

TM 55-1520-210-23-2

11-30. Inspection - Pilots Collective Stick (Disassembled).

NOTE

Pilots collective stick elbow PN 204-001-1943 need to be replaced at overhaul because of previously drilled jackshaft tube attachment holes. Replace elbow if the largest diameter of the jackshaft attachment tapered hole exceed 0.500 inch.

- a. Inspect all parts of pilots collective stick for nicks, scratches, dents, broken or damaged tubing or frayed or broken cabling.
- b. Inspect friction mechanism on pilots collective stick for general condition. Inspect friction shoes (11) for condition and secure bonding to housing.
- c. Inspect bearings for wear or roughness. Refer to paragraph 11-185 for bearing replacement.
- d. Check switches on collective stick (Appendix F).

11-31. Repair or Replacement - Pilots Collective Stick.

- a. Replace all parts that are worn, damaged, broken, bent, or corroded.
- b. Replace electrical wires if frayed, or broken.
- c. Replace bearings if worn, rough, or damaged (paragraph 11-185).

NOTE

During removal of housing assembly (14) ensure that the reducer sleeves stay with the elbow (20).

d. Replace friction lines on housing assembly if separation of bonded area has occurred, if damaged liners are less than .005 inch above rivets. Liners without rivets are to be replaced if thickness is less than .035 inch in wear area. Replace liners as follows:

(1) Where applicable, drill out rivets holding to housing assembly. (Refer to TM 55-1500-204-23-1).

(2) Remove old liner and adhesive residue by grinding using #80 grit or finer. Exercise care while removing liner. Do not gouge metal on bonding surface of housing area. If necessary finish removal to a bare metal surface by using abrasive cloth #250 grit or finer, P-C-451C, (C9).

e. Bond liners to housing part no. 204-001-601 as follows:

(1) With suitable brush, apply magnesium pickle (Chromic Acid) to bonding surface of housing area. (Refer to TM 1-1500-344-23). Allow solution to remain on the part for one (1) to three (3) minutes. Wipe off excess magnesium pickle solution with a clean rag, or rinse off with cold water. Blow air onto the treated area to facilitate drying.

(2) Apply a coat of epoxy adhesive (C29) to bonding surface of housing area. A minimum bonded adhesive thickness of .007 TO .015 inch is recommended.

(3) Align and clamp liner to housing area using small "C" clamps.

(4) Remove excess adhesive squeeze-out from bond line areas before curing.

(5) Cure adhesive at 350 degrees F for 60 minutes. Allow part to air cool to room temperature and remove clamps.