

NOTE

Do not coat threads of bolt 24 with CPC.

h. Coat the mating surface of pitch horn (25) and grip (4) with primer (C312) while primer is still wet, install pitch horn (25) on grip (4). Coat bolt 24 with CPC (C87) and secure with bolts (24) and washer (23). Torque bolts 160 to 190 inch pounds and lockwire (C155).

i. Install drag braces (2) and blade bolts, making sure the same items are installed on the same side from which removed.

j. (AVIM) Adjust main rotor grip spacing (paragraph 5-23).

k. Service hub, refer to paragraph 1-7.

l. Balance main rotor hub assembly if required. (See Note at the beginning of paragraph 5-18.g.) Reference paragraph 5-95 for balancing instructions.

5-23. Grip Spacing — Main Rotor Hub. (AVIM)

Premaintenance requirements for grip spacing on main rotor hub

Condition	Requirements
Model	All
Part No. or Serial No.	All
Special Tools	(T34) (T41) (T49) (T59) (T62)
Test Equipment	None
Support Equipment	None
Minimum Personnel Required	Two
Consumable Materials	None
Special Environmental Conditions	None

a. Position hub on buildup bench (T34) (8, figure 5-22) equipped with adapter plate (7) (T49). Install grip positioning links (6) (T41) on each side of hub and adjust links (6) such that tip of grip spacing tool (2) (T59) is centered on blade bolt. Install flap stops (5) (T62) on each side of trunnion with side marked 204 seated on hub yoke.

b. Tighten nut (13) until hub grip is fully seated in-board and then backoff nut (13) one full turn. Tap grip outboard using a heavy plastic mallet to seat hub parts. Repeat on opposite side of hub.