

MT152-1 Spindle Removal & Installation Fixture Upgrade Kit Instructions

Kit installs a second jack support assembly to enhance jack stability.

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-5502-1Instr.	Kit Instructions	1
2	D210-6	Nut	2
3	MT151-2	Jack Support Assembly	1
4	NAS6606-12	Bolt	2

Special Tools

- Drilling and deburring tools
- Drill bit, size 25/64

Kit Instructions

1. Refer to Figure 1. Remove installation hardware securing MT149-1 jack assembly & MT152-2 jack support assembly to base. Remove jack assembly & jack support assembly, leaving jack assembly secured to support. Retain hardware.
2. Refer to Figure 2. Layout & mark location of (2) 0.390–0.397 inch diameter holes.

NOTE

Drilling a pilot hole and progressively enlarging hole to final dimension is recommended.

3. Drill (2) 0.390–0.397 inch diameter holes in base assembly as marked. Deburr holes and clean up debris.
4. Refer to Figure 1. Install jack assembly & jack support assembly using retained hardware. Install new MT151-2 jack support assembly to base using (2) NAS6606-12 bolts & (2) D210-6 nuts. Standard torque per R22 MM § 23-32, R44 MM § 23-32, or R66 MM § 20-32.
5. Ensure smooth operation of MT149-1 jack assembly.

