

ALERT SERVICE BULLETIN



A Textron Company

NO. 206L-08-149

DATE JAN 31, 2008

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DATE
REV

MODEL AFFECTED: 206L SERIES

SUBJECT: SUPPORT ASSEMBLY P/N 206-033-501-003 AND -004, INSPECTION OF

HELICOPTERS AFFECTED: 206L Helicopters serial number 45004 through 45153 and 46601 through 46617.

206L-1 Helicopters serial number 45154 through 45790.

206L-3 Helicopters serial number 51001 through 51612.

206L-4 Helicopters serial number 52001 through 52362.

[Model 206L-4 helicopters S/N 52363 and subsequent will have support assembly P/N 206-033-501-101 and -102 installed prior to delivery.]

COMPLIANCE: **Part I** at the next scheduled inspection but no later than 30 days after receiving this bulletin.

Part II within the next 300 hours but no later than 90 days after receiving this bulletin.

Part III At customer's option.

DESCRIPTION:

Bell helicopter has found that a fouling condition may exist between aft arm assembly P/N 206-033-505-105, /-107 and aft support assembly P/N 206-033-501-003, /-004 on 206L series helicopters.

Part I of this Alert Service Bulletin introduces a one-time inspection for fouling between the aft arm assembly and the aft support assembly.

Part II provides the instructions to remove material from the aft support assembly, if a fouling condition exists.

Part III introduces new support assemblies P/N 206-033-501-101 and -102 that have improved manufacturing tolerances for proper clearance with the aft arm assembly. The support assemblies -101 and -102 are direct replacement for the -003 and -004 respectively.

APPROVAL:

The engineering design aspects of this bulletin are Transport Canada Civil Aviation (TCCA) approved.

MANPOWER:

Approximately 0.5 man-hour is required to complete Part I of this bulletin and approximately 8 man-hours are required to complete Part II. No additional man-hours are required for Part III if accomplished during routine maintenance. Manpower is based on hands-on time, and may vary with personnel and facilities available.

WARRANTY:

There is no warranty credit applicable for parts or labor associated with this bulletin.

REQUIRED MATERIAL:

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
206-033-501-101	L/H Support	1 note (1)
206-033-501-102	R/H Support	1 note (1)

Note1: Needed only if support assembly require replacement

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>
MIL-C-81706	Alodine 1200	A/R	C-100
MIL-PRF-23377, Type 1 Classe C	Epoxy Polyamide Primer	A/R	C-204 (1)
Commercial	220/400 Grit Abrasive Cloth or Paper	A/R	C-423

Note: Primer C-246 can be used as an alternate.

SPECIAL TOOLS:

Not required

WEIGHT AND BALANCE:

Not affected

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-206L-MM-1, Chapter 66
BHT-206L-1-MM-1, Chapter 66
BHT-206L-3-MM-6, Chapter 63
BHT-206L-4-MM-6, Chapter 63
BHT-206L-CR&O, Chapter 63
BHT-ALL-SPM

PUBLICATIONS AFFECTED:

BHT-206L-SERIES-IPB Illustrated Parts Breakdown

ACCOMPLISHMENT INSTRUCTIONS:

Part I: Inspection for Fouling Condition.

1. Gain access to the transmission arm and support assemblies.
2. Using a mirror and a bright light, inspect for fouling between the aft arm assembly and the support assembly at the area shown in Figure 1 view A. Inspect the L/H and R/H support.
3. If no fouling exists, make an entry in the helicopter records to indicate that this bulletin has been accomplished.
4. If fouling exists, proceed with Part II.

Part II: Support Assembly Rework Instruction.

-NOTE-

Use applicable 206L Series Maintenance Manual and BHT-206L-SERIES-CR&O, chapter 63 for components removal and installation instructions.

-NOTE-

Inspection criteria published in the BHT-206L-SERIES-CR&O apply to parts reworked in accordance with this bulletin.

