

**CHAPTER 67**

**FLIGHT CONTROLS**

<i>Figure</i>	<i>Title</i>	<i>Page</i>
67-1	Cyclic Control System . . . . .	67.0
67-5	Cyclic Pivot Assembly and Torque Tube . . . . .	67.4
67-9	Push-Pull Tube Assemblies (Lower) . . . . .	67.8
67-11	Cyclic Grip Assembly . . . . .	67.10
67-15	Cyclic Grip Assembly . . . . .	67.14
67-19	Cyclic Friction Assembly . . . . .	67.18
67-21	Collective Stick Assembly . . . . .	67.20
67-25	Jackshaft Weldment Installation . . . . .	67.24
67-27	Push-Pull Tube Assemblies (Upper) . . . . .	67.26
67-29	Tail Rotor Controls – Adjustable Pedals . . . . .	67.28
67-31	Tail Rotor Controls – Pedal Cover Installation . . . . .	67.30
67-33	F334 Support Assembly Installation . . . . .	67.32
67-35	C317 Bellcrank Assembly . . . . .	67.34
67-37	F316 Bellcrank Assembly . . . . .	67.36
67-39	A331 Bellcrank Assembly . . . . .	67.38
67-41	Swashplate Assembly . . . . .	67.40
67-45	Swashplate Ball Installation (C017 Revision AD & Subsequent) . . . . .	67.44
67-47	Swashplate Ball Installation (C017 Revision AA thru AC) . . . . .	67.46

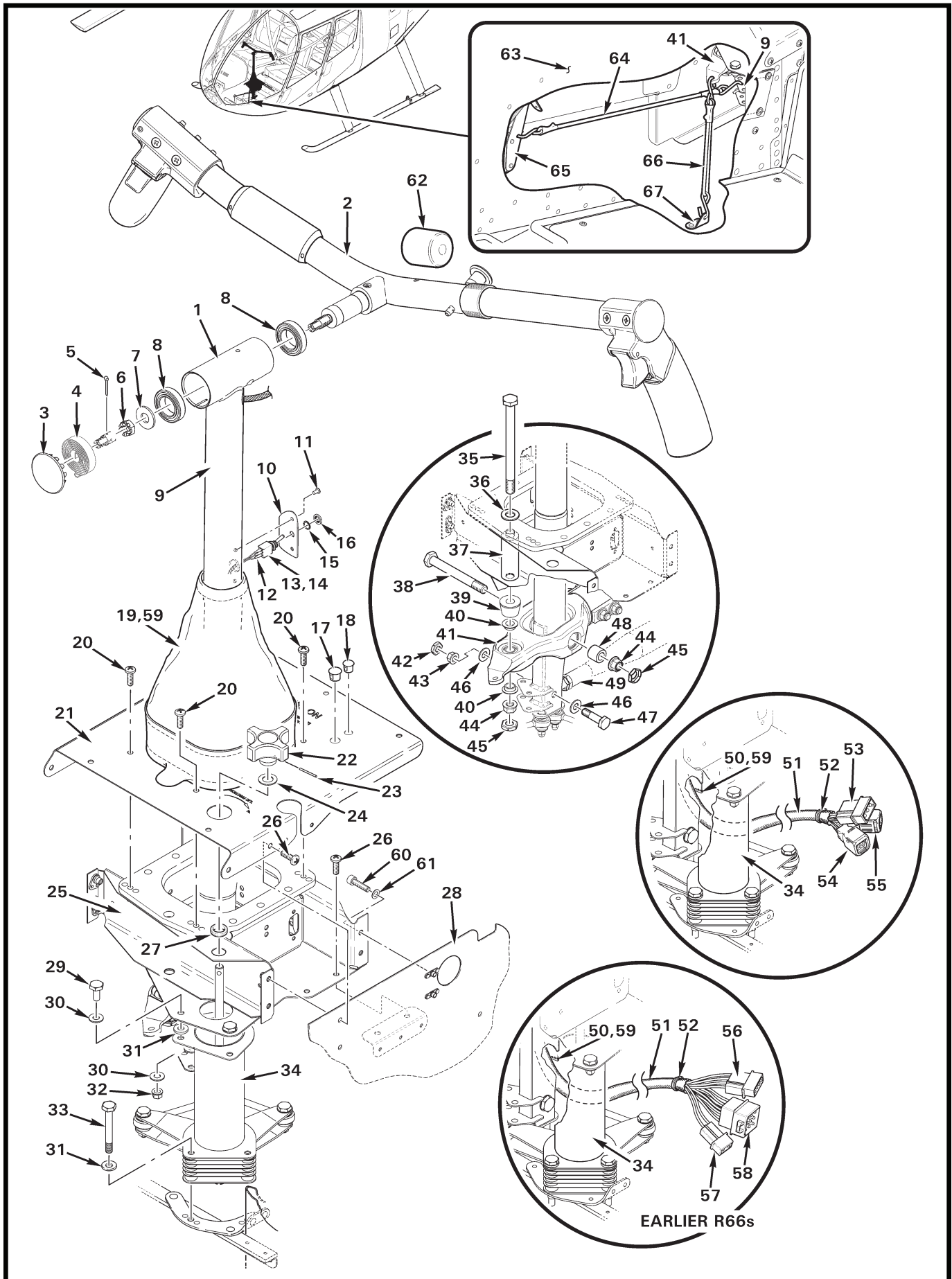


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC CONTROL SYSTEM</b>				
67-1-1	C069-14	Cyclic Control Assembly (Incl items 2 thru 9, 11, 13, 19, 21, 25, 37, 39 thru 45, 48, and 51 thru 55) . . . . .	X	1
	C069-8	Cyclic Control Assembly (Ref, no longer available)		
2	C058-10	Grip Assembly – Cyclic (see Figure 67-11) . . . . .	X	1
3	B209-4	Plug . . . . .	X	1
4	D684-1	Spring . . . . .	X	1
5	MS24665-69	Cotter Pin . . . . .	X	1
6	MS17825-5	Nut . . . . .	X	1
7	A141-40	Washer . . . . .	X	1
8	A647-2	Bearing . . . . .	X	2
9	D320-8	Stick Assembly (Ref)		
10	B306-4	Mount . . . . .	X	1
11	SR-3035B	Rivet . . . . .	X	2
12	B158-1	Heat Shrink (around terminals) . . . . .	X	A/R
13	C049-9	Switch Assembly – Landing Light (Incl items 10, 12, 14, and wires) . . . . .	X	1
14	B300-1	Switch (Incl items 15 and 16) . . . . .	X	1
15	B227-3	Lockwasher . . . . .	X	1
16	B227-11	Dress Nut . . . . .	X	1
17	2613	Hole Plug . . . . .	X	1
18	2603	Hole Plug . . . . .	X	1
19	A677-4	Boot (install using item 59) . . . . .	X	1
20	MS27039C0808	Screw . . . . .	X	4
21	F444-2	Cover Assembly – Cyclic . . . . .	X	1
	F444-1	Cover Assembly – Cyclic . . . . .	O	1
22	A499-2	Knob . . . . .	X	1
23	MS16562-35	Spring Pin . . . . .	X	1
24	NAS1149F0432P	Washer (or NAS1149F0463P) . . . . .	X	A/R
25	F338-1	Cyclic Box Assembly . . . . .	O	1
26	MS27039C0806	Screw . . . . .	X	14
27	NAS557-6A	Grommet . . . . .	X	1
28	—	Keel Panel (Ref)		
29	NAS6603-2	Bolt . . . . .	X	2
30	NAS1149F0332P	Washer . . . . .	X	4
31	NAS1149F0363P	Washer . . . . .	X	4

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
CYCLIC CONTROL SYSTEM (Cont'd)				
67-1-32	MS21042L3	Nut . . . . .	X	5
33	NAS6603-18	Bolt . . . . .	X	2
34	C048-1	Cyclic Friction Assembly (Ref; see also Figure 67-19)		
35	NAS6605-56	Bolt . . . . .	X	1
36	NAS1149F0532P	Washer . . . . .	X	1
37	A130-6	Spacer . . . . .	X	1
38	NAS1305-35	Bolt . . . . .	X	5
39	A339-1	Spacer . . . . .	X	1
40	A340-1	Spacer . . . . .	X	2
41	C177-5	Pivot Assembly . . . . .	X	1
42	B330-13	Palnut . . . . .	X	1
43	D210-4	Nut . . . . .	X	1
44	D210-5	Nut . . . . .	X	2
45	B330-16	Palnut . . . . .	X	2
46	NAS1149F0432P	Washer . . . . .	X	1
47	NAS6604-9	Bolt . . . . .	X	1
48	C105-3	Journal . . . . .	X	1
49	C121-1	Push-Pull Tube (Ref, see Figure 67-5)		
50	MS21266-1N	Grommet (install using item 59) . . . . .	X	A/R
51	B266-8	Sleeving . . . . .	X	A/R
52	B268-3	Lacing Tape (at both ends of sleeve) . . . . .	X	A/R
53	B263-14	Housing . . . . .	X	1
	B263-1	Pin . . . . .	X	3
54	D269-11	Plug (includes [9] M39029/57-354 sockets) . . . . .	X	1
55	D269-9	Plug (includes [9] M39029/58-360 pins) . . . . .	X	1
56	B263-36	Housing . . . . .	X	1
	B263-1	Pin . . . . .	X	4
57	B263-12	Housing . . . . .	X	1
	B263-1	Pin . . . . .	X	2
58	B263-20	Housing . . . . .	X	1
	B263-1	Pin . . . . .	X	9
59	B270-8.5oz	Adhesive . . . . .	X	A/R
60	NAS1352-08-6P	Screw . . . . .	X	4
61	NAS620-8L	Washer . . . . .	X	4
62	A959-5	Cap . . . . .	X	1

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
CYCLIC CONTROL SYSTEM (Cont'd)				
67-1-63	F033	Lower Console Assembly (Ref)		
64	D918-1	Elastic Cord Assembly (3 lb ± 0.25) . . . . .	X	1
65	F407-5	Gusset (Ref)		
66	D918-2	Elastic Cord Assembly (5 lb ± 0.50) . . . . .	X	1
67	A748-8	Angle (Ref)		
NOTES				

