

ALERT SERVICE BULLETIN

429-11-04  
21 December 2011

**MODEL AFFECTED:** 429

**SUBJECT:** EXHAUST EJECTOR P/N 429-363-111-101/-102,  
INSPECTION AND REPAIR OF.

**HELICOPTERS AFFECTED:** Serial number 57001 and subsequent.

**COMPLIANCE:** **Part I:** As soon as possible within the next 10 hours of operation and every 10 hours of operation until Part II is accomplished.

**Part II:** As soon as practical but no later than next scheduled inspection or 31 January 2012, whichever comes first.

**DESCRIPTION:**

Bell Helicopter has received several reports of the metal blanket covering the ejector insulation cracking and, in some cases, coming loose from the aft section of the exhaust ejector. Investigation is underway to determine the exact cause of the cover failures. However, if this condition is left unattended, pieces of the blanket could tear off and be ingested by the oil cooler blowers. This bulletin introduces procedures to secure the blanket to the ejector thus preventing further damage to the blanket.

**APPROVAL:**

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

## CONTACT INFO:

For any questions regarding this bulletin, please contact:

Bell Helicopter Product Support Engineering - Intermediate Helicopters  
Tel: 450-437-2077 / 1-800-463-3036 / pseinter@bellhelicopter.textron.com

## MANPOWER:

Approximately 0.5 man-hour is required to complete Part I of this bulletin. This estimate is based on hands-on time, and may vary with personnel and facilities available.

Approximately 2.0 man-hours are required to complete Part II of this bulletin. This estimate 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.

## MATERIAL:

### Required Material:

None required.

### 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>Qty</u>	<u>Reference</u> *
363, 2.00 WIDE	3M Tape # 363 (Note 1)	1 Roll	
Scotch-Brite	Abrasive pad	A/R	C-407
Acetone	Acetone (Note 2)	A/R	C-316

Note 1: Only 3M high temperature aluminum foil/glass cloth tape P/N 363, 2.00" WIDE is approved for this application.

Note 2: As alternate, Toluene (C-306), MEK (C-309) or Solvent (C-304) may be used.

\* C-XXX numbers refer to the consumables list in BHT-ALL-SPM Standard Practices Manual.

**SPECIAL TOOLS:**

None required.

**WEIGHT AND BALANCE:**

Not affected.

**ELECTRICAL LOAD DATA:**

Not affected.

**REFERENCES:**

BHT-429-IPB Illustrated Parts Breakdown  
BHT-429-MM Maintenance Manual

**PUBLICATIONS AFFECTED:**

None affected.

**ACCOMPLISHMENT INSTRUCTIONS:****PART I :****Exhaust ejector inspection**

1. Prepare helicopter for maintenance.
2. Gain access to the exhaust ejectors by removing both forward exhaust fairings (700GL and 700GR). Refer to BHT-429-MM-1, Chapter 53.
3. Inspect the exhaust ejector assembly paying particular attention to the condition of the stainless steel blanket at and around the weld joint at the aft section of the ejector.
  - a. If the blanket is securely attached to the ejector and there is no sign of damage, crack or tear, no further action required. Repeat inspection of ejectors every 10 hours of operation until Part II of this bulletin is accomplished.
  - b. If the blanket is damaged and/or is separated from the ejector at the weld joint, accomplish Part II of this bulletin before next flight.

