



AIRGLAS INSTALLATION,
MAINTENANCE, SERVICE
INSTRUCTIONS & ILLUSTRATED PARTS
LIST (IMSIPL) MANUAL

MODEL L20500A SKI KIT

CODE IDENT NO. 17564

18 March, 2021

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AIRGLAS, INC.

AIRGLAS, INC
ANCHORAGE, ALASKA 99507

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EQUIPMENT AND MATERIALS

INITIAL SETUP

PERSONNEL REQUIRED

- One: AH-64 Helicopter Repairer
- One: Aircraft Structural Repairer
- Three: Assistants

TOOLS

- Aircraft Mechanic's Tool Kit
- Torque Wrench, 0 – 600 in. lbs,
GGG-W-686

MATERIALS/PARTS

- Corrosion Preventative Compound, MIL-C-16173D,
Grade 2
- Dry Cleaning Solvent, MIL PRF-680 Type II
- SuperLube Synthetic Grease (PTFE)
- Readily Available Anti-Seize agent
- Rag, Clean, DDD-T-541

LANDING GEAR SKIS - INSTALL MAIN AND TAIL

SKI - PREPARATION MAIN LANDING GEAR

Section 1.0

Preparation of both skis is the same except where noted.
Right side is shown.

1. Remove and save hardware (AN3-27A bolt, AN960-10 Washer, and AN365-1032 Nut) holding the Axle Assy., Outboard (L20500A-6) in place. *See figure 1.0*
2. Slide Axle Assy., Outboard out of fitting in ski. *See figure 1.0*
3. Remove Shipping Tube covering the Axle, Main Landing Gear (L20500A-7). *See figure 1.0*
4. Remove the Axle (L20500A-7) *See figure 1.0*
5. DO NOT REMOVE AXLE ASSY., INBOARD. *See figure 1.0*
6. Remove Tail Wheel Assembly and Check Cable from rear of the Main Ski by removing Elevator Bolts (EB616-20, EB616-21) from the bottom of the ski *See figure 1.1* Save all hardware for future use.

SKI - PREPARATION TAIL LANDING GEAR

Section 2.0

7. Remove Tail Wheel Bracket Kit (L20500-18) from back of Tail Ski Assy. (L20500A-3). Save all hardware for future use. *See Figure 2.0*
8. Remove Tail Ski Axle Adapter (L20500A-13). Save all hardware for future use *See Figure 2.0*

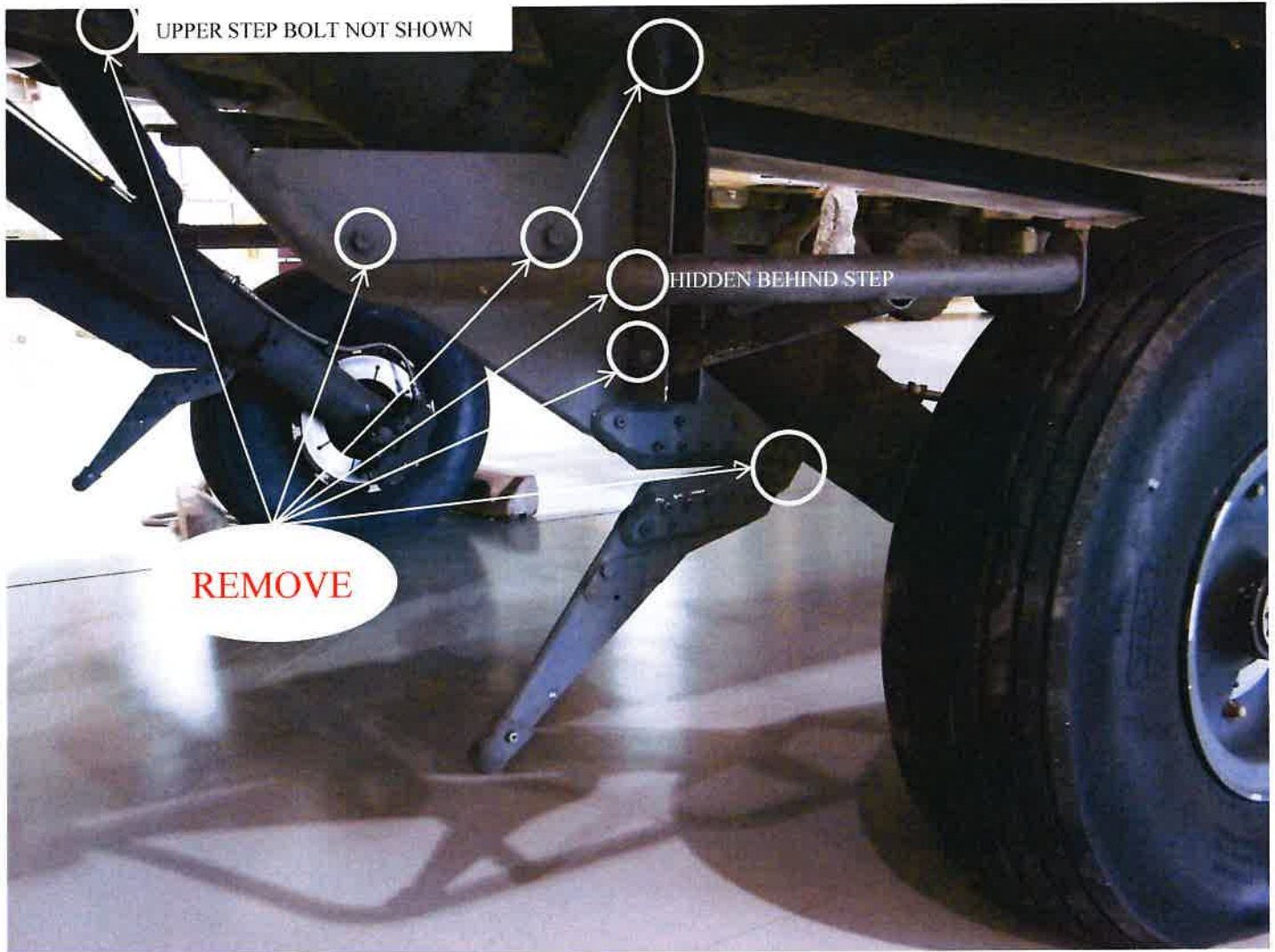
HELICOPTER - PREPARATION MAIN LANDING GEAR

Section 3.0

Preparation of both skis is the same except where noted.
Right side is shown.

9. Remove Step Assembly (7-511113527-1 & -2). Keep existing hardware for future use. *See figure 3.0.*
10. Remove Wire Cutter Assembly (443-83020-2). Keep hardware and wire cutter assy. for future use. *See figure 3.0*
11. Attach Airglas Bracket Assembly (L20500A-20 R.H., L20500A-21 L.H.) to Main Landing Gear using existing hardware *See Figure 3.1*
TORQUE VALUE
12. Bolt Bracket Assembly to Clamp (443-83023-1) (both sides) using existing hardware from Step 10. *See Figure 3.1*
13. Re-install Step Assembly (7-511113527-1 & -2) to Bracket Assembly (L20500A-20, L20500A-21) using existing hardware from Step 9. *See Figure 3.1 inboard*
14. Remove Jack Pad (1168321-1). Keep existing hardware. *See Figure 3.2*
15. Slide Axle, Main Landing Gear (L20500A-7) into the Trailing Arm (1168320-101) axle housing. *See Figure 3.2*
16. Line up clearance hole on Axle (L20500A-7) with clearance hole on Trailing Arm (1168320-101).
17. Re-install existing hardware from Step 14 to hold Axle (L20500A-7) in place. *See Figure 3.2*
TORQUE VALUE
18. Remove both inboard pylons.
19. Remove inboard attach bolts
20. Install check cable attach bracket PN L20500A-11-3, see fig. 5..6
21. Match torque of existing pylon bolts.
22. Set levelers to make full contact with side of pylon. Tighten NAS509-3C and safety the two nuts.

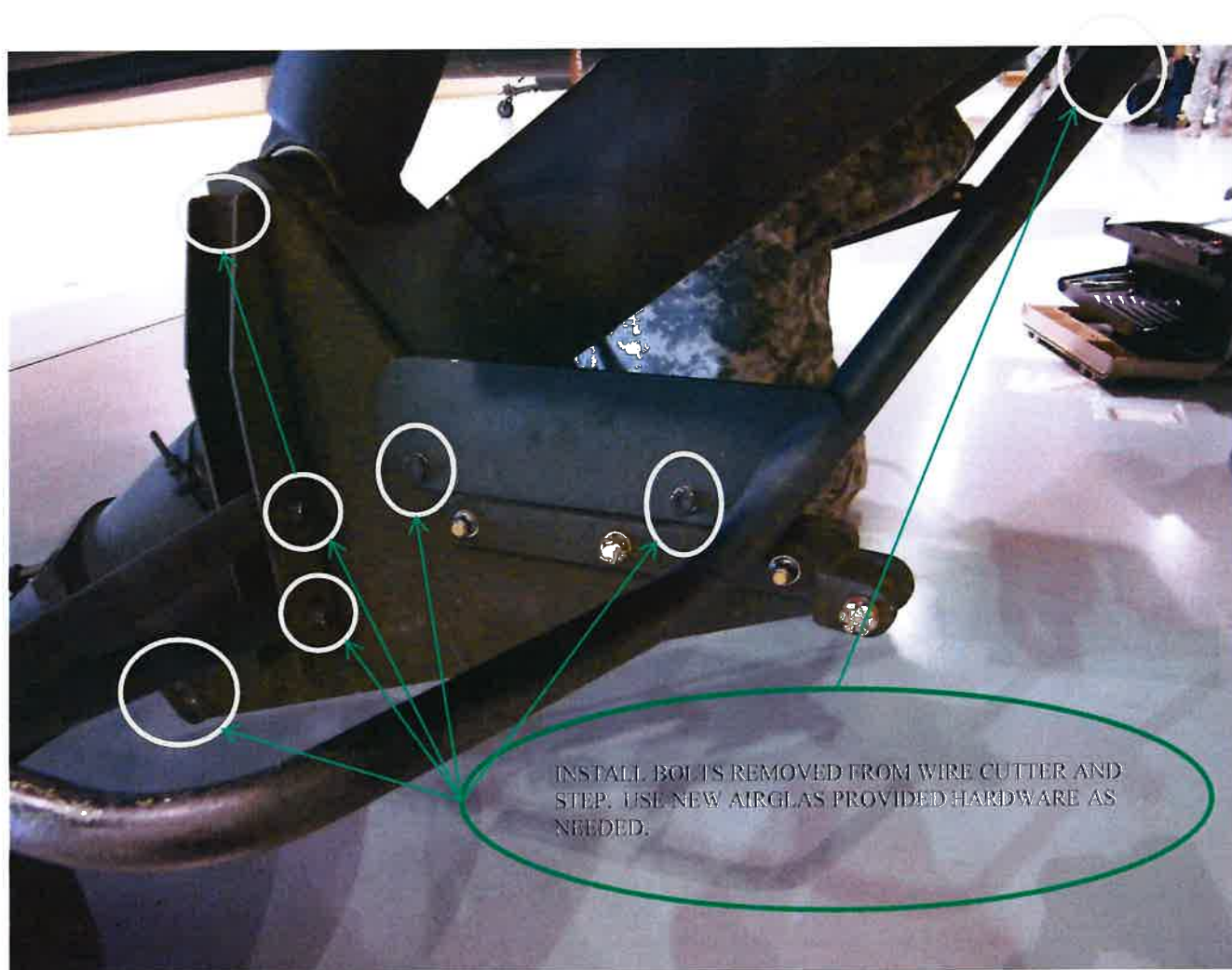
REMOVAL OF STEP AND WIRE CUTTER



REMOVE HARDWARE CIRCLED IN PICTURE. NOTE: ONE OF THE FASTENERS IS HIDDEN BEHIND THE STEP, ONE (UPPER STEP BOLT) IS NOT IN PICTURE.

NOTE: RETAIN ALL HARDWARE FOR LATER USE.

INSTALLATION OF AIRGLAS ADAPTER ASSEMBLY (L20500A-20 RH SIDE, L20500A-21 LH Side)



SEE FIG 3.1 FOR SPECIFIC DETAILS ON HARDWARE AND
TORQUE REQUIREMENTS

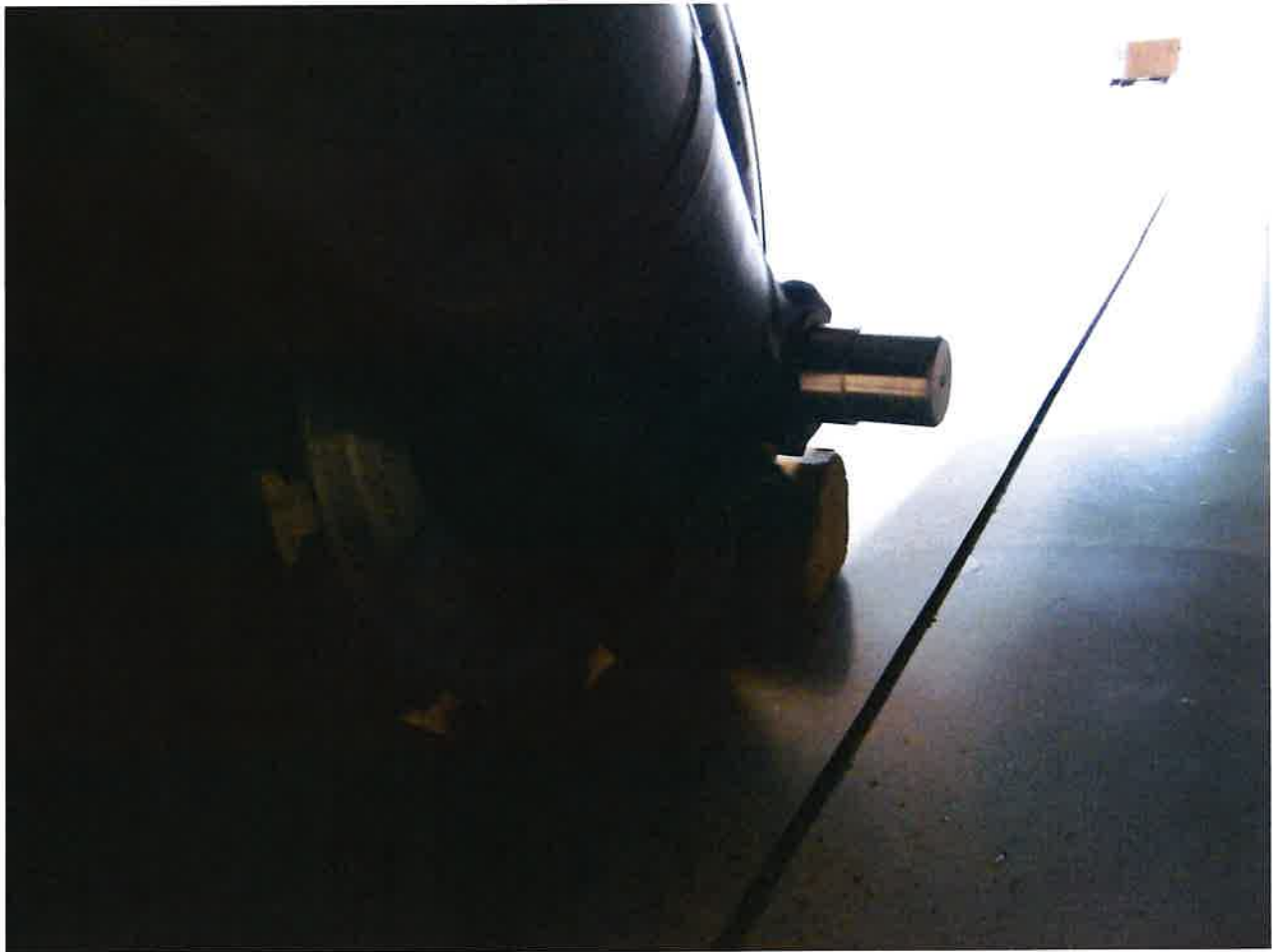
REMOVE JACK PAD



JACK PAD IS INSTALLED WITH ONE BOLT. REMOVE BOLT AND THEN TWIST AND PULL ON PAD TO REMOVE.