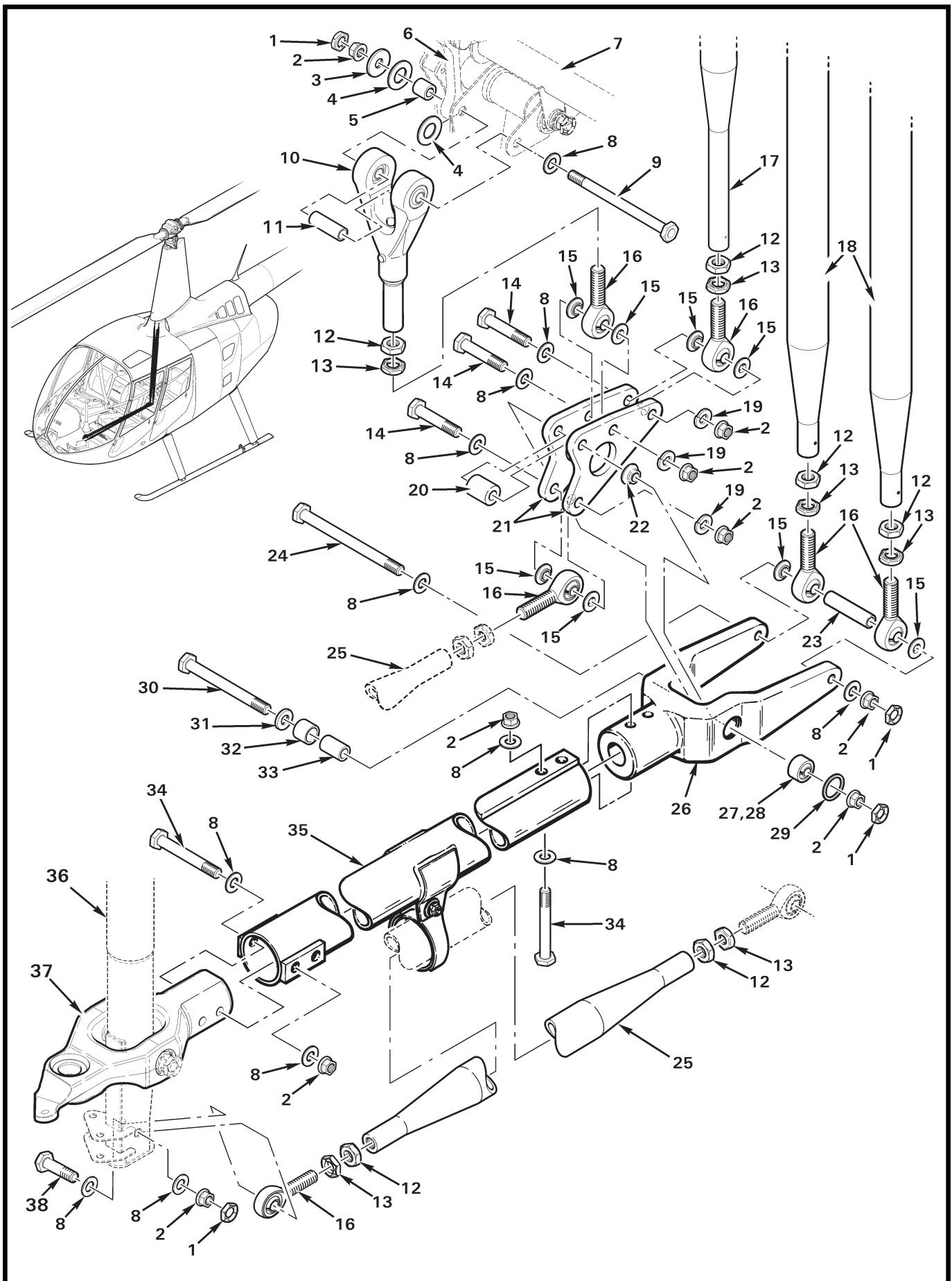


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC PIVOT ASSEMBLY AND TORQUE TUBE</b>				
67-5-1	B330-13	Palnut . . . . .	X	4
2	D210-4	Nut . . . . .	X	11
3	A214-3	Washer . . . . .	X	1
4	A214-11	Washer . . . . .	X	2
5	A105-14	Journal . . . . .	X	1
6	C327-1	Link Assembly (Ref, see Figure 67-33)		
7	F334	Aft Support Assembly (Ref, see Figure 67-33)		
8	NAS1149F0432P	Washer . . . . .	X	16
9	NAS6604-37	Bolt . . . . .	X	1
10	G205-1	Fork Assembly . . . . .	X	1
11	C130-12	Spacer . . . . .	X	1
12	AN316-5R	Nut . . . . .	X	6
13	B330-16	Palnut . . . . .	X	6
14	NAS6604-15	Bolt . . . . .	X	3
15	A115-1	Spacer . . . . .	X	8
16	B163-2*	Rod End . . . . .	X	6
17	F121-7	Push-Pull Tube (Incl items 12, 13 and 16, [1] each) . . . . .	X	1
18	F121-5	Push-Pull Tube (Incl items 12, 13 and 16, [1] each) . . . . .	X	2
19	B332-441	Lockwasher . . . . .	X	3
20	A130-8	Spacer . . . . .	X	1
21	C958-6	Bellcrank . . . . .	X	2
22	A137-1	Spacer . . . . .	X	1
23	C130-47	Spacer . . . . .	X	1
24	NAS6604-47	Bolt . . . . .	X	1
25	C121-1	Push-Pull Tube Assembly (Incl item 12, 13, and 16) . . . . .	X	1
26	D696-6	Yoke Assembly (Incl items 27 thru 29, and 32) . . . . .	X	1
27	A103-4	Bearing (install using item 28) . . . . .	X	1
28	B270-11	Adhesive . . . . .	X	A/R
29	WH-62-S02	Ring . . . . .	X	1
30	NAS6604-36	Bolt . . . . .	X	1
31	NAS1149F0463P	Washer . . . . .	X	1
32	O6DU06	Bearing . . . . .	X	1
33	A105-6	Journal . . . . .	X	1
34	NAS6604-25	Bolt . . . . .	X	4
35	C319-5	Torque Tube Assembly . . . . .	X	1

NOTES \* Coat all threads with A257-2 or A257-22 oil before assembly.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
CYCLIC PIVOT ASSEMBLY AND TORQUE TUBE (Cont'd)				
67-5-36	C069	Cyclic Control Assembly (Ref, see Figure 67-1)		
37	C177-5	Pivot Assembly (Ref, see Figure 67-1)		
38	NAS6604-9	Bolt (Ref, see Figure 67-1)		
39	C175-5	Pivot Assembly – Cyclic (Incl items 1 thru 5, 8 thru 16, 19 thru 26, 30, 31, and 33 thru 35) . . . . .	0	1
NOTES				



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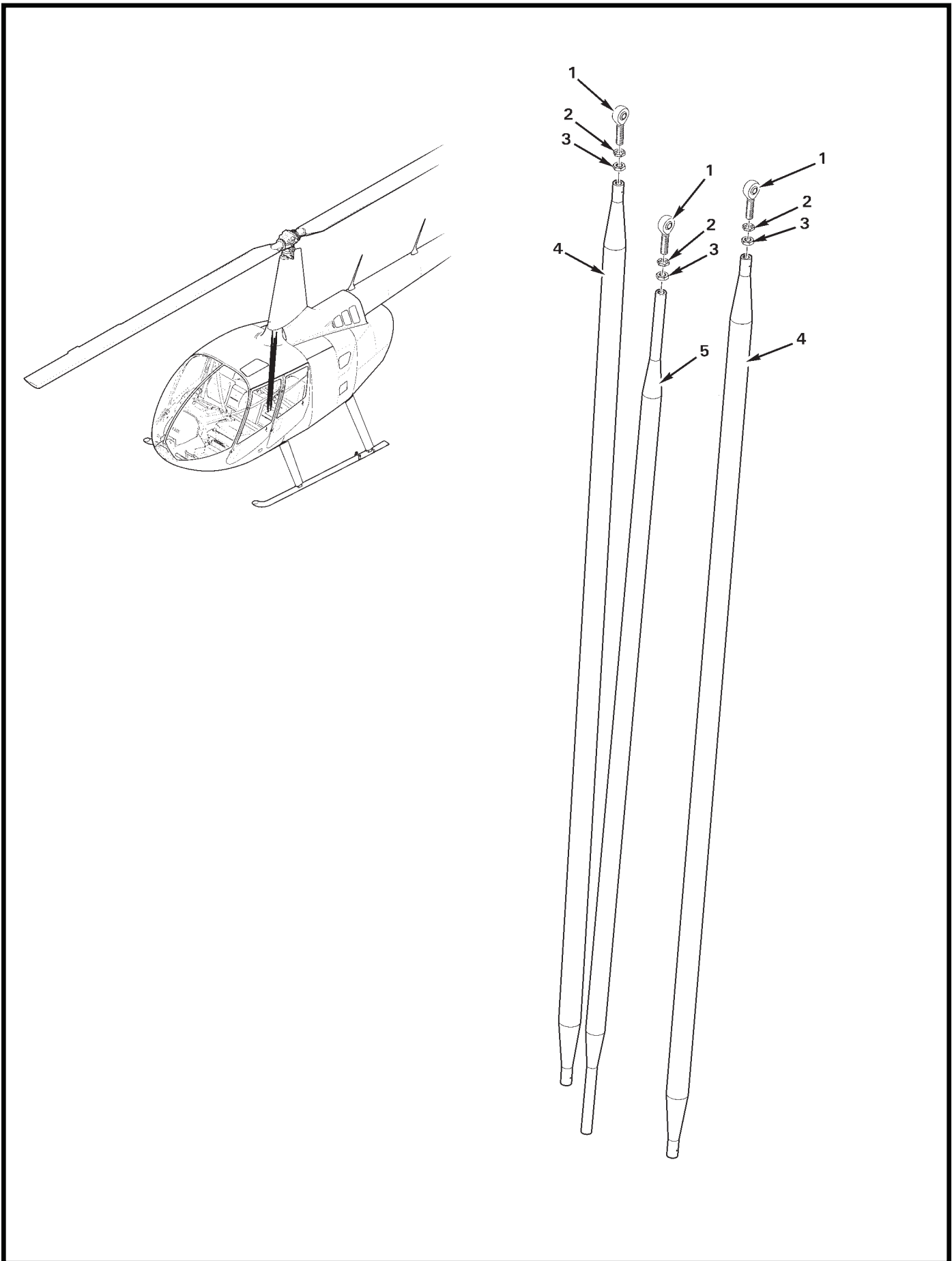


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
PUSH-PULL TUBE ASSEMBLIES (LOWER)				
67-9-1	B163-2*	Rod End . . . . .	X	1
2	B330-16	Palnut . . . . .	X	1
3	AN316-5R	Nut . . . . .	X	1
4	F121-5	Push-Pull Tube Assembly (Incl items 1 thru 3, [1] each) . . . . .	X	2
5	F121-7	Push-Pull Tube Assembly (Incl items 1 thru 3, [1] each) . . . . .	X	1

NOTES \* Coat all threads with A257-2 or A257-22 oil before assembly.

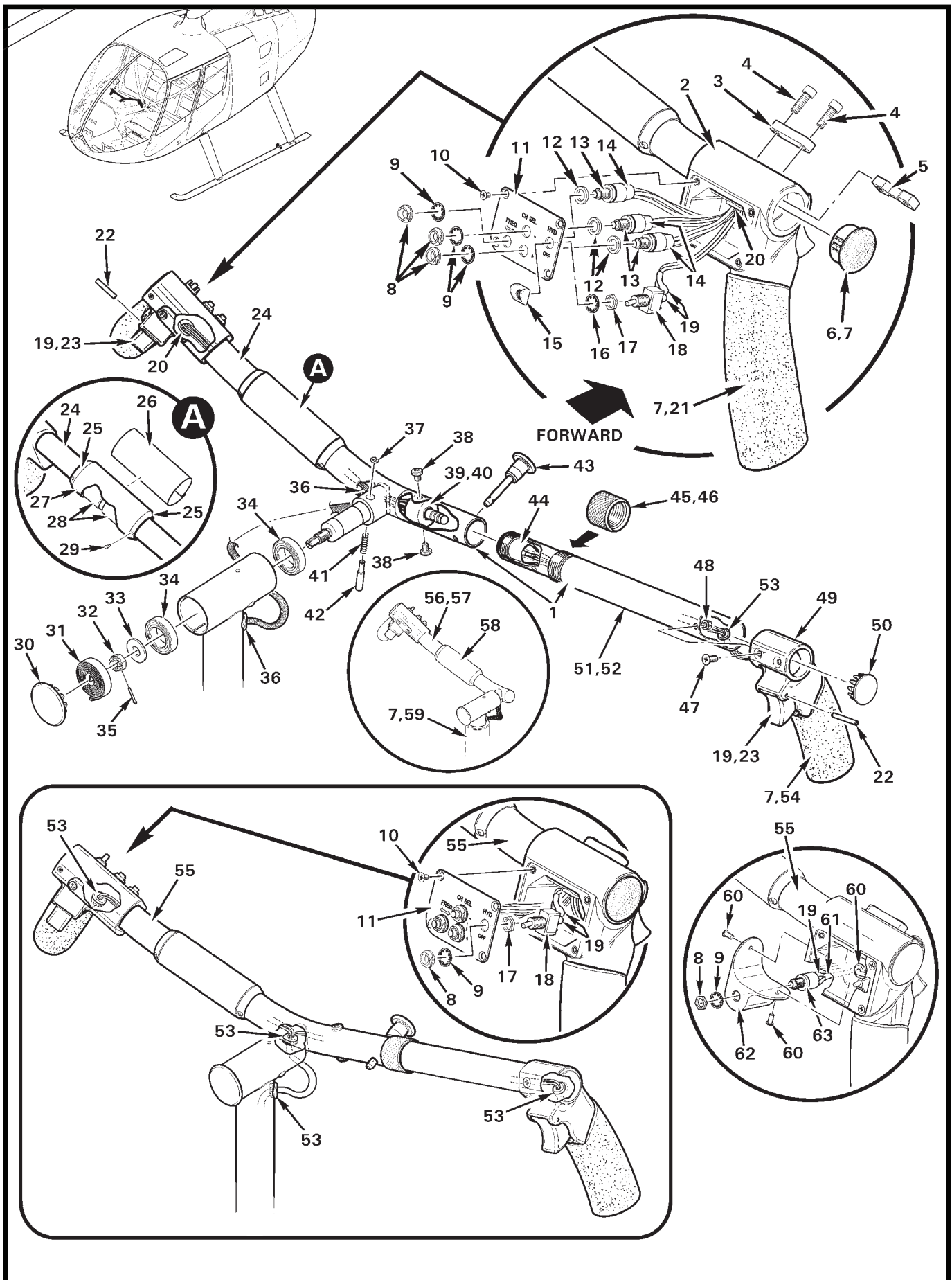


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC GRIP ASSEMBLY</b>				
67-11-1	C058-10	Grip Assembly – Cyclic (Incl items 2 thru 7, 10, 11, 13 thru 15, 18 thru 29, 36 thru 50, and 52 thru 54) . . . . .	X	1
2	D379-1	Grip . . . . .	X	1
3	D443-5	Bar . . . . .	X	1
4	91251A194	Screw . . . . .	X	2
5	D443-3	Block Assembly . . . . .	X	1
6	2703	Hole Plug (install using item 7) . . . . .	X	1
7	B270-15	Adhesive . . . . .	X	A/R
8	B227-4	Dress Nut . . . . .	X	1
9	B227-3	Lockwasher . . . . .	X	1
10	MS24693-S1	Screw . . . . .	X	4
11	C214-24	Plate . . . . .	X	1
12	94773A770	Washer . . . . .	X	3
13	B227-2	Switch Assembly (“FREQ” and “CH SEL” [2]; includes items 8, 9, and 12) . . . . .	X	3
14	B158-6	Heat Shrink . . . . .	X	A/R
15	D443-7	Guard . . . . .	X	1
16	—	Lockwasher . . . . .	O	1
17	—	Hex Nut (5/16”) . . . . .	O	1
18	B300-3	Switch Assembly – “HYD OFF” (includes items 16 and 17) . .	X	1
19	B158-2	Heat Shrink . . . . .	X	A/R
20	NAS557-6A	Grommet . . . . .	X	A/R
21	D379-2	Cover (install using item 7) . . . . .	X	2
22	NAS1407N9L14	Pin . . . . .	X	2
23	U2-279	Trigger Switch . . . . .	X	2
24	A756-24	Grip Weldment (Revision A1 and subsequent) . . . . .	O	1
25	G725-3	Collar . . . . .	X	2
26	F654-4	Decal (flight limitations) . . . . .	X	1
	F654-28	Decal (flight limitations, Police ships) . . . . .	X	1
	G682-14	Decal (flight limitations, E.N.G. ships) . . . . .	X	1
27	G725-2	Tube . . . . .	X	1
28	B175-12	Loop Tape . . . . .	X	A/R
29	SR-2032B	Rivet . . . . .	X	4
30	B209-4	Plug . . . . .	X	1
31	D684-1	Spring . . . . .	X	1

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
CYCLIC GRIP ASSEMBLY (Cont'd)				
67-11-32	MS17825-5	Nut . . . . .	X	1
33	A141-40	Washer . . . . .	X	1
34	A647-2	Bearing . . . . .	X	2
35	MS24665-69	Cotter Pin . . . . .	X	1
36	G1042	Grommet . . . . .	X	2
37	MS16633-2012	Retaining Ring . . . . .	X	1
38	MS35206-241	Screw . . . . .	X	2
39	A776-1	Mount . . . . .	X	1
40	A781-1	Plug . . . . .	X	1
41	D774-6	Spring . . . . .	X	1
42	A321-16	Pin . . . . .	X	1
43	B232-1	Pin . . . . .	X	1
44	TJT-120	Jack . . . . .	X	1
45	A321-22	Collar . . . . .	X	1
46	A257-7	Dry Film Lube . . . . .	X	A/R
47	MS24694-S3	Screw . . . . .	X	2
48	MS21042L08	Nut . . . . .	X	2
49	D690-1	Grip . . . . .	X	1
50	B209-3	Plug . . . . .	X	1
51	C058-9	Grip Assembly – Co-Pilot (Incl items 7, 19, 22, 23, 43 thru 50, and 52 thru 54; for spares) . . . . .	X	1
52	A321-21	Tube . . . . .	X	1
53	MS35489-4	Grommet . . . . .	X	A/R
54	D690-2	Cover (install using item 7) . . . . .	X	1
55	A756-24	Grip Weldment (Ref; revision AH)		
56	C058-11*	Grip Assembly – Cyclic (includes items 2 thru 7, 13 thru 15, 25, 27 thru 29, 36, 37, 41, 42, 57, and 58) . . . . .	X	1
57	A756-20*	Grip Weldment (Ref)		
58	F654-28*	Decal (flight limitations, Police ships) . . . . .	X	1
59	A601-3*	Grip (install using item 7) . . . . .	X	1
60	MS20470AD3**	Rivet . . . . .	X	2
61	B158-6**	Heat Shrink . . . . .	X	A/R
62	G136-8**	Housing . . . . .	X	1
63	B227-2**	Switch Assembly (Audio Panel transmit key [pilot]; includes items 8 and 9) . . . . .	X	1
	C058-2329**	Wire (Ref)		
	C058-2441**	Wire (Ref)		

NOTES \* Earlier R66 police ships.  
 \*\* Geneva Audio push to talk button for E.N.G. ships.

