



A Textron Company

Distribution A: Approved for Public Release IAW DoD Memo 12-S-0781

ALERT SERVICE BULLETIN

UH-1H-II-12-21

5 January 2012

MODEL AFFECTED: UH-1H-II

SUBJECT: INSPECTION, AND REWORK OF MAIN ROTOR GRIPS P/N 204-011-121-009/-121

HELICOPTERS AFFECTED: All model UH-1H-II helicopters.

GRIP SERIAL NUMBERS AFFECTED:

| | | | | | | | | |
|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| A-05181 | A-05769 | A-05873 | A-05940 | A-05971 | A-06020 | A-06055 | A-06156 | A-06218 |
| A-05182 | A-05771 | A-05875 | A-05941 | A-05974 | A-06021 | A-06056 | A-06159 | A-06220 |
| A-05183 | A-05772 | A-05881 | A-05945 | A-05975 | A-06022 | A-06057 | A-06163 | A-06222 |
| A-05184 | A-05775 | A-05882 | A-05946 | A-05976 | A-06023 | A-06058 | A-06164 | A-06226 |
| A-05298 | A-05779 | A-05883 | A-05947 | A-05978 | A-06024 | A-06059 | A-06165 | A-06227 |
| A-05299 | A-05782 | A-05887 | A-05948 | A-05979 | A-06025 | A-06068 | A-06166 | A-06231 |
| A-05376 | A-05798 | A-05888 | A-05949 | A-05980 | A-06026 | A-06071 | A-06181 | A-06233 |
| A-05377 | A-05805 | A-05889 | A-05950 | A-05981 | A-06027 | A-06075 | A-06182 | A-06238 |
| A-05387 | A-05807 | A-05893 | A-05951 | A-05982 | A-06028 | A-06077 | A-06185 | A-06242 |
| A-05390 | A-05809 | A-05894 | A-05952 | A-05983 | A-06029 | A-06080 | A-06187 | A-06244 |
| A-05637 | A-05820 | A-05895 | A-05953 | A-05984 | A-06030 | A-06083 | A-06189 | A-06246 |
| A-05639 | A-05830 | A-05908 | A-05954 | A-05985 | A-06031 | A-06084 | A-06193 | A-06248 |
| A-05641 | A-05831 | A-05911 | A-05955 | A-05986 | A-06032 | A-06089 | A-06194 | A-06253 |
| A-05642 | A-05834 | A-05913 | A-05956 | A-05987 | A-06034 | A-06090 | A-06195 | A-06254 |
| A-05676 | A-05837 | A-05914 | A-05957 | A-05991 | A-06035 | A-06091 | A-06199 | A-06256 |
| A-05711 | A-05839 | A-05915 | A-05958 | A-05992 | A-06040 | A-06119 | A-06200 | A-06257 |
| A-05712 | A-05847 | A-05916 | A-05959 | A-06001 | A-06041 | A-06120 | A-06203 | A-06259 |
| A-05717 | A-05852 | A-05918 | A-05960 | A-06002 | A-06045 | A-06130 | A-06204 | A-06267 |
| A-05721 | A-05859 | A-05920 | A-05961 | A-06003 | A-06046 | A-06131 | A-06205 | A-06268 |
| A-05722 | A-05862 | A-05922 | A-05962 | A-06004 | A-06048 | A-06132 | A-06209 | A-06269 |
| A-05723 | A-05863 | A-05923 | A-05963 | A-06005 | A-06049 | A-06133 | A-06212 | A-06273 |
| A-05764 | A-05865 | A-05925 | A-05964 | A-06006 | A-06050 | A-06139 | A-06213 | A-06274 |
| A-05767 | A-05866 | A-05930 | A-05965 | A-06011 | A-06052 | A-06153 | A-06215 | A-06277 |
| A-05768 | A-05871 | A-05938 | A-05967 | A-06018 | A-06053 | A-06155 | A-06217 | |

