MODEL AFFECTED: **206L SERIES**

SUBJECT: **HORIZONTAL STABILIZER 206-023-119-167, INSPECTION AND REPLACEMENT OF**

HELICOPTERS AFFECTED: **All Model 206L4 listed in Table 1 and all model 206L series that had the stabilizer 206-023-119-167 replaced after March 01, 2004.**

TABLE 1: List of affected horizontal stabilizers 206-023-119-167 and the helicopter serial number they were installed on at delivery

STABILIZER S/N	ORIGINAL ALLOCATION	STABILIZER S/N	ORIGINAL ALLOCATION
BP1516	52288	BP1607	**Note**
BP1519	52283	BP1608	**Note**
BP1521	52284	BP1610	52315
BP1530	52286	BP1612	52312
BP1533	52293	BP1615	52313
BP1536	52290	BP1622	52314
BP1539	52289	BP1629	**Note**
BP1542	52291	BP1630	52316
BP1560	52300	BP1631	52318
BP1566	52298	BP1634	52317
BP1569	52299	BP1643	52319
BP1572	52301	BP1646	52320
BP1584	**Note**	BP1659	**Note**
BP1587	**Note**		

NOTE:
These stabilizers were sold in Spare and may have been installed on any fielded 206L series

COMPLIANCE:

PART I AND PART II

Within the next 100 hours but no later than 30 days after receipt of this bulletin and every 600 hours or annual inspection thereafter until PART III is accomplished.

PART III

No later than September 30, 2008.

DESCRIPTION:

It has been determined by Bell Helicopter that the horizontal stabilizers 206-023-119-167 as listed in Table 1, may have flaws present on the inside surface of the upper and/or lower skin at the tailboom attachment inserts area. Over time the flaws may produce cracks in the upper and/or lower skin

PART I of this bulletin provides instructions to verify the serial number of the horizontal stabilizer.

PART II of this bulletin introduces a first inspection and a recurring 600 hour / annual inspection that have to be performed until PART III can be accomplished.

PART III of this bulletin mandates the replacement of all affected stabilizers. This will be considered as the terminating action for the recurring inspection introduced by PART II of this bulletin

APPROVAL:

The engineering design aspects of this bulletin are Transport Canada approved.

MANPOWER:

Approximately 2.5 man-hours are required to complete Part I of this bulletin.
Approximately 4.0 man-hours are required to complete Part II of this bulletin. Approximately 8.0 man-hours are required to complete Part III of this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

WARRANTY:

Owner / Operators of aircraft that have the subject serial numbers installed on their aircraft or that have the one or more of the subject serial numbers in their stock that comply with the instructions outlined in this bulletin are eligible for 100% credit for the replacement part mentioned in the “Required Material” section of this bulletin.

To Receive This Credit:

- Purchase the required part from an approved BHTI supply source.
- Comply with this bulletin no later than 30 September, 2008.
- Submit a completed MMIR report to BHTI no later than 30 days after completion of this bulletin.

Customers that fail to comply with the instructions outlined in this bulletin before September 30, 2008 are not eligible for the special warranty provisions listed above.

Exclusions To Warranty:

Warranty consideration for parts found in the “Consumable Material” section of this bulletin and labor to inspect or remove and replace the horizontal stabilizer are not a subject of this ASB.

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.

Part Number	Nomenclature	Quantity
206-023-119-167	Horizontal stabilizer	1

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.

Part Number	Nomenclature	Quantity	Reference
EC2216 B/A TAN N/S	Adhesive	1	C-322
299-947-100TY2CL2G50	Adhesive	50 g	C-317
MIL-PRF-81733 TY2 PT	Sealant	1 pint	C-392
ACETONE GALLON	Acetone (per Q-A-51)	l gallon	C-316(Note 1)
EWDE072	Primer	1 quart	C-204(Note2)
299-947-110TY3CL1 2I	Teflon tape (2 inch wide)	1 roll	C-460
PETROLATUM 13 OZ	Petrolatum jelly	13 oz	C-008
P-P-101	Aluminum oxide sandpaper	1	C-423
CCCC0046	Cheesecloth	1	C-486

Notes:
1. As an alternate, use Methyl Ethyl Ketone (C-309)
2. As an alternate, use MIL-P-23377

SPECIAL TOOLS:

None required

WEIGHT AND BALANCE:

Weigh and balance is not affected.