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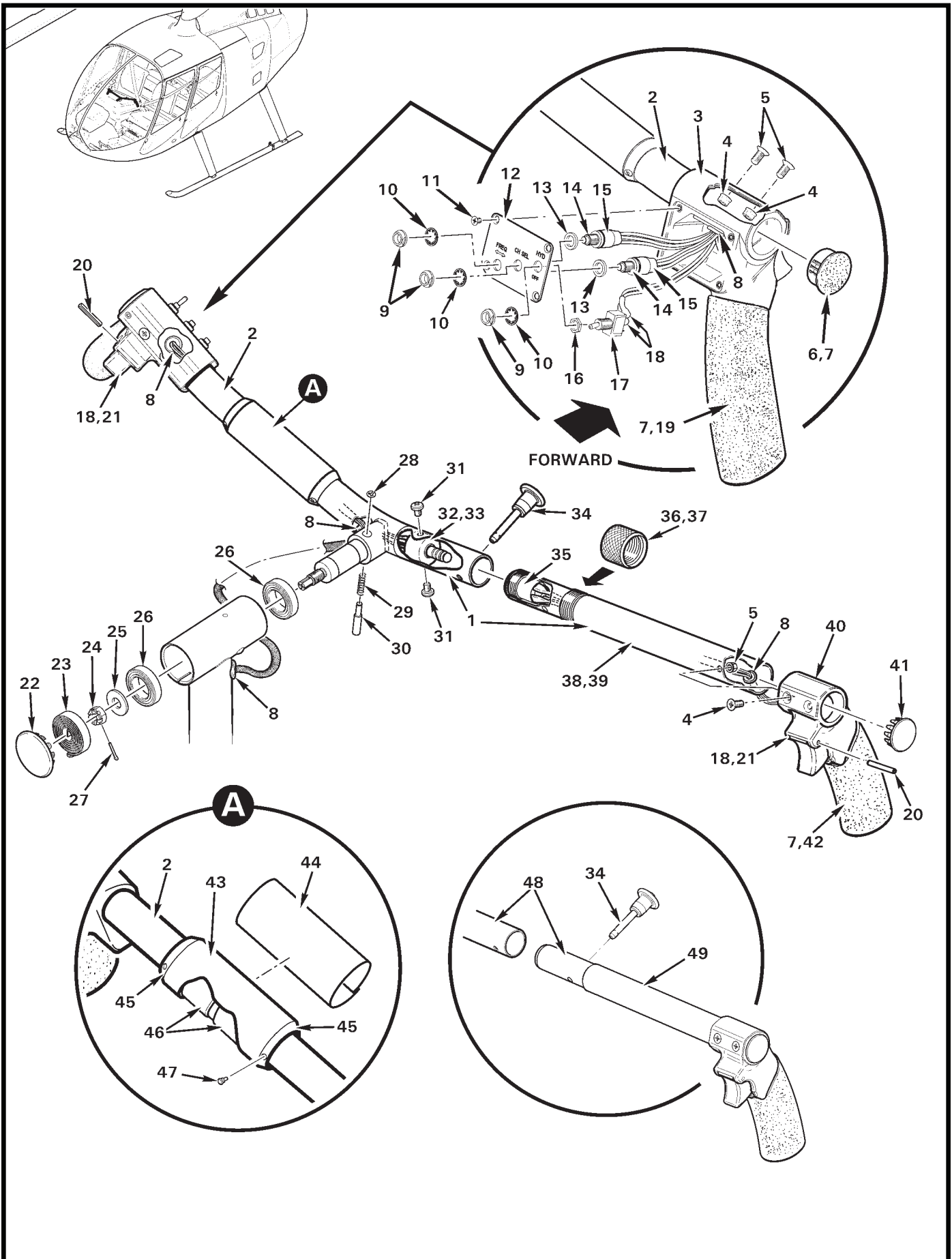




FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC GRIP ASSEMBLY</b>				
67-15-1	C058-10*	Grip Assembly – Pilot/Co-Pilot (Ref; revision AL)		
2	A756	Grip Weldment (Ref; non-adjusting grip [item 3])		
3	D379-1	Grip . . . . .	X	1
4	MS21042L08	Nut . . . . .	X	4
5	MS24694-S3	Screw . . . . .	X	4
	MS24694-S4	Screw (used with item 48) . . . . .	X	4
6	2703	Hole Plug (install using item 7) . . . . .	X	1
7	B270-15	Adhesive . . . . .	X	A/R
8	MS35489-4	Grommet . . . . .	X	4
9	B227-4	Dress Nut . . . . .	X	1
10	B227-3	Lock Washer . . . . .	X	1
11	MS24693-S1	Screw . . . . .	X	4
	MS24693-S2	Screw (used with item 48) . . . . .	X	4
12	C214-10	Plate . . . . .	X	1
13	94773A770	Washer . . . . .	X	1
14	B227-2	Switch (“FREQ” and “CH SEL”, includes items 9, 10, and 13)	X	2
15	B158-6	Heat Shrink . . . . .	X	A/R
16	—	Hex Nut (5/16 in.) . . . . .	O	1
17	B300-3	Switch (“HYD OFF”, includes item 16 and lockwasher [not shown]) . . . . .	X	1
18	B158-2	Heat Shrink . . . . .	X	A/R
19	D379-2	Cover (install using item 7) . . . . .	X	1
20	NAS1407N9L14	Pin . . . . .	X	2
21	U2-279	Trigger Switch . . . . .	X	2
22	B209-4	Plug . . . . .	X	1
23	D684-1	Spring . . . . .	X	1
24	MS17825-5	Nut . . . . .	X	1
25	A141-40	Washer . . . . .	X	1
26	A647-2	Bearing . . . . .	X	2
27	MS24665-69	Cotter Pin . . . . .	X	1
28	MS16633-2012	Retaining Ring . . . . .	X	1
29	D774-6	Spring . . . . .	X	1
30	A321-16	Pin . . . . .	X	1
31	MS35206-241	Screw . . . . .	X	2
32	A776-1	Mount . . . . .	X	1

NOTES \* Some parts/assemblies no longer available. To replace refer to Figure 67-11.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC GRIP ASSEMBLY (Cont'd)</b>				
67-15-33	A781-1	Plug .....	X	1
34	B232-1	Pin .....	X	1
35	TJT-120	Jack .....	X	1
36	A321-22	Collar .....	X	1
37	A257-7	Dry Film Lubricant .....	X	A/R
38	C058-9*	Grip Assembly – Co-Pilot (Adjustable, revision AL. Includes items 4, 5, 7, 8, 20, 21, 34, 35, 40 thru 42.) .....	X	1
39	A321-19	Tube (Ref)		
40	D690-1	Grip .....	X	1
41	B209-3	Plug .....	X	1
42	D690-2	Cover (install using item 7) .....	X	1
43	G725-2	Tube .....	X	1
44	F654-4	Decal (flight limitations) .....	X	1
45	G725-3	Collar .....	X	2
46	B175-12	Loop Tape .....	X	A/R
47	SR-2032B	Rivet .....	X	4
***				
48	C058-10*	Grip Assembly – Pilot/Co-Pilot (Ref; revision AK and prior)		
49	C058-9	Grip Assembly – Co-Pilot (Ref; revision AK and prior, non-adjusting. To replace, order item 38.)		

NOTES \* Some parts/assemblies no longer available. Refer to Figure 67-11 for replacement.

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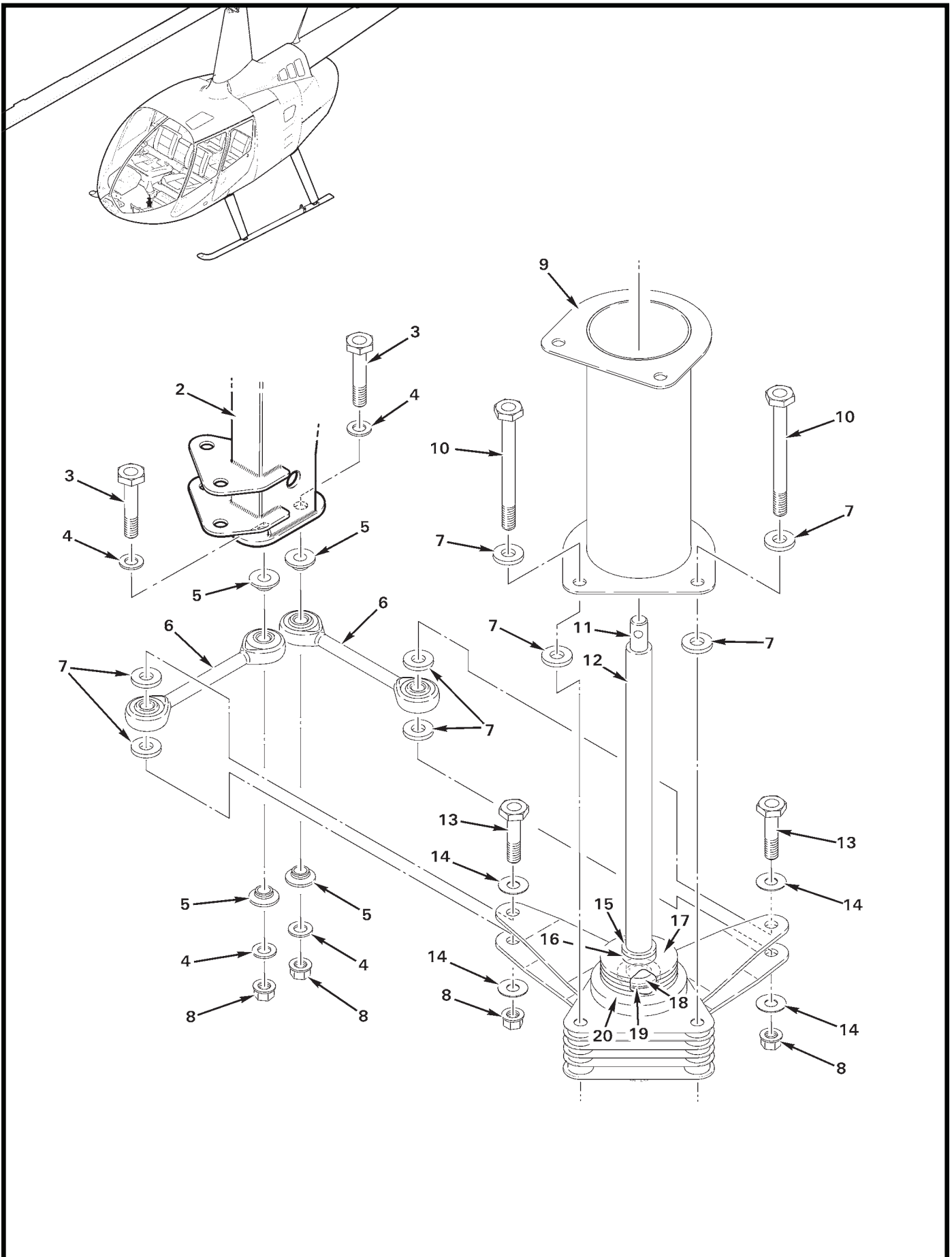


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>CYCLIC FRICTION ASSEMBLY</b>				
67-19-1	C048-1	Cyclic Friction Assembly (Incl items 6 thru 20) . . . . .	X	1
2	C069	Cyclic Control Assembly (Ref, see Figure 67-1)		
3	NAS6603-11	Bolt . . . . .	X	2
4	NAS620-10L	Washer . . . . .	X	4
5	A341-1	Spacer . . . . .	X	4
6	B564-1	Link . . . . .	X	2
7	NAS1149F0363P	Washer . . . . .	X	8
8	D210-3	Nut . . . . .	X	4
9	D337-1	Torque Tube Weldment . . . . .	X	1
10	NAS6603-27	Bolt . . . . .	X	2
11	C494-1	Shaft (Ref)		
12	C130-2	Spacer . . . . .	X	1
13	NAS6603-8	Bolt . . . . .	X	2
14	NAS1149D0316J	Washer . . . . .	X	4
15	NAS1149F0463P	Washer . . . . .	X	1
16	A130-18	Spacer . . . . .	X	1
17	A478-1	Spring Washer . . . . .	X	4
18	NAS1149F0632P	Washer . . . . .	X	1
19	NAS1149D0616J	Washer (installed between items 18 and 20) . . . . .	X	A/R
20	A497-1	Washer (Ref)		