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| | | | | | | | | |
|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| A-06278 | A-06348 | A-06631 | A-06709 | A-06771 | A-06841 | A-06938 | A-07318 | A-07318 |
| A-06279 | A-06368 | A-06634 | A-06711 | A-06772 | A-06843 | A-06939 | A-07319 | A-07319 |
| A-06441 | A-06370 | A-06635 | A-06712 | A-06773 | A-06844 | A-06941 | A-07320 | A-07320 |
| A-06442 | A-06371 | A-06636 | A-06713 | A-06774 | A-06845 | A-06942 | A-07333 | A-07333 |
| A-06444 | A-06372 | A-06638 | A-06714 | A-06775 | A-06847 | A-06943 | A-07335 | A-07335 |
| A-06445 | A-06373 | A-06640 | A-06715 | A-06776 | A-06848 | A-06986 | A-07111 | |
| A-06446 | A-06376 | A-06641 | A-06716 | A-06777 | A-06850 | A-06992 | A-07112 | |
| A-06447 | A-06377 | A-06642 | A-06717 | A-06778 | A-06851 | A-06993 | A-07114 | |
| A-06449 | A-06378 | A-06643 | A-06718 | A-06779 | A-06852 | A-06994 | A-07115 | |
| A-06450 | A-06380 | A-06644 | A-06719 | A-06786 | A-06853 | A-06995 | A-07117 | |
| A-06452 | A-06382 | A-06648 | A-06720 | A-06795 | A-06856 | A-06997 | A-07166 | |
| A-06459 | A-06383 | A-06651 | A-06722 | A-06797 | A-06857 | A-06998 | A-07167 | |
| A-06491 | A-06390 | A-06657 | A-06725 | A-06798 | A-06859 | A-06999 | A-07170 | |
| A-06492 | A-06391 | A-06661 | A-06726 | A-06801 | A-06861 | A-07000 | A-07171 | |
| A-06493 | A-06412 | A-06662 | A-06729 | A-06802 | A-06862 | A-07001 | A-07172 | |
| A-06494 | A-06414 | A-06663 | A-06730 | A-06803 | A-06864 | A-07003 | A-07182 | |
| A-06497 | A-06416 | A-06664 | A-06731 | A-06804 | A-06865 | A-07007 | A-07183 | |
| A-06498 | A-06420 | A-06666 | A-06732 | A-06805 | A-06866 | A-07008 | A-07184 | |
| A-06514 | A-06426 | A-06667 | A-06734 | A-06806 | A-06867 | A-07010 | A-07185 | |
| A-06515 | A-06429 | A-06668 | A-06736 | A-06807 | A-06868 | A-07015 | A-07186 | |
| A-06516 | A-06440 | A-06672 | A-06737 | A-06808 | A-06871 | A-07018 | A-07188 | |
| A-06517 | A-06469 | A-06674 | A-06738 | A-06809 | A-06872 | A-07023 | A-07189 | |
| A-06518 | A-06470 | A-06675 | A-06739 | A-06810 | A-06873 | A-07025 | A-07190 | |
| A-06519 | A-06474 | A-06677 | A-06740 | A-06811 | A-06875 | A-07038 | A-07191 | |
| A-06520 | A-06475 | A-06678 | A-06741 | A-06812 | A-06880 | A-07039 | A-07193 | |
| A-06521 | A-06478 | A-06679 | A-06742 | A-06813 | A-06882 | A-07040 | A-07195 | |
| A-06528 | A-06479 | A-06680 | A-06743 | A-06814 | A-06885 | A-07041 | A-07198 | |
| A-06529 | A-06480 | A-06685 | A-06744 | A-06815 | A-06886 | A-07042 | A-07199 | |
| A-06530 | A-06481 | A-06686 | A-06745 | A-06816 | A-06888 | A-07043 | A-07232 | |
| A-06531 | A-06484 | A-06688 | A-06747 | A-06817 | A-06922 | A-07044 | A-07234 | |
| A-06532 | A-06549 | A-06689 | A-06748 | A-06823 | A-06925 | A-07045 | A-07235 | |
| A-06533 | A-06550 | A-06690 | A-06758 | A-06824 | A-06927 | A-07046 | A-07237 | |
| A-06534 | A-06614 | A-06691 | A-06759 | A-06831 | A-06929 | A-07047 | A-07238 | |
| A-06535 | A-06620 | A-06692 | A-06760 | A-06833 | A-06932 | A-07048 | A-07239 | |
| A-06536 | A-06621 | A-06693 | A-06761 | A-06834 | A-06933 | A-07050 | A-07311 | |
| A-06819 | A-06626 | A-06698 | A-06762 | A-06835 | A-06934 | A-07052 | A-07312 | |
| A-00665 | A-06627 | A-06700 | A-06763 | A-06836 | A-06935 | A-07054 | A-07314 | |
| A-06295 | A-06628 | A-06705 | A-06764 | A-06837 | A-06936 | A-07087 | A-07316 | |
| A-06345 | A-06630 | A-06706 | A-06765 | A-06838 | A-06937 | A-07103 | A-07317 | |

COMPLIANCE: At the next scheduled 300 hour inspection, overhaul or 6 months whichever occurs first.

DESCRIPTION:

During conversion to a greased lubricated grip P/N 204-011-121-009/-121 was identified incorrectly and in the wrong location.

APPROVAL:

The engineering design aspects of this bulletin are Bell Helicopter approved.