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-206L-MM-5, Maintenance Manual, chapter 53
BHT-206L1-MM-5, Maintenance Manual, chapter 53
BHT-206L3-MM-5, Maintenance Manual, chapter 53
BHT-206L4-MM-5, Maintenance Manual, chapter 53
TB 206L-00-203 Horizontal Stabilizer Supports 206-023-131-ALL, Installation of

PUBLICATIONS AFFECTED:

BHT-206L-MM-1, Maintenance Manual, chapter 4
BHT-206L1-MM-1, Maintenance Manual, chapter 4
BHT-206L3-MM-1, Maintenance Manual, chapter 4
BHT-206L4-MM-1, Maintenance Manual, chapter 4

ACCOMPLISHMENT INSTRUCTIONS:

PART I: Horizontal stabilizer serial number verification

1. Determine if you have an affected horizontal stabilizer as listed in Table 1. Refer to Figure 1. Part number and serial number can be found on identification tag (30) that is located in the middle section of the trailing edge of the stabilizer (7).

-NOTE-

Horizontal stabilizer does not require to be removed from tailboom.

-NOTE-

Do not damage liquid shim compound between the lower supports (14) and stabilizer (7). If liquid shim is damaged during removal of the parts, the shimming procedure shall be repeated as described in TB 206L-00-203.

2. Remove the screws (11) and the washers (12) from the L/H and R/H lower supports (14).

3. Remove L/H and R/H lower supports (14).

4. Remove screws (2) and the washers (3) attaching R/H finlet (1) to stabilizer (7).

5. Disconnect position light wiring and carefully remove R/H finlet (1) from stabilizer (7).

6. Remove nut (28), washers (27) and bolt (26). Detach control tube (29) from horn (19).

7. Remove the three screws (23) and washers (24) from support (32).

8. Remove the two screws (6) and washers (5) from the L/H fitting (4). Removal of the fitting (4) will allow the L/H and R/H elevator to move backward as an assembly and permit its removal without the requirement to remove the L/H finlet (1).

CAUTION

Do not drop the fitting (4) during the removal of the elevator (10) because it is free to move at the end of elevator (10).

9. Slide elevator (10) aft until it clears the two pins (9) and remove the L/H and R/H elevator (10) as an assembly.

10. Carefully remove the minimum amount of sealant covering the wiring and get access to the identification tag (30). Record the serial number.

11. If the serial number of the stabilizer is not listed in Table 1, reinstall the elevator (10) and stabilizer (7) as follows and make an entry to indicate that this bulletin has been accomplished.

    a. Position the fitting (4) at the end of L/H elevator (10). Slide the elevator assembly (10) through the tailboom opening and move forward assuring proper mating of pin (9) with hole provided in elevator (10).

    b. Attach L/H fitting (4) to fin (1) with washers (5) and screws (6).

    c. Attach support (32) to support (25) with the three washers (24) and screws (23).

    d. Attach control tube (29) to horn (19) with bolt (26) washers (27) and nut (28).

    e. Connect position light wiring and reinstall R/H finlet (1) with washers (3) and screws (2).

    f. Reinstall the L/H and R/H lower supports (14) with washers (12) and screws (11).

12. If you have an affected horizontal stabilizer, accomplish Part II immediately or Part III if a replacement stabilizer is available.

PART II: Horizontal stabilizer – First inspection and recurring 600 hour / annual inspection

1. Refer to figure 1. Inspect the horizontal stabilizer (7) as follows:

-NOTE-

Horizontal stabilizer does not require to be removed from tailboom.

-NOTE-

Do not damage liquid shim compound between upper and lower supports (13 and 14) and stabilizer (7). If liquid shim is damaged during removal of the parts, the shimming procedure shall be repeated as described in TB 206L-00-203.

2. Remove the screws (11) and the washers (12) from the L/H and R/H lower supports (14).

3. Remove L/H and R/H lower supports (14).

4. Refer to Figure 1 Detail B. Clean and prepare lower surface of the stabilizer for inspection using cheesecloth (C-486) moistened with acetone (C-316).

5. Inspect stabilizer in area of the inserts (31), on the lower surfaces for cracks and deformation using a 10X power magnifying glass. Inspect the area around each inserts and between inserts for debonding using tap test method.

