

# DEPARTMENT OF THE ARMY TECHNICAL BULLETIN

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## INSPECTION AND REPAIR OF STATION 635 FRAME ASSEMBLY FOR TAIL WHEEL STRUT INSTALLATION CLEARANCE

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Headquarters, Department of the Army, Washington, D. C.

30 November 1998

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### NOTE

THIS PUBLICATION IS EFFECTIVE UNTIL RESCINDED OR SUPERSEDED.

#### 1. **Priority Classification.** Routine

a. Aircraft in Use. Upon receipt of this Technical Bulletin (TB) the condition status symbol of the cited aircraft will be changed to a **red horizontal dash "-"**. The **red horizontal dash "-"** may be cleared when the inspection of paragraph 8 below is completed. Failure to comply with the requirements of this TB within the time frame will cause the status symbol to remain a red horizontal dash.

b. Aircraft in Depot Maintenance. Same as paragraph 1a.

c. Aircraft Undergoing Maintenance. Same as paragraph 1a.

d. Aircraft in Transit.

(1) Surface/Air Shipment. Same as paragraph 1a.

(2) Ferry Status. Same as paragraph 1a. Inspect aircraft at final destination.

e. Maintenance Trainers (Category A). Same as paragraph 1a. (Category B and C): N/A.

f. Component/Parts in Stock Including War Reserves at All Levels (Depot and Others). N/A.

2. **Task/Inspection Suspense Date.** Within the the next phase inspection.

3. **Reporting Compliance Suspense Date.** N/A.

#### 4. **Summary of the Problem.**

a. To eliminate an interference at station 635 lower frame and the tail wheel strut.

**TB 1-1520-237-20-167**

- b. For manpower/downtime and funding impacts. See paragraph 12.
  - c. The purpose of this TB is to add a clearance notch in station 635 lower frame for the tail wheel strut.
- 5. End Items to be Inspected.** UH-60A series helicopters serial number 77-22714 through 89-26172. UH-60L series helicopters serial number 89-26179 through 90-26277.
- 6. Assembly to be Modified.**

Nomenclature	Part Number	NSN
Frame Assembly	70211-05009-041	1560-01-253-0358

**7. Parts to be Inspected.** N/A.

**8. Inspection Procedures.** Inspect helicopter lower frame at station 635 figure 1 for notched with an angle riveted across bottom of frame web, if repair is complete, TB does not apply, continue to paragraph 9, and annotate log book.

**9. Correction Procedures.** The red horizontal dash "-" status imposed by paragraph 1 a. may be cleared after a one time inspection of station 635 lower frame or modifying the lower frame assembly as follows:

- a. Remove tail landing gear per TM 1-1520-237-23, Chapter 3.
- b. Cut or route a 1.00 inch X 0.40 inch deep notch with 0.160 inch radius in station 635 lower web (70211-05009-101) centered on butline 0 (Figure 1).
- c. Trime frame assembly flange as follows:
  - (1) Measure outboard 2.00 inches on each side of butline 0
  - (2) Measure back from front of flange 0.380 inch.
  - (3) Remove material from front of flange.
- d. Treat new exposed surfaces with Chemical Coating for Aluminum (MIL-C-81706, Class 1A) and Epoxy Primer (MIL-P-23377).
- e. Temporarily clamp angle (70211-05009-110) on front of station 635 frame assembly centered on butline 0, or 3.46 inches from tooling hole, approximately 0.40 inch below top of frame flange.
- f. Transfer-drill seven No. 40 (0.098-inch diameter) holes from angle through frame assembly and open to final size No. 21 (0.159-inch diameter).
- g. Remove angle (70211-05009-110) from station 635 frame assembly and deburr drilled parts.
- h. Attach angle to station 635 with seven MS20470AD5 rivets.
- i. Install tail landing gear per TM 1-1520-237-23, Chapter 3.

**10. Supply/Parts and Disposition.**

- a. Parts Required

NSN	NOMENCLATURE	CAGE	PART NUMBER	QUANTITY
	Angle	78286	70211-05009-110	1
	Rivet	96906	MS20470AD5	7

b. Requisitioning Instructions. Requisition replacement parts through normal supply channels using normal supply procedures. All requisitions shall use project code "CST" per this TB.

- c. Bulk and Consumable Materials. N/A.

