

Procedure 6.090 Installation of the Aft Elevator Bellcrank

In this procedure ...

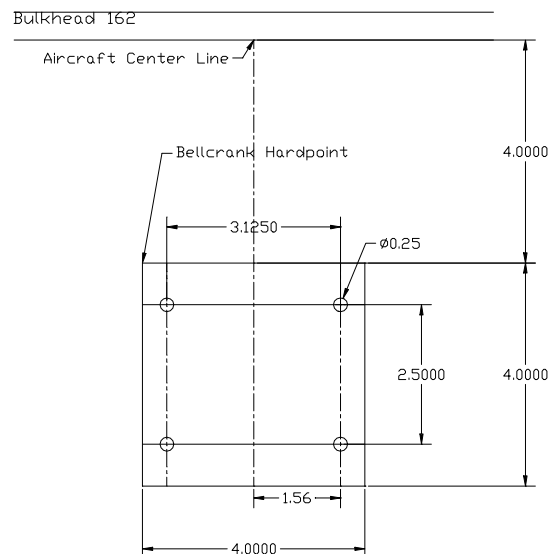
The mount holes for the aft elevator bellcrank will be drilled into the hardpoint. The helicole inserts will be installed and the idler bellcrank installed.

SUPPLIED MATERIAL:

<u>Part Number</u>	<u>Qty</u>	<u>Description</u>
213-14-006	2	Bracket
213-14-004	2	Idler Horn
AN4-24A	1	Bolt
AN960-416	2	Washers
AN365-428	1	Nut
AN3H-4A	4	Bolts
AN960-10	4	Washers
NAS43DD3-32	2	Spacer
NAS43DD3-24FC	1	Spacer

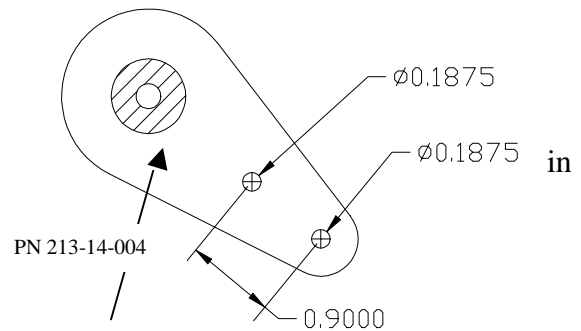
Step 1. Install helicole inserts in hardpoint.

Mark out the 4 mounting holes per the diagram at the right and drill the four mounting holes. Drill 1/4" pilot holes and then follow the instructions contained in the helicole kit for drill to final demention and installing the insert.



Step 2. Assemble the Aft Bellcrank.

Some elevator horns (PN 213-14-004) were shipped without the second .1875" hole drilled. If this is the case drill the hole in accordance with the dimensions the drawing at the right.



Place one of the AN960-419 on the AN4-24A bolt.

Insert the bolt through one of the 213-14-006 brackets. Place one of the .5" bushing on the bolt and then on of the 213-14-004 horns. Place the .275" busing on the bolt followed by the other horn. Install the second .5 bushing, bracket, washer and nut. Torque the nut to 35 in/lb.

Place the bellcrank assembly on the hardpoint and install the 4 bolts with washers. Torque the bolts to 20 in/lb. Safety wire the bolts. Check for freedom of movement of the bellcrank assembly.