AFTER REMOVAL OF JACK PAD, CLEAN THE INTERIOR OF THE AXLE CAVITY TO REMOVE ALL FOREIGN MATERIAL. USE OF A ROUND (BORE) BRUSH AND SHOP AIR WILL BE NEEDED.

INSERT L20500A-7 AXLE INTO MAIN LANDING GEAR
AXLE CAVITY.



INSERTION OF THE AIRGLAS L20500A-7 AXLE CAN HAVE BE COMPLICATED BY PAINT OVERSPRAY INSIDE AXLE CAVITY. BOEING DID NOT SPECIFY A PAINT THICKNESS IN THIS AREA. DO A TEST INSERTION TO SEE HOW FAR AXLE WILL GO IN WITH NO FORCE. IF IT DOES NOT GO IN ALL THE WAY, TAP LIGHTLY WITH A RUBBER Mallet.

NOTE: BE SURE TO ALIGN HOLES OF THE AIRGLAS AXLE (L20500A-7) AND THE MAIN LANDING GEAR AXLE.

YOU MAY NEED TO DO A SERIES OF INSERTIONS AND PAINT CHIP REMOVAL TO GET AXLE TO GO ALL THE WAY IN. IF YOU SEE ANY METALLIC CHIPS, STOP AND HAVE IT ASSESSED BY A TECHNICAL EXPERT.

HELICOPTER - PREPARATION TAIL LANDING GEAR

Section 4.0

23. Remove Wire Strike (Deflector) from Tail Landing Gear and all associated hardware.

NOTE: The bolts that attach wire strike to tail wheel axle will need to be replaced with NAS6405-32 bolts, or an alternate temporary method by using a washer stack added to replace the thickness of the wire strike attach lugs. Washers should be replaced at the next major maintenance inspection. These bolts are in shear, so washer stack has no impact on joint strength.

TAIL SKI - INSTALLATION

Section 5.0

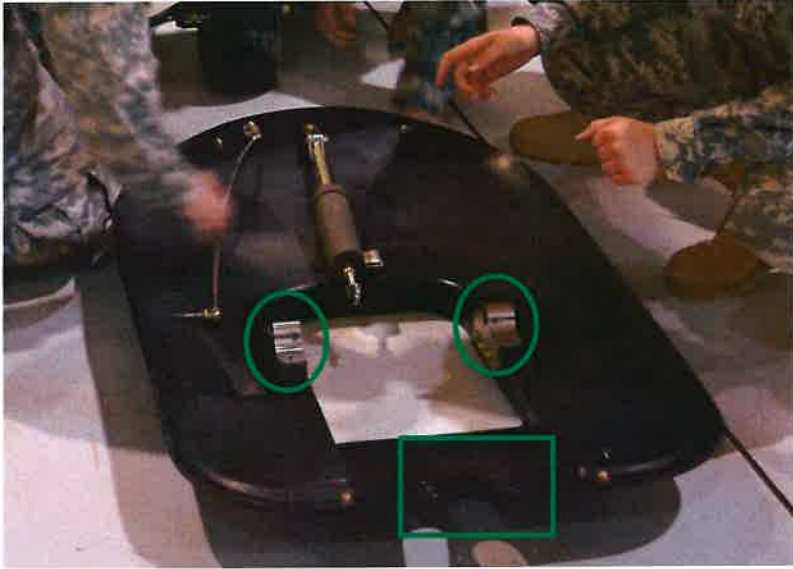
24. Remove Bolts (AN4-7A), Washers (AN960-416), and Nuts (A365-428), (and NAS70C-4 Washers) holding tail ski, Tail Wheel Bracket Kit (L20500-18) to ski and remove Tail Wheel Bracket Kit. *See Figure 2.0* (retain hardware)

Note: Remove the L20500A-14-2 bracket (Item 38 of IPB on Page 28) prior to towing helicopter onto tail ski. This bracket will create interference with tow bar. This is done by removing the two AN5-12A bolts and one AN3-21A bolt (Item 8 & 41 on page 28) attaching bracket to the L20500A-14 (Item 22 on page 28)

25. Center Tail Ski in front of Tail Gear Wheel. *See Figure 5.0*
- 26.. Tow helicopter, or push helicopter forward, with help of assistants, until Tail Wheel is centered in Ski Wheel Well.
27. Lift rear ski so the Tail Ski Attach Brackets (L20500A-14) line up with the Tail Wheel Axle (1168819-1). *See Figure 6.0*

Note: Re-install the L20500A-14-2 bracket (Item 38 of IPB on Page 28) attaching bracket to the L20500A-14 (Item 22 on page 28) This is done by installing the two AN5-12A bolts and one AN3-21A bolt (Item 8 & 41 on page 28) removed in Step 24 above. Torque AN5-12A to 100-140 IN LBS, the AN3-21A to 20-25 IN LBS.

28. Insert Tail Ski Axle Adapter(s) (L20500A-13) through Ski Attach Bracket(s), place Axle Spacer(s) (L20500A-16) on Tail Ski Axle Adapter(s). *See Figure 6.0*
29. Push Ski Axle Adapter (s) into Tail Ski Axle until clearance holes line up on Ski Attach Bracket(s) and Ski Axle Adapter (s). *See Figure 6.1*
30. Insert Bolt(s) (AN3-14A) through clearance holes, affix Washer(s) (AN960-10) and Nut(s) (AN365-1032). *See Figure 6.1* TORQUE VALUE
31. Attach Spring Cylinder, Tail Ski (L20500A-15) to Tail Ski, Lower Attach Fitting (L20500A-19) with Bolt (AN26-21), Washer (AN960-616L) and Nut (AN320-6). Secure Nut with Cotter Pin (MS24665-302). *See Figure 6.2* TORQUE VALUE
32. Insert Bushings (L20500A-22) into 3/8 hole in Eye Bolt, SPL (L20500A-23) one from each side. *See Figure 6.2*
33. Hold the Spring Cylinder in one hand, lift the front of the ski, and position the upper Eye Bolt (L20500A-23) so that the Eye Bolt is lined up with the Bushings and tlg wheel fork assy lugs 1168850. Insert Eye Bolt (L20500A-24) Affix Washer (AN960-416) and Nut (AN310-4). Instl MS24665-151 cotter pin. *See Figure 6.2*
34. Install Safety Cable Tail Ski (L20500A-17) onto Tail Ski using Washer (30185), Screw (NAS514P524-16), Washer (AN960-516) and Nut (AN365-524). *See Figure 6.3* TORQUE VALUE
35. Attach upper portion of Safety Cable to Eye Bolt (L20500A-24) using Clevis Pin (AN394-15) and Cotter Pin (MS24665-151). *See Figure 6.3*
36. Re-Install Tail Wheel Bracket Kit (L20500-18). *See Figure 2.0*



Tail ski with L20500A-14-2 Tow Bar Adapters and L20500-18 tail wheel assembly removed



Tail ski with L20500A-14-2 Tow Bar Adapters reinstalled and connected to tow bar.



Tail ski with L20500A-14-2 Tow Bar Adapters reinstalled and L20500-18 tail wheel assembly being installed.

LANDING GEAR SKIS - INSTALL MAIN AND TAIL

MAIN SKI - INSTALLATION

Section 6.0

37. Center Main Skis in front of Main Landing Gear Wheels *See Figure 5.0*
38. CAUTION – To avoid damage to ski take extreme care to ensure that the wheels are on the outboard part of the wheel wells.
39. Install Airglas installation ramps on both main skis.
40. Tow helicopter or push helicopter forward with help of assistants until the main wheels are centered in the ski wheel well.
41. Lubricate Axle, Main Landing Gear (L20500A-7) with thin coat of Synthetic Grease (PTFE).
42. Lift tail of main ski off the ground and slide fore or aft to align the Axle Assembly, Inboard (L20500A-5) (which was left on the ski) with the Axle, Main Landing Gear (L20500A-7). Slide ski outboard until Axle (L20500A-7) is properly seated in Inboard Axle (L20500A-5). *See Figure 5.1*
43. Coat Axle Assy., Outboard (L20500A-6) threads with anti-seize agent. Coat Axle Assy., Outboard (L20500A-6) body with corrosion preventative compound, MIL-C-16173D, Grade 2.
44. Insert Axle Assy., Outboard (L20500A-6) into Main Ski Bushing Assy. (L20500-4) and thread Ski Axle into Ski Bushing. *See Figure 5.1*
45. Thread Inboard and Outboard Ski Axles until both are evenly seated on Axle, Main Landing Gear (L20500A-7). *See Figure 5.2*
46. Back off Inboard and Outboard Ski Axles until the holes line up to slots on the Ski Bushing.
47. Install bolt(s) (AN3-27A) through Inboard and Outboard Axles and Ski Bushing. Affix Washer(s) (AN960-10) and Nut(s) (AN365-1032) onto bolt(s) *See Figure 5.2*. TORQUE NUTS TO 20 – 25 INCH-POUND.
48. Install Spring Cylinder, Main Ski (L20500A-8) on forward Ski Eye Bolt (AN47-14) with Clevis Bolt (AN396-23) and Cotter Pin (MS24665-302) and to the Upper Mounting Bracket (L20500A-21-3) with Clevis Bolt (AN26-25), (2) Washers (AN960-616L) and Nut (AN320-6), (4) Special Washers (P/N 528D378D050 (2 each side of rod end)). *See Figure 5.3* TORQUE VALUE
49. Install Check Cable (L20500A-11) to check cable bracket, PN L20500A-11-3 using Clevis Pin and Cotter Pin.
50. Re-Install Tail Wheel Assembly (L20500-D501A) *See Figure 1.1*
51. Align Check Cable to Ski Angle Bracket (L20500A-11-1A, L20500A-11-1B), Insert Clevis Pin (AN396-23) and Cotter pin (MS24665-302). *See Figure 5.4*
52. Install lower end of Safety Cable Assy. (L20500A-12) to ski with Bolt (AN5-6A) Washer (AN960-516L) Nut (AN365-524). *See Figure 5.5*. TORQUE VALUE Install upper end to Eye Bolt (AN45-11) at 2nd hole back on Bracket Assy. (P/N L20500A-20, L20500A-21) Fasten with clevis pin (AN395-17) and secure with cotter pin MS249665-302. *See Figure 5.5*.

