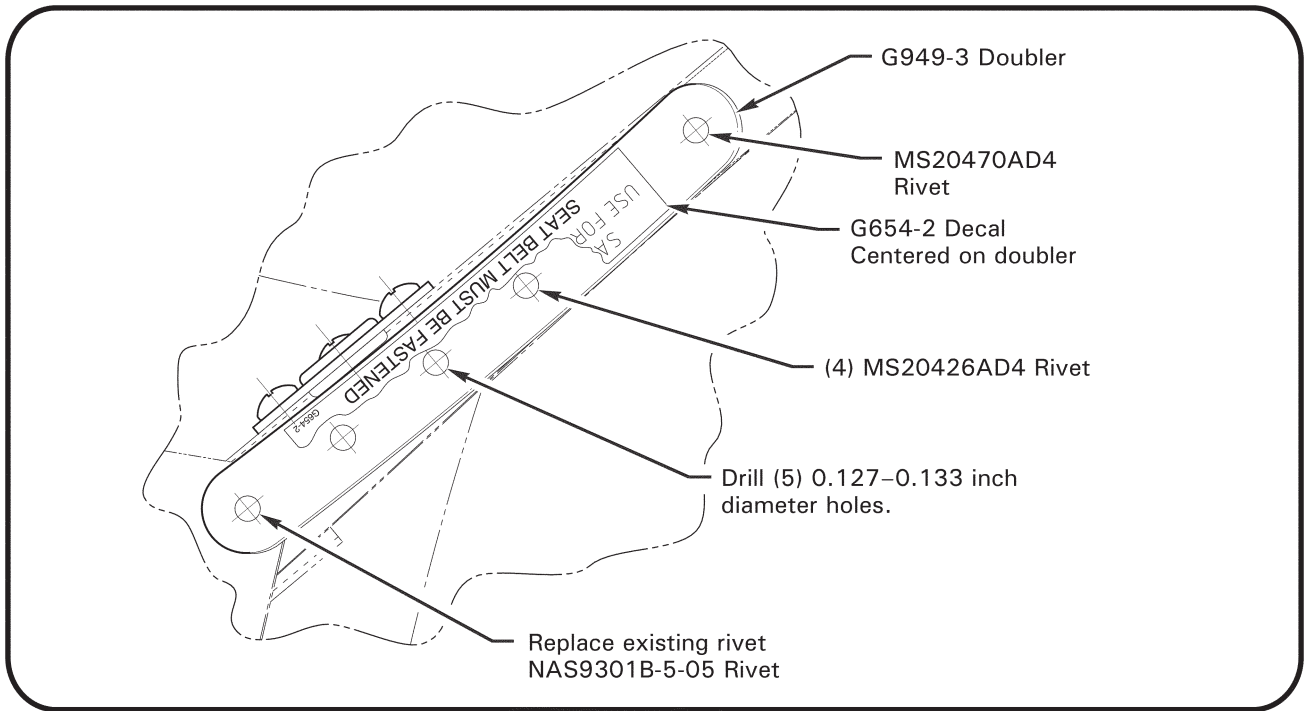


FIGURE 2 LH G494-3 Doubler inside cabin
(View looking upward from aft cabin LH seat; RH similar)

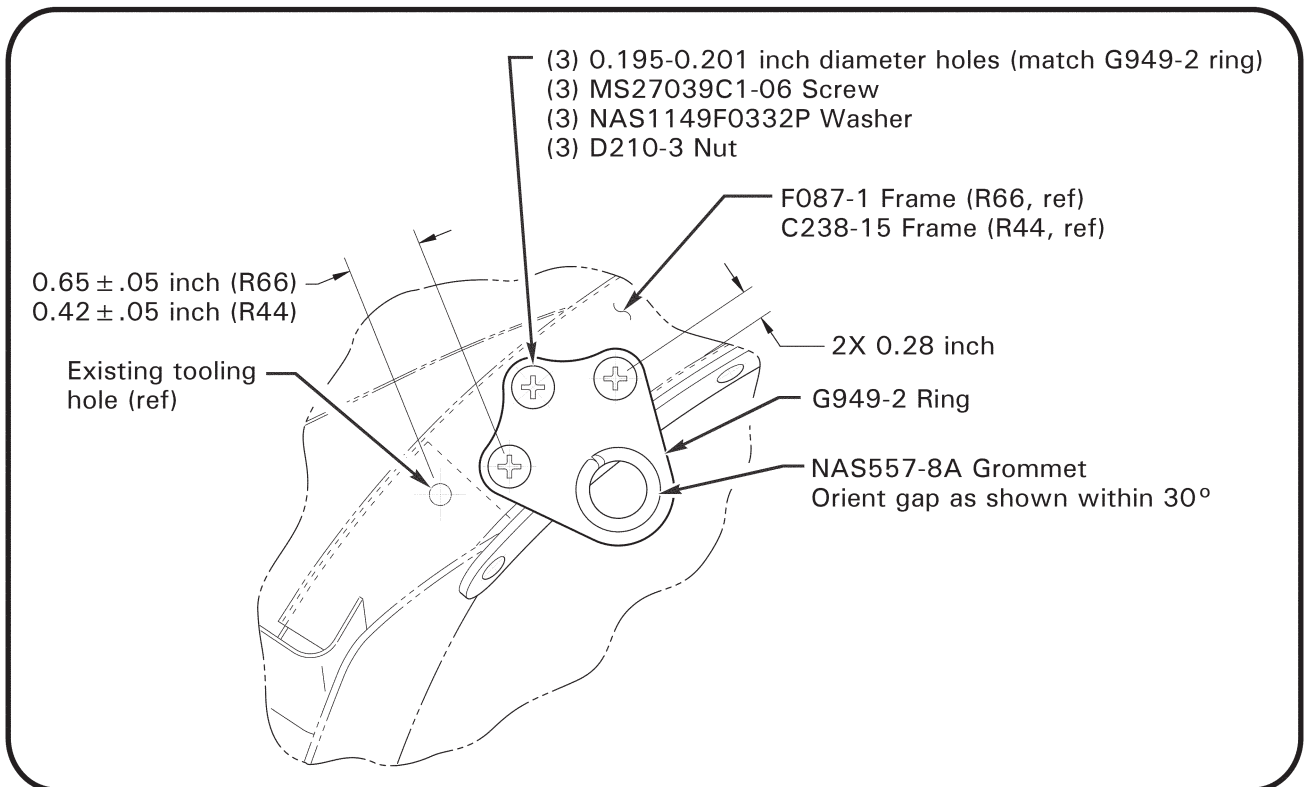


FIGURE 3 G494-2 Ring
(LH installation shown; RH installation similar)