

H-60 Servo/Transmission Beams Installation Kit

Note: H-60 refers to all versions of the Blackhawk Series Helicopters

Mastered Tool

Tool Features

- Light Weight ~85 Pounds
- Separates into 3 pieces
- Made of Non-corrosive Metal (Aluminum and CRES)
- Transmission Plate Removable from Welded Structure
- Servo Beam Rail Plane Removable from Welded Structure
- Tapered Pins for locating Transmission Plate and Servo Beam Rails to Welded Structure
- CRES Wear Plates adjacent to A/C Structure
- Hardened CRES Material Index Pins
- Zero-out Servo Beam Pin Position to Master Tool, but adjustable in A/C Axis by $\pm \frac{1}{4}$ Inch
- Maintains 2.500 Inch Offset between Servo Beam WL (271.500) and Transmission Beam WL (269.000)



SBIT in Storage Case

Servo/Transmission Beam Installation Tool (SBIT) Description

This tool aligns an H-60 Servo Beam Rail to the helicopter's Transmission Beam and other in-place Servo Beam Rails.

The tool can also align an individual Transmission Beam to the other Transmission Beams. The Transmission Plate can be removed from the Welded Structure for this operation, providing a lighter tool. It is noted that the ceiling beams of the helicopter must be stabilized when replacing a Transmission Beam. (See H-60 Jack Kit Flyer.)



SBIT with Support Detail Kits

SBIT Usage

- Aligns a Servo Beam Rail to the Transmission Beam and other Servo Beam Rails
- Aligns a Transmission Beam to the other in-place Transmission Beams

The SBIT offers considerable flexibility for accomplish the above functions. However, the user is cautioned to follow existing Depot Maintenance Work Requirements (DMWR) when performing these operations.

ADC has created a Master Gage tool for fabricating the SBIT. This gage was developed from digital master tooling data provided by the OEM. The OEM utilizes master tooling to locate the hole-pattern in the transmission beam. This same technology is used to locate the Servo Beam hole-pattern and the Transmission hole-pattern in the SBIT. However, it is known that certain replaced H-60 Transmission Beam hole-patterns have been drilled from engineering drawing dimensions, which vary somewhat from those of the master tooling. ADC has incorporated the flexibility to attach the SBIT to transmissions drilled to this alternate hole-pattern array.

ASSEMBLED SERVO/TRANSMISSION BEAM INSTALLATION TOOL DIMENSIONS

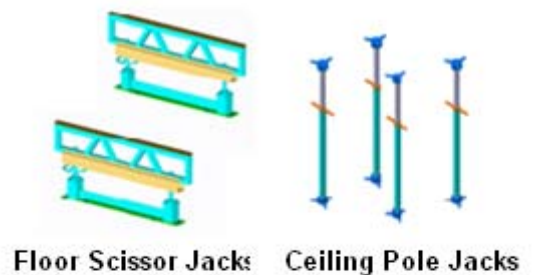
Length 21 Feet 11 Inches
Width 6 Feet 11 Inches
Height 6 Feet .5 Inches

Beam Installation Support Products

ADC offers the following additional tooling products supporting Servo Beam and Transmission Beam installation operations.

Underside and Ceiling Jack Kit

Two floor-located Scissor Jacks for lifting and supporting the H-60 fuselage underside mold surface, plus four Pole Jacks for supporting the ceiling beams from the floor of the H-60. (See *H-60 Jacking Kit Flyer*).



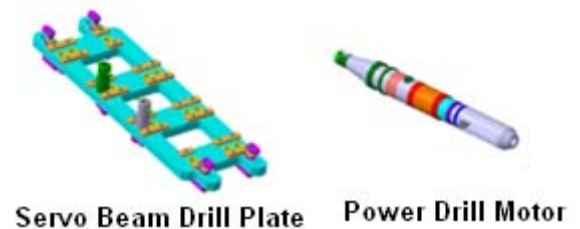
Floor Scissor Jacks

Ceiling Pole Jacks

Servo Beam Array Drill Plate

A Power Feed Drill Plate and Power Drill for drilling the Servo Beam Rail hole-patterns

- Power Feed Drill (Air Feed)
- Power Feed Bushing Nose Tips
- Two sizes of undersize drills for drilling bushing holes before reaming
- Full Size Reamer (.3750 Dia.)
- Index Clamping Pins used for locating the undersize Servo Beam Rail Fitting holes relative to the Power Feed Drill Plate
- Tooling Barrel Nuts used with the Indexed Clamping Pins



Servo Beam Drill Plate

Power Drill Motor