MAIN SKI – SKI PREPARATION FOR ASSEMBLING TO AH-64D

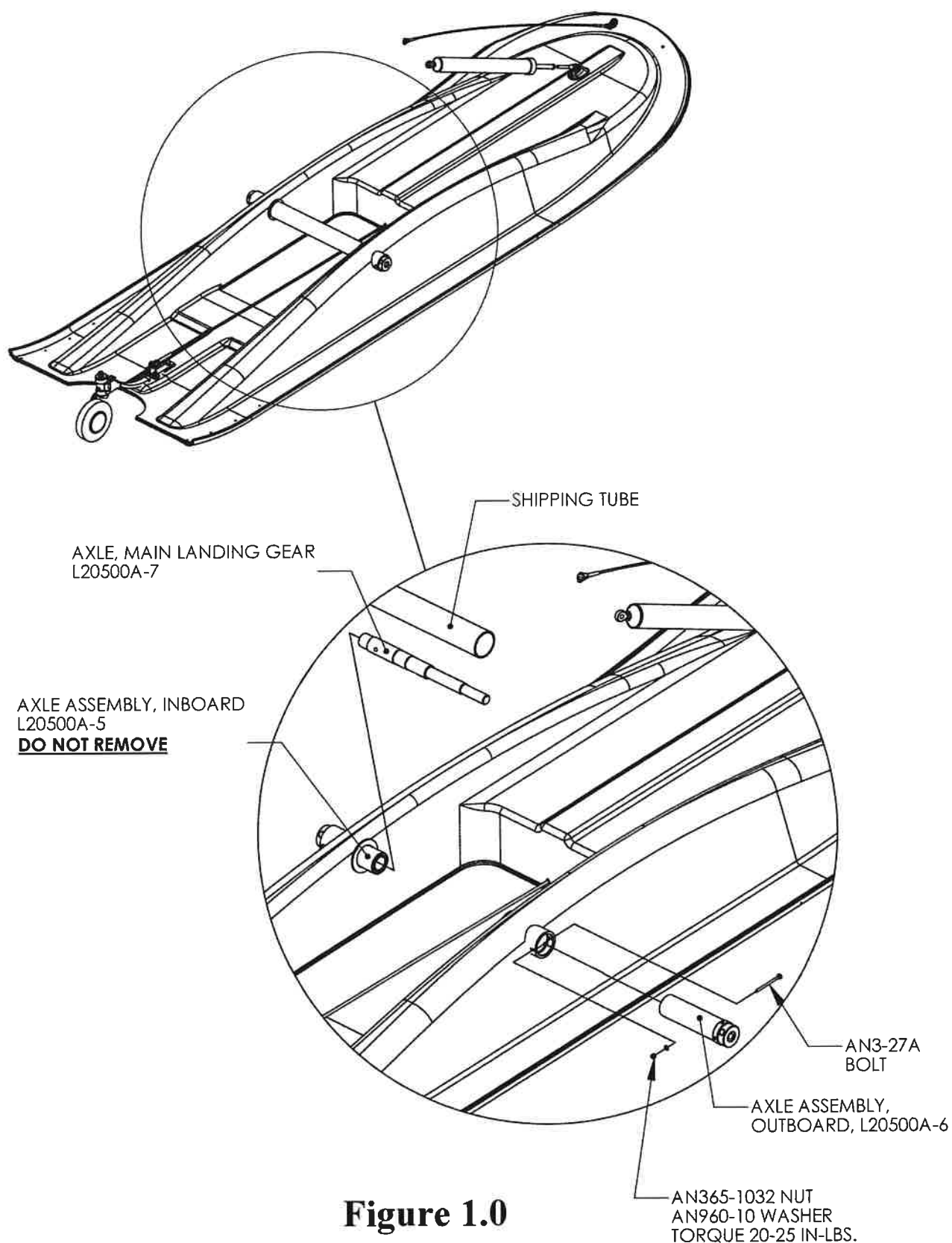


Figure 1.0

MAIN SKI – SKI PREPARATION FOR ASSEMBLING TO AH-64D

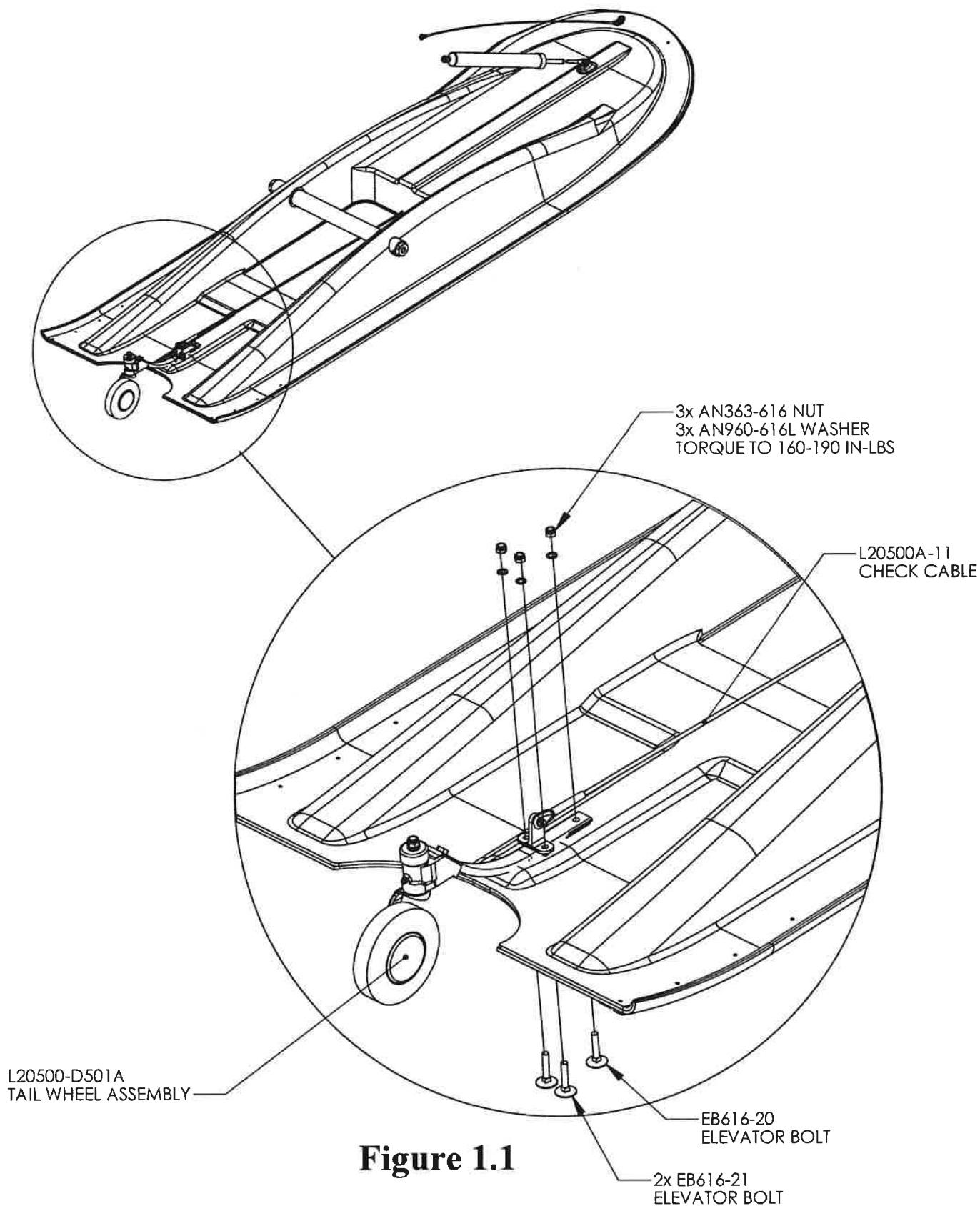


Figure 1.1

TAIL SKI – SKI PREPARATION FOR ASSEMBLING TO AH-64D

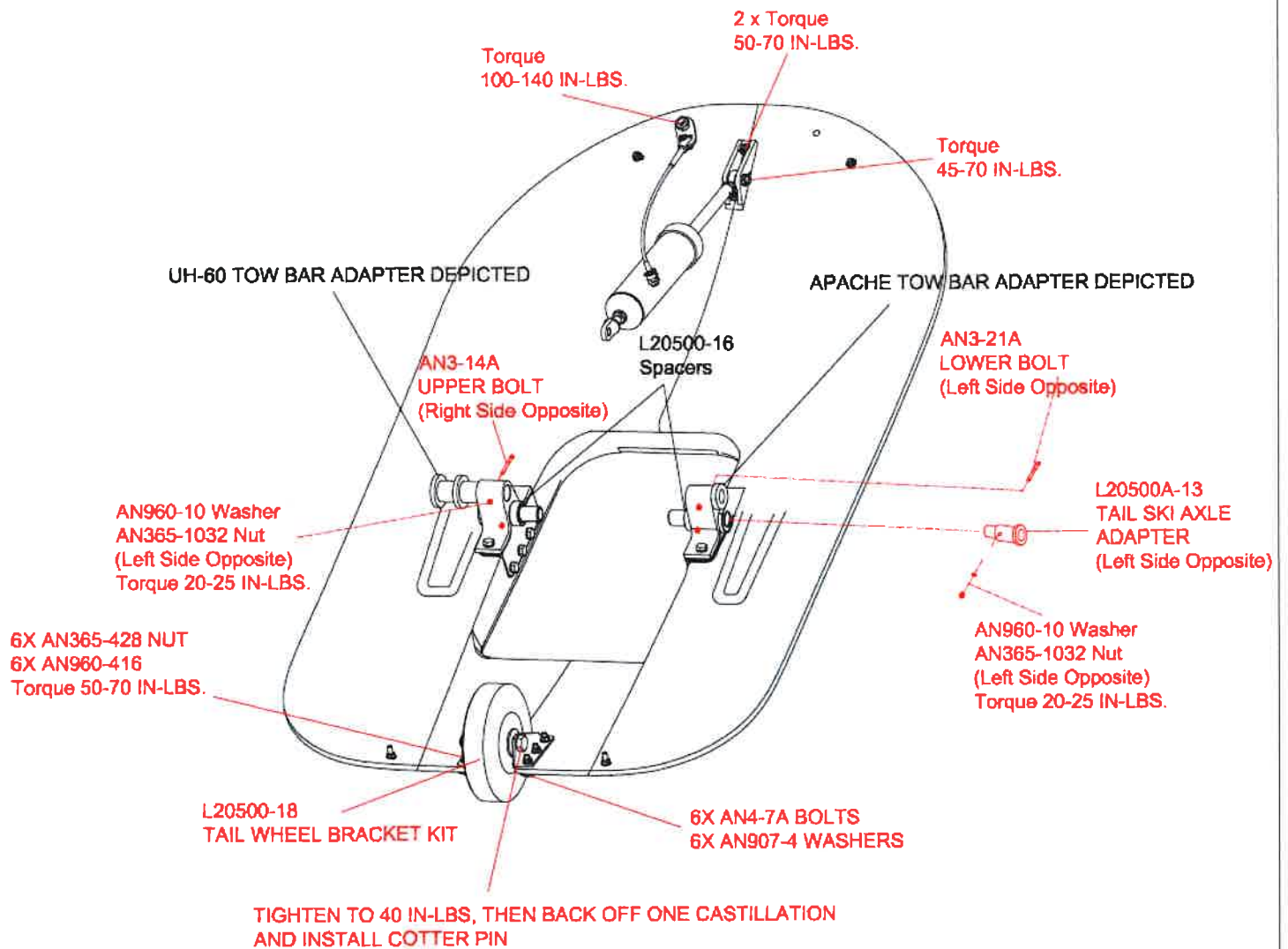


FIGURE 2.