## **PART II:**

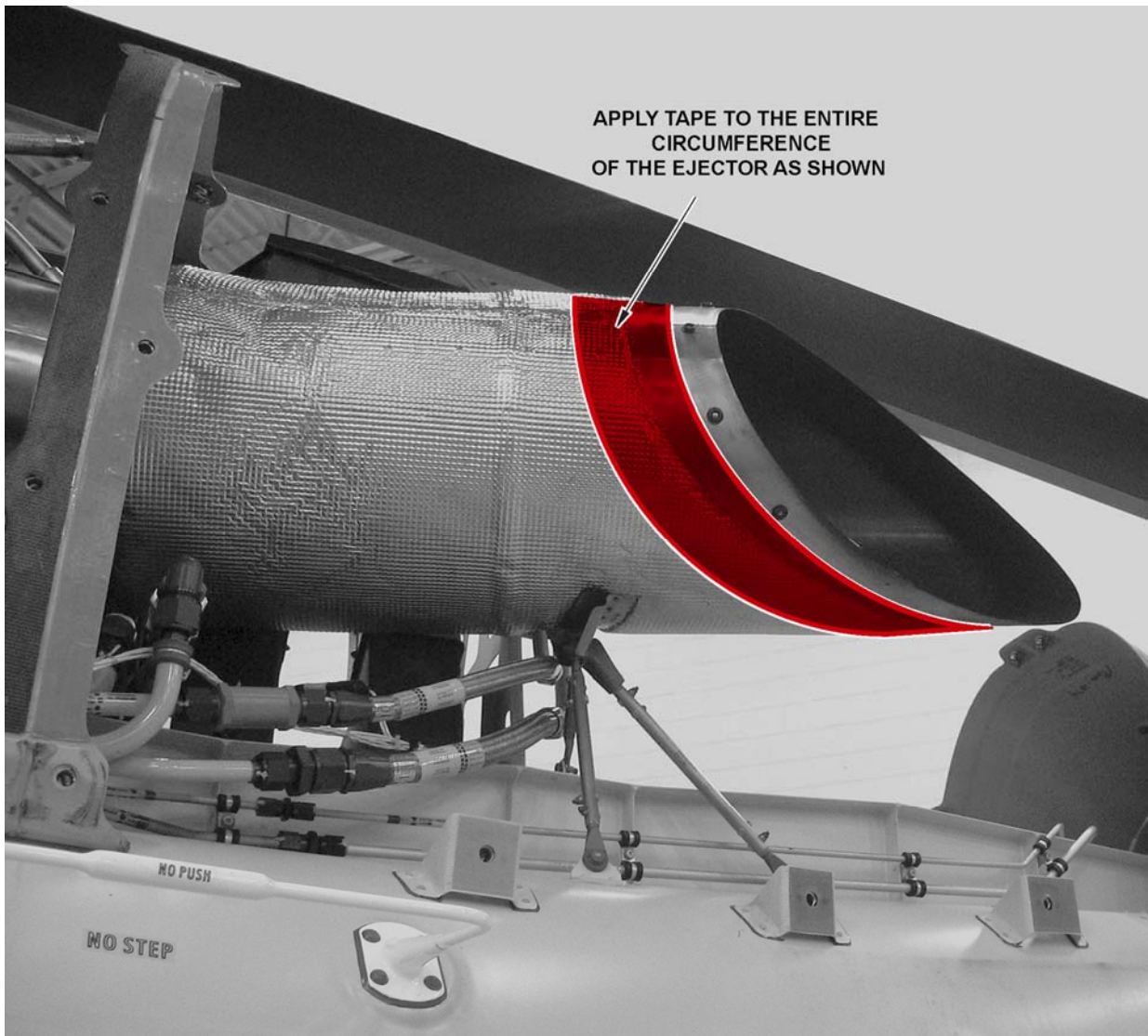
### **Exhaust ejector repair**

1. Prepare helicopter for maintenance.
2. Gain access to the exhaust ejectors by removing both forward exhaust fairings (700GL and 700GR). Refer to BHT-429-MM-1, Chapter 53.
3. If required, trim off any torn or raised portion of the stainless steel blanket. The damaged/missing blanket should not extend more than 4 inches from the weld joint and should not be wider than 4 inches. Do not remove the insulation blanket.
4. Clean and prepare the surface of the ejector outboard flange and the section of the blanket on which the tape will be applied as follows:
  - a. Using acetone (C-316) and scotch-brite (C-407), scrub the blanket and ejector to remove dirt and oil residues.
  - b. Allow the blanket and ejector to air dry.

-NOTE-

Following application of tape to the exhaust ejectors, ensure the tape is firmly secured and well seated in place.

5. Apply 3M high temperature aluminum foil/glass cloth tape P/N 363, 2.00" WIDE to the ejector and blanket. Refer to Figure 1 for application details.
  - a. Start the first layer of tape at the edge of the ejector doubler. Run the tape around the entire circumference of the ejector. Overlap end of tape by approximately 2 inches.
  - b. Apply the second layer of tape around the entire circumference of the ejector overlapping by approximately 1 inch the first layer of tape. Overlap end of tape by approximately 2 inches.
  - c. Repeat sub-step 5b until reaching approximately 6 to 8 inches from the edge of the ejector doubler. Refer to Figure 1.
6. Reinstall both forward exhaust fairings (700GL and 700GR). Refer to BHT-429-MM-1, Chapter 53.
7. Make an entry in helicopter historical service records indicating compliance with this bulletin.



11580\_001

**Figure 1**  
Ejector assembly