6. If any damage is found, the stabilizer is not repairable. Accomplish Part III immediately.

7. If no damage is found, reinstall L/H and R/H lower supports (14) with screws (11) and washers (12).

8. Remove the screws (11) and the washers (12) from the L/H and R/H upper supports (13).

9. Remove L/H and R/H upper supports (13).

10. Refer to Figure 1 Detail B. Clean and prepare upper surface of the stabilizer for inspection using cheesecloth (C-486) moistened with acetone (C-316).

11. Inspect stabilizer in area of the inserts (31), on the upper surfaces for cracks and deformation using a 10X power magnifying glass. Inspect the area around each inserts and between inserts for debonding using tap test method.

12. If any damage is found, the stabilizer is not repairable. Accomplish Part III immediately.

13. If no damage is found, reinstall upper supports (13) with screws (11) and washers (12).

14. Make an entry in the helicopter records to indicate that Part II of this bulletin has been accomplished and that a recurring 600 hour or annual inspection is required until Part III is accomplished.

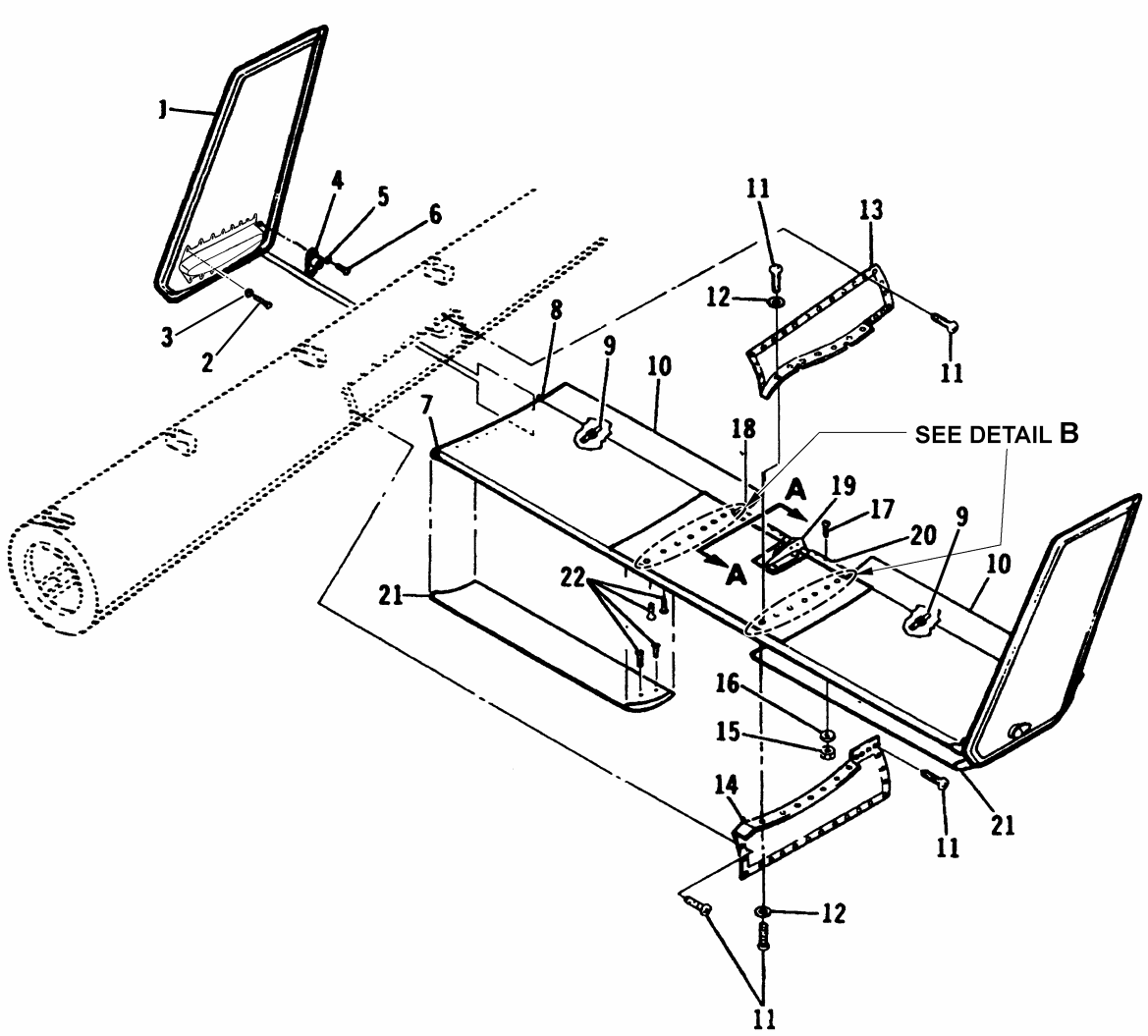
PART III: Replacement of horizontal stabilizer

-NOTE-

Replacement of the horizontal stabilizer requires re-shimming of the lower and upper supports (13 and 14).