MAIN GEAR – BOEING STEP AND PLATE REMOVAL

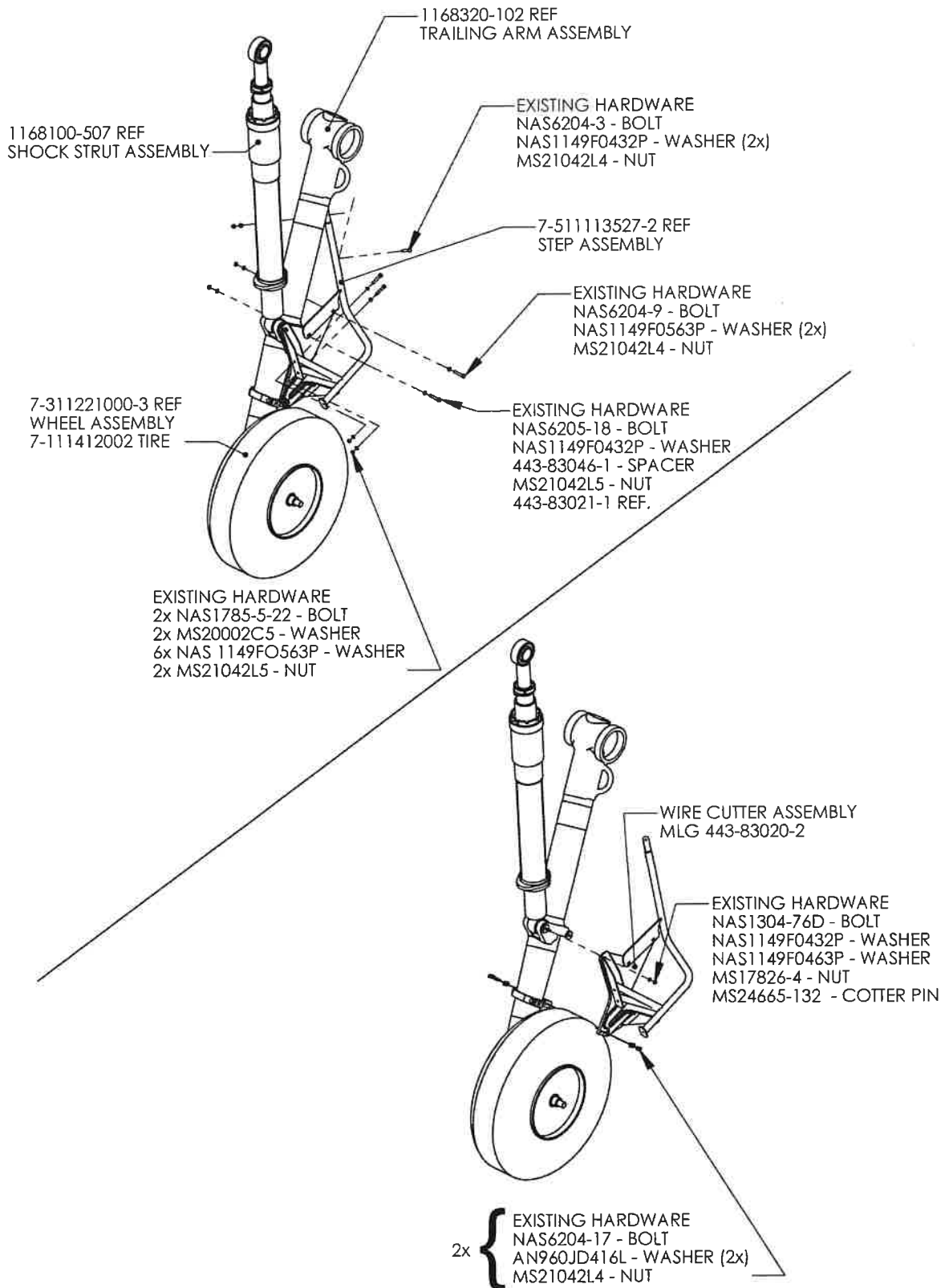


Figure 3.0

MAIN GEAR – AIRGLAS BRACKET AND STEP ASSEMBLY

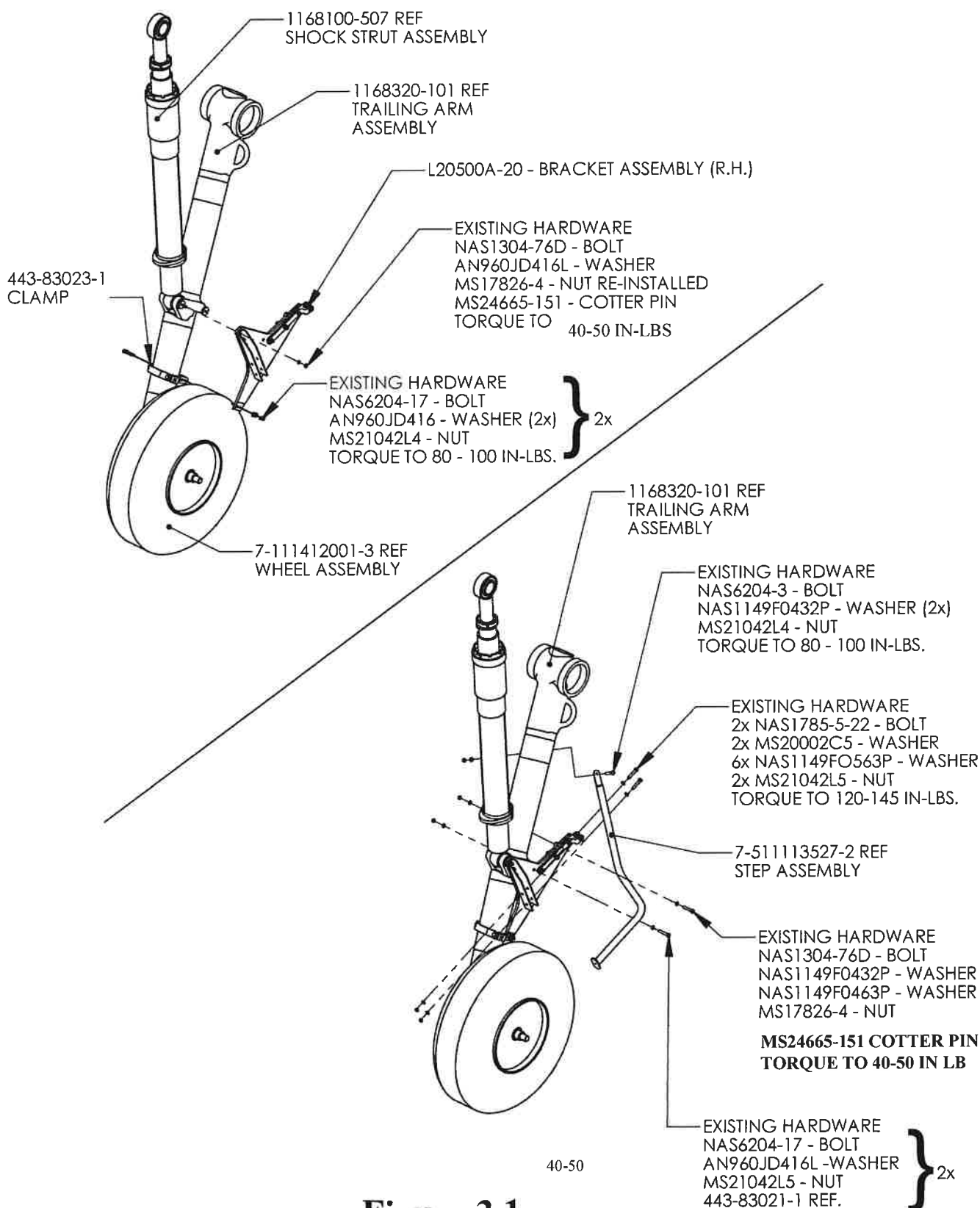


Figure 3.1

MAIN GEAR – JACK PAD REMOVAL / AXLE ASSEMBLY

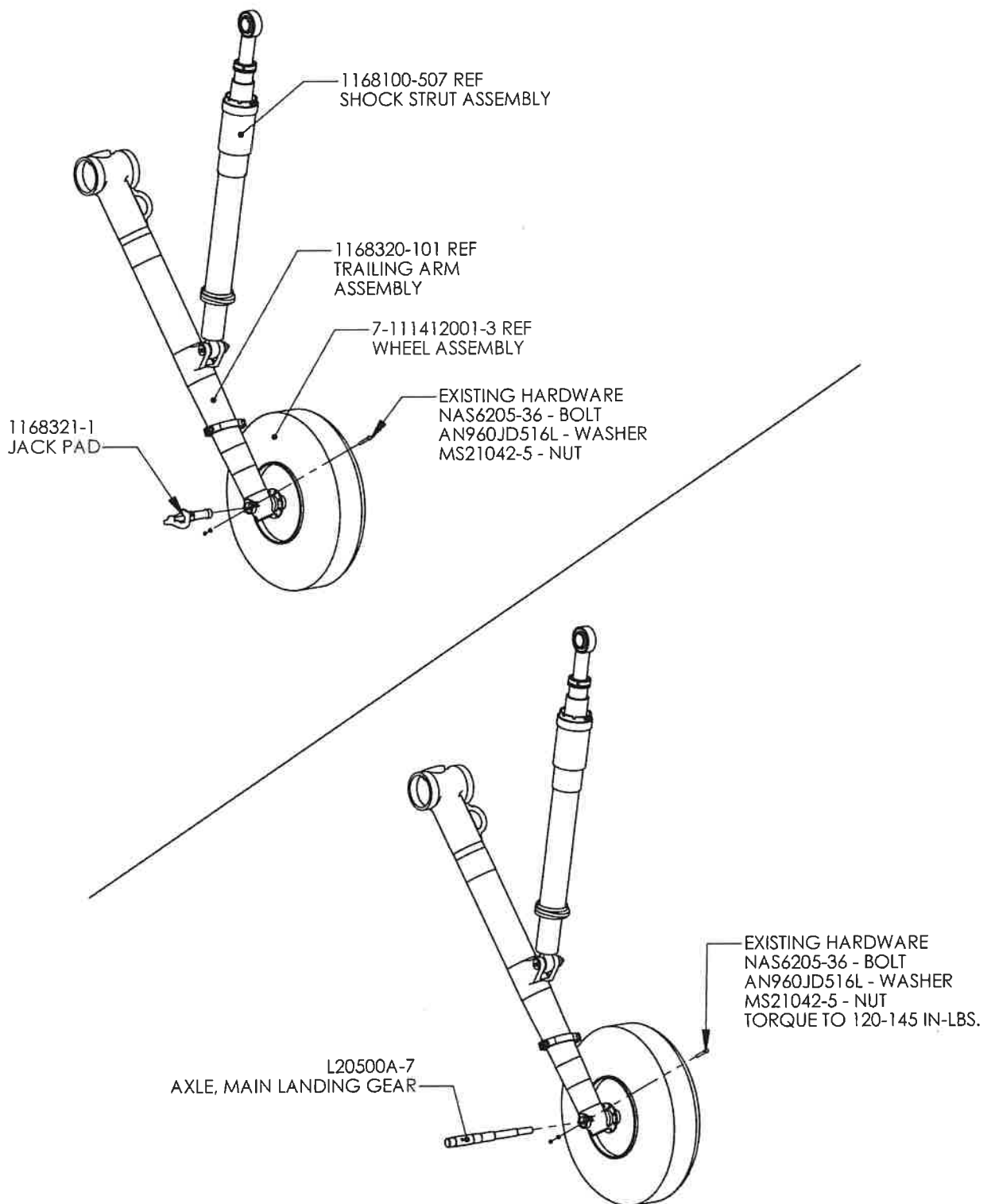


Figure 3.2

MAIN GEAR / TAIL GEAR – PRE-INSTALL SKI POSITION

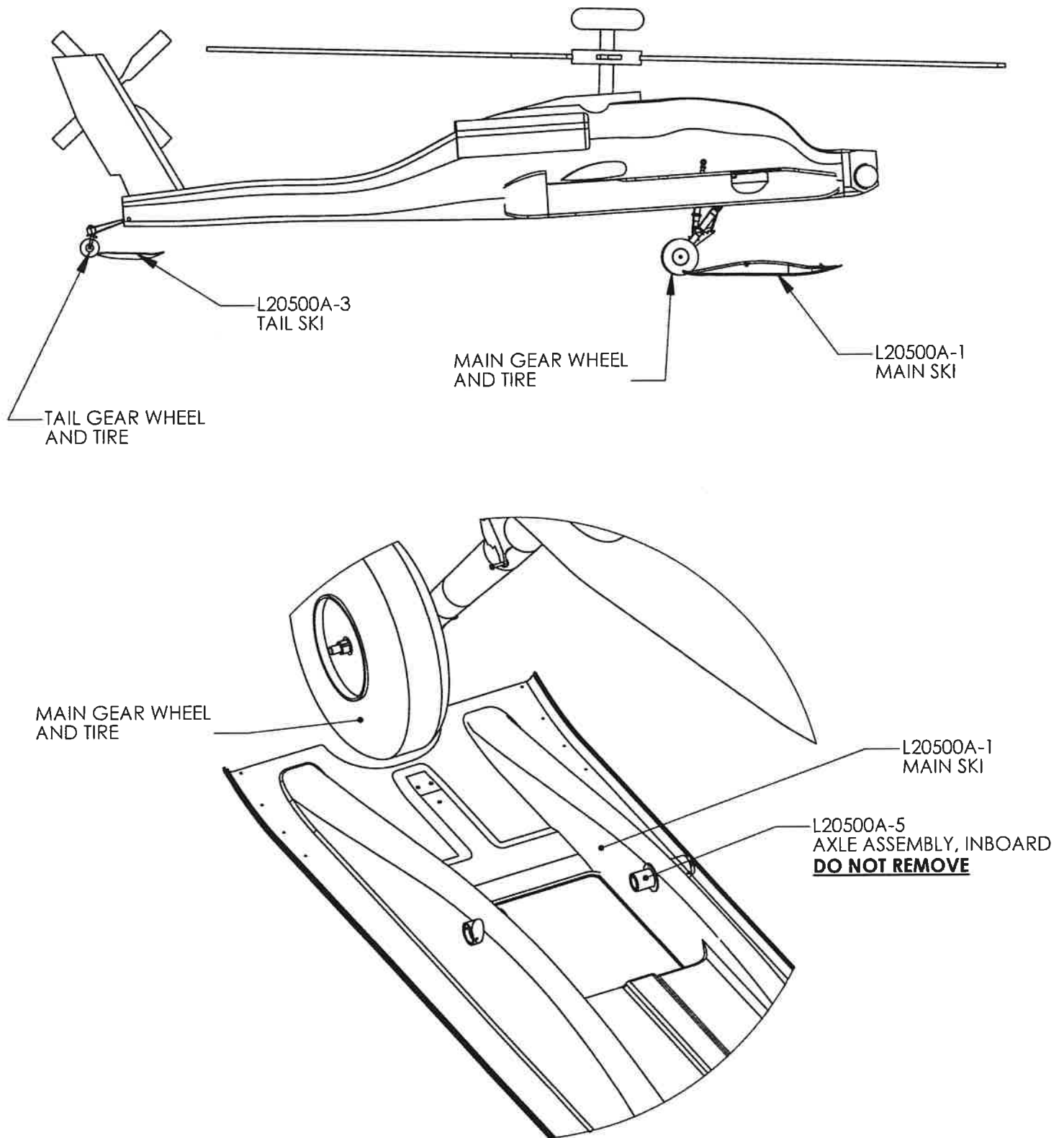


Figure 5.0

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MAIN SKI – AXLE POSITIONING AND ASSEMBLY

MOVE SKI FORE OR AFT TO ALIGN
AXLE ASSEMBLY, INBOARD (L20500A-5)
WITH AXLE, MAIN LANDING GEAR (L20500A-7)

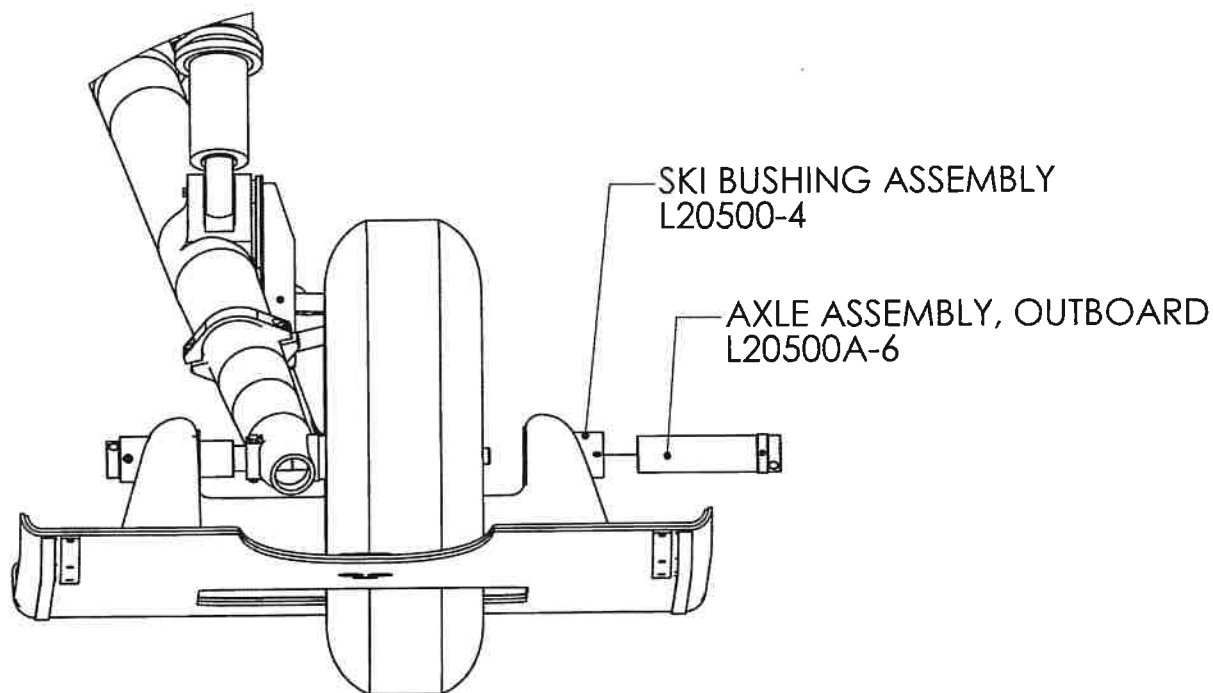
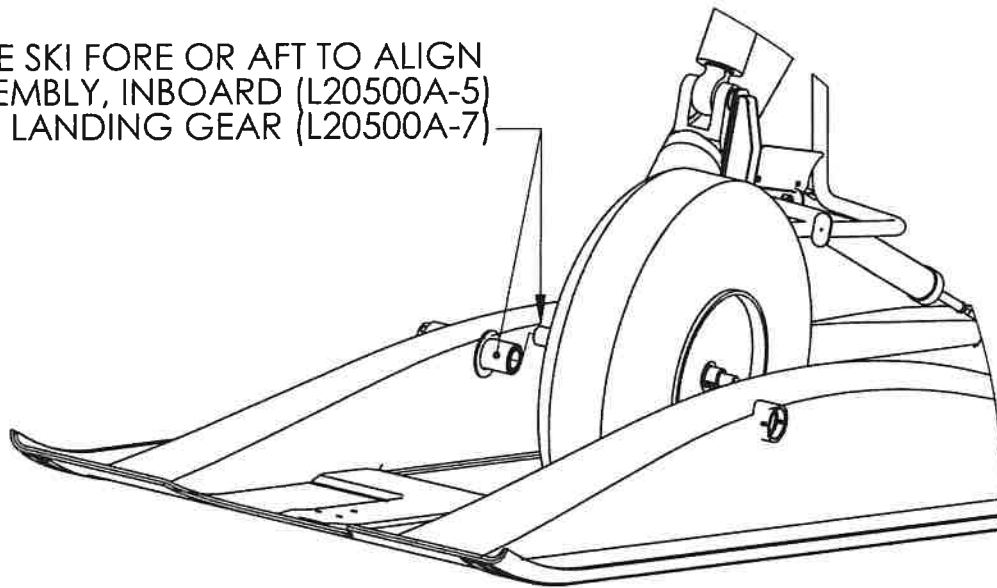