CAUTION

DO NO USE POWER TOOLS TO REMOVE MATERIAL

1. Remove aft arm assembly P/N 206-033-505.
2. Starting with a smooth cut hand file and then finishing with 220 and 400 grit abrasive cloth or paper (C-423), remove 0.100inch (2.54mm) material maximum from the support assembly as shown in Figure 1 sheet 2 Ensure smooth transition to the surrounding areas. Break all sharp edges in repaired areas. Repeat process for the opposite side.

-NOTE-

As an alternate to Fluorescent Penetrant Inspection it is acceptable to perform a 10X Magnifying Glass Inspection

3. Perform a Fluorescent Penetrant Inspection of the repaired areas per the BHT-ALL-SPM. Ensure complete material removal. Ensure no cracks exist in the repaired area.
4. Apply chemical film material (C-100) to repaired area and touch up with epoxy polyamide primer (C-204).
5. Identify the reworked support assembly with suffix FM at the end of the part number using permanent ink marker.
6. Install aft arm assembly.
7. Make an entry in the helicopter records to indicate that this bulletin has been accomplished.

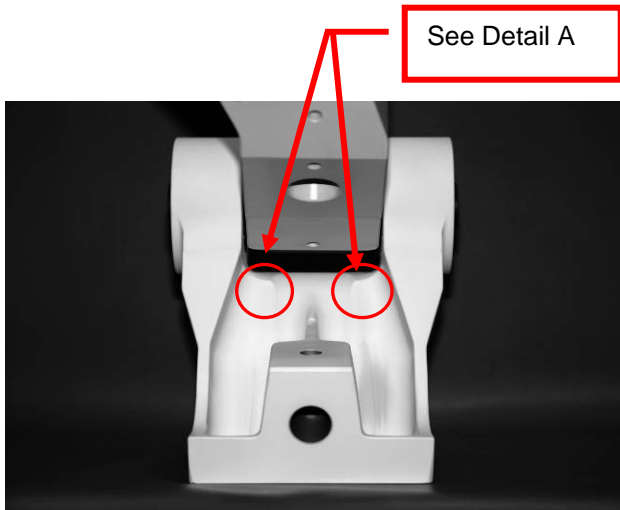
Part III. New Support Assembly P/N 206-033-501-101 and -102, Introduction of

1. If support assembly replacement is required, refer to applicable 206L Series Maintenance Manual for instructions.
2. Support assemblies -003 / -101 left side and -004 / -102 right side can be mixed and matched.
3. Damage limits published in the BHT-206L-CR&O apply.



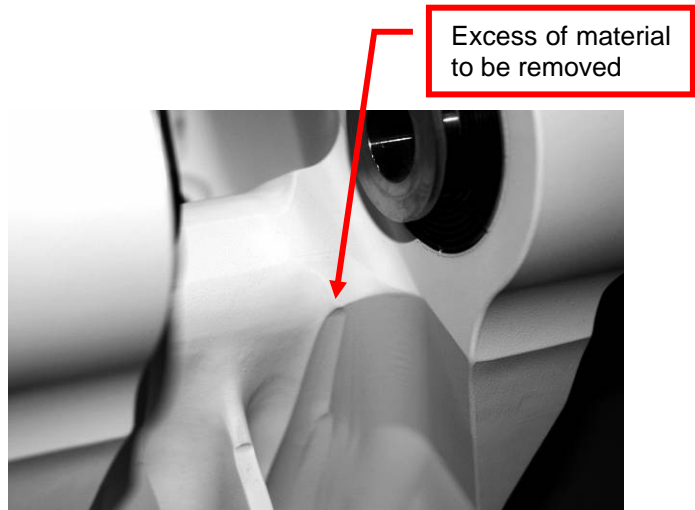
Inspect support
for fouling from
behind looking
forward

VIEW A Arm & Support Assembly



See Detail A

VIEW B Area of Fouling



Excess of material
to be removed

DETAIL A

Remove 0.100in (2.54 mm) maximum from top to base of the defined pyramid.