CONTACT INFO:

For any questions regarding this bulletin, please contact:

Bell Helicopter Product Support Engineering - Medium Military Helicopters
Tel: 817-280-3548 or mts-medium@bellhelicopter.textron.com

MANPOWER:

Approximately 5.0 man-hours are required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

WARRANTY:

There is no warranty provided for this bulletin.

MATERIAL:

Required Material:

The following material is required for the accomplishment of this bulletin and may be obtained through the government supply system.

| <u>Part Number</u> | <u>Nomenclature</u> | <u>Qty</u> |
|--------------------|---------------------|------------|
| 100-140-2N/A | Data Plate | 2 |

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 the government supply system.

| <u>Part Number</u> | <u>Nomenclature</u> | <u>Quantity</u> | <u>Reference</u> |
|----------------------------|-------------------------|-----------------|------------------|
| ABRASIVE 240 GRIT | Abrasive Cloth or paper | A/R | C-423 |
| Chemical Film Material for | Alodine 1201 | A/R | C-100 |

| | | | | |
|---------------------------------------|-------------------------------|------|-------|--|
| Aluminum | | | | |
| MIL-PRF-12277, TYPE I or II, CLASS C2 | Primer, Epoxy Polyamide | A/R | C-204 | |
| MIL-L-PRF-53039 (37038) | Coating, Polyurethane (Black) | A/R | | |
| MIL-L-PRF- 85285D (16440) | Coating, Polyurethane (Gray) | A/R | | |
| TT-N-95, Type II | Aliphatic Naphtha | A/R | C-305 | |
| ASTM D740 | METHYL Ethyl Keytone | 1 PT | C-309 | |
| 299-947-100 | Adhesive, Epoxy Base | 1 PT | C-317 | |
| CCC-C-440, CLASS 1 | Cheesecloth, Cotton | A/R | C-486 | |

SPECIAL TOOLS:

Surface Finish Scale
Pin Mike Gage

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-PUB 92-004-23P-IPB Illustrated Parts Breakdown
BHT-PUB 92-004-23 MM Maintenance Manual
BHT-212 CR&O Component Repair and Overhaul Manual
BHT-ALL-SPM Standard Practices Manual

PUBLICATIONS AFFECTED:

None affected.

ACCOMPLISHMENT INSTRUCTIONS:

PART ONE

1. Access Mair Rotor Hub and inspect grip data plate for impression stamped identification. Grip data plate should have "G" vibro-etched on data plate, not on grip, Reference Figure 1. If data plate is marked correctly no further action is required. Annote Historical Records as ASB UH-1H-II-21-11 not applicable. If grip was marked incorrectly, comply with Part Two.

-NOTE-

If Main Rotor Grip has been converted to a "greased" grip, and "G" it's not visible on either the data plate or on the grip, its possible the "G" has been filled with paint. Removal of paint will be required

1. Remove paint in accordance with BHT-ALL-SPM, Chapter 4 and inspect the area 1.5" adjacent to the data plate, Reference Figure 1.

PART TWO

- 1 Using Pin Mike gauge, measure the depth of the stamped "G". If depth is less than .030 grip is repairable. Document the depth of the stamping.
2. Unbond and remove data plate.
3. Perform a Dye Penetrant Inspection of area, no cracks allowed.
4. Using C-423, sand the grip in a span wise direction to remove the documented depth of the stamping plus 0.020. Maximum repair depth not to exceed 0.050". Sand the grip to a surface finish of a 63 RMS. A minimum blend radius of 1 inch should be observed.

NOTE

Repeening of the repair not required.

5. To ensure no induced damage, perform another Dye Penetrant Inspection of area, no cracks allowed.
6. Using C-100, alodine the repair area.
7. Using C-204, prime the repaired area.
8. Using the correct color of paint (see consumables) paint the repaired area.
9. Vibroetch the part number and serial number on the replacement data plate (100-140-2), prior to installation on grip.
10. Install new data plate per BHT-ALL-SPM, Chapter 8. Install new data plate in the same location on grip where old data plate was located. Reference Figure 3.