NOTES

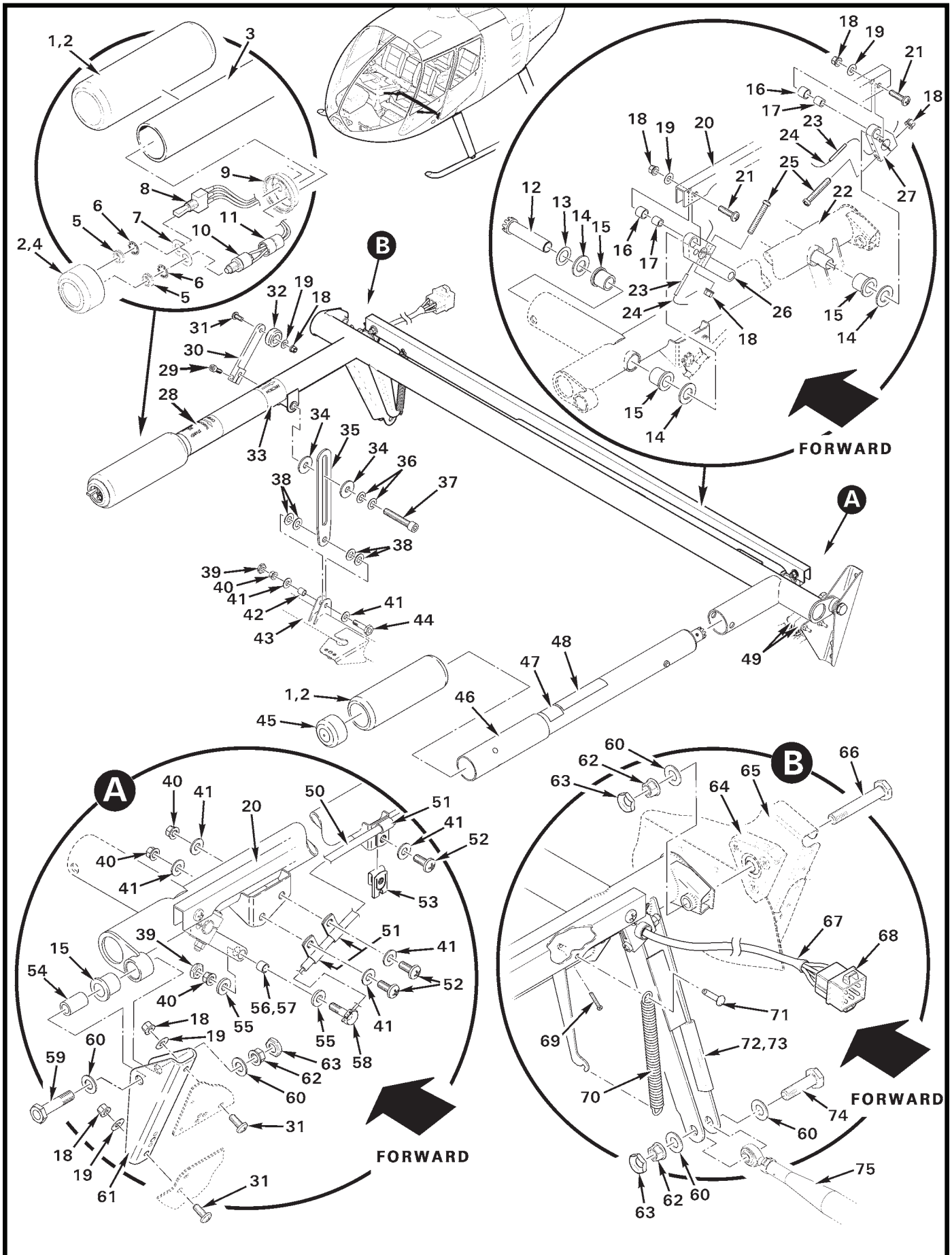


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>COLLECTIVE STICK ASSEMBLY</b>				
67-21-1	A601-1	Grip (install using item 2) . . . . .	X	1
2	B270-15	Adhesive . . . . .	X	A/R
3	F758-1	Stick Assembly – Collective (RH [pilot]; includes items 1, 2, 4, 8 thru 10, 12 thru 37, 39 thru 42, 51 thru 63, & 67 thru 74) . .	X	1
4	A959-2	Cap (install using item 2) . . . . .	X	1
5	B227-4	Dress Nut . . . . .	X	1
6	B227-3	Lockwasher . . . . .	X	1
7	B252-7	Bracket . . . . .	X	1
8	B280-6	Switch Assembly (Incl items 5 and 6) . . . . .	X	1
9	B252-8	Mount . . . . .	X	1
10	B280-5	Switch Assembly (Incl items 5, 6, and 11) . . . . .	X	1
11	B158-6	Heat Shrink . . . . .	X	A/R
12	A765-2	Coupling . . . . .	O	1
13	NAS1149D0616J	Washer (as required for shimming) . . . . .	X	A/R
14	A141-16	Washer ([2] each, co-pilot and pilot stick) . . . . .	X	4
15	A139-1	Bearing . . . . .	X	5
16	04DU04	Bushing . . . . .	X	1
17	A105-5	Journal . . . . .	X	2
18	MS21042L08	Nut . . . . .	X	7
19	NAS1149FN816P	Washer . . . . .	X	5
20	F328-1	Connecting Rod . . . . .	X	1
21	MS27039C0810	Screw . . . . .	X	2
22	F764	Stick Weldment (Ref)		
23	MS16562-18	Spring Pin . . . . .	X	2
24	MS20995C32	0.032 in. dia Safety Wire . . . . .	X	A/R
25	A486-2	Screw . . . . .	X	2
26	A325-3	Arm . . . . .	X	1
27	A325-1	Arm . . . . .	X	1
28	F654-1	Decal – “THROTTLE OPEN” . . . . .	X	1
29	NAS1352-08LE8P	Screw . . . . .	X	1
30	A332-2	Lever . . . . .	X	1
31	MS27039C0806	Screw . . . . .	X	3
32	A431-1	Knob . . . . .	X	1
33	A654-7	Decal – “FRICTION INCREASE” . . . . .	X	1
34	A141-20	Washer . . . . .	X	2

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
COLLECTIVE STICK ASSEMBLY (Cont'd)				
67-21-35	A333-1	Stop . . . . .	X	1
36	B0500-022-S	Belleville Washer . . . . .	X	2
37	NAS1352-4-24P	Screw . . . . .	X	1
38	NAS1149F0432P	Washer (or NAS1149F0463P to adjust axial play) . . . . .	X	4
39	B330-7	Palnut . . . . .	X	2
40	D210-3	Nut . . . . .	X	4
41	NAS1149F0332P	Washer . . . . .	X	7
42	A130-4	Spacer . . . . .	X	1
43	F348-1	Anchor (Ref)		
44	NAS6603-5	Bolt . . . . .	X	1
45	A959-1	Cap (install using item 2) . . . . .	X	1
46	C758-2	Stick Assembly – Collective (LH [Co-pilot]; includes items 45, 47, and 48) . . . . .	X	1
47	A654-6	Decal – “THROTTLE OPEN” . . . . .	X	1
48	A654-21	Decal – “NO STOWAGE / KEEP AREA CLEAR” . . . . .	X	1
49	V3-1	Switch (Hourmeter and Low RPM Warning, Ref; see Figure 96-23)		
50	C522-10	Control Cable (Ref, see Figure 76-1)		
51	AN742-3	Clamp . . . . .	X	3
52	MS27039C1-07	Screw . . . . .	X	3
53	B162-4	Clipnut . . . . .	X	1
54	A105-6	Journal . . . . .	X	1
55	NAS1149E0363R	Washer . . . . .	X	1
56	A130-48	Spacer (install using item 57) . . . . .	X	1
57	A257-1	Grease . . . . .	X	A/R
58	A462-4	Fitting . . . . .	X	1
59	NAS6604-11	Bolt . . . . .	X	1
60	NAS1149F0432P	Washer . . . . .	X	5
61	F303-1	Support Assembly . . . . .	X	1
62	D210-4	Nut . . . . .	X	3
63	B330-13	Palnut . . . . .	X	3
64	C329-3	Bearing Block Assembly (Ref)		
65	F290-1	Seat Support Assembly (RH, forward; Ref)		
66	NAS6604-17	Bolt . . . . .	X	1
67	B158-3	Heat Shrink . . . . .	X	A/R

NOTES

Continues



FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>COLLECTIVE STICK ASSEMBLY (Cont'd)</b>				
67-21-68	B263-18	Housing .....	X	1
	B263-1	Pin .....	X	5
69	MS24665-132	Cotter Pin .....	X	2
70	B774-4	Spring .....	X	2
71	MS20392-1C13	Pin .....	X	2
72	MS21266-1N	Grommet (install using item 73) .....	X	A/R
73	B270-8qt	Adhesive .....	X	A/R
74	NAS6604-9	Bolt .....	X	1
75	F121-1	Push-Pull Tube Assembly (Ref)		

NOTES

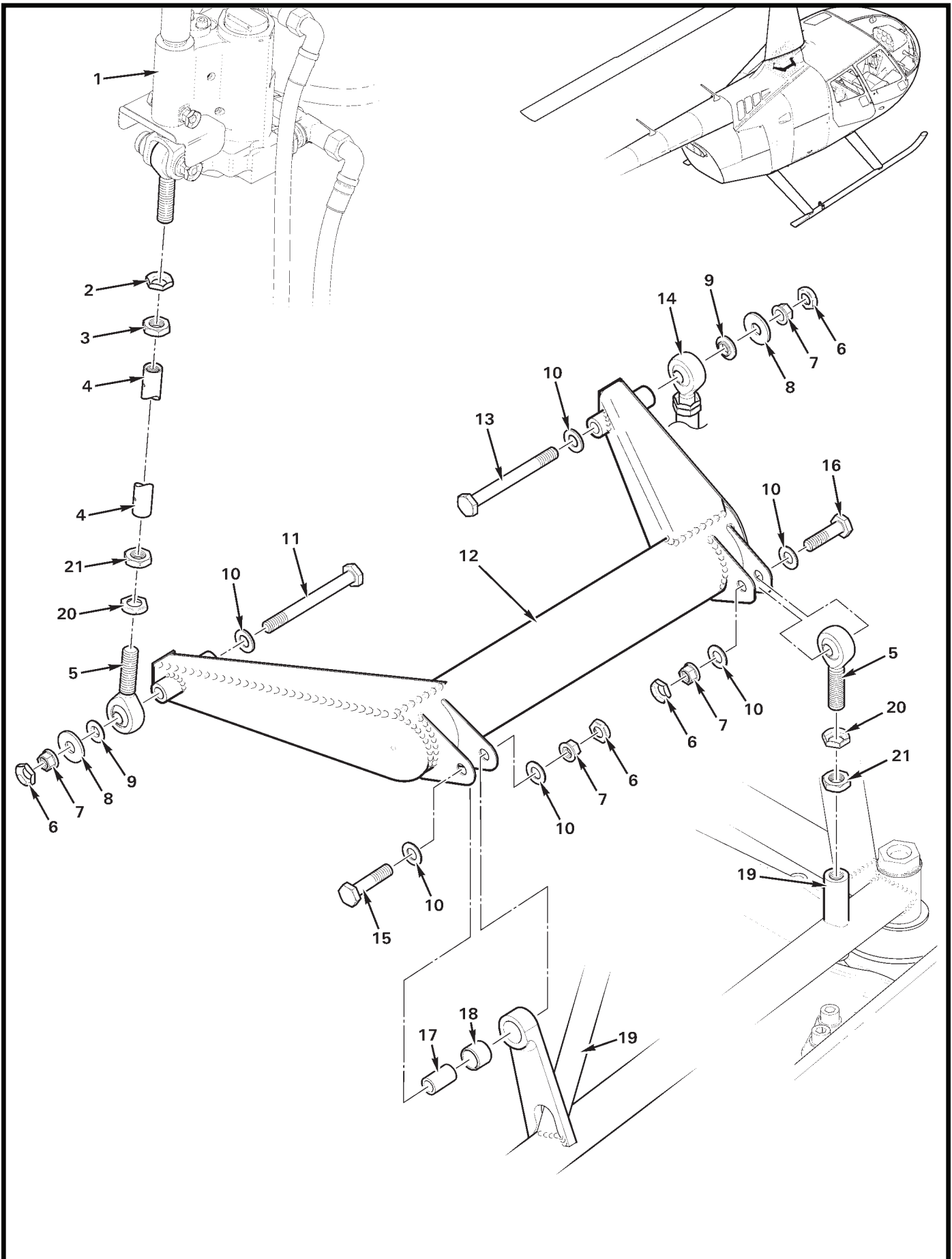


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>JACKSHAFT WELDMENT INSTALLATION</b>				
67-25-1	D212-6	Servo Assembly (aft, Ref; see Figure 29-11)		
2	B330-16	Palnut (Ref)		
3	AN316-5R	Nut (Ref)		
4	C343-8*	Tube . . . . .	X	1
5	B163-2	Rod End . . . . .	X	2
6	B330-13	Palnut . . . . .	X	4
7	D210-4	Nut . . . . .	X	4
8	A214-3	Washer . . . . .	X	2
9	A115-1	Spacer . . . . .	X	2
10	NAS1149F0432P	Bolt . . . . .	X	6
11	NAS6604-29	Bolt . . . . .	X	1
12	F339-1	Jackshaft Weldment Assembly . . . . .	X	1
13	NAS6604-33	Bolt . . . . .	X	1
14	F121-7	Push-Pull Tube Assembly (Ref, see Figure 67-5)		
15	NAS6604-11	Bolt . . . . .	X	1
16	NAS664-8	Bolt . . . . .	X	1
17	A105-6	Journal . . . . .	X	1
18	O6DU06	Bearing (install bearing using wet primer) . . . . .	X	1
19	G201-1	Frame Assembly – Hydraulic Servo Support (Ref)		
20	B330-16	Palnut . . . . .	X	2
21	AN316-5R	Nut . . . . .	X	2

NOTES \* Apply B270-21 protectant to threads.

