

**ALERT SERVICE BULLETIN**

**Bell Helicopter** **TEXTRON**  
A Subsidiary of Textron Inc.

**NO.** 230-01-24

**DATE** 05-18-01

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<b>DATE</b>
<b>REV</b>

**MODEL AFFECTED:** Model 230

**SUBJECT:** MAIN ROTOR PENDULUM WEIGHT SUPPORT  
P/N 222-011-114-103, REPLACEMENT OF

**HELICOPTERS AFFECTED:** Model 230 Serial Number 23001 through 23038

**COMPLIANCE:** Within 25 hours of operation after receipt of this  
bulletin but no later than December 31, 2001

**DESCRIPTION:**

Bell Helicopter has recently been made aware of an incident where one of the main rotor pendulum weight support P/N 222-011-114-103 failed shedding the pendulum weight set in flight. An increase in rotor vibration levels had been observed by the flight crew before the failed support was found. Mission was completed and aircraft was landed safely.

Subsequent investigation revealed that the failed support had manufacturing discrepancies. Further investigation revealed that all supports P/N 222-011-114-103 identified with a serial number having the prefix "HD" are suspect and will require replacement. Since 1995, BHT has been using another vendor for machining of the main rotor pendulum weight supports.

This bulletin provides procedures for replacement of all main rotor pendulum weight supports identified with a serial number having the prefix "HD".

**APPROVAL:**

Not Required

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AN APPROPRIATE ENTRY SHOULD BE MADE IN THE AIRCRAFT LOG BOOK UPON ACCOMPLISHMENT  
IF OWNERSHIP OF AIRCRAFT HAS CHANGED PLEASE FORWARD TO NEW OWNER

**MANPOWER:**

Approximately 6.0 man-hours are required to complete this bulletin if all four pendulum weight supports require replacement. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

**WARRANTY:**

Owners/operators of 230 helicopters who comply with the instructions outlined in this bulletin will receive a special 100% warranty credit for the kit contained in the "Required Material" section of this bulletin.

To receive this credit:

- Purchase the required parts from an approved BHTI supply source.
- Comply with the instructions contained in this bulletin no later than December 31, 2001.
- Submit a completed malfunction report to BHTI Warranty no later than 30 days after completion of this bulletin.

-NOTE-

Customers who fail to comply with the instructions outlined in this bulletin prior to December 31, 2001 will not be eligible for the special warranty credit provisions listed above.

**MATERIAL:**

**Required Material:**

The following material is required for the accomplishment of this bulletin and may be obtained through your Bell Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
222-011-114-103	Support	4
MS21042L5	Nut	8
MS21042L6	Nut	4
NAS1149F0563P	Washer	8
NAS1351C4LE20	Screw	16
NAS6605-21	Bolt	8
140-009D25S42	Washer	4
140-009E17S25	Washer	16

**Note:** Material quantities shown is sufficient for the replacement of all four pendulum weight supports. However, the actual quantities required will vary depending on the number of affected supports (serial number having the prefix “HD”) installed on the aircraft.

**Consumable Material:**

The following material is required to accomplish this bulletin, but may not require ordering, depending on the operator’s consumable material stock levels. This material may be obtained through your Bell Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>	<u>Reference</u>
GSC137-2 *	Primer	1	C-202
MIL-C-16173,GR1 2OZ	COR PREV	1	C-101
MIL-C-16173,GR2 6OZ	COR PREV	1	C-104
299-947-100TY2CL2G50	Adhesive	1	C-317

\* Same as MIL -P-23377 Type 1 Class C primer.

**Note:** Consumable material quantities shown is sufficient for the replacement of all four-pendulum weight supports.

**SPECIAL TOOLS:**

None required

**WEIGHT AND BALANCE:**

Not affected

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-230-MM-6, chapter 62-99-00  
BHT-230-CR&O-2, chapter 62-00-00

**PUBLICATIONS AFFECTED:**

None affected

**ACCOMPLISHMENT INSTRUCTIONS:**

**-NOTES-**

The part and serial numbers of the pendulum weight support are vibro etched on the outboard surface of one tang of the support in the area of the two attachments bolt holes.

The pendulum weight supports are time life components therefore serial numbers are recorded in the aircraft historical records (hard cards).

Main rotor pendulum weight support P/N 222-011-114-101 is not affected by this Alert Service Bulletin.

1. Determine the serial number of the pendulum weight supports installed on aircraft.

**-NOTE-**

Main Rotor dynamic balance may require adjustment following pendulum weight support replacement

**-NOTE-**

Removal of main rotor blades is NOT required to replace pendulum weight supports

2. Replace any pendulum weight support P/N 222-011-114-103 that have a serial number with the prefix "HD". Refer to procedures in chapter 62-00-00 of BHT-230-CR&O-2.
3. Return affected pendulum weight support P/N 222-011-114-103 with completed Malfunction Report to:  
  
Bell Helicopter Textron Inc.  
Logistics Center  
3000 S. Norwood  
Hurst, Texas 76053  
Attn: CPR Monitor (Warranty Return)
4. Annotate applicable historical card.
5. Annotate aircraft records to reflect compliance with this bulletin.