NSN	NOMENCLATURE	CAGE	PART NUMBER	QUANTITY
8010-00-229-4813	Primer, Epoxy	81349	MIL-P-23377	As Required
8030-00-142-9272	Chemical Coating for Aluminum	81349	MIL-C-81706, Class 1A	As Required

- d. Disposition. N/A.
- e. Disposition of Hazardous Material. N/A.

**11. Special Tools, Jigs and Fixtures Required. N/A.**

**12. Application,**

- a. Total of 8.0 man-hours using one person
- b. Total of 8.0 hours downtime for one end item.
- c. TB/MWO to be Applied Prior to or Concurrently with this Inspection/Modification. N/A.

d. Publications Which Require Change as a Result of this Inspection/Modification. TM 1-1520-237-23 shall be changed to reflect this TB. A copy of this TB shall be inserted in the appropriate TM as authority to implement the change until the printed change is received.

**13. References. N/A.**

**14. Recording and Reporting Requirements.**

a. Reporting Compliance Suspense Data (Aircraft). Upon entering requirements of this Technical Bulletin on DA Form 2408-13-1 on all subject Mission Design Series (MDS) aircraft, forward a priority message, datafax or E-Mail to Commander, AMCOM, ATTN: AMSAM-SF-A, (SOF Compliance Officer), Redstone Arsenal, AL 35898-5222, per AR 95-3. Datafax number is DSN 987-211 or Commercial (205) 3113-2111. E-Mail address is safeadm@redstone.army.mil. The report will cite this Technical Bulletin number, date of entry in DA Form 2408-13-1, the aircraft Mission Design Series and serial numbers of aircraft in numerical order.

b. The following forms are applicable and are to be completed in accordance with DA PAM 738-751,15 June 1992:

- (1) DA Form 24-08-13, Aircraft Status Information Record.
- (2) DA Form 2408-13-1, Aircraft Inspection and Maintenance Record.
- (3) DA Form 2408-15, Historical Record for Aircraft.
- (4) DA Form 2408-18, Equipment Inspection List.

**15. Weight and Balance. N/A.**

**16. Points of Contact**

a. Technical point of contact for this TB is Mr. Greg Kirchhofer, AMSAM-AR-EI-C-U, DSN 645-0668 or (205) 955-0668. Datafax DSN 645-6590 or (205) 955-6590, E-mail is "kirchhofer.ga@redstone.army.mil".

b. Logistical point of contact for this TB is Mr. Joe Hoover, AMSAM-DSA-UH-L, DSN 645-7898 or (205)-955-7898. Datafax is DSN 645-6590 or 205) 955-6590. E-mail is hoover.jl@redstone.army.mil".

c. Wholesale Materiel point of contact (SPARES) point of contact is Mr. Dan Delao AMSAM-MMC-USU, DSD 897-1303 or (205) 313-1303. Datafax is DSN 897-1556. E-mail is "delao-dt@redstone.army.mil".

d. Forms and Records point of contact for this TB is Ms. Ann Waldeck, AMSAM-MMC-RE-F DSN 876-5564 or (205)746-5564, Datafax is DSN 897-4904 or (205) 313-4904. E-mail is waldeck-ab@redstone.army.mil".

