

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

**NO** 206-00-171

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| <b>DATE</b> |
| <b>REV.</b> |

**MODELS AFFECTED:** 206A/B Series

**SUBJECT:** **SWASHPLATE AND SUPPORT ASSEMBLY, 206-010-450-ALL, UPGRADE AND CONFIGURATION OF.**

**HELICOPTERS AFFECTED:** 206A, S/N 004 through 660, and 672 through 715.  
 206B, S/N 661 through 671, 716 through subsequent, and 5101 through subsequent.

**SWASHPLATE AND SUPPORT ASSEMBLY AFFECTED:**

| SWASHPLATE AND SUPP. ASSY. P/N | NOTES   | PRODUCTION EFFECTIVITY                       |
|--------------------------------|---------|--|
| 206-010-450-001                | (1)     | 206A, 0004 through 0413                      |
| 206-010-450-005                | (1)     | 206A, 0414 through 0660<br>0672 through 0715 |
| 206-010-450-005                | (1)     | 206B, 0661 through 0671<br>0716 through 1336 |
| 206-010-450-007                | (1)     | 206B, 1337 through 1937                      |
| 206-010-450-011                | (1)     | 206B, 1938 through 3566                      |
| 206-010-450-113                | (1)     | 206B, 3567 through 4522                      |
| 206-010-450-113                | (1)     | 206B, 5101 through 5267.                     |
| 206-010-450-125                | (1)     | 206B, 4523 through 4550                      |
| 206-010-450-129                | (1) (2) | 206B, 4551 through sub.                      |
| 206-010-450-129                | (1) (2) | 206B, 5268 through sub.                      |

**NOTES:**

1. All swashplate and support assemblies can be upgraded to a newer configuration of swashplate and support assembly. Refer to Table 1.
2. The swashplate and support assembly -129 is the stocked spare swashplate and support assembly that you can use on all 206A and 206B helicopters.

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**COMPLIANCE:**

At the option of the operator, but it is recommended that this Bulletin be accomplished at the next swashplate and support assembly overhaul.

- NOTE -

This Technical Bulletin cancels and supersedes  
Technical Bulletin 206-82-64 dated 4-28-82.

**DESCRIPTION:**

This Technical Bulletin gives the changes necessary to upgrade older model 206A/B series swashplate and support assemblies to a newer swashplate and support assembly configuration.

The current swashplate and support assembly production configuration 206-010-450-129 can be used on all 206A/B series helicopters.

**APPROVAL:**

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

**MANPOWER:**

No additional man-hours are required to upgrade the swashplate and support assembly to the latest configuration if done during normal overhaul.

**MATERIAL:**

Refer to ACCOMPLISHMENT INSTRUCTION. Standard replacement parts necessary at overhaul are not included. Parts for the upgrade can be obtained through your Bell Helicopter Textron Supply Center.

**SPECIAL TOOLS:**

Refer to Model 206A/B Series, Maintenance & Overhaul Instruction Manual, Section IV or Model 206B-III Component Repair & Overhaul Manual, Chapter 62.

**WEIGHT AND BALANCE:**

Not affected.

**ELECTRICAL LOAD DATA:**

Not affected.

**REFERENCES:**

BHT-206A/B-M&O-1, 01 June 1974, Rev. 36, 31 July 1984, and Rev. 12, 03 December 1977.

Section IV, Overhaul, Part I.

BHT-206B3-CR&O, 15 September 1993.

Chapter 62, Main Rotor.

BHT-206A/B-SERIES-IPB, 01 May 1996.

Chapter 62, Main Rotor.

T.B. 206-79-24 SWASHPLATE PIVOT SLEEVE ASSEMBLY  
P/N 206-010-454-001 AND /-005, MODIFICATION OF.

T.B. 206-77-8 SWASHPLATE, P/N 206-010-450, LUBRIFICATION  
AND MODIFICATION OF.

A.S.B. 206-93-74, Rev. B SWASHPLATE SUPPORT ASSEMBLY  
206-010-452-001, /-005, /-009, INSPECTION OF.

A.S.B. 206-00-93 COLLECTIVE LEVER ASSEMBLY 206-010-467-001,  
MODIFICATION AND NEW COLLECTIVE LEVER  
ASSEMBLY /-105, INTRODUCTION OF.

**PUBLICATIONS AFFECTED:**

BHT-206A/B-M&O-1, 01 June 1974, Rev. 36, 31 July 1984, and, Rev. 12, 03 December 1977.

Section IV, Overhaul, Part I.

