

H-60 Tailcone Refurbishment Fixture

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

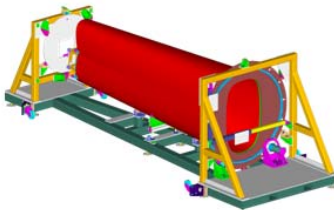
Mastered Tool

Fixture Features

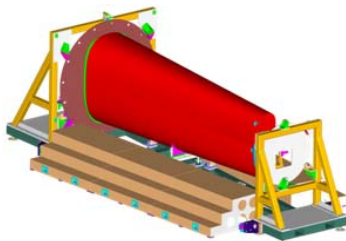
- *Minimum Footprint*
- *Easy Inside Access*
- *360 Degree Motorized Rotation*
- *Mastered End Bulkhead Locations*
- *Removable Step Platforms (both sides)*



Tailcone Refurbishment Fixture with Tailcone Loaded



Tailcone Inside Entry Through Outer Rotation Ring



Tailcone Side Steps Installed (Both Sides)

Tailcone Fixture Functions

This tool is designed to refurbish existing H-60 Tailcone Assemblies. It can be used to rebuild damaged tailcone structures and for installation of structural components.



Tailcone Refurbishment Fixture

- *Supports Skin replacement*
- *Stringer Installations*
- *Fitting Replacements*
- *Forward and Aft Drive Shaft Bracket Alignment*
- *Locates Aft Landing Gear Fitting (Blackhawk)*
- *Installation of Station 485 Bulkhead*
- *Installation of the Canted Bulkhead*

Tailcone Fixture Description

This steel structure fixture is floor mounted and incorporates a trunnion turning configuration that allows workers easy access to the inside of the tailcone. The use of an outside motor driven rotation ring avoids the need to utilize an axial internal shaft, which would clutter the inside of the tailcone.

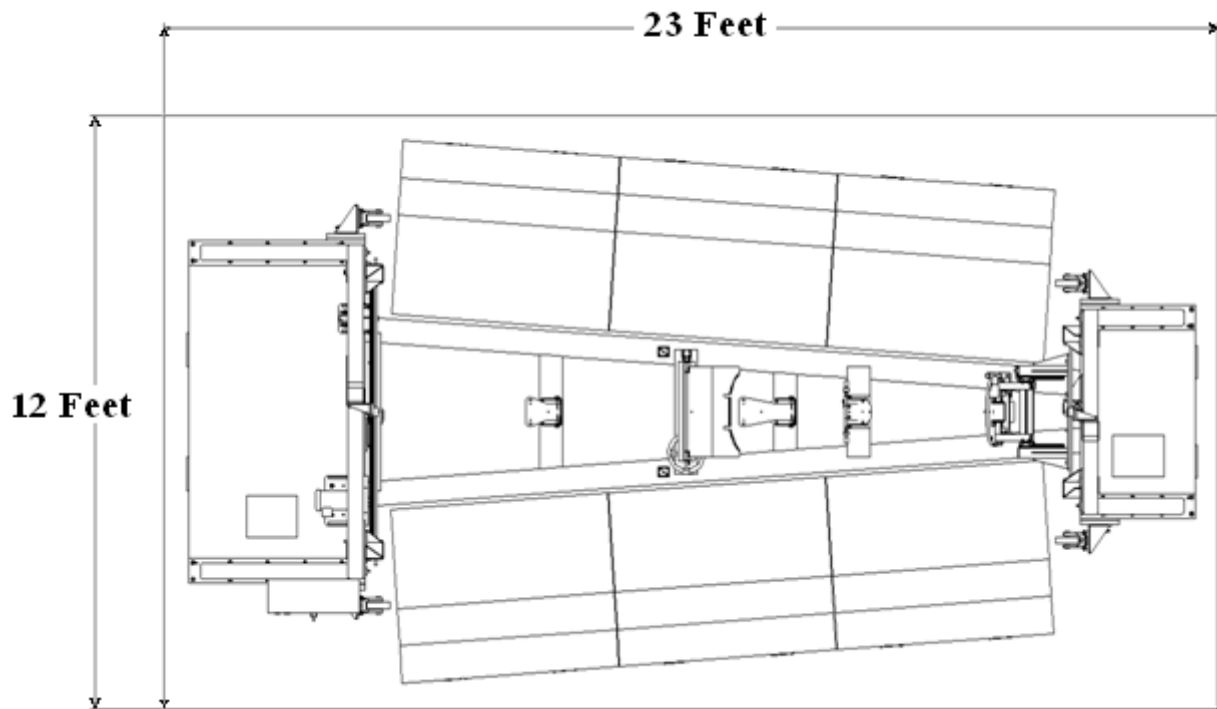
The fixture is assembled using master tools of the 485 Station bulkhead and the Canted bulkhead. These masters are positioned by sighting tooling locations on the masters using laser technology.



TAILCONE REFURBISHMENT FIXTURE DIMENSIONS

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

Tailcone Refurbishment Footprint



Tailcone Fixture Footprint with Side Steps installed

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