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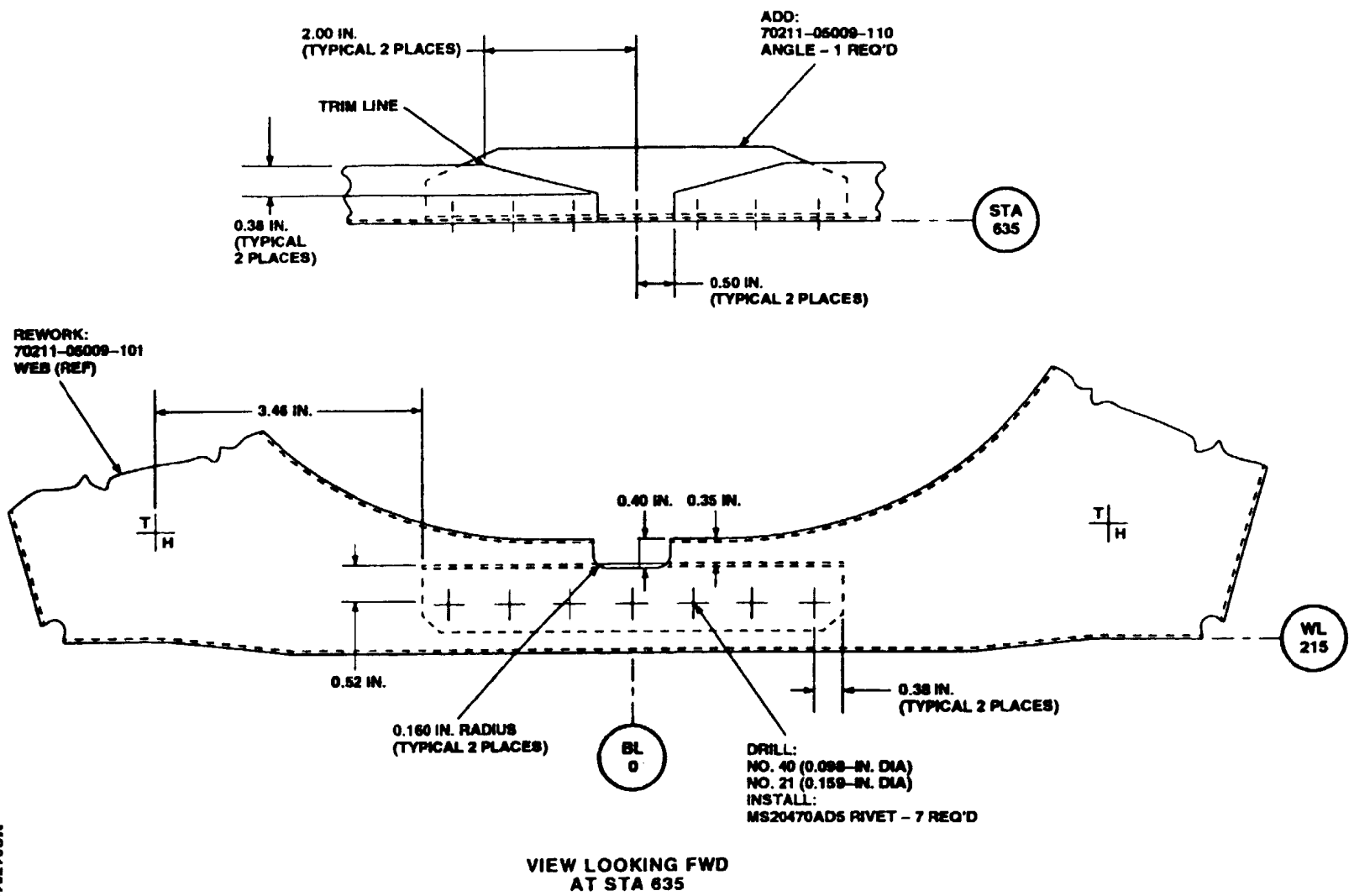
e. Safety point of contact for this TB is Mr. Dave Scott, AMSAM-SF-A, DSN 897-2068 or (205) 313-2068, Datafax is DSN 897-2111 or (205) 313-2111 E-mail is "Scott-dc@redstone.army.mil".

f. Foreign Military Sales (FMS) recipients requiring clarification of action advised by this TB should contact Mr. Ronnie W. Sammons, AMSAM-SA-CS-NF, DSN 897-0869 or (205) 313-0869. Datafax is DSN 897-0916 or (313-0916. E-mail is "sammons-rw@redstone.army.mil" (Huntsville is GMT minus 6 hrs).

g. After hours contact AMCOM Command Operations Center (COC) DSN 897-2066/7 or (205) 313-2066/7.

**17. Reporting of Errors and Recommending Improvements.** You can help improve this TB. You may submit your recommended changes by E-mail directly to ls-lp@redstone.army.mil. A reply will be furnished to you. Instructions for sending an electronic 2028 may be found at the back of this manual.

FIGURE 1 MODIFICATION OF STATION 635 FRAME ASSEMBLY

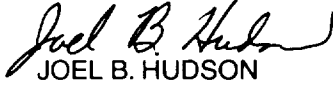


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**TB 1-1520-237-20-167**

By Order of the Secretary of the Army:

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Subject: DA Form 2028

1. **From:** Joe Smith
2. Unit: home
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4. City: Hometown
5. **St:** MO
6. **Zip:** 77777
7. **Date Sent:** 19-OCT-93
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19. Paragraph: 3
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23. Figure: 7
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27. **Text:**

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