



THE ENSTROM HELICOPTER CORPORATION

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TAIL ROTOR ASSEMBLY (Wide Chord) 28-150077-1-3-5 & 7

A. Disassembly (Teetering Bearings) 28-01056-1

Reference Drawing

1. Clamp Spindle, 28-150074-11 or -13, (1) in a vise using brass jaws to avoid damaging spindle.
2. Remove Snap Ring, N5002-100. (2)
3. Remove End Plate, 28-150076-11. (3)
4. Remove Thrust Bumper, 28-150076-13. (5)
5. Remove Shims, 28-150078-10, -12, -13, or -15. (4)
6. Remove Seal, 28-150076-19. (6)
7. Rotate spindle in vise and repeat Steps 2, 3, 4, 5, and 6, on opposite spindle ear.
8. Using Special Tool, T-2893, press both Bearings, B-1210, (7) out as far as possible.

NOTE: Bearings will NOT come all the way out.

9. Install Half Moon Spacers from Special Tool, T-2893, over Journals (8) and press out bearings. (2 places)
10. Heat Journals and remove from Hub, 28-150067-15. (9)
11. Remove Washers, 28-150076-17, (10) from Hub. (2 places)

B. Assembly (Teetering Bearings)

1. Check Hub, Washers and Journals for slide fit.

NOTE: Polish Hub as required.

2. Clean Hub and Journals with Loc Quick Primer.
3. Install Washer on Hub ear, chamfer on I.D. inboard.
4. Apply Loctite to I.D. of Journal and install on Hub ear.
5. Install Hub into Spindle bore, then install second Washer and Journal, Loctiting Journal on Hub ear.

NOTE: Remove excess Loctite and allow to set for two or three minutes.

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B. Assembly (Teetering Bearings) - Continued

6. Using Special Tool Cap (11) press Bearings into Spindle using Nut as a guide. (2 places)

NOTE: Flat end of Bearing with writing outboard or rounded end inboard.

NOTE: Press Bearings to depth of Special Tool Cap.

7. Install Seal.

8. Install Shims into End Plate recess.

NOTE: Begin with .015", each side.

9. Install Thrust Bumper, notched end outboard.

10. Install End Plate, then Snap Ring.

NOTE: Assure Snap Ring is fully seated.

NOTE: If Snap Rings are not fully seated, an incorrect preload will be obtained.

11. Repeat Steps 7 through 10 to opposite side.

12. Design an arm to install in the Hub splines and measure 6" from the center of the Hub.

13. Using a pull scale, drag should be $\frac{1}{2}$ PSI.

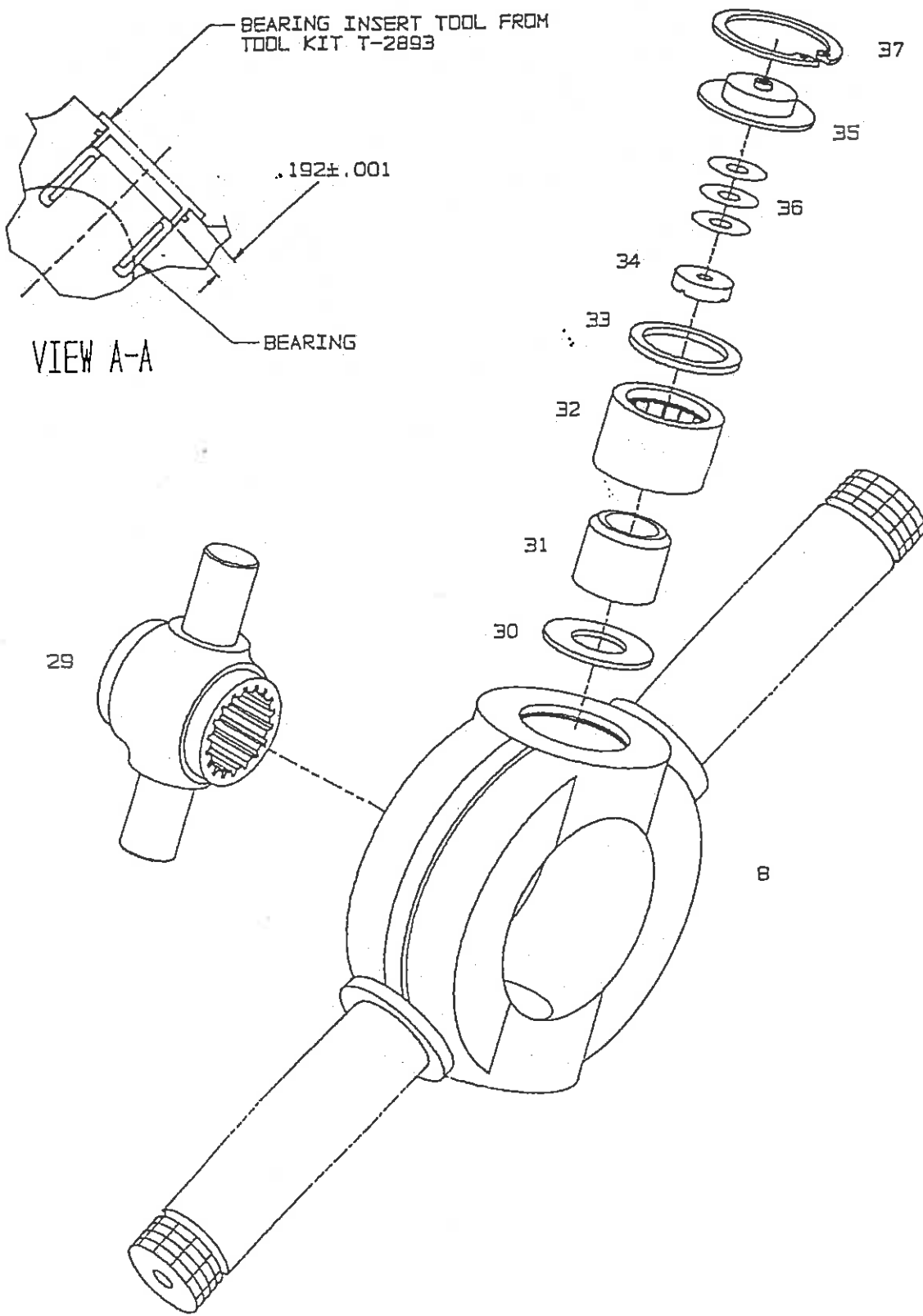
NOTE: Adjust preload by adding shims (increases preload) or subtracting shims (decreases preload) until desired preload is obtained.

NOTE: Shimming should be within .003" of either side.

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PARTS - 28-01056-1 ASSEMBLY

<u>P/N</u>	<u>QTY</u>	<u>NOMENCLATURE</u>
B-1210	2	NEEDLE BEARING
N5002-100	2	SNAP RING
T-2893	1	SPECIAL TOOL
28-150067-15	1	TAIL ROTOR HUB
28-150074-11 or -13	1	TAIL ROTOR SPINDLE
28-150076-11	2	END PLATE
28-150076-13	2	THRUST BUMPER
28-150076-15	2	BEARING JOURNAL
28-150076-17	2	WASHER
28-150076-19	2	SEAL
28-150078-10	A/R	SHIM (.010")
28-150078-12	A/R	SHIM (.002")
28-150078-13	A/R	SHIM (.003")
28-150078-15	A/R	SHIM (.005")



28-01056-1-KI½ Tail Rotor Assembly