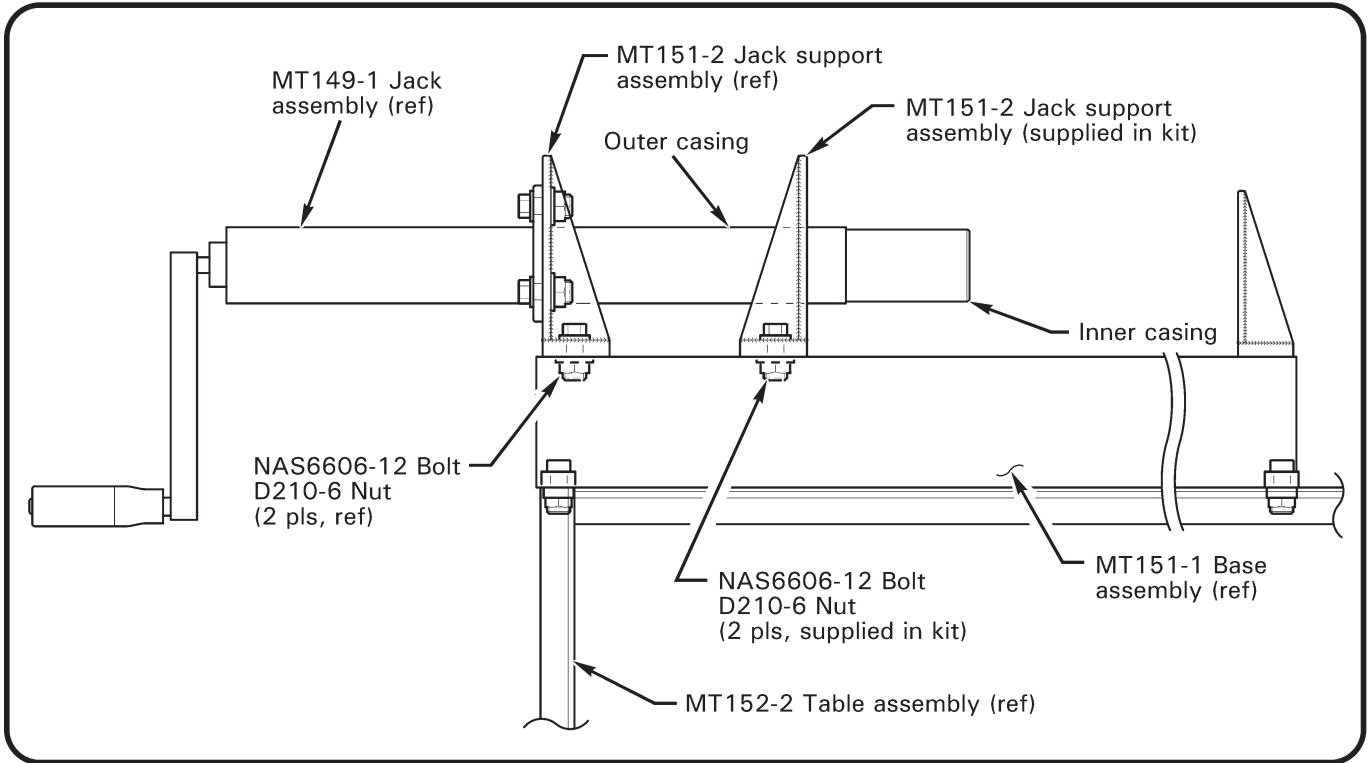


FIGURE 1 MT151-2 Jack support assembly installation

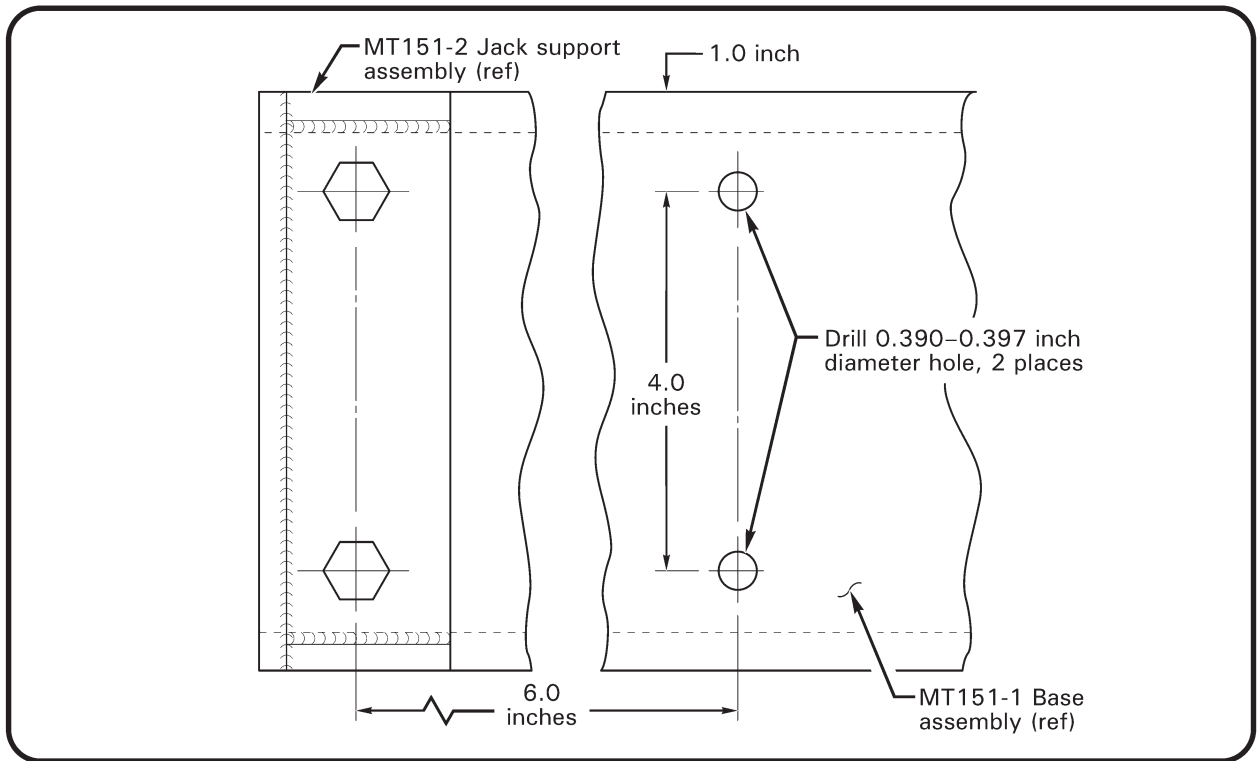


FIGURE 2 Locating MT151-2 Jack support assembly (with reference dimensions shown)