

KI-235 R66 TRDS Forward Yoke Assembly and Hanger Installation Kit Instructions

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 NUMBER	PART NUMBER	DESCRIPTION	QTY PER KI-235
KIT CONTENTS			
1	KI-235 Instr.	Kit Instructions	1
2	B330-7	Palnut	4
3	B330-13	Palnut	5
4	B330-21	Palnut	4
5	B900-11	Modification Data Plate	1
6	D210-3	Nut	4
7	D210-4	Nut	5
8	D210-7	Nut	4
9	D224-5	Yoke Assembly (includes C647-8 bearing and F172-3 housing)	1
10	F193-2	Hanger	1
11	MS3367-5-9	Ty-rap	10
12	MS3367-6-0	Ty-rap	4
13	NAS6603-8	Bolt	2
14	NAS6604-8	Bolt	2

Consumables

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

- Epoxy primer

KI-235 Kit Instructions

NOTE

Kit includes necessary D210-series nuts to comply with R66 Service Letter SL-09 during installation.

1. Remove tail rotor drive shaft assembly (TRDS) per MM § 65-20. Remove hardware securing F193-1 hanger to tailcone forward bulkhead; retain hardware but discard nuts and palnuts.
2. Remove hardware securing F195-1 yoke weldment to D196-1 shaft assembly. Retain C191-7 blocks and hardware but discard nuts.
3. Secure a long wooden dowel (approximately 1 to 2 inches diameter) to F195-1 yoke flange arms using MS3367-6-0 ty-raps.

KI-235 Kit Instructions (continued)

4. Secure D195-2 (aft) yoke in a bench vise with nylon jaws and support shaft assembly.
5. Place a suitable catch basin beneath forward end of shaft. Heat approximately 2 liters of drinking water until boiling. Carefully pour hot water on forward end of D196-1 shaft assembly where shaft overlaps F195-1 yoke. Twist and pull combined yoke and A553-3 block from D196-1 shaft assembly using wooden dowel.
6. Clean D196-1 shaft interior using acetone. Apply primer to bare shaft of D224-5 yoke assembly and D196-1 shaft interior. While primer is wet, insert yoke into D196-1 shaft assembly, align fastener holes, install C191-7 blocks & yoke retaining hardware, and standard torque fasteners per MM § 20-32. Apply primer to blocks and assembled hardware. (Optional: Paint visible portion of yoke shaft and touch-up hardware per MM § 20-60.)
7. Refer to Figure 1. Clean area where B900-11 data plate will be installed using acetone. Remove liner from back of data plate and press plate firmly in location shown. Apply pressure uniformly to remove air pockets and to bond edges.
8. Install hardware securing F193-2 hanger to tailcone forward bulkhead and standard torque fasteners per MM § 20-32.
9. Install tail rotor drive shaft assembly per MM § 65-20. (Note: Different length bolts are installed at new hanger bearing.)
10. Check tail rotor drive shaft runout per MM § 65-21. Perform fan shaft balancing per MM § 18-70.
11. Make appropriate maintenance record entries. No change to helicopter weight and balance.

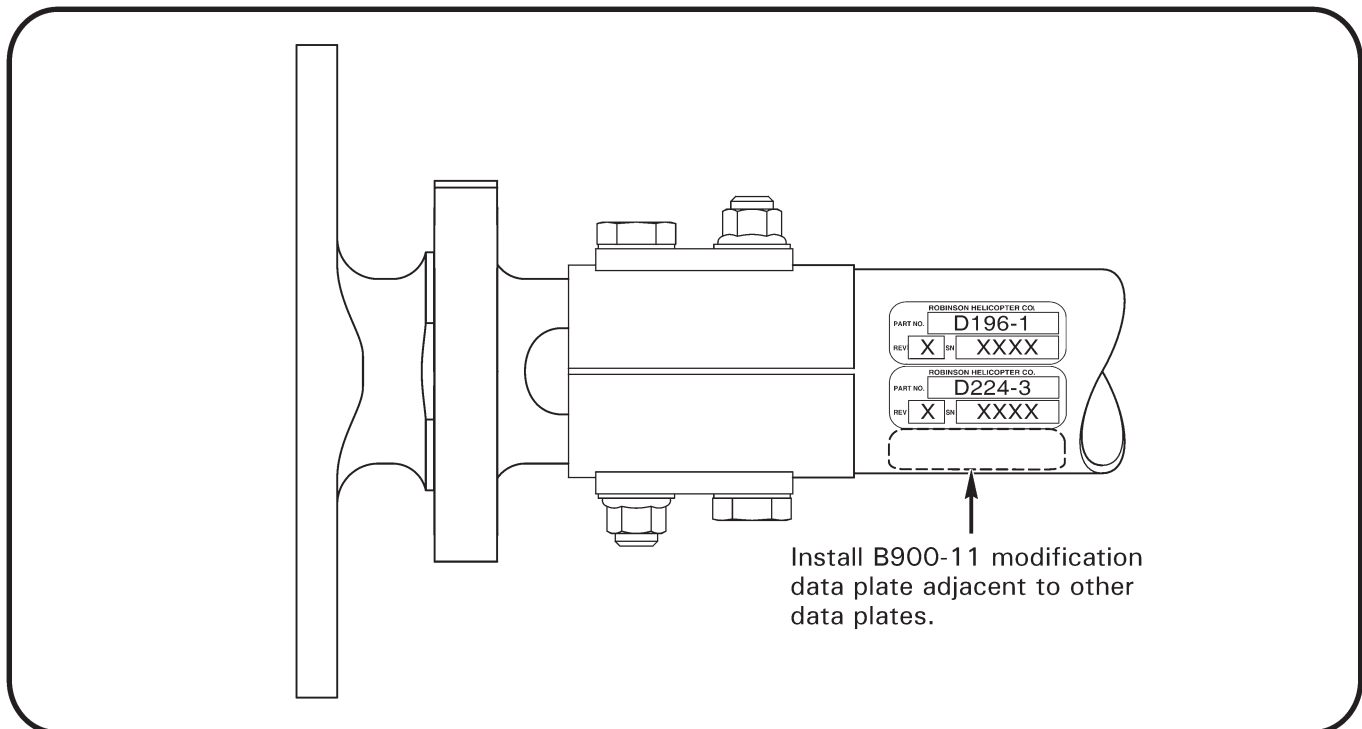


FIGURE 1