Figure 5.1

MAIN SKI – AXLE POSITIONING AND ASSEMBLY

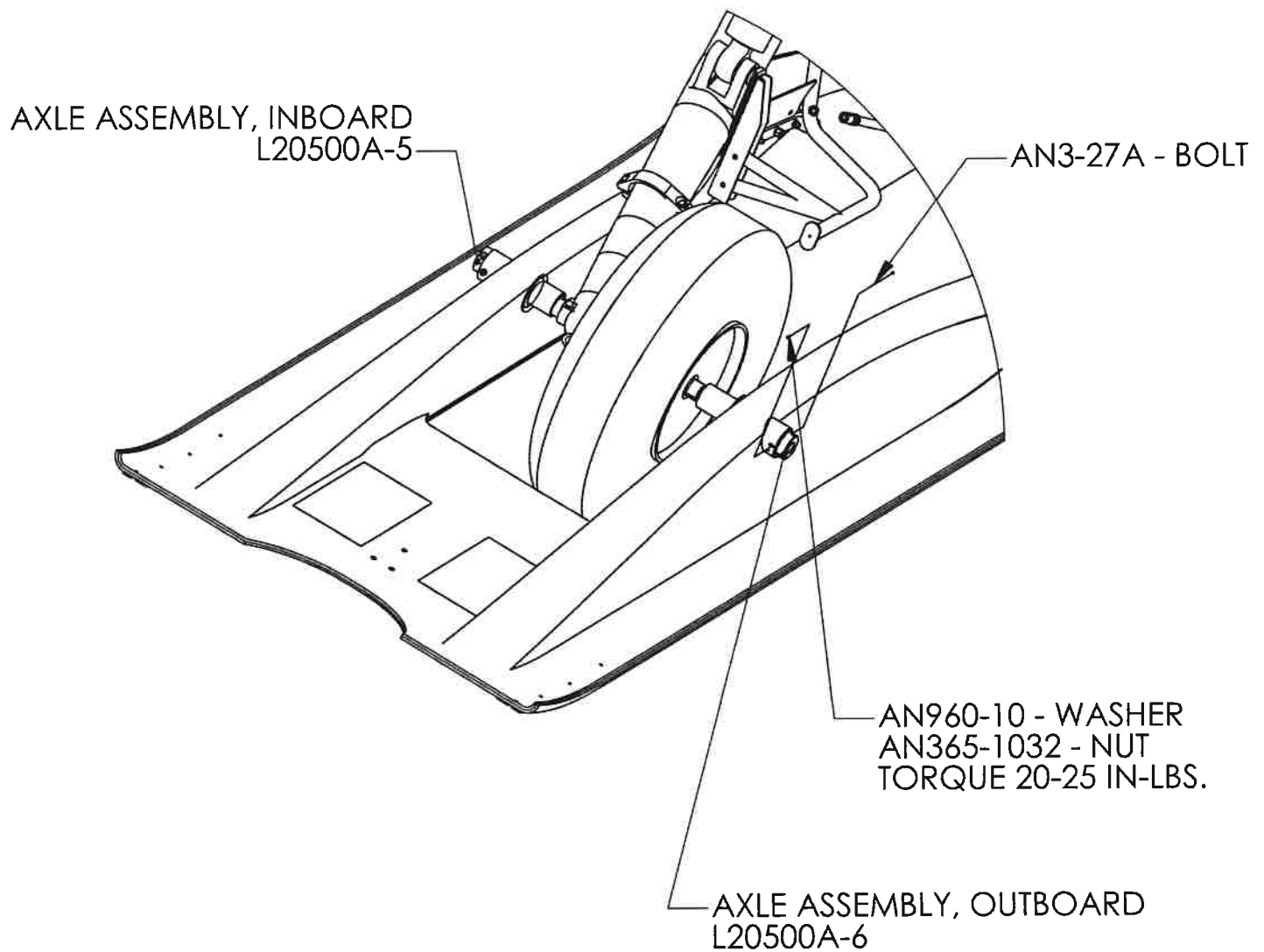


Figure 5.2

MAIN SKI – SPRING CYLINDER POSITIONING AND ASSEMBLY

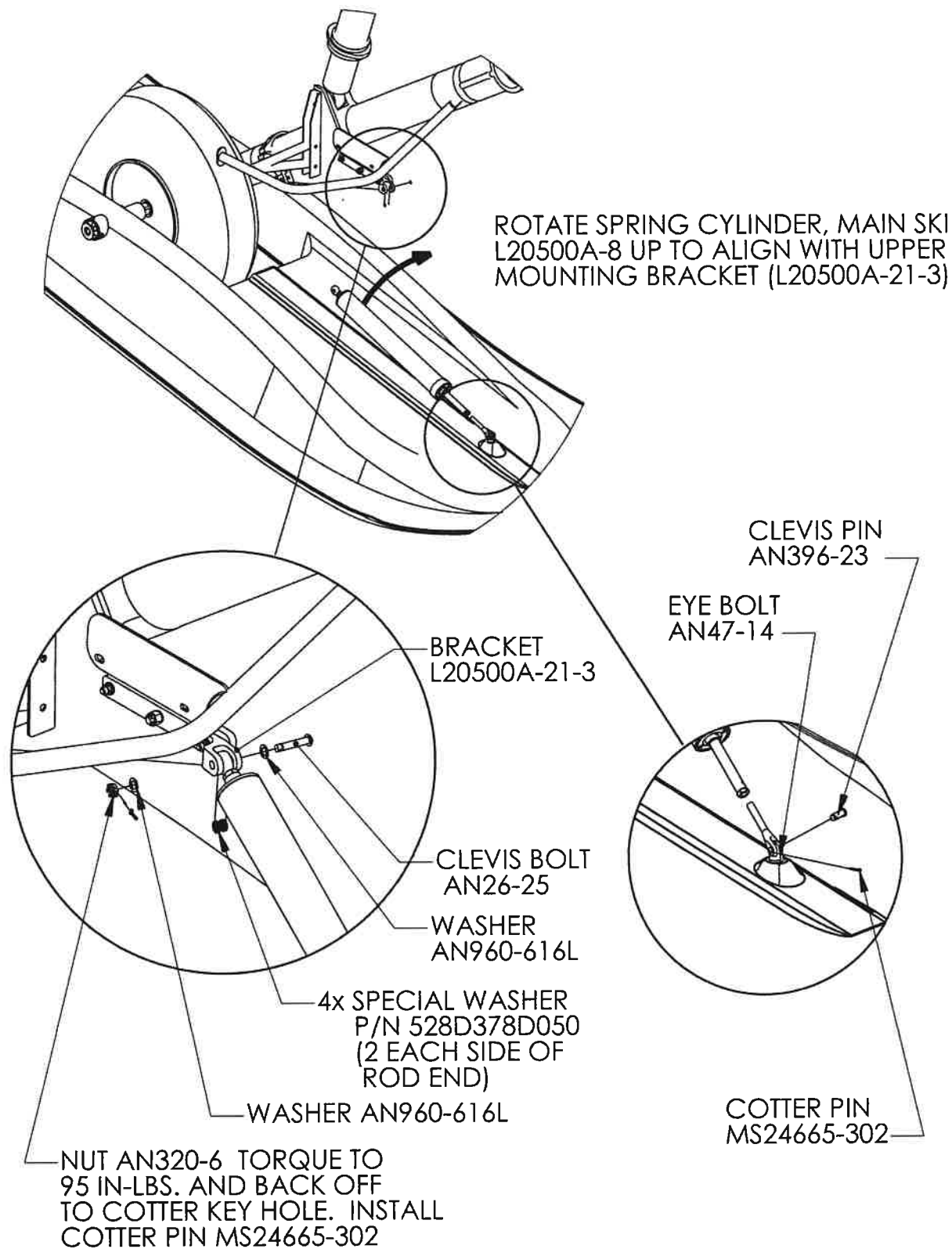


Figure 5.3

MAIN SKI – CHECK CABLE ASSEMBLY

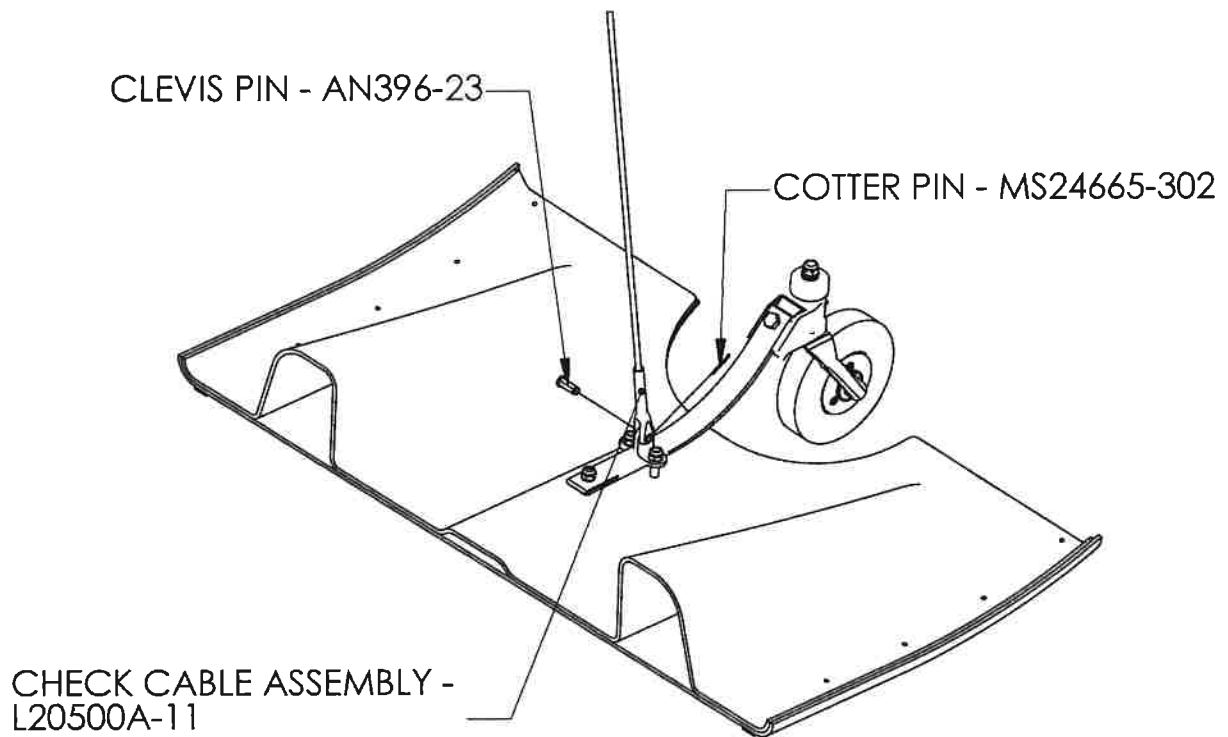


Figure 5.4

MAIN SKI – SAFETY CABLE ASSEMBLY

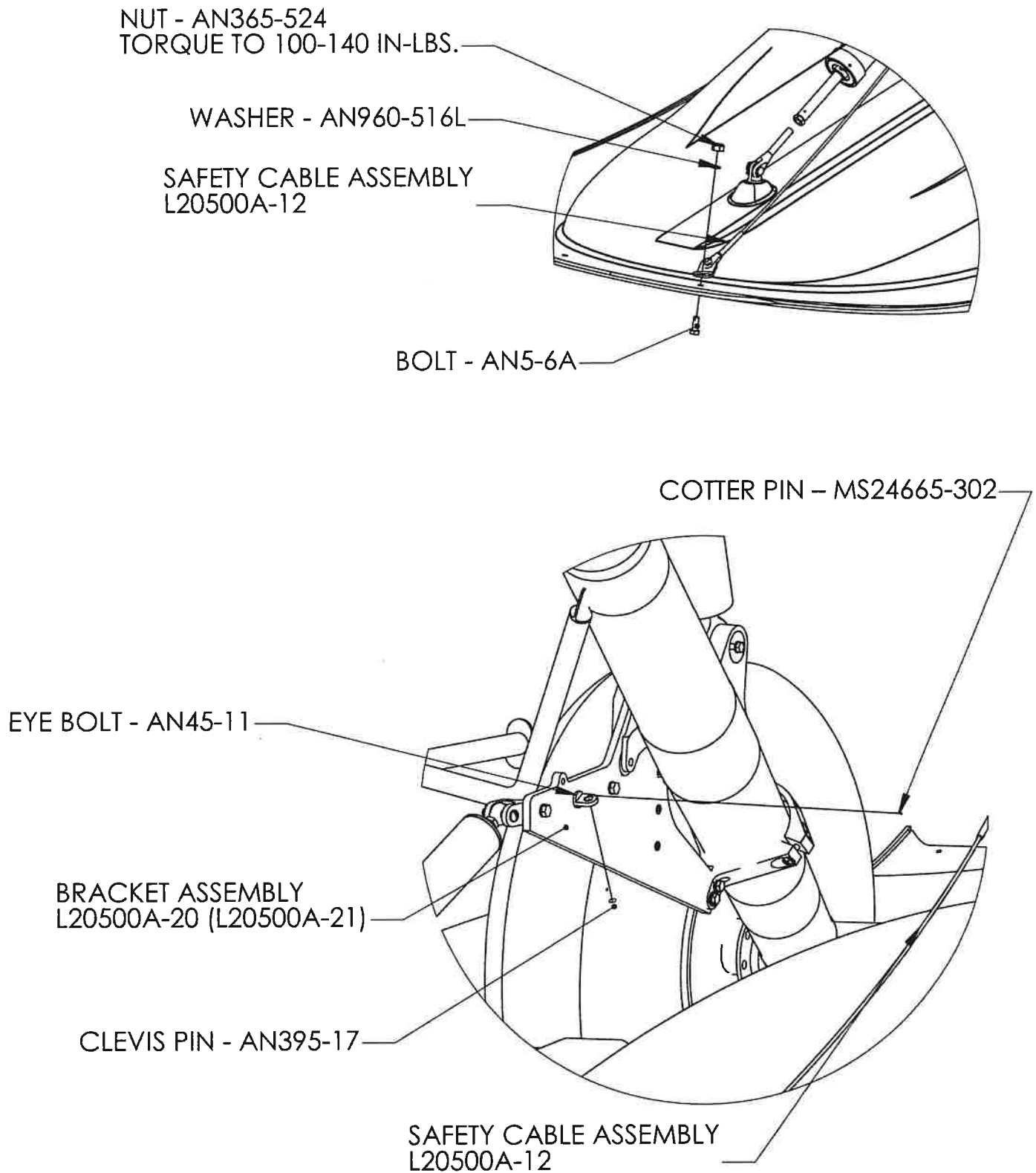


Figure 5.5

PYLON CHECK CABLE BRACKET INSTALL

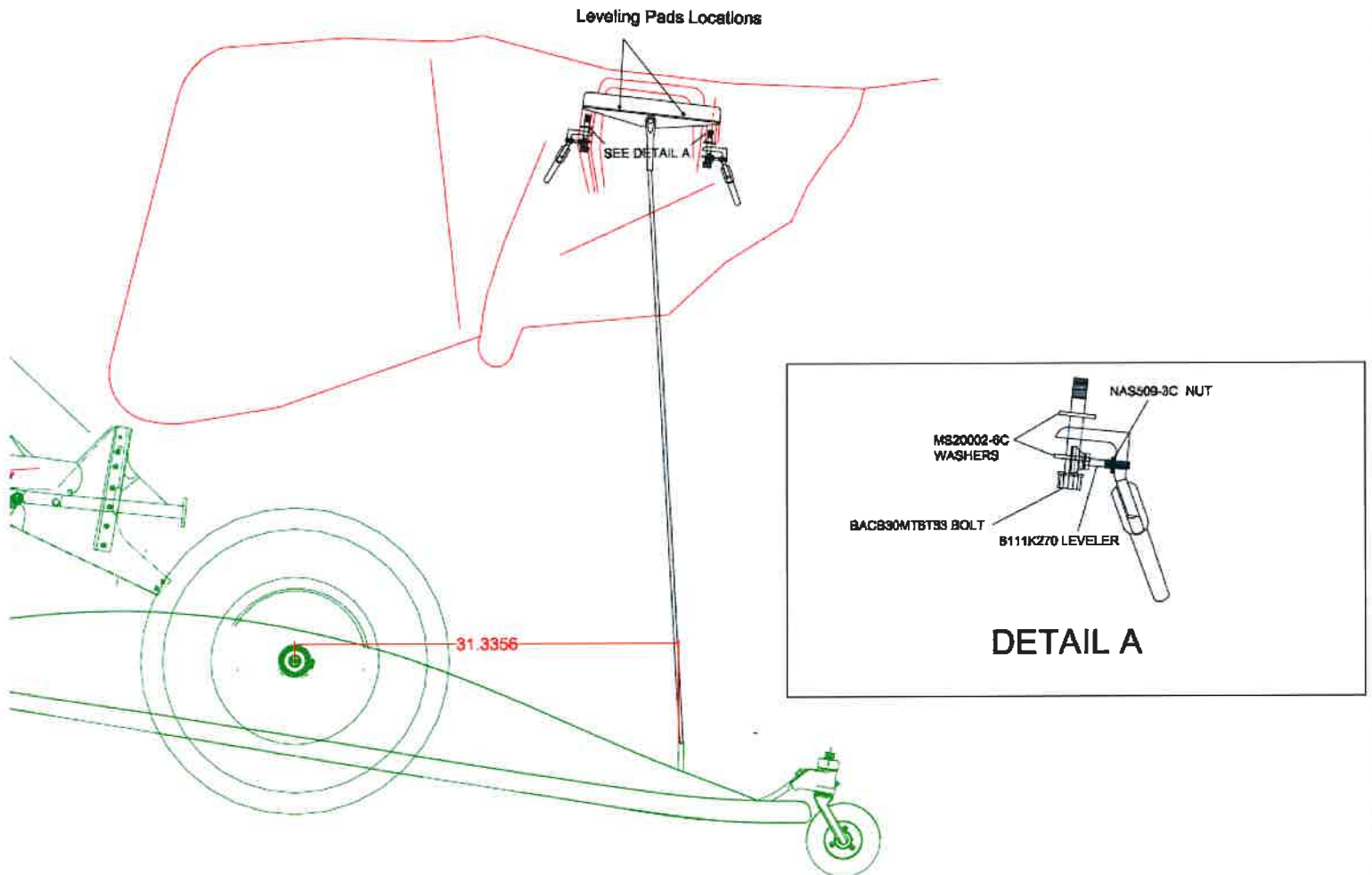


FIGURE 5.6

TAIL SKI – AXLE LOCATION AND ASSEMBLY

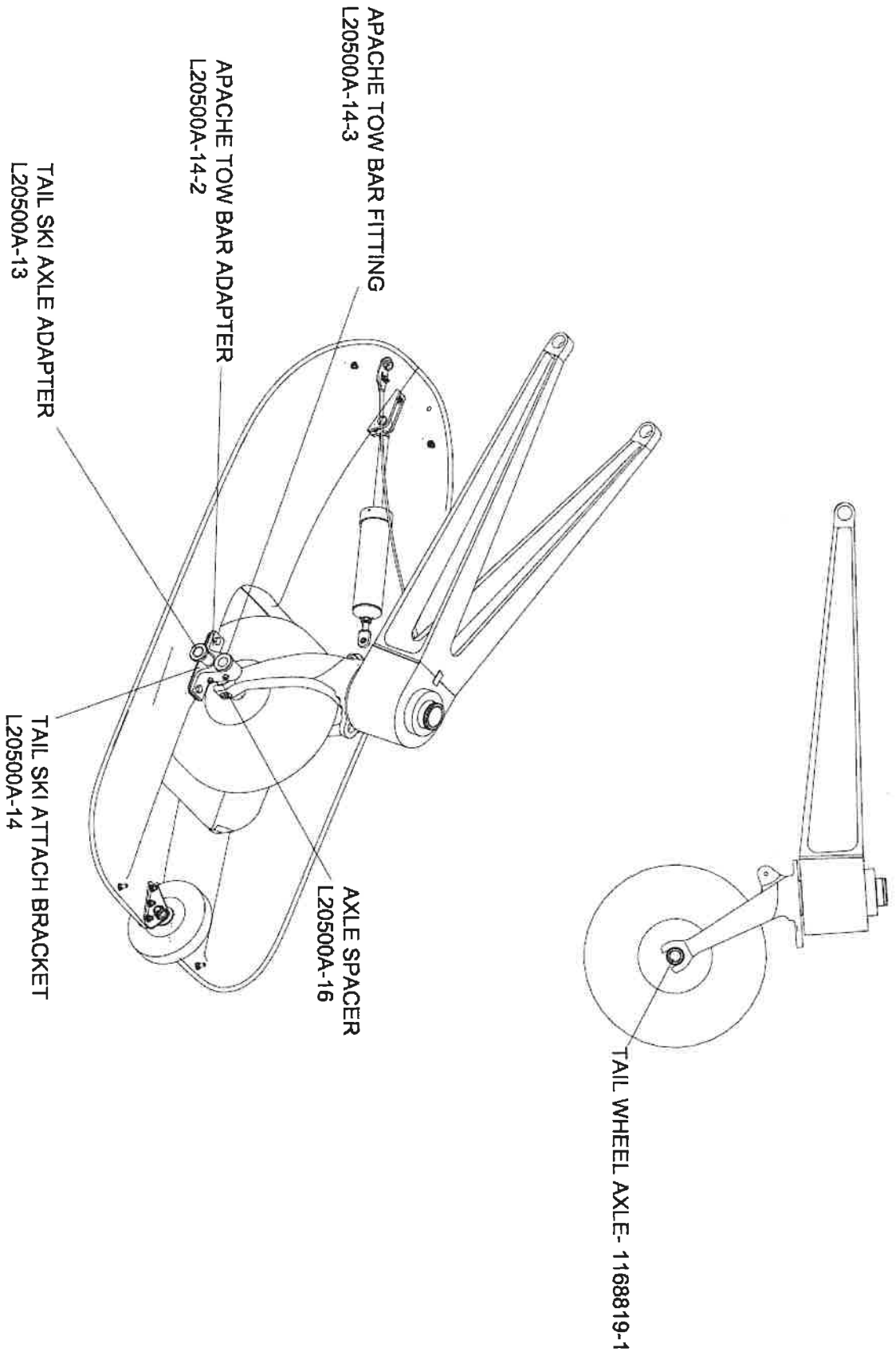


FIGURE 6.0

TAIL SKI – AXLE LOCATION AND ASSEMBLY

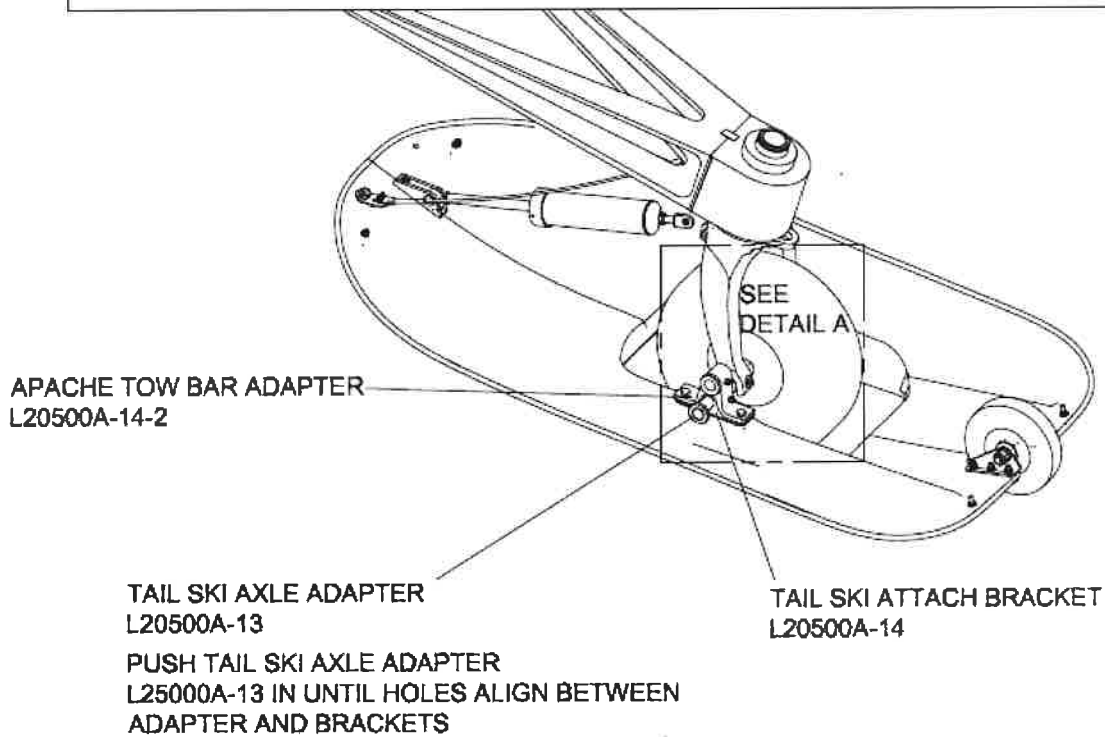
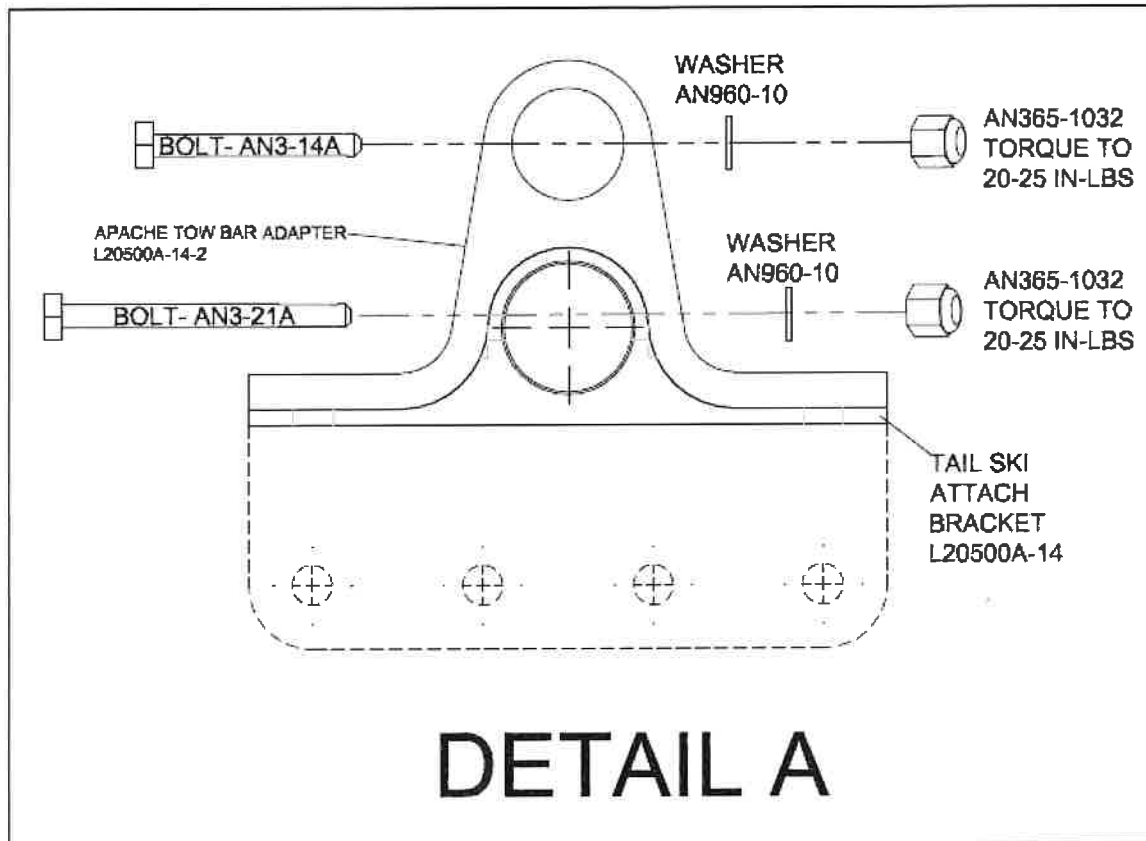


FIGURE 6.1

TAIL SKI – SPRING CYLINDER POSITIONING AND ASSEMBLY

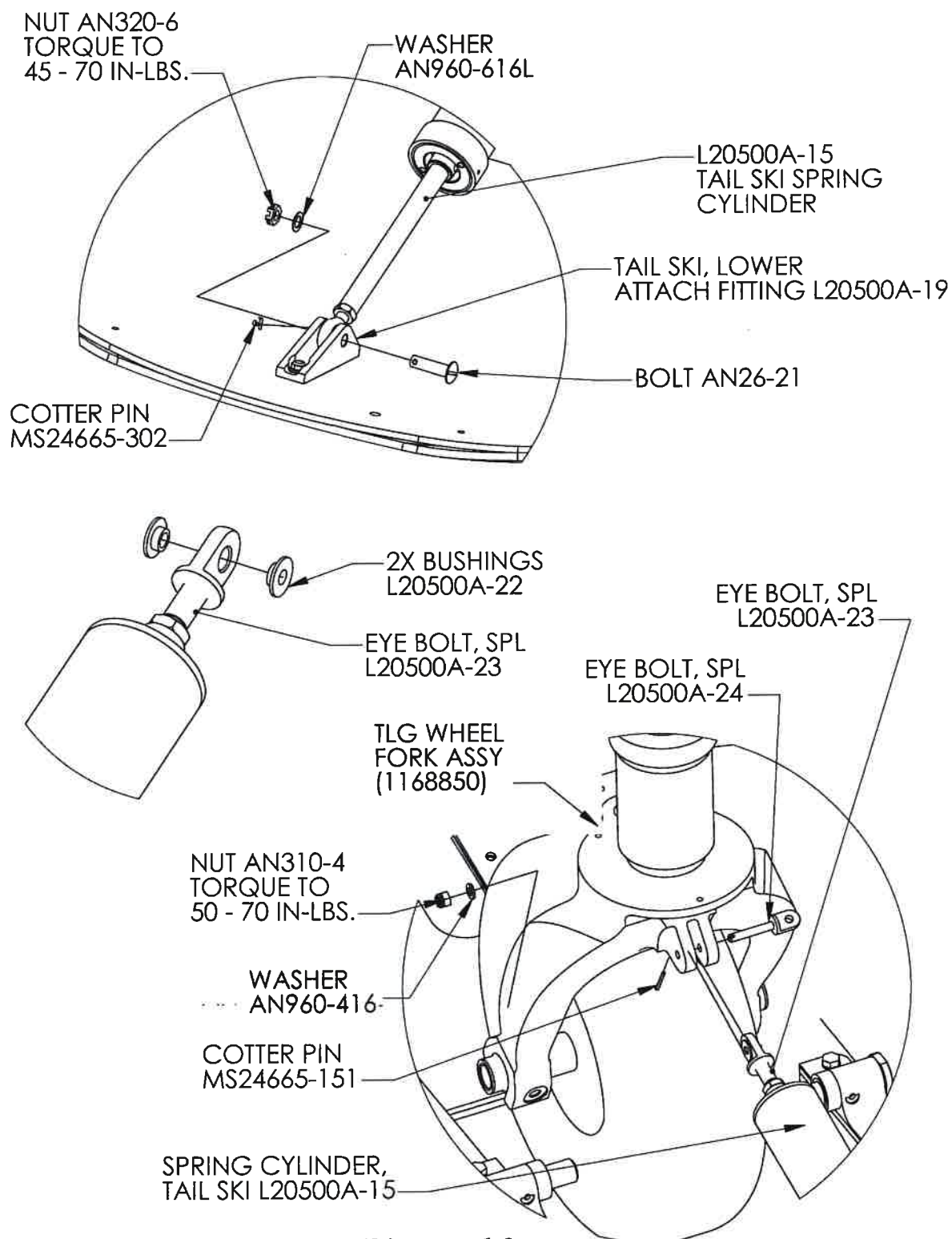


Figure 6.2