BHT-206B3-CR&O, 15 September 1993.

Chapter 62, Main Rotor.

BHT-206A/B-SERIES-IPB, 01 May 1996.

Chapter 62, Main Rotor.

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Swashplate and support assembly, disassembly and assembly instructions.
  - For 206A and 206B S/N 004 through 2211, refer to the BHT-206A/B-M&O-1, Section IV, Overhaul, Part I.
  - For 206B S/N 2212 and subsequent and 5101 and subsequent, refer to the BHT-206B3-CR&O, Chapter 62.

- NOTE -

Table 1 contains only the major components of the swashplate and support assembly. Refer to the applicable Illustrated Parts Breakdown Manual for the other necessary parts.

2. Use the information of Table 1 to upgrade the swashplate and support assemblies. The components that are listed in the column of an assembly dash number in Table 1 are included in the specified configuration.
3. Identify the swashplate and support assembly with the new configuration dash number that you defined in Step 2 followed by the suffix "FM".
  - a. Identify the data plate of the swashplate and the support assembly with the use of a vibrating tool. The depth of the vibroetch must not exceed 0.005 inch (0.13 mm).

Example: 206-010-450-~~113~~-125 FM

- NOTE -

You must do all the changes defined in Table 1 for that part number, to change the part number on the data plate or the Historical Record (HR) sheet.

4. Make an entry in the swashplate and support assembly History Record (HR) to show:

- The new part number.
- The new Time Between Overhaul (TBO), if it applies.
- The new retirement life of the swashplate and the component parts, if it applies.
- That this Technical Bulletin is completed.

**TABLE 1 – Swashplate and support assembly configuration.**

| NOMENCLATURE/PART NUMBER |                 | NOTES              | SWASHPLATE AND SUPPORT – 206-010-450 |             |             |             |             |             |      |
|--------------------------|-----------------|--------------------|--------------------------------------|-------------|-------------|-------------|-------------|-------------|------|
|                          |                 |                    | -001<br>(1) (2)                      | -005<br>(3) | -007<br>(4) | -011<br>(5) | -113<br>(6) | -125<br>(7) | -129 |
| Support assembly         | 206-010-452-001 | (8) (9) (10)       | X                                    | X           | X           |             |             |             |      |
|                          | 206-010-452-005 | (9) (10) (11)      |                                      |             |             | X           |             |             |      |
|                          | 206-010-452-109 | (9) (12) (13) (14) |                                      |             |             |             | X           |             |      |
|                          | 206-010-452-113 | (9) (13) (14)      |                                      |             |             |             | X           | X           | X    |
| Inner ring assembly      | 206-010-451-001 | (15)               | X                                    |             |             |             |             |             |      |
|                          | 206-010-451-005 | (16)               |                                      | X           | X           | X           | X           |             |      |
|                          | 206-010-451-109 | (17)               |                                      |             |             |             |             | X           | X    |
| Outer ring assembly      | 206-010-453-001 | (2) (18) (19)      | X                                    |             |             |             |             |             |      |
|                          | 206-010-453-005 | (2) (20)           |                                      | X           |             |             |             |             |      |
|                          | 206-010-453-009 | (21)               |                                      |             | X           | X           | X           |             |      |
|                          | 206-010-453-113 | (22)               |                                      |             |             |             |             | X           | X    |
| Sleeve assembly          | 206-010-454-001 | (23) (24) (25)     | X                                    | X           | X           |             |             |             |      |
|                          | 206-010-454-005 | (24) (25) (26)     |                                      |             |             | X           |             |             |      |
|                          | 206-010-454-109 | (27)               |                                      |             |             |             | X           | X           | X    |
| Bearing                  | 206-010-420-001 | (28)               | X                                    |             |             |             |             |             |      |
|                          | 206-010-420-003 | (19) (29)          |                                      | X           |             |             |             |             |      |
|                          | 206-010-443-001 | (19)               |                                      |             | X           | X           | X           | X           | X    |
| Inner cap                | 206-010-455-001 | (30) (31)          | X                                    | X           | X           | X           | X           |             |      |
|                          | 206-010-455-103 | (32)               |                                      |             |             |             |             | X           | X    |
| Bearing set              | 206-010-457-001 | (33)               | X                                    |             |             |             |             |             |      |
|                          | 206-010-440-001 |                    |                                      | X           | X           | X           | X           | X           | X    |
| Outer cap                | 206-010-456-001 | (34)               | X                                    | X           |             |             |             |             |      |
|                          | 206-010-444-001 |                    |                                      |             | X           | X           | X           | X           | X    |
| Lever assembly           | 206-010-467-001 |                    | X                                    | X           | X           | X           | X           | X           |      |
|                          | 206-010-467-105 | (35)               |                                      |             |             |             | X           |             | X    |
| Link assembly            | 206-010-407-001 |                    | X                                    | X           | X           | X           |             | X           | X    |