After material removal, minimum wall thickness shall be above 0.300 in (7.62 mm)

Smooth transition is not shown for clarity.

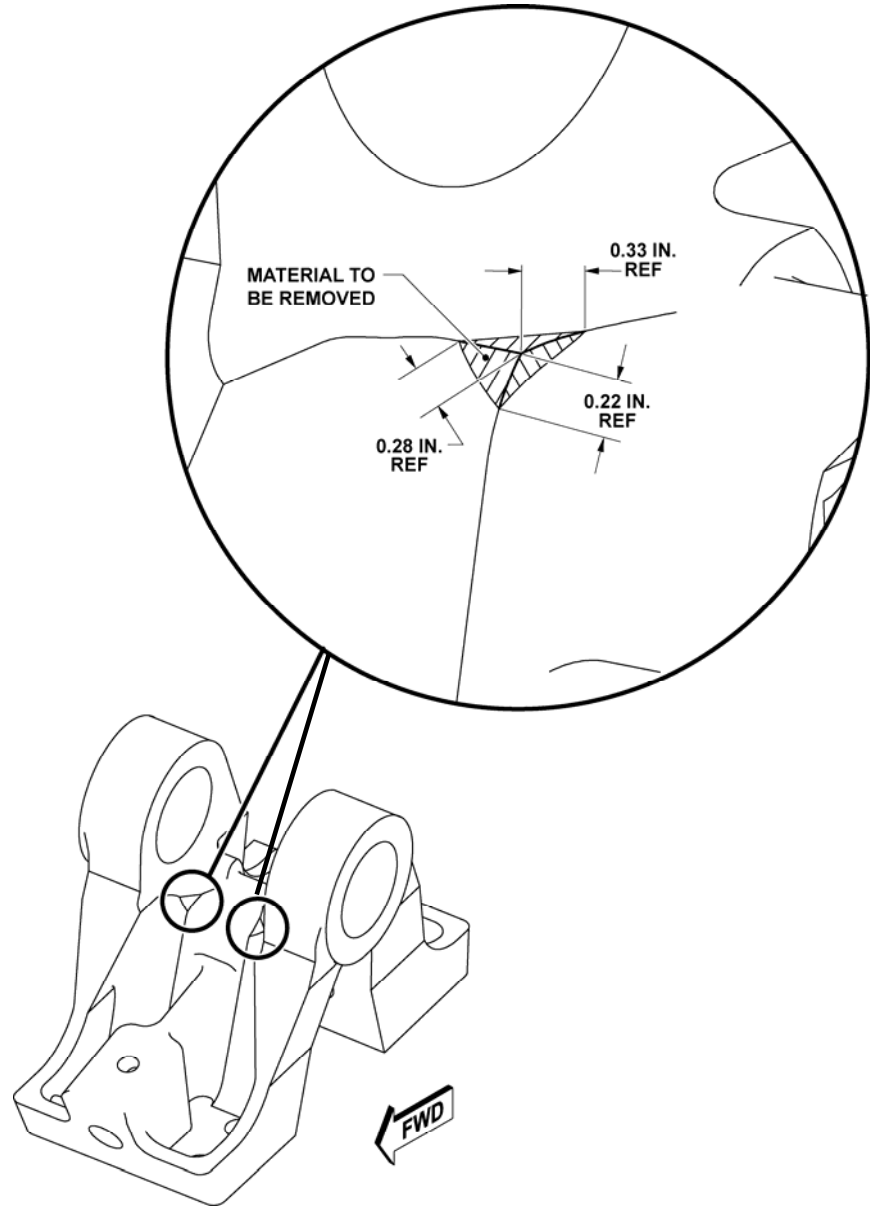


FIGURE 1 Support Assembly sheet 2 of 2