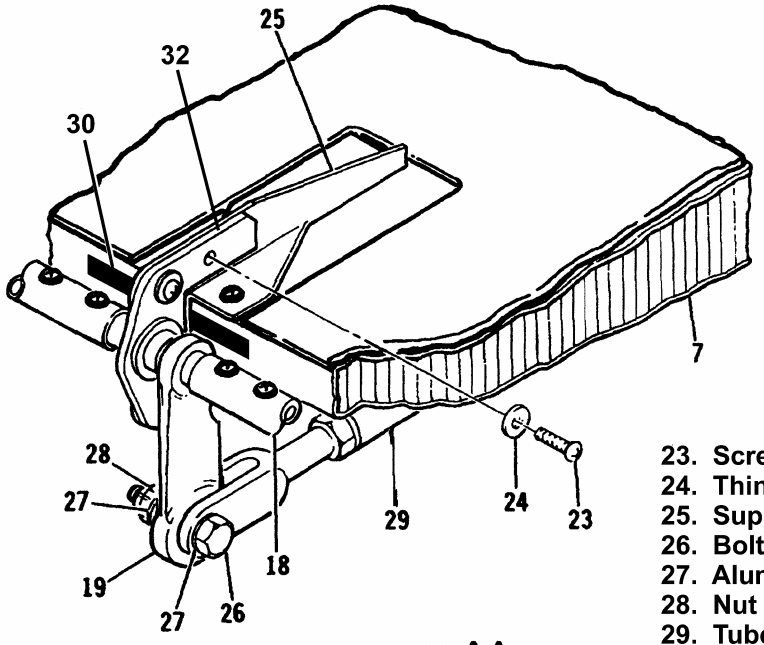
1. Remove and retire from service affected horizontal stabilizer. Install a serviceable horizontal stabilizer in accordance with the appropriate Maintenance Manual and TB 206L-00-203 for stabilizer shimming procedure.

2. Make an entry in the helicopter records to indicate that this bulletin has been accomplished



1. Fin
2. Screw
3. Thin aluminum washer
4. Fitting
5. Aluminum washer
6. Screw
7. Stabilizer
8. Pin
9. Pin
10. Elevator
11. Screw
12. Thin aluminum washer
13. Support
14. Support
15. Nut
16. Washer
17. Screw
18. Tube
19. Horn
20. Tube
21. Slat
22. Screw

Figure 1 – Horizontal stabilizer, first inspection and 600 hour / annual inspection (Sheet 1 of 2)



VIEW A-A

23. Screw
24. Thin aluminum washer
25. Support
26. Bolt
27. Aluminum washer
28. Nut
29. Tube
30. Identification tag
31. Inserts
32. Support

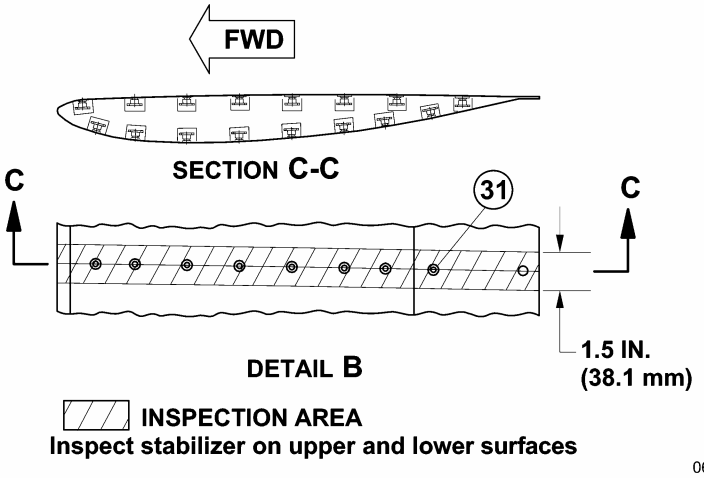


Figure 1 – Horizontal stabilizer, first inspection and 600 hour / annual inspection (sheet 2 of 2)