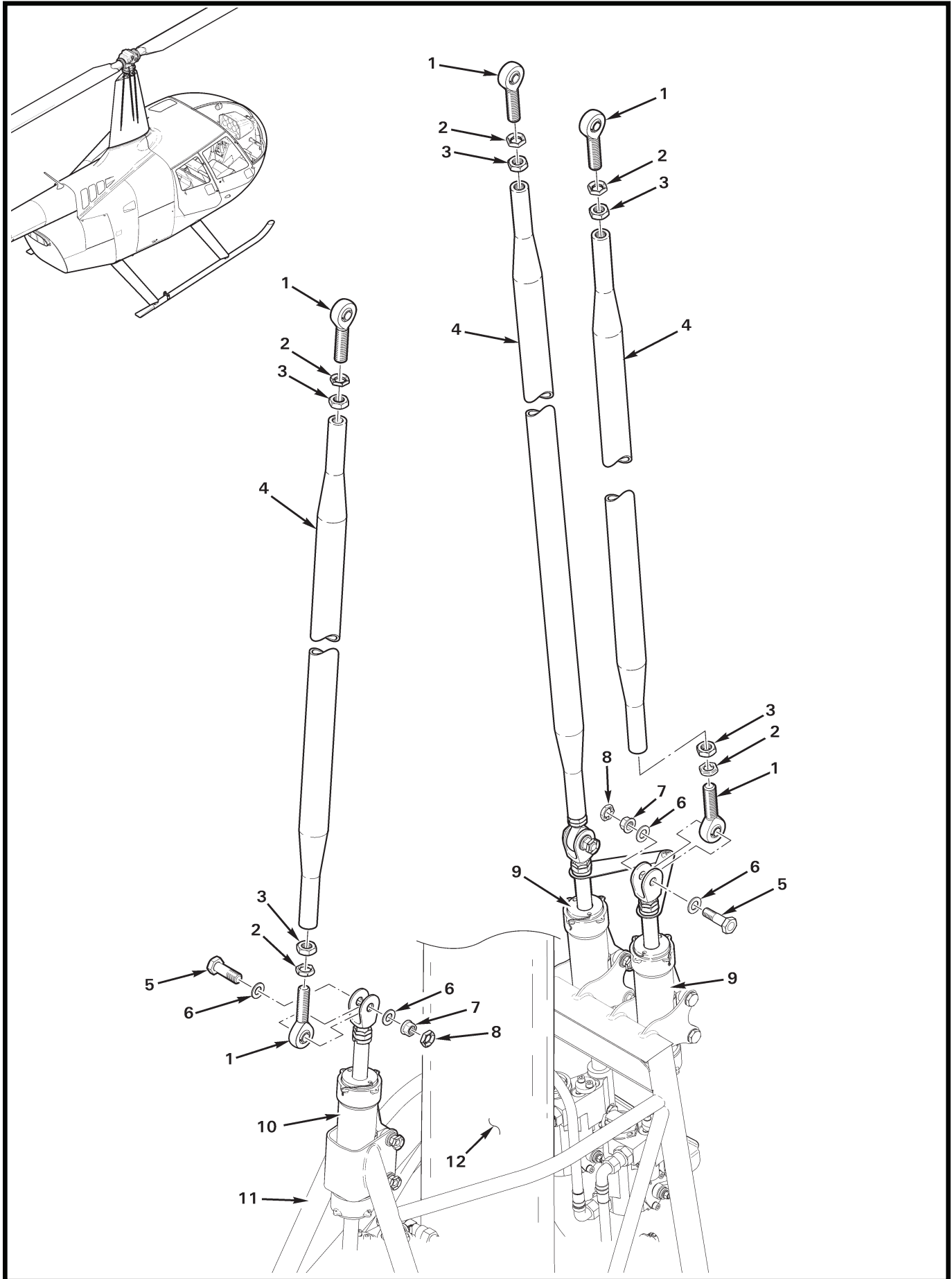


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>PUSH-PULL TUBE ASSEMBLIES (UPPER)</b>				
67-27-1	D173-2*	Rod End .....	X	2
2	B330-19	Palnut .....	X	2
3	AN316-6R	Nut .....	X	2
4	F121-3	Push-Pull Tube Assembly (Incl items 1 thru 3) .....	X	3
5	NAS6605-9	Bolt .....	X	3
6	NAS1149F0532P	Washer .....	X	6
7	D210-5	Nut .....	X	3
8	B330-16	Palnut .....	X	3
9	D212-5	Servo Assembly (Ref, forward)		
10	D212-6	Servo Assembly (Ref, aft)		
11	G201-1	Frame Assembly – Hydraulic Servo Support (Ref)		
12	F006	Main Rotor Gearbox Assembly (Ref)		

NOTES \* Apply B270-21 protectant to threads.

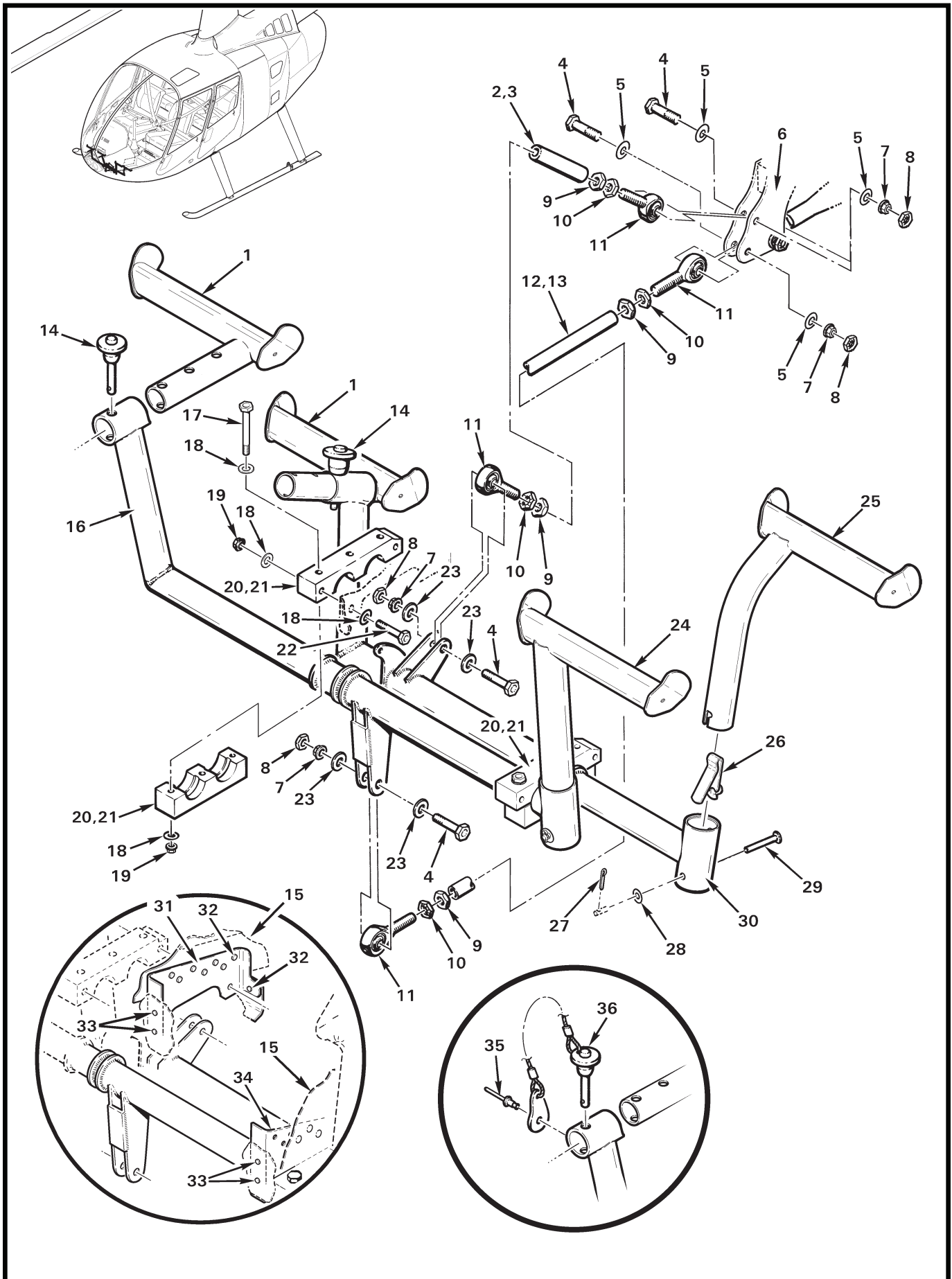


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>TAIL ROTOR CONTROLS – ADJUSTABLE PEDALS</b>				
67-29-1	F755-1	Pedal – Pilot Side (left and right foot) . . . . .	X	2
2	C343-13*	Tube Assembly (Incl items 3, and 9 thru 11) . . . . .	X	1
3	C343-14	Tube (Ref)		
4	NAS6604-9	Bolt . . . . .	X	4
5	NAS1149FN432P	Washer . . . . .	X	4
6	C317-9	Bellcrank Assembly (Ref; see Figure 67-35)		
7	D210-4	Nut . . . . .	X	4
8	B330-13	Palnut . . . . .	X	4
9	AN316-5R	Nut . . . . .	X	2
10	B330-16	Palnut . . . . .	X	2
11	A101-4	Rod End . . . . .	X	2
12	C343-11**	Tube Assembly (Incl items 9 thru 11, and 13) . . . . .	X	1
13	C343-12	Tube (Ref)		
14	B232-1	Pin (locking; button handle) . . . . .	X	2
15	F033	Lower Console Assembly (Ref)		
16	D755-4	Pedal Assembly (right foot, includes items 14, and 27 thru 29)	X	1
17	NAS6603-20	Bolt . . . . .	X	6
18	NAS1149FO332P	Washer . . . . .	X	20
19	D210-3	Nut . . . . .	X	14
20	A318-1-2	Bearing Block Set (install using item 21 in grooves) . . . . .	X	1
21	A257-1	Grease . . . . .	X	A/R
22	NAS6603-13	Bolt . . . . .	X	4
23	NAS1149F0436P	Washer . . . . .	X	4
24	F755-3	Pedal Assembly – Co-Pilot (right foot, includes item 26) . . . . .	X	1
	F755-10	Pedal Assembly – Short Co-Pilot (right foot, includes item 26)	X	1
25	F755-2	Pedal Assembly – Co-Pilot (left foot, includes item 26) . . . . .	X	1
	F755-9	Pedal Assembly – Short Co-Pilot (left foot, includes item 26)	X	1
26	A795-4	Pin . . . . .	X	2
27	MS24665-132	Cotter Pin . . . . .	X	2
28	NAS1149D0316J	Washer (or AN960PD10L) . . . . .	X	2
29	MS20392-2C33	Flathead Pin . . . . .	X	2
30	D755-1	Pedal Assembly (left foot, includes items 14, and 27 thru 29)	X	1
31	A359-2	Support – RH . . . . .	X	1
32	MS20470AD4	Rivet . . . . .	X	20
33	MS20470AD3	Rivet . . . . .	X	4

NOTES \* 5.30-inch nominal center to center. Apply B270-21 protectant to threads.  
 \*\* 5.82-inch nominal center to center. Apply B270-21 protectant to threads.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
TAIL ROTOR CONTROLS – ADJUSTABLE PEDALS (Cont'd)				
67-29-34	A359-1	Support – LH .....	X	1
35	NAS9301B-4-02	Rivet .....	X	2
36	B232-3	Pin (Locking; button handle with lanyard and tab. Ref; to replace, order item 14.) .....	O	2
NOTES				



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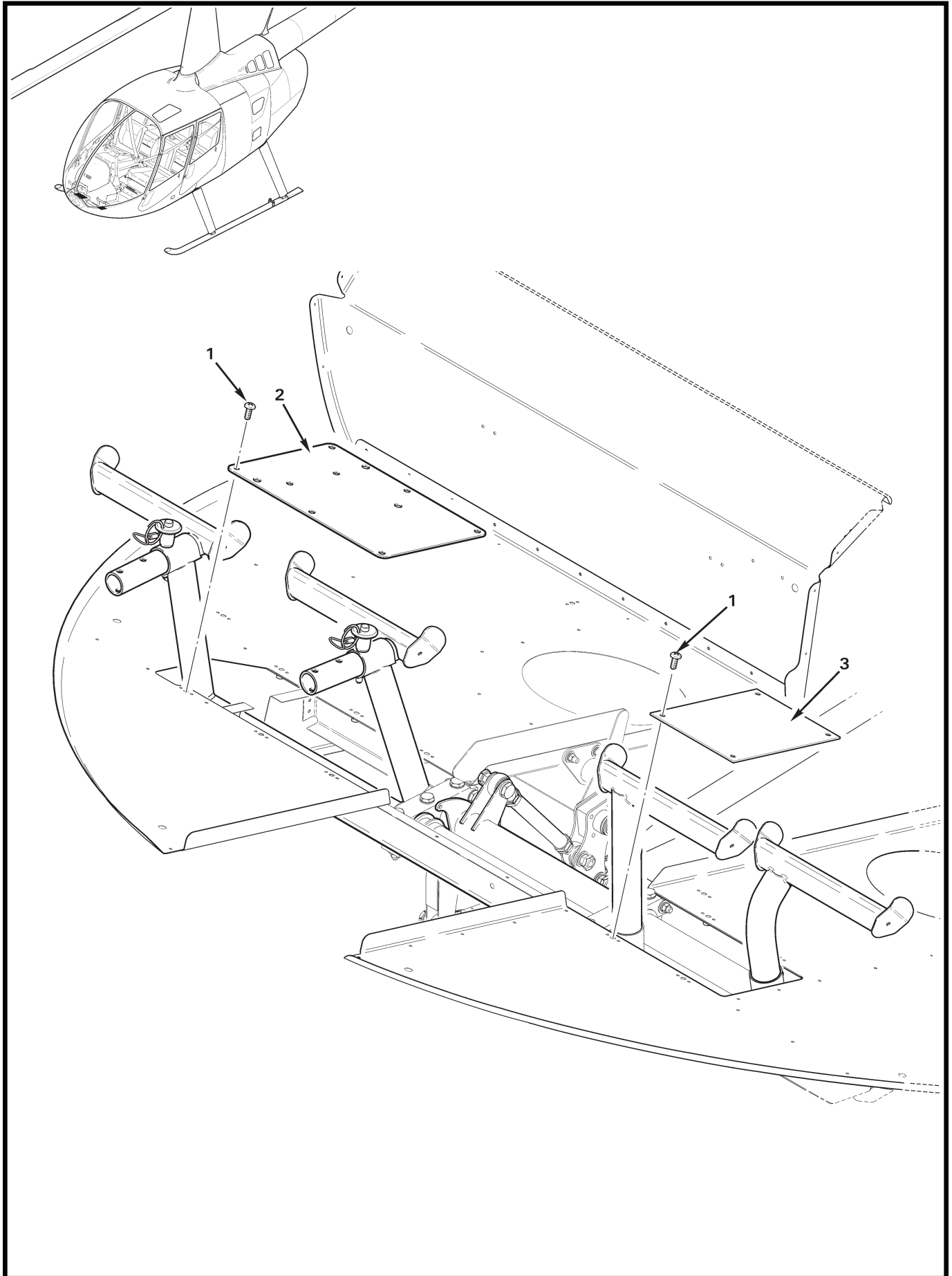


