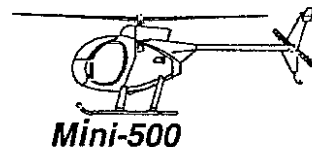




# REVOLUTION

HELICOPTER CORP., INC.



1905 W. Jesse James Rd. • Excelsior Springs, Missouri 64024  
Phone (816) 637-2800 • Fax (816) 637-7936

September 28, 1995

Service information letter #092695

Subject: Rotor head shims

1. The rotor head shims part number 0697 that are included in your kit, provide a means of shifting the rotor head to correct for an out of balance condition. At present the shims provided will allow the head to be shifted a maximum of .005 inches. Experience gained from dynamically balancing several rotor systems has shown that it may require more than the allowed .005 shift. We have added (8) .005 shims part number 0709 which when installed as prescribed below will allow the rotor head to be shifted a total of .025 inches.
2. The two rotor head teeter spacer bushings #0010 must have .020 inches machined off to bring them to the dimensions called for on the provided print. You may either have a local machine shop do this or you may send them to Revolution helicopter and we will do the modification at no charge and send them back. You will be responsible for shipping charges. Re-plating is not necessary if you apply a corrosion preventative to the part during installation.
3. After part number 0010 is machined to the correct dimensions, temporarily slide #0010 onto the spud on #0009 as shown in the exploded view of the rotor head. Then slip the hub plate #0012 onto the spud **with no shims**, (simulating a maximum shift condition). If the spud on #0009 protrudes past the bearing in #0012, then the spud must be ground off until it no longer protrudes past the bearing. This must be accomplished or the bearing will not tighten down completely if the maximum of .025 shift is needed. A small 90 deg. die grinder or similar tool works well. Repeat this process for the other spud.
4. Assemble the rotor head as shown in the exploded view.

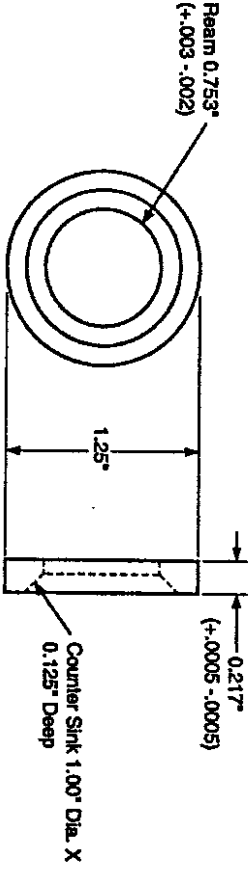
If you have any questions please contact Brian Thomas at (816) 637-2800.

Note: All Dimensions And  
Tolerances Are After Surface  
Finishing, Poling, Or Anodizing

Metric Projection

UNLESS OTHERWISE SPECIFIED  
XX ± 0.10"  
XXX ± 0.05"  
ANODIZING ± 0.005"  
MACHINED SURFACES 125° MAX  
GROUND SURFACES 90° MAX  
BREAK SHARP EDGES 0.05" R 0.10"

CONFIDENTIAL



**NOTE:**  
Tumble Deburr To Remove Machining  
Marks, Sharp Corners And Burrs.  
Electrolysis Nickel Plate 0.0005 To  
0.001 Dychromate Seal

**REVOLUTION Helicopter Corp. Inc.**  
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Excelator Springs, Mo. 64024  
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Scale: (1"=1")	Approved By:	Drawn By: D.F.
Date: 07/13/95	Checked:	Revised:
Description: MinH-500 / RH Teeter Spacer Bushing 2 each		
1.25" Dia. 4130 Steel Bar Stock	Drawing Number:	#0010