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SERVICE LETTER #23A

R E V I S E D

Date: 12 June 1984

Revised: 20 June 1984

Subject: Special Caution When Installing Vee Belts or Other Driveline Components

Rotorcraft Affected: All R22 Helicopters

Background: RHC is still receiving reports of Vee Belts coming off or rolling over in flight after new belts are installed or other driveline components replaced. Loss of Vee Belts in-flight could result in a serious accident and special precautions must be observed.

The following procedure must be used to install new Vee Belt sets.

1. The engine must be shimmed up, by adding equal amount of shims to both lower engine mounts, per Section 6.130, Figure 6-2, of the R22 Maintenance Manual.
2. Install new Vee Belt set per Section 7.282 of the Maintenance manual.

NOTE

Any wear of sheave grooves that produce ridges of .006 or greater requires sheave replacement.

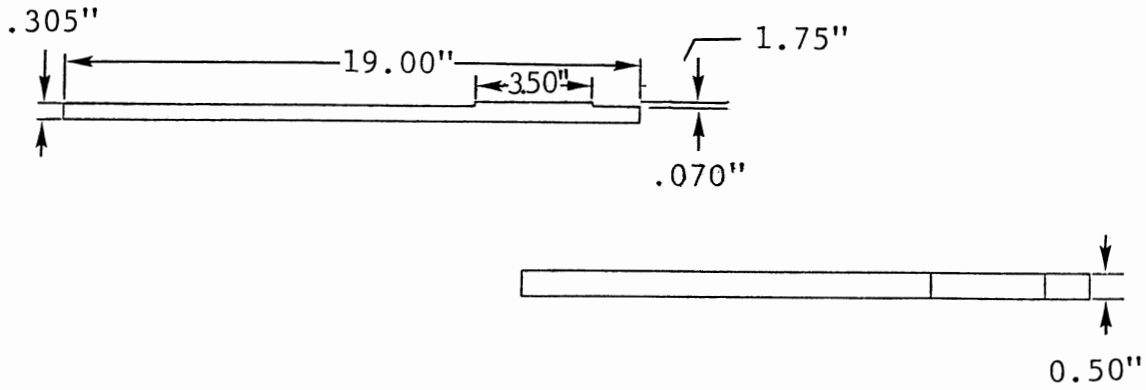
3. Engage clutch.
4. Using the MT331 Sheave Alignment Bar, check sheave alignment on left and right sides of upper and lower sheaves per Figure 2.

The upper clutch sheave must be aligned with the lower sheave within the following tolerances:

- a) The upper sheave must not be forward of lower sheave. It must be .000" to .070" aft of lower sheave.
- b) The difference between the left and right sheave alignment measurements must not be greater than .020". If measurements differ more than .020", adjust lateral clutch centering per Section 7.250 of the Maintenance Manual.

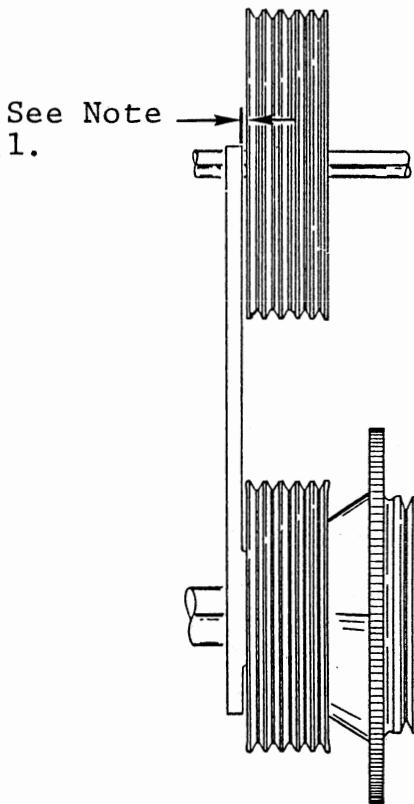
NOTE

The MT331 alignment bar may be manufactured locally per Figure 1.

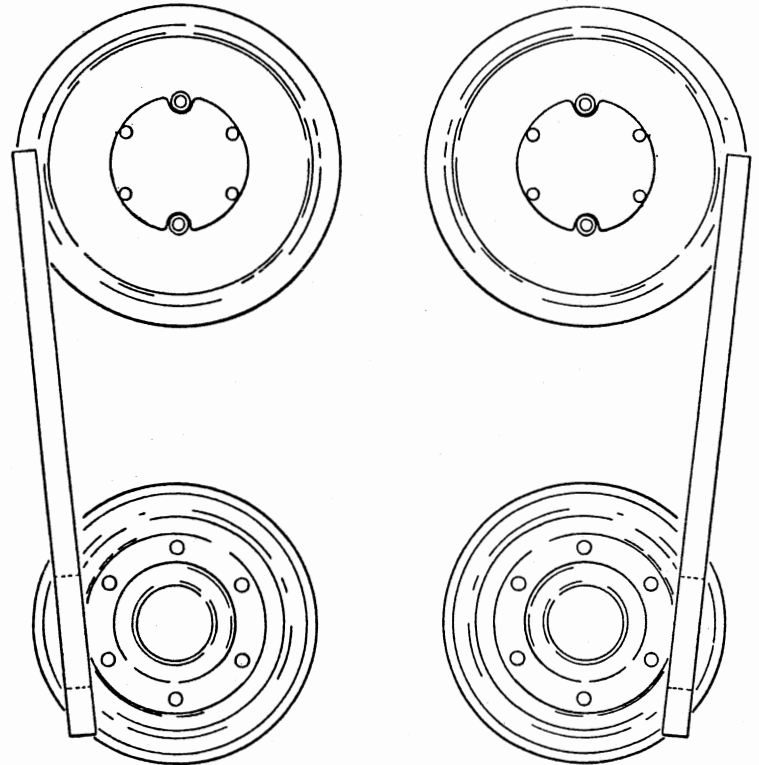


Note 1.

This gap will be .070" when sheaves are aligned and .000" when upper sheave is .070" aft of the lower sheave.



View from right side.



Left side

Right side

Sheave alignment bar position.