TAIL SKI – SAFETY CABLE ASSEMBLY

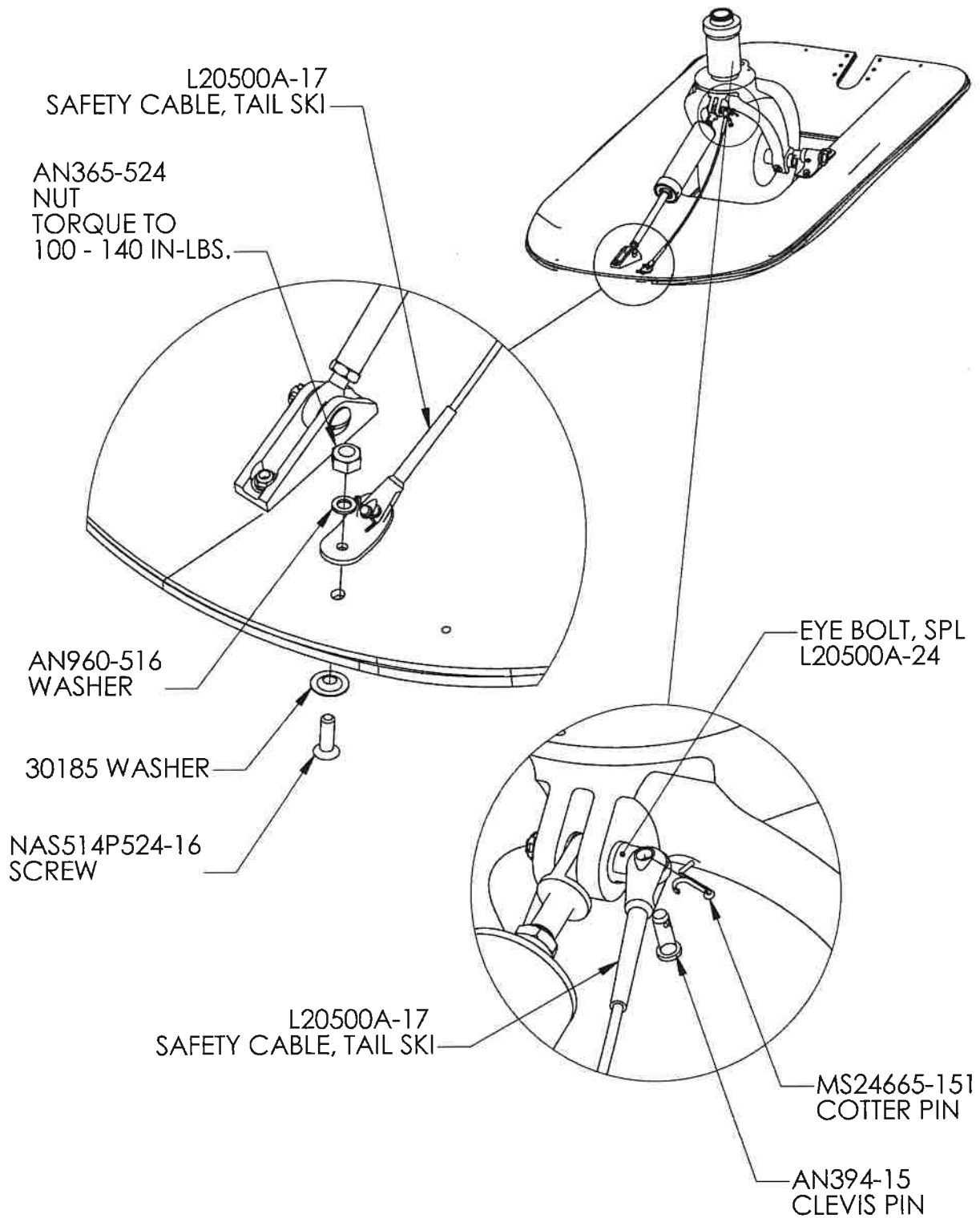


Figure 6.3

MAINTENANCE AND INSPECTION CRITERIA

Section 7.0 MAINTENANCE AND GROUND HANDLING RESTRICTIONS

1. **DO NOT** – Push or Pull on skis to move aircraft
2. **DO NOT** – Subject to flame or high heat
3. **DO NOT** - Attempt to jack aircraft with skis installed
4. **DO NOT** – Subject to harsh solvents or caustic chemicals
5. **DO NOT** – Use skis as a tie down for the aircraft
6. **DO NOT** – Disassemble the Main Ski Spring Cylinder (Airglas Part No.# L20500A-8)
7. **DO NOT** – Disassemble the Tail Ski Spring Cylinder (Airglas Part No.# L20500A-15)
8. **DO NOT** – Attempt to change a main gear tire with the skis installed
9. **DO NOT** – Attempt to change a tail gear tire with the skis installed
10. **DO NOT** – Use standard wheel chocks with skis installed