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
TAIL ROTOR CONTROLS – PEDAL COVER INSTALLATION				
67-31-1	MS27039C0806	Screw .....	X	12
2	A412-3	Cover (RH) .....	X	1
3	A412-1	Cover (LH) .....	X	1
NOTES				

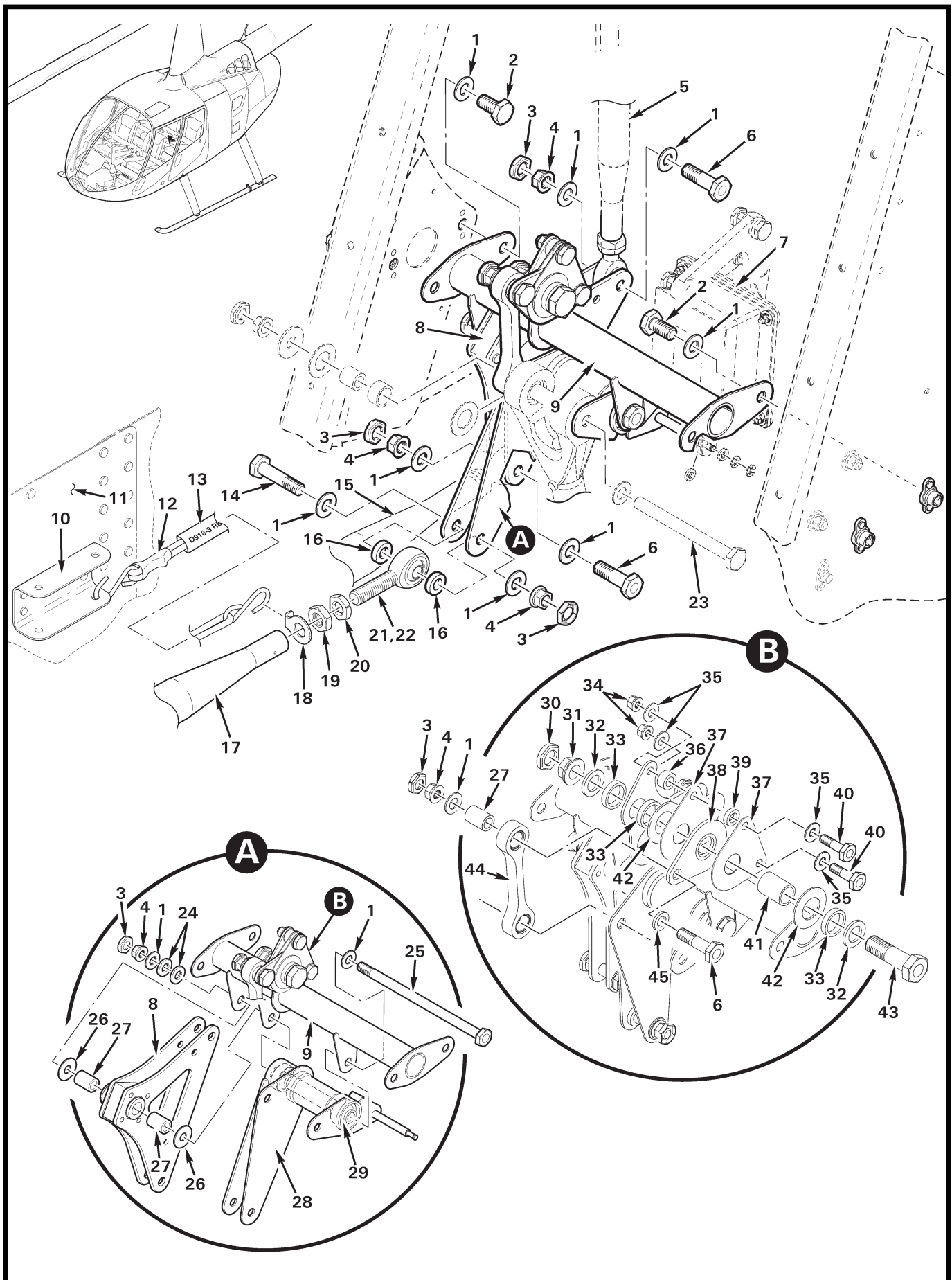


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>F334 SUPPORT ASSEMBLY INSTALLATION</b>				
67-33-1	NAS1149F0432P	Washer . . . . .	X	13
2	NAS6604-2	Bolt . . . . .	X	4
3	B330-13	Palnut . . . . .	X	4
4	D210-4	Nut . . . . .	X	3
5	F121-11	Push Pull Tube Assembly (Ref)		
6	NAS6604-9	Bolt . . . . .	X	3
7	F334-2	Actuator Assembly (Ref, see Figure 76-7)		
8	C317-7	Bellcrank . . . . .	X	1
9	F334-1	Aft Support Assembly (Incl items 1, 3, 4, 6, 8, 14, 16, and 24 thru 45) . . . . .	X	1
10	A697-3	Anchor (Ref)		
11	F293-2	Keel Panel (forward, Ref)		
12	D918-3	Elastic cord Assembly (6 lb ±0.25) . . . . .	X	1
13	B158-6	Heat Shrink (labeled "D918-3 Rev...") . . . . .	X	A/R
14	NAS6604-11	Bolt . . . . .	X	1
15	F121-9	Push-Pull Tube Assembly (Ref)		
16	A130-47	Spacer . . . . .	X	2
17	F121-1	Push-Pull Tube Assembly (Incl items 18 thru 22) . . . . .	X	1
18	A697-6	Tab . . . . .	X	1
19	AN316-5R	Nut . . . . .	X	2
20	B330-16	Palnut . . . . .	X	2
21	A101-4	Rod End (install using item 22 on threads) . . . . .	X	2
22	B270-21	Protectant . . . . .	X	A/R
23	NAS6604-37	Bolt (Ref, see Figure 67-5)		
24	NAS1149F0463P	Washer . . . . .	X	2
25	NAS6604-67	Bolt . . . . .	X	1
26	A141-3	Washer . . . . .	X	2
27	A105-3	Journal . . . . .	X	3
28	F326-1	Bellcrank Weldment (Ref)		
29	B303-1	Bearing (Ref)		
30	B330-19	Palnut . . . . .	X	1
31	D210-6	Nut . . . . .	X	1
32	NAS1149F0663P	Washer . . . . .	X	2
33	C130-25	Spacer . . . . .	X	3
34	D210-3	Nut . . . . .	X	2

NOTES

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
F334 SUPPORT ASSEMBLY INSTALLATION (Cont'd)				
67-33-35	NAS1149F0332P	Washer .....	X	4
36	A130-21	Spacer .....	X	2
37	D336-1	Plate .....	X	2
38	B249-6	Arm Assembly .....	X	1
39	C130-24	Spacer .....	X	2
40	NAS6603-6	Bolt .....	X	2
41	B250-13	Journal .....	X	1
42	A478-4	Spring Washer (install with concave towards item 38) .....	X	2
43	NAS6606-11	Bolt .....	X	1
44	C327-1	Link Assembly .....	X	1
45	A141-11	Washer .....	X	1
NOTES				

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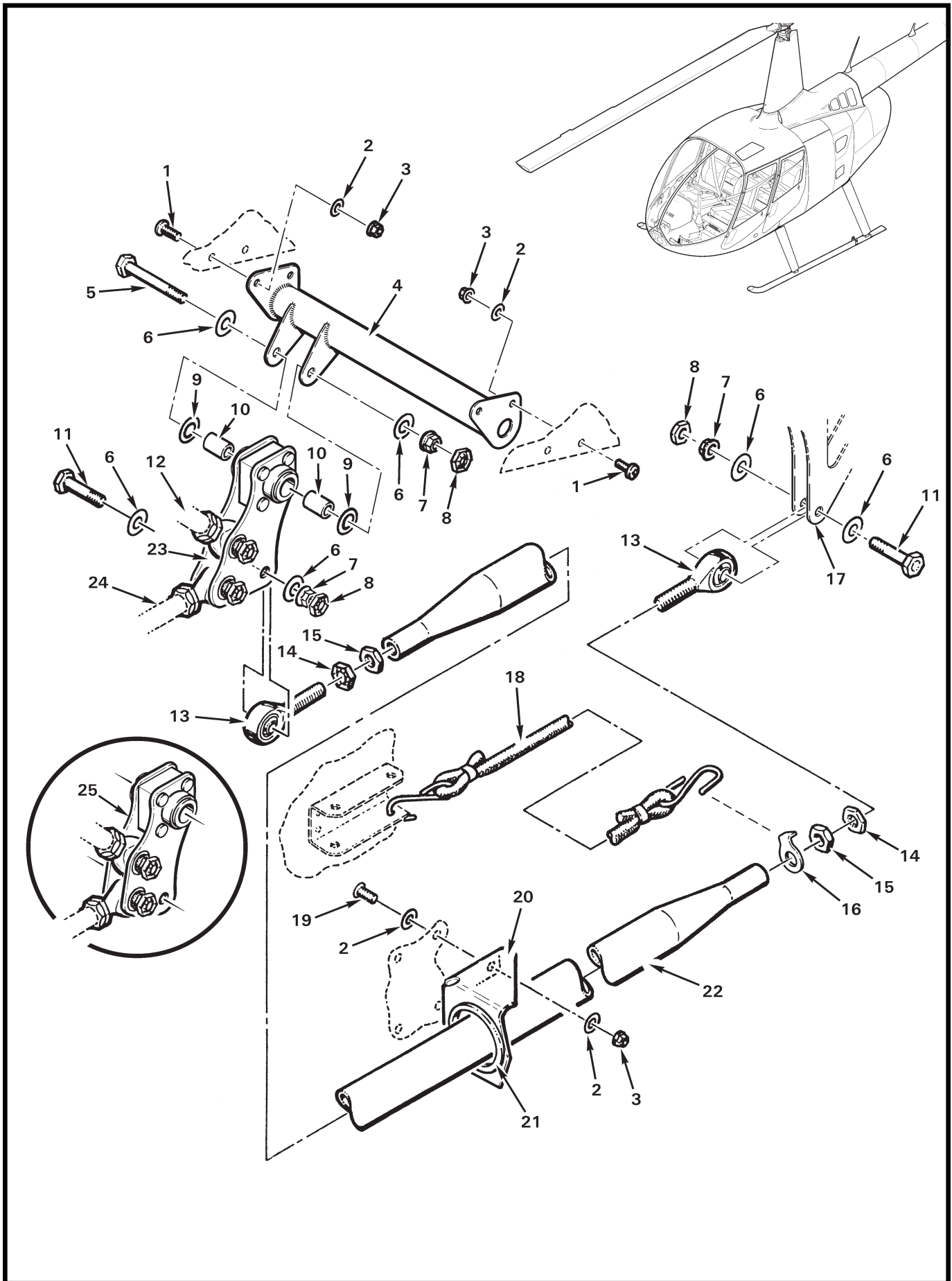




FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>C317 BELLCRANK ASSEMBLY</b>				
67-35-1	MS27039C0807	Screw . . . . .	X	4
2	NAS1149FN832P	Washer . . . . .	X	12
3	MS21042L08	Nut . . . . .	X	8
4	F349-1	Support Assembly . . . . .	X	1
5	NAS6604-19	Bolt . . . . .	X	1
6	NAS1149F0432P	Washer . . . . .	X	8
7	D210-4	Nut . . . . .	X	4
8	B330-13	Palnut . . . . .	X	4
9	A141-3	Washer . . . . .	X	2
10	A105-3	Journal . . . . .	X	2
11	NAS6604-9	Bolt . . . . .	X	3
12	C343-13	Push-Pull Tube Assembly (Ref, see Figure 67-29)		
13	A101-4	Rod End . . . . .	X	2
14	B330-16	Palnut . . . . .	X	2
15	AN316-5R	Nut . . . . .	X	2
16	A697-6	Tab . . . . .	X	1
17	C317-7	Bellcrank Assembly (Ref, revision H and subsequent. See also Figure 67-33.)		
18	A918-1	Elastic Cord Assembly (6 lb) . . . . .	X	1
	A918-2	Elastic Cord Assembly (8 lb) . . . . .	X	1
	A918-3	Elastic Cord Assembly (10 lb) . . . . .	X	1
	A918-4	Elastic Cord Assembly (12 lb) . . . . .	X	1
	A918-5	Elastic Cord Assembly (14 lb) . . . . .	X	1
	A918-6	Elastic Cord Assembly (16 lb) . . . . .	X	1
	A918-7	Elastic Cord Assembly (18 lb) . . . . .	X	1
	A918-8	Elastic Cord Assembly (20 lb) . . . . .	X	1
19	MS27039C0806	Screw . . . . .	X	4
20	C346-1	Restraint . . . . .	X	1
21	NAS557-22A	Grommet . . . . .	X	1
22	F121-9	Push-Pull Tube Assembly (Incl items 13 thru 16) . . . . .	X	1
23	C317-9	Bellcrank Assembly (Must be used only with item 17, revision "H" and subsequent, and item 25 from Figure 67-37.) . . . . .	X	1
24	C343-11	Push-Pull Tube Assembly (Ref, see Figure 67-29)		
25	C317-5	Bellcrank Assembly (For earlier R66's. Superseded by item 23.)	X	1