11. Annotate compliance with ASB in the aircraft Historical Records.



Figure 1

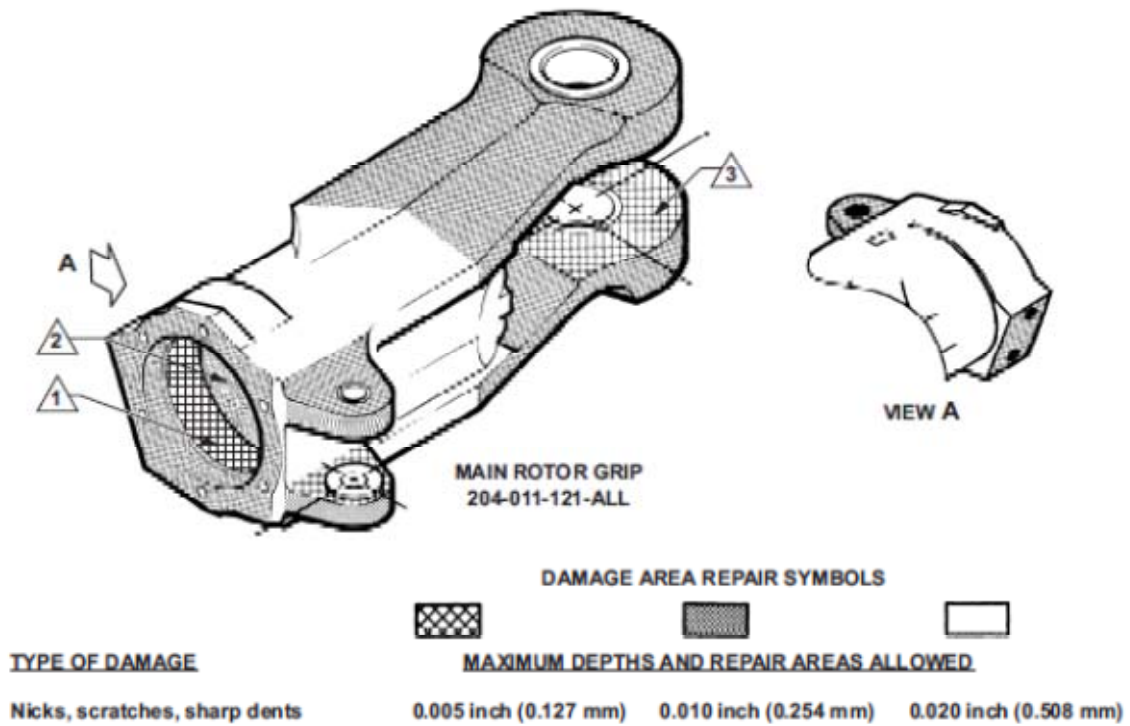


Figure 2

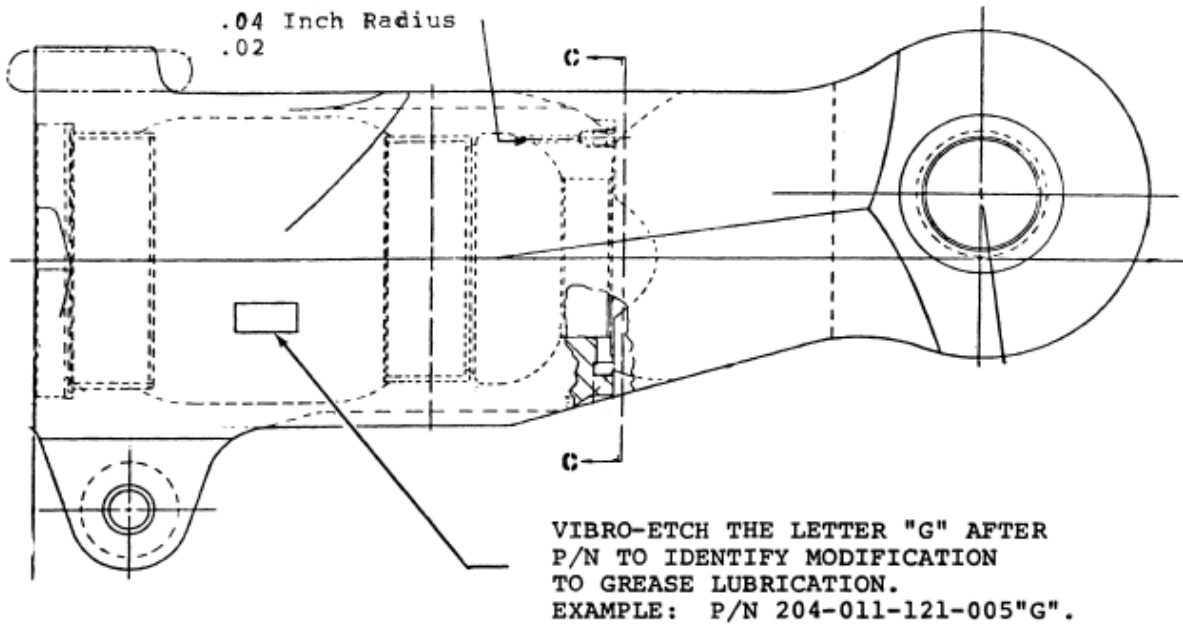


Figure 3