## NOTES

1. Replaced by swashplate and support assembly 206-010-450-005.
2. Can be modified per T.B. 206-77-8 to give a better lubrication of the duplex bearing.
3. Replaced by swashplate and support assembly 206-010-450-007.
4. Replaced by swashplate and support assembly 206-010-450-011.
5. Replaced by swashplate and support assembly 206-010-450-113.
6. Replaced by swashplate and support assembly 206-010-450-125.
7. Replaced by swashplate and support assembly 206-010-450-129.
8. Replaced by support assembly 206-010-452-005.
9. Refer to ASB 206-93-74 Revision B, SWASHPLATE SUPPORT ASSEMBLY, 206-010-452-001/-005/-109, INSPECTION OF. This ASB also introduces 206-010-452-113 swashplate support assembly as a direct replacement for the -001, -005, -109.
10. Support Assemblies 206-010-452-001 and /-005 have a hard-anodized surface.
11. Replaced by support assembly 206-010-452-109.
12. Replaced by support assembly 206-010-452-113.
13. Support Assemblies 206-010-452-109 and /-113 have a tungsten carbide surface.
14. Support assembly 206-010-452-109 was installed on 206B S/N 3567 through 4286 and 5101 through 5114. Support assembly 206-010-452-113 was installed on 206B, S/N 4287 through subsequent, and 5115 through subsequent.
15. Replaced by inner ring assembly 206-010-451-005.
16. Replaced by inner ring assembly 206-010-451-109.

17. Improved inner ring assembly 206-010-451-109 has a smaller outside diameter to permit the application of Polyamide Epoxy Primer MIL-P-85582. The primer gives a better corrosion resistance of the inner ring assembly that is in contact with the duplex bearing inner race. Inner ring assembly 206-010-451-001 and /-005 cannot be modified to a /-009 inner ring assembly.
18. Replaced by outer ring assembly 206-010-453-005.
19. Outer ring assembly 206-010-453-001 must be modified per Service Letter 206A-115 to permit installation of the 206-010-420-003 or the 206-010-443-001 duplex bearings.
20. Replaced by outer ring assembly 206-010-453-009 if the Technical Bulletin 206-77-8 is accomplished.
21. Replaced by outer ring assembly 206-010-453-113.
22. The 206-010-453-113 outer ring assembly has a larger inside diameter to permit the application of Polyamide Epoxy Primer MIL-P-85582. The primer gives a better corrosion resistance of the outer ring assembly surface that is in contact with the duplex bearing outer race. Outer ring assembly 206-010-453-001, /-005, and /-009 cannot be modified to /-113 outer ring assembly.
23. Replaced by sleeve assembly 206-010-454-005.
24. The 206-010-454-001 and /-005 sleeve assemblies have a hard anodized-surface. When you have the 206-010-454-001 or the /-005 sleeve assembly installed, the swashplate friction should be adjusted between 24 to 32 lbs. (10.90 to 14.53 Kg).
25. Sleeve assembly 206-010-454-001 and /-005 can be modified per T.B. 206-79-24 to facilitate the removal of the sleeve bearings.
26. Replaced by sleeve assembly 206-010-454-109.
27. The 206-010-454-109 sleeve assembly has a tungsten carbide surface that offers a better life in service. When you have the 206-010-454-109 sleeve installed, the swashplate friction should be adjusted between 15 and 32 lbs. (6.96 to 14.53 Kg).
28. Replaced by bearings 206-010-420-003 if the outer ring assembly 206-010-453-001 is modified per Service Letter 206A-115.
29. Replaced by bearing 206-010-443-001.

30. Replaced by inner cap 206-010-455-103.
31. Inner cap 206-010-445-001 has a hard anodized-surface.
32. Inner cap 206-010-455-103 has a tungsten carbide surface.
33. Replaced by bearing set 206-010-440-001.
34. Replaced by outer cap 206-010-444-001 if the Technical Bulletin 206-77-8 is accomplished.
35. Refer to ASB 206-00-93 COLLECTIVE LEVER ASSEMBLY 206-010-467-001, MODIFICATION AND NEW COLLECTIVE LEVER ASSEMBLY /-105, INTRODUCTION OF.