NOTES

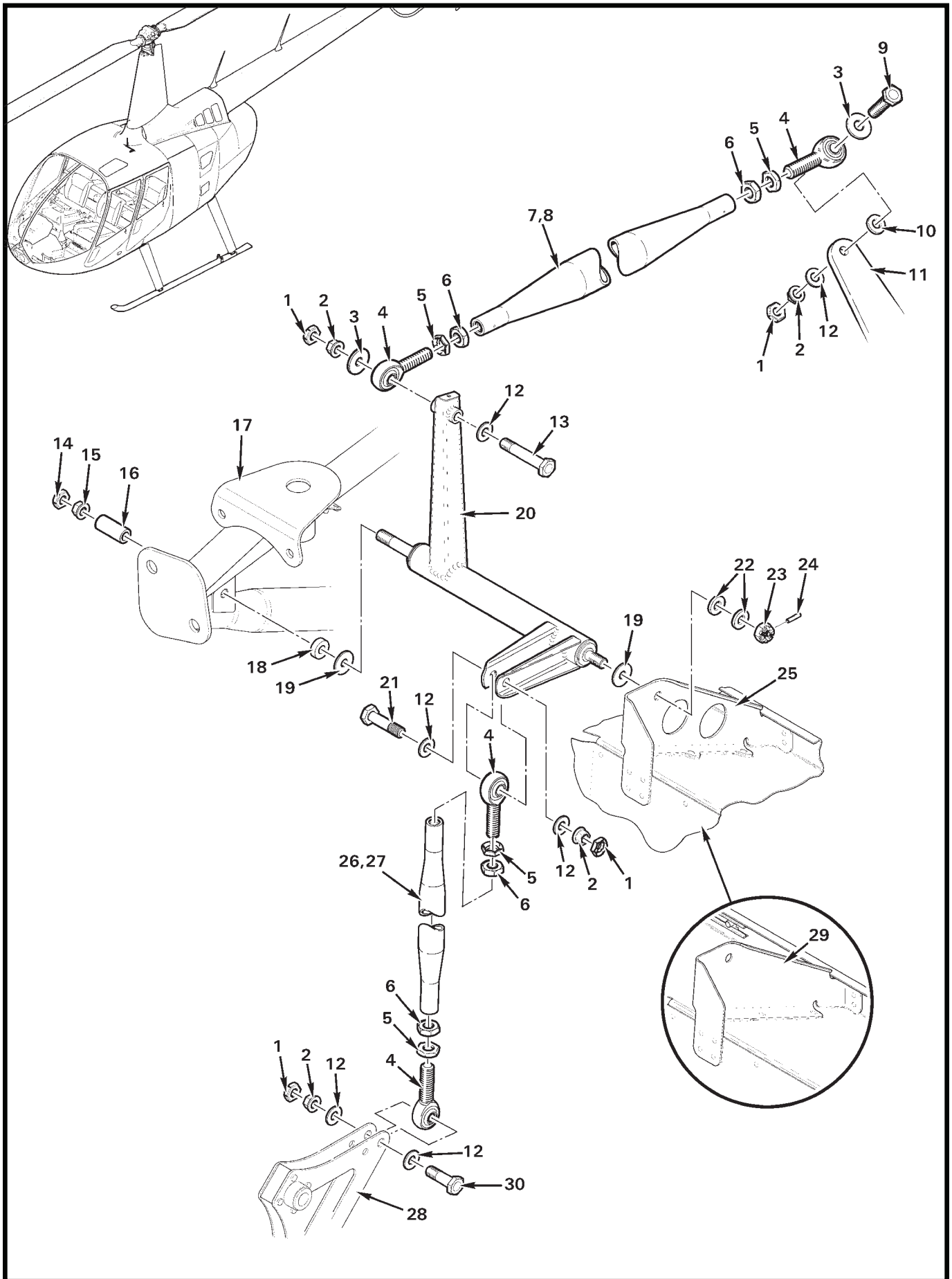


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>F316 BELLCRANK ASSEMBLY</b>				
67-37-1	B330-13	Palnut . . . . .	X	4
2	D210-4	Nut . . . . .	X	4
3	A214-3	Washer . . . . .	X	2
4	A101-4	Rod End . . . . .	X	2
5	B330-16	Palnut . . . . .	X	2
6	AN316-5R	Nut . . . . .	X	2
7	F121-13	Push-Pull Tube Assembly (Incl items 3 thru 6) . . . . .	X	1
8	F121-14	Tube (Ref)		
9	NAS6604-11	Bolt . . . . .	X	1
10	MS20002-4	Washer . . . . .	X	1
11	A331-4	Bellcrank Assembly (Ref, see Figure 67-39)		
12	NAS1149F0432P	Washer . . . . .	X	6
13	NAS6604-21	Bolt . . . . .	X	1
14	B330-13	Palnut . . . . .	X	1
15	D210-4	Nut . . . . .	X	1
16	C130-34	Spacer . . . . .	X	1
17	F020	Frame Assembly (Ref)		
18	A130-42	Spacer . . . . .	X	1
19	A141-3	Washer . . . . .	X	2
20	F316-1	Bellcrank Assembly (Incl items 14 thru 16, 18, 19, and 22 thru 24) . . . . .	X	1
21	NAS6604-8	Bolt . . . . .	X	1
22	NAS1149F0463P	Washer . . . . .	X	2
23	MS17825-4	Nut . . . . .	X	1
24	MS16562-14	Spring Pin . . . . .	X	1
25	G247-1	Support Assembly (revision "C" and subsequent) . . . . .	O	1
26	F121-11	Push-Pull Tube Assembly (Incl items 4 thru 6, and 26) . . . . .	X	1
27	F121-12	Tube (Ref)		
28	C317-7	Bellcrank Assembly (Ref, see Figure 67-33)		
29	G247-1	Support Assembly (Ref, revision "B" and prior, earlier R66s. Superseded by item 25.)		
30	NAS6604-9	Bolt . . . . .	X	1

NOTES



FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>A331 BELLCRANK ASSEMBLY</b>				
67-39-1	NAS6604-11	Bolt . . . . .	X	1
2	A214-3	Washer . . . . .	X	3
3	MS20002-4	Washer . . . . .	X	1
4	NAS1149F0432P	Washer . . . . .	X	6
5	D210-4	Nut . . . . .	X	4
6	A120-5	Bellcrank (Ref)		
7	A331-4	Bellcrank Assembly . . . . .	X	1
8	NAS6604-35	Bolt . . . . .	X	1
9	A141-3	Washer . . . . .	X	2
10	A105-3	Journal . . . . .	X	2
11	NAS6604-9	Bolt . . . . .	X	1
12	A127-4	Rod End . . . . .	X	2
13	B330-13	Palnut . . . . .	X	6
14	AN316-4R	Nut . . . . .	X	2
15	C121-17	Push-Pull Tube Assembly (Incl items 12 thru 14, and 16) . . . .	X	1
16	C121-18	Tube (Ref)		
17	NAS6604-10	Bolt . . . . .	X	1
18	NAS1149F0432P	Washer (or NAS1149F0462P as required for minimum clearance) . . . . .	X	A/R

NOTES

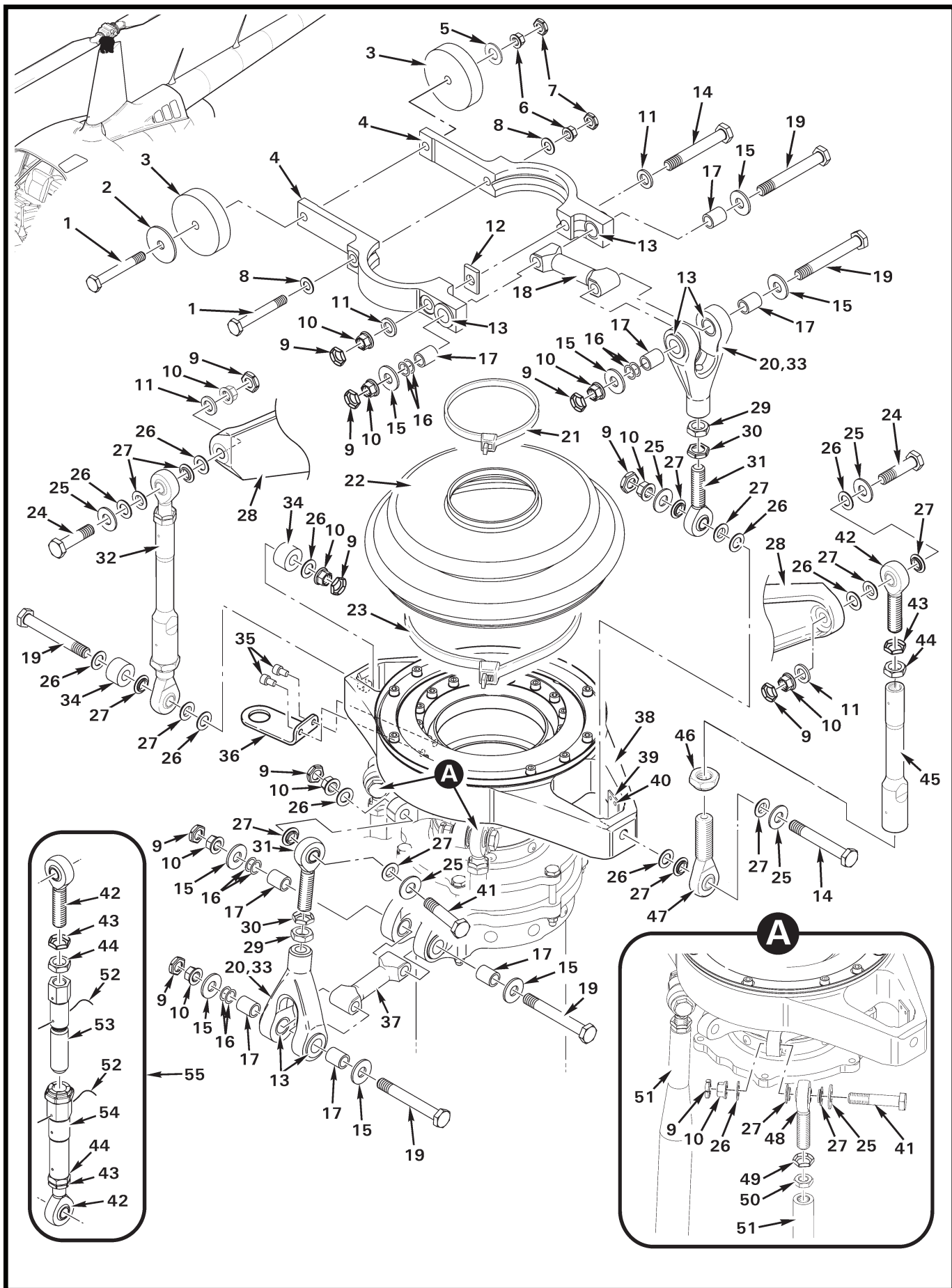


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>SWASHPLATE ASSEMBLY</b>				
67-41-1	NAS6604-24*	Bolt . . . . .	X	2
2	AN970-4**	Washer (A/R for balance) . . . . .	X	A/R
3	A255-1**	Counter Weight (1.10 in. O.D.) . . . . .	X	A/R
	A255-2**	Counter Weight (1.90 in. O.D.) . . . . .	X	A/R
4	C203-5	Yoke Assembly (Incl item 13) . . . . .	X	2
5	NAS1149F0432P*	Washer (or NAS1149F0463P as required for proper thread engagement) . . . . .	X	A/R
6	D210-4	Nut . . . . .	X	2
7	B330-13	Palnut . . . . .	X	2
8	NAS1149F0432P	Washer . . . . .	X	2
9	B330-16	Palnut . . . . .	X	11
10	D210-5	Nut . . . . .	X	13
11	NAS1149F0563P	Washer . . . . .	X	2
12	A210-1	Key . . . . .	X	1
13	C648-2	Bearing – Journal (install wet; see R66 MM § 20-60 for approved primer) . . . . .	X	8
14	NAS6605-28	Bolt . . . . .	X	2
15	C141-19	Washer . . . . .	X	8
16	C117-67	Shim (thickness = 0.016 in.) . . . . .	X	A/R
	C117-68	Shim (thickness = 0.020 in.) . . . . .	X	A/R
	C117-69	Shim (thickness = 0.025 in.) . . . . .	X	A/R
17	C105-6	Journal (length = 0.526 in.) . . . . .	X	8
18	C204-3	Arm (upper) . . . . .	X	1
19	NAS6605-31	Bolt . . . . .	X	5
20	A205-7	Fork Assembly (Incl item 13) . . . . .	X	2
21	MS3367-7-9	Ty-Rap . . . . .	X	1
22	C480-1	Boot . . . . .	X	1
23	MS3367-6-0	Ty-Rap . . . . .	X	1
24	NAS665-18	Bolt . . . . .	X	2
25	C141-1	Washer . . . . .	X	6
26	NAS1149-F0532P	Washer . . . . .	X	9
27	C115-1	Spacer . . . . .	X	14
28	C005-13	Blade and Spindle Assembly – Main Rotor (Ref)		
29	AN316-6R	Nut . . . . .	X	2
30	B330-19	Palnut . . . . .	X	2