Section 8.0 MAINTENANCE OPERATIONAL CHECKS

10-14 Check (10 hour or 14 day inspection)

1. **CHECK** – Force required to move main ski tail wheel (Airglas Part No. # L20500-D501A) sideways, force shall be 3-5 lbs (22.24 Newtons).
2. **CHECK**- Main landing gear skis (if installed) inspect for cracks, excessive wear, fractures and abrasions. Security of spring cylinders. Main ski safety and check cables for security (Airglas Part No.# L20500A-12-1) & (Airglas Part No.# L20500A-11).
3. **CHECK** – Main landing gear ski tail wheel spring for damage and security (Airglas Part No. # L20500-D501A).
4. **CHECK**- Tail landing gear skis (if installed) inspect for cracks, excessive wear, fractures and abrasions. Security of the spring cylinder (Airglas Part No. # L20500A-15, Boeing Part No.# 7-511210303-003). Security of the safety cable No. (Airglas Part No. # L20500A-17). Security of the tail wheel assembly (Airglas Part No. # L20500-18).

Section 9.0 INSPECTION CRITERIA

500-Annual (500 hour or Annual inspection)

1. **INSPECT** – The main landing gear ski (Airglas Part No.# L20500A-01) for excessive cracks, wear, fractures and abrasions. Inspect the bottom for cracks, scratches and excess wear. If damaged consult manufacturer. Lubricate tail wheel fittings with SuperLube Synthetic Grease (PTFE).
2. **INSPECT** – The tail landing gear ski (Airglas Part No.# L20500A-03) for excessive cracks, wear, fractures and abrasions. Inspect the bottom for cracks, scratches and excess wear. If damaged consult manufacturer. Lubricate tail wheel fittings with SuperLube Synthetic Grease (PTFE).
3. **INSPECT** – The main landing gear safety cable (Airglas Part No.# L20500A-12) for integrity and fraying. The main landing gear check cable (Airglas Part No.# L20500A-11) for integrity and fraying. The main landing gear spring cylinder (Airglas Part No.# L20500A-8) for cracks, dents, wear, fractures and abrasions. The main landing gear bracket assembly (Airglas Part No.# L20500A-20 & 21) for integrity, cracks, dents and excessive wear.
4. **INSPECT**- The tail landing gear ski safety cable (Airglas Part No.# L20500A-17) for integrity and fraying. The tail landing gear spring cylinder (Airglas Part No.# L20500A-15) for cracks, dents, wear, fractures and abrasions.
5. **INSPECT**- The main landing gear ski axle (Airglas Part No.# L20500A-7 for cracks, dents and fractures. The main landing gear ski axle assemblies (Airglas Part No.# L20500A-5 and L20500A-6) for cracks, dents, fractures and thread integrity.
6. **INSPECT** –The tail landing gear ski axle adapters (Airglas Part No.# L20500A-13) for cracks, dents and fractures. The two (2) special eyebolts (Airglas Part No.#'s L20500A-24 & L20500A-23) for cracks and integrity.

MAINTENANCE TASKS

Section 10.0 MAINTENANCE TASKS

10.1 TOP SURFACE MAINTENANCE

The surface of the ski has a very durable plastic coating that is not affected by gas or oil or environmental conditions. It may be brightened up with rubbing compound and wax occasionally but should not require painting. (NOTE) Small hairline crack marks may appear in this coating at stress points. These do not affect the strength of the ski in any way and ARE NOT to be considered cracks as they are only in the surface coating and don't extend into the laminate.

10.2 BOTTOM SURFACE MAINTENANCE

1. The Teflon urethane coating allows maximum sliding in all snow conditions. No wax is required. Additional coats may be applied by brush or spray when necessary.
2. When bottom surface becomes excessively scratched or worn, it may be sanded down with a small belt or disc sander and re-coated with a brush application of the graphite filled epoxy resin coating 4B2. This is allowed to cure at room temperature and is then roughed up. Then it is coated with a Teflon urethane coating. A kit for this process is obtainable from manufacturer. If major repairs are necessary, manufacturer can advise on proper procedure.

TYPES OF POSSIBLE DAMAGE

A.) Negligible damage

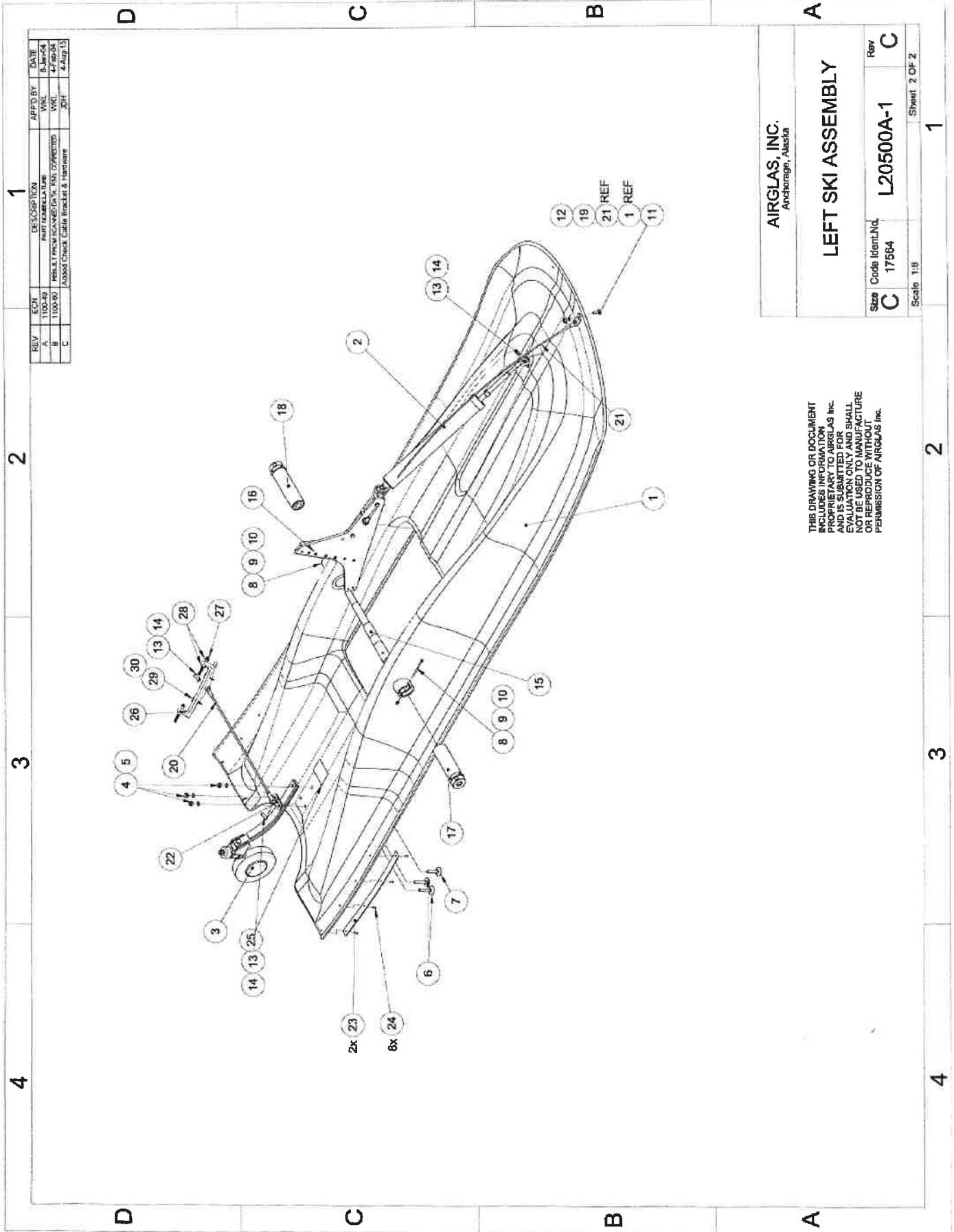
1. Small nicks, scratches or abraded areas in top or bottom of ski.

B.) Repairable damage

1. **Cracks or fractures** - except in area of ski bushing or spring cylinder attach points. Airglas should be consulted on repairs in this area.
2. **Delamination** - except in area of ski bushing and spring cylinder attach points. Airglas should be consulted on repairs in this area.
3. **Small holes** - max. 2" dia.
4. **Abrasion** - bottom wear due to contact with rocks etc., bottom coatings worn through to glass fibers.
5. **Demolished section** - if under 30% of the area of the ski and it must be confined to forward or aft 1/3 of ski. Consult Airglas for repair.
6. **Major bottom damage** - complete new or partial bottom may be factory installed.

C.) DAMAGE NECESSITATING REPLACEMENT

1. Major damage in area of ski bushings.
2. Damage to more than 30% of area of top of ski. This could be a combination of cracks, fractures, delamination, and demolished sections. This type of damage would be caused from a crash.



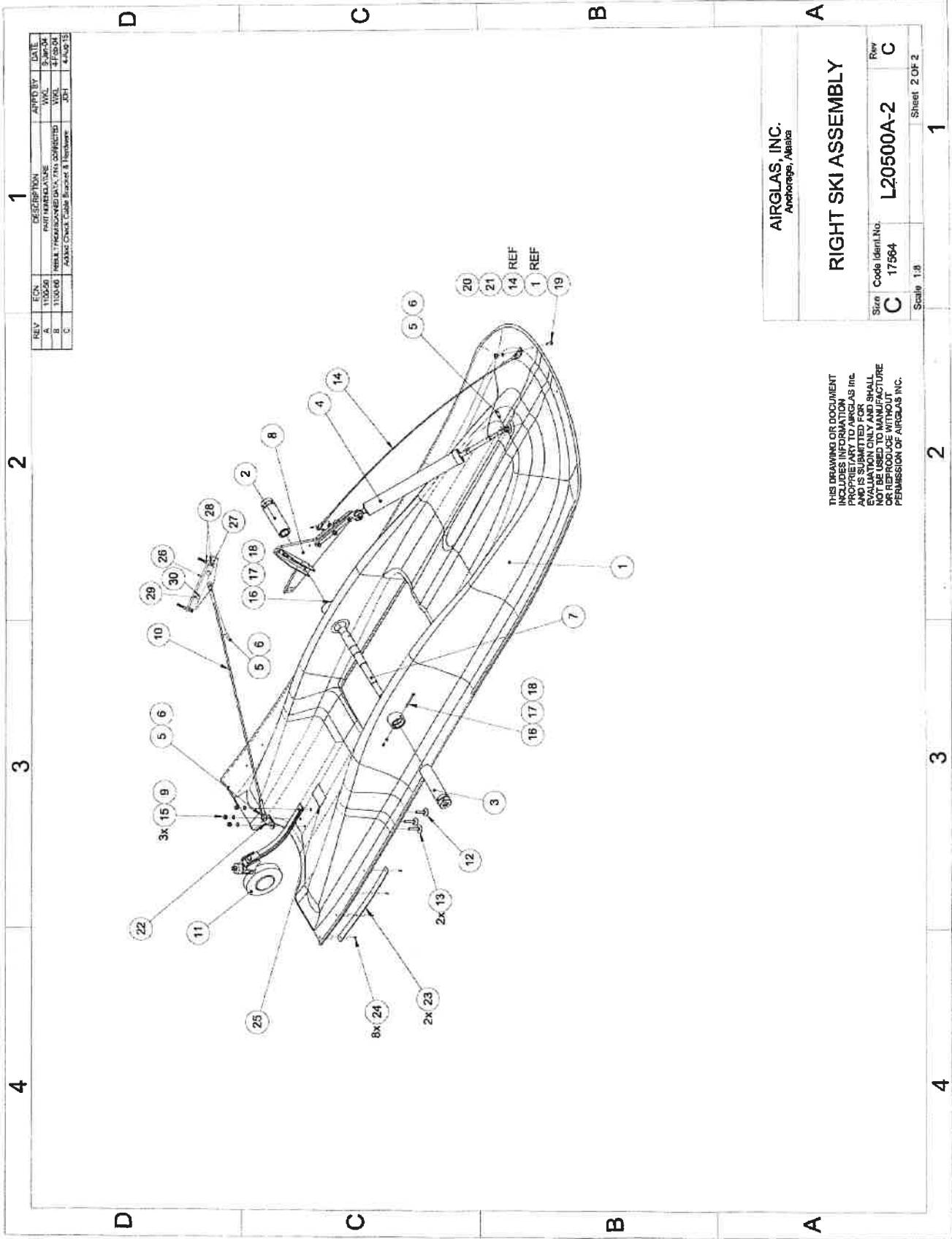
AIRGLAS, INC.
Anchorage, Alaska

LEFT SKI ASSEMBLY

Size	Code IdentNo.	Rev
C	17564	C
Scale 1:8 Sheet 2 OF 2		

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PERMISSION OF AIRGLAS INC.