NOTES \* Select bolt length which, after correct torque is applied, exposes 2 to 4 threads beyond nut.  
 \*\* Refer to R66 MM § 18-14 PART C.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>SWASHPLATE ASSEMBLY (Cont'd)</b>				
67-41-31	D173-3	Rod End . . . . .	X	2
32	C258-5	Pitch Link Assembly (Incl items 42 thru 47) . . . . .	X	2
33	B270-13	Sealant (to fill cavity in item 20) . . . . .	X	A/R
34	A255-3	Counter Weight . . . . .	X	2
35	NAS1352N08-4	Screw . . . . .	X	2
36	B769-2	Bracket . . . . .	X	1
37	C204-2	Arm (lower) . . . . .	X	1
38	C017-6	Swashplate Assembly (Incl items 35, 36, 39, and 40) . . . . .	X	1
39	C769-2	Interrupter . . . . .	X	1
40	MS20470AD3	Rivet . . . . .	X	2
41	NAS6605-17	Bolt . . . . .	X	4
42	D173-3*	Rod End . . . . .	X	1
43	B330-19	Palnut . . . . .	X	1
44	AN316-6R	Nut . . . . .	X	1
45	C258-6*	Barrel Assembly . . . . .	X	2
46	21FKF-813	Nut . . . . .	X	1
47	D173-4*	Rod End . . . . .	X	1
48	D173-2	Rod End (Ref)		
49	B330-19	Palnut (Ref)		
50	AN316-6R	Nut (Ref)		
51	F121-3	Push-Pull Tube Assembly (Ref, includes items 48 thru 50. See also Figure 67-27.)		
52	MS20995C32	0.032 in. dia Safety Wire . . . . .	X	A/R
53	C258-2	Fitting . . . . .	O	1
54	C258-4*	Link Assembly (Incl items 42 thru 44) . . . . .	O	1
55	C258-1**	Pitch Link Assembly (Incl items 42 thru 44, 53, and 54) . . . . .	O	2
***				
56	KI-6604	R44-series & R66 C017-5 Swashplate Installation Kit Instructions (See <a href="http://www.robinsonheli.com">www.robinsonheli.com</a> for complete kit contents. Also, see Figure 67-41.) . . . . .	X	1

NOTES \* Apply A257-2 or A257-22 oil on threads.  
 \*\* Earlier R66s, no longer available.



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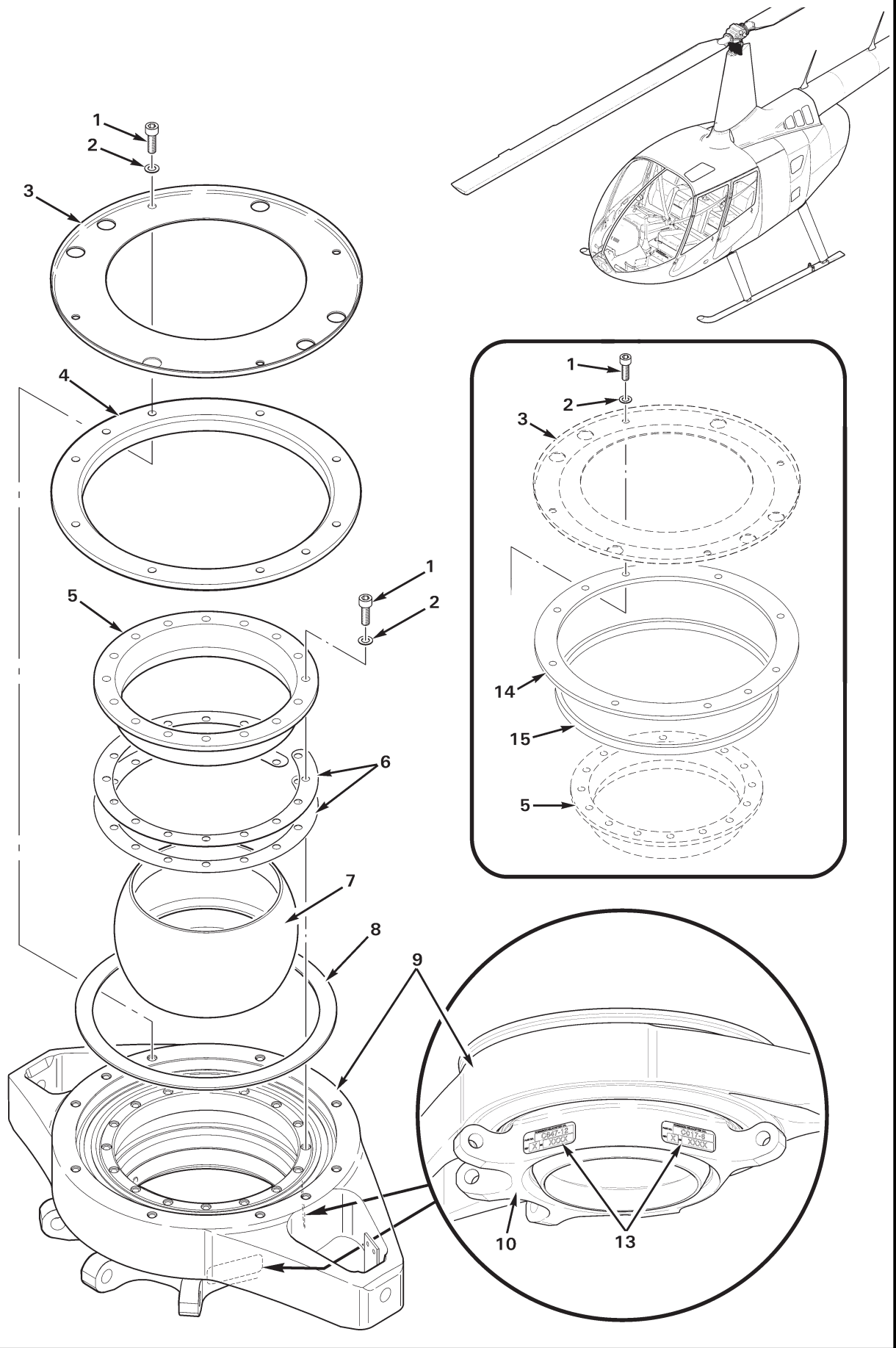


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>SWASHPLATE BALL INSTALLATION (C017 REVISION AD &amp; SUBSEQUENT)</b>				
67-45-1	NAS1352N08-8	Screw (install using item 11 on threads) . . . . .	X	26
2	NAS620-8L	Washer . . . . .	X	26
3	C206-2	Retainer . . . . .	X	1
4	C200-4	Retainer (supersedes items 14 and 15) . . . . .	X	1
5	C205-1	Sleeve Assembly . . . . .	X	1
6	C197-1	Spacer (thickness = 0.016 in.) . . . . .	X	A/R
	C197-2	Spacer (thickness = 0.020 in.) . . . . .	X	A/R
	C197-3	Spacer (thickness = 0.025 in.) . . . . .	X	A/R
	C197-4	Spacer (thickness = 0.032 in.) . . . . .	X	A/R
	C197-5	Spacer (thickness = 0.040 in.) . . . . .	X	A/R
	C197-6	Spacer (thickness = 0.050 in.) . . . . .	X	A/R
7	C201-1	Ball Assembly . . . . .	X	1
8	C217-1	Seal (upper) . . . . .	X	1
9	C199-2	Swashplate Assembly – Upper (Ref)		
10	F198-1	Swashplate Assembly – Lower (Ref)		
11	A257-9	Anti-Seize . . . . .	X	A/R
12	C647-12	Bearing Set – Swashplate (Ref; connects items 9 and 10; not shown)		
	A257-3	Grease (pack bearing set with grease per MM § 12-90) . . . . .	X	A/R
13	—	Identification Plate* (C017-6 Assembly, and C647-12 bearing set; part number, revision letter and serial number) . .	O	2
14	C200-3**	Retainer . . . . .	X	1
15	C219-3**	Spacer . . . . .	X	1

NOTES \* Refer to MM § 20-93 for replacement procedures.  
 \*\* Superseded by item 4.

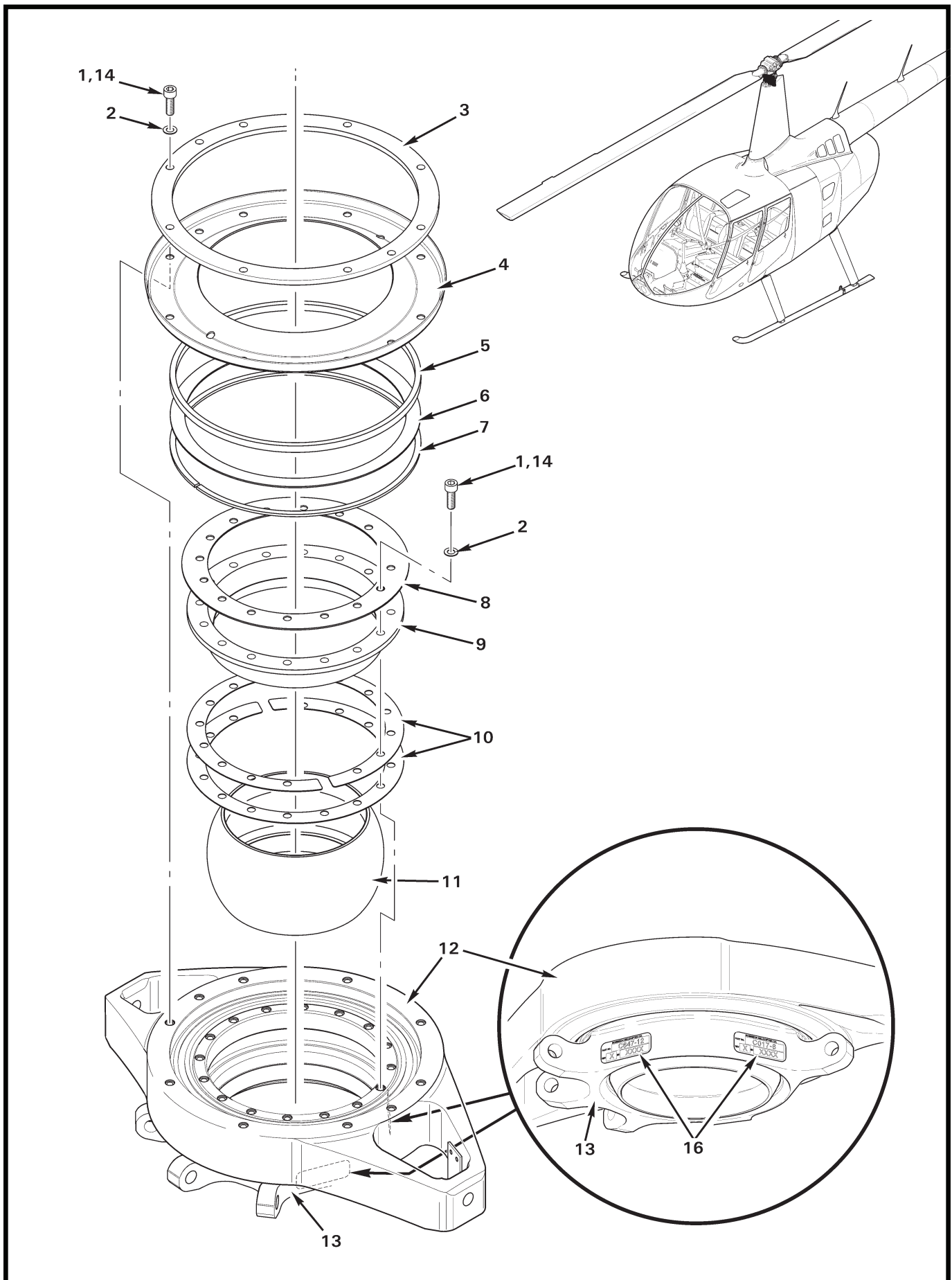


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
<b>SWASHPLATE BALL INSTALLATION (C017 REVISION AA THRU AC)</b>				
67-47-1	NAS1352N08-8	Screw (install using item 14 on threads) . . . . .	X	26
2	NAS620-8L	Washer . . . . .	X	26
3	C200-1 *	Retainer (Ref, no longer available)		
4	C206-1 *	Retainer (Ref, no longer available)		
5	C219-2 *	Spacer (Ref, no longer available)		
6	C218-2 *	Shield (Ref, no longer available)		
7	C219-1 *	Spacer (Ref, no longer available)		
8	C218-1 *	Shield (Ref, no longer available)		
9	C205-1	Sleeve Assembly . . . . .	X	1
10	C197-1	Spacer (thickness = 0.016 in.) . . . . .	X	A/R
	C197-2	Spacer (thickness = 0.020 in.) . . . . .	X	A/R
	C197-3	Spacer (thickness = 0.025 in.) . . . . .	X	A/R
	C197-4	Spacer (thickness = 0.032 in.) . . . . .	X	A/R
	C197-5	Spacer (thickness = 0.040 in.) . . . . .	X	A/R
	C197-6	Spacer (thickness = 0.050 in.) . . . . .	X	A/R
11	C201-1	Ball Assembly . . . . .	X	1
12	C199-2	Swashplate Assembly – Upper (Ref)		
13	F198-1	Swashplate Assembly – Lower (Ref)		
14	A257-9	Anti-Seize . . . . .	X	A/R
15	C647-12	Bearing Set – Swashplate (Ref; connects items 12 and 13; not shown)		
16	—	Identification Plate** (C017-6 Assembly, and C647-12 bearing set; part number, revision letter and serial number) . .	O	2

NOTES \* To replace parts, upgrade swashplate assembly per R66 Service Bulletin SB-30.  
 \*\* Refer to MM § 20-93 for replacement procedures.

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