NO.	QTY	CODE-IDENT-NO	PART NO.	DESCRIPTION	STOCK SIZE	MATERIAL
1	1	17564	L20500A-01	MAIN SKI		
2	1	17564	L20500A-8	SPRING CYLINDER, MAIN SKI		
3	1	17564	L20500-D501HD	TAIL WHEEL, ASSY (Heavy Duty)		
4	3		AN363-616	NUT		
5	3		AN960-616L	WASHER		
6	2	17564	EB616-24	ELEVATOR BOLT		
7	1	17564	EB616-22	ELEVATOR BOLT		
8	2		AN3-27A	BOLT		
9	2		AN960-10	WASHER		
10	2		AN365-1032	NUT		
11	1		AN5-6A	BOLT		
12	1		AN365-524	NUT		
13	3		AN396-23	CLEVIS PIN		
14	3		MS24665-302	COTTER PIN		
15	1	17564	L20500A-7	AXLE, MAIN LANDING GEAR		
16	1	17564	L20500A-21	BRACKET ASSEMBLY		
17	1	17564	L20500A-5	AXLE ASSY, INBOARD		
18	1	17564	L20500A-6	AXLE ASSY, OUTBOARD		
19	1		AN960-516L	WASHER		
20	1	17564	L20500A-11	CHECK CABLE		
21	1	17564	L20500A-12	SAFETY CABLE ASSY		
22	1	17564	L20500A-11-1A	SKI ANGLE BRACKET, L.H.		
23	2	17564	L20500-44	MAIN SKI RUNNER / L20500-44HD Is a Heavy Duty R		
24	8		SSB6-10	RIVET / USE AN509-10R-16 or MS24694S8, With MS21C		
25	1	17564		PLACARD		
26	1	17564	L20500A-11-3	CHECK CABLE BRACKET		
27	2		BACB30MT6T33	BOLT		



REV	ECN	DESCRIPTION	APPROVED	DATE
A	110050	INITIAL RELEASE	WVL	5-JUN-04
B	110050	REPAIR PROGRAMMED DATA, FWD CONNECTED	WVL	27-SEP-04
C		ADDED CHINESE CABLE BRACKET & HARDWARE	JOH	4-AUG-15

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Anchorage, Alaska

RIGHT SKI ASSEMBLY

Size	Code Ident. No.	Rev
C	17564	C
Scale 1:1		Sheet 2 OF 2

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REV	DATE	DESCRIPTION	APPROVED
A	1/15/04	REVISIONS	WKL
B	1/15/04	REVISIONS	WKL
C	1/15/04	REVISIONS	WKL
D	1/15/04	REVISIONS	WKL

WKL: 10/15/03 09:00 AM

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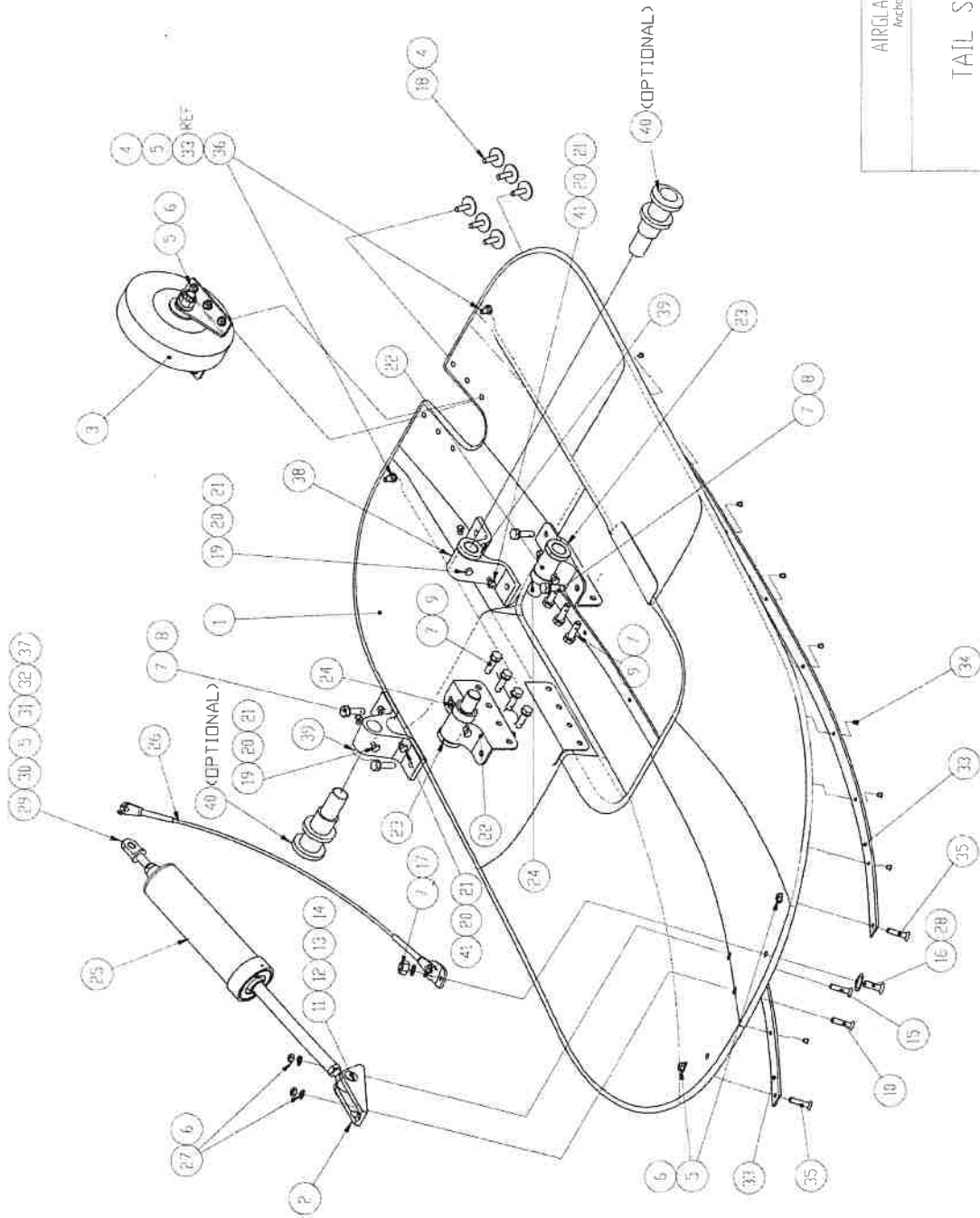
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NO.	QTY	CODE	DESCRIPTION	STOCK SIZE	MATERIAL	MATERIAL SPEC	WEIGHT/LBS	FINISH	ZONE
3	1	17564	MAIN SKI						
2	1	17564	AXLE ASSY. INBOARD						
3	1	17564	AXLE ASSY. OUTBOARD						
4	1	17564	SPRING CYLINDER, MAIN SKI						
5	3	17564	COTTER PIN						
6	3	17564	CLEVIS PIN						
7	1	17564	AXLE, MAIN LANDING GEAR						
8	1	17564	BRACKET ASSEMBLY						
9	3	17564	WASHER						
10	1	17564	CHUCK CAM						
11	1	17564	TAIL WHEEL ASSY (Heavy Duty)						
12	1	17564	ELEVATOR BOLT						
13	2	17564	ELEVATOR BOLT						
14	1	17564	SAFETY CABLE ASSY						
15	3	17564	NUT						
16	2	17564	BOLT						
17	2	17564	WASHER						
18	2	17564	NUT						
19	3	17564	BOLT						
20	1	17564	NUT						
21	3	17564	WASHER						
22	1	17564	SKI ANGLE BRACKET, R/L						
23	2	17564	MAIN SKI RUNNER / L20500-44HD is a Heavy Duty Runner. L20500-44HD has countersunk holes in it.						
24	8	17564	RIVET / USE AN509-10R-14 or MS24646-3, WITH MS21042-3 NUT on Heavy Duty Runner						
25	1	17564	PLACARD						
26	1	17564	Check Cable Bracket						
27	2	17564	BOLT						
28	4	17564	WASHER, BEVELED						
29	2	17564	SS LEVELER						
30	3	17564	NUT						

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES EXCEPT AS NOTED:
FRACTIONS DECIMALS ANGLES
1/16 1/32 1/64 1/8 1/4 1/2 3/4 1 1 1/2 2 3 4 5 6 8 10 12 14 16 18 20 22 24 26 28 30 32 34 36 38 40 42 44 46 48 50 52 54 56 58 60 62 64 66 68 70 72 74 76 78 80 82 84 86 88 90 92 94 96 98 100 102 104 106 108 110 112 114 116 118 120 122 124 126 128 130 132 134 136 138 140 142 144 146 148 150 152 154 156 158 160 162 164 166 168 170 172 174 176 178 180 182 184 186 188 190 192 194 196 198 200 202 204 206 208 210 212 214 216 218 220 222 224 226 228 230 232 234 236 238 240 242 244 246 248 250 252 254 256 258 260 262 264 266 268 270 272 274 276 278 280 282 284 286 288 290 292 294 296 298 300 302 304 306 308 310 312 314 316 318 320 322 324 326 328 330 332 334 336 338 340 342 344 346 348 350 352 354 356 358 360 362 364 366 368 370 372 374 376 378 380 382 384 386 388 390 392 394 396 398 400 402 404 406 408 410 412 414 416 418 420 422 424 426 428 430 432 434 436 438 440 442 444 446 448 450 452 454 456 458 460 462 464 466 468 470 472 474 476 478 480 482 484 486 488 490 492 494 496 498 500 502 504 506 508 510 512 514 516 518 520 522 524 526 528 530 532 534 536 538 540 542 544 546 548 550 552 554 556 558 560 562 564 566 568 570 572 574 576 578 580 582 584 586 588 590 592 594 596 598 600 602 604 606 608 610 612 614 616 618 620 622 624 626 628 630 632 634 636 638 640 642 644 646 648 650 652 654 656 658 660 662 664 666 668 670 672 674 676 678 680 682 684 686 688 690 692 694 696 698 700 702 704 706 708 710 712 714 716 718 720 722 724 726 728 730 732 734 736 738 740 742 744 746 748 750 752 754 756 758 760 762 764 766 768 770 772 774 776 778 780 782 784 786 788 790 792 794 796 798 800 802 804 806 808 810 812 814 816 818 820 822 824 826 828 830 832 834 836 838 840 842 844 846 848 850 852 854 856 858 860 862 864 866 868 870 872 874 876 878 880 882 884 886 888 890 892 894 896 898 900 902 904 906 908 910 912 914 916 918 920 922 924 926 928 930 932 934 936 938 940 942 944 946 948 950 952 954 956 958 960 962 964 966 968 970 972 974 976 978 980 982 984 986 988 990 992 994 996 998 1000 1002 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AIRGLAS, INC.
Anchorage, Alaska

TAIL SKI ASSEMBLY

Size	Case Ident.	Rev
C	17564	B
Scale	1:1	Sheet 2 of 2

REMOVAL OF SKISPROCEDURE

The best method to remove the L20500A Ski kit is to remove the Tail Ski (L20500A-3) first.

Tail Ski Removal Procedure:

1. Remove Bolts (AN4-7A), Washers (AN960-416), and Nuts (A365-428), (and NAS70C-4 Washers) holding tail ski, Tail Wheel Bracket Kit (L20500-18) to ski and remove Tail Wheel Bracket Kit. *See Figure 2.0* (retain hardware)
2. Remove Cotter pin (MS24665-151), Washer (AN960-416) and Nut (AN310-4) from Eye Bolt (L20500A-24) attached to TLG wheel fork assembly lugs 1168850.
3. Hold the Spring Cylinder in one hand, lift the front of the ski, and remove the L20500A-24 from TLG lug. Retain the upper Spring Cylinder Eye Bolt (L20500A-23) and Bushings. After removal from the TLG lug, loosely reinstall the L20500A-24 back into the L20500A-23 Eyebolt, using the Washer (AN960-416) and Nut (AN310-4). Note: The Safety cable (L20500A-17) can remain attached to eyebolt (L20500A-24) for storage. *See Figure 6.2*
4. Remove Bolt(s) (AN3-21A) lower bolts of Apache Tow Bar Adapter (L20500A-14-2). Retain Bolt, Washer(s) (AN960-10) and Nut(s) (AN365-1032). *See page 29& 30 of Manual for Breakdown of parts*
5. Remove Tail Ski Axle Adapter(s) (L20500A-13) from Ski Attach Bracket(s), remove Axle Spacer(s) (L20500A-16) on Tail Ski Axle Adapter(s). *See page 29& 30 of Manual for Breakdown of parts*
6. Remove Ski Axle Adapter (s) (L20500A-13) from Tail Ski Axle. Use care in holding up ski during this step.
7. Once ski is completely removed from tail landing gear, connect tow vehicle to standard axle location.
8. Tow helicopter backwards until the wheel rolls over and out of tail ski.
9. Re-Install Tail Wheel Bracket Kit (L20500-18) onto tail ski. *See Figure 2.0*
10. Reinstall a Wire Strike (Deflector) onto Tail Landing Gear using all hardware identified in Helicopters Illustrated Parts Breakdown (IPB).

Main Ski Removal Procedure:

NOTE: Preparation of both skis is the same except where noted.

11. Remove Tail Wheel Assembly and Check Cable from rear of the Main Ski by removing Elevator Bolts (EB616-20, EB616-21) from the bottom of the ski *See figure 1.1* Save all hardware for future use.
12. Remove bolt(s) (AN3-27A) from Inboard and Outboard Axles and Ski Bushing. Retain Washer(s) (AN960-10) and Nut(s) (AN365-1032) onto bolt(s) *See Figure 5.2*.
13. Remove Spring Cylinder, Main Ski (L20500A-8) from Upper Mounting Bracket (L20500A-21-3), retain Clevis Bolt (AN26-25), (2) Washers (AN960-616L) and Nut (AN320-6), (4) Special Washers (P/N 528D378D050 (2 each side of rod end). *See Figure 5.3*
14. Remove upper end of Safety Cable Assy. (L20500A-12) from to Eye Bolt (AN45-11) at 2nd hole back on Bracket Assy. (P/N L20500A-20, L20500A-21) Retain clevis pin (AN395-17) and cotter pin MS249665-302. *See Figure 5.5*
15. Completely remove Axle Assy's., Inboard & Outboard (L20500A-5 & L20500A-6) from Main Ski Bushing Assy. (L20500-4) . Lift Rear of ski to take weight off of axles. *See Figure 5.1* Note: Assistance will be needed to support ski during this operation.
16. Remove Check Cable (L20500A-11) from check cable bracket, PN L20500A-11-3 by removing Clevis Pin and Cotter Pin.
17. Install Airglas installation ramps on both main skis. Ensure all attachments to gear are removed.

18. Tow helicopter or push helicopter aft with help of assistants until the main wheels are completely outside of skis. CAUTION – To avoid damage to ski take extreme care to ensure that the wheels are on the outboard part of the wheel wells. *See Figure 5.0*
19. Re-Install Tail Wheel Assembly (L20500-D501A) *See Figure 1.1*
20. Once ski is removed, continue to remove other hardware as needed. If skis are only removed for maintenance or other issues, all remaining hardware can remain installed on helicopter.

RETURNING AIRCRAFT TO ORIGINAL CONFIGURATION (WITHOUT SKIS)

21. Remove Axle (L20500A-7) from Trailing Arm (1168320-101). Remove bolt, and slide axle out by rotating and pulling on it. Retain existing hardware for later install of Jack Pad (1168321-1) . *See Figure 3.2*
22. Install Jack Pad (1168321-1) and align with Trailing Arm (1168320-101), using hardware from Step 21 above. Torque to value given in Figure 3.2
23. Remove both inboard pylons.
24. Remove inboard attach bolts and check cable bracket (L20500-11-3).
25. Install original HS6170V6-22 bolts back into inboard pylon.
26. Re-install pylon. Match torque of existing pylon bolts.
27. Remove Step Assembly (7-511113527-1 & -2). Keep existing hardware for future use. *See figure 3.0.*
28. Remove Airglas Bracket Assembly (L20500A-20 R.H., L20500A-21 L.H.) to Main Landing Gear, retain existing hardware *See Figure 3.1*
29. Install Wire Cutter Assembly (443-83020-2). *See figure 3.0*, Bolt Wire Cutter to Clamp (443-83023-1) (both sides) using existing hardware from Step 28. *See Figure 3.1*
30. Re-install Step Assembly (7-511113527-1 & -2) to Wire Cutter Assembly using existing hardware from Step 27. *See Figure 3.1 inboard .*