

TECHNICAL BULLETIN

Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc.

No. 206-04-182

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DATE
REV

MODEL AFFECTED: 206A/B SERIES HELICOPTERS

SUBJECT: AIRFRAME, AFT CROSSTUBE SUPPORT STRUCTURE, IMPROVEMENT OF.

HELICOPTERS AFFECTED: Model 206A helicopters serial number 4 through 660 and 672 through 715.

Model 206B helicopters serial number 661 through 671 and 716 through 4359.

[Model 206B helicopters serial number 4360 and subsequent will have the intent of this bulletin accomplished prior to delivery]

COMPLIANCE: At Customer's Option or when damage to aft crosstube tunnel structure beyond reparability is found.

DESCRIPTION:

Bell Helicopter has introduced improvement to the aft crosstube tunnel structure on the 206B model serial number 4360 and subsequent. This improvement uses reinforced parts manufactured by chem-milling process. These parts are now procurable through BHT-Approved spares and are direct replacement for the existing parts installed on helicopters built prior to S/N 4360. BHT recommends that all the parts making the improved aft crosstube tunnel structure be installed when a component that is damaged on your helicopter requires replacement.

This bulletin provides information and instructions for the installation of these new parts to reinforce the aft crosstube tunnel structure on helicopters listed in the affected block.

APPROVAL:

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

MANPOWER:

Approximately 36.0 man-hours are required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

MATERIALS:**Required Material:**

Order the parts that follow;

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
206-031-301-121S	Support (Sta. 125.00)	1(Note 1)
206-031-301-129S	Support (left)	1(Note 1)
206-031-301-130S	Support (right)	1(Note 1)
206-031-302-269S	Support (Sta. 130.00)	1
120-098-05B480	Shim	2(Note 2)
MS21059L3	Nutplates	15
100-048-5-4	Pin	20
30-015-5	Collar	20
MS20426AD3-4	Rivet	100
MS20426AD3-4-5	Rivet	100
MS20426AD3-5	Rivet	100
MS20426AD4-4	Rivet	100
MS20426AD4-4-5	Rivet	100
MS20426AD4-5	Rivet	100
MS20470AD4-3	Rivet	100
MS20470AD4-3-5	Rivet	100
MS20470AD4-4	Rivet	100
MS20470AD4-4-5	Rivet	100
MS20470AD4-5	Rivet	100
MS20470AD4-5-5	Rivet	100
MS20470AD4-6	Rivet	50
MS20470AD4-6-5	Rivet	50
MS20470AD4-7	Rivet	50
MS20470AD4-8	Rivet	50
MS20470AD5-6-5	Rivet	20
MS20470AD5-7	Rivet	20
MS20470AD5-7-5	Rivet	20
NAS1097AD4-5	Rivet	20
NAS1097AD5-5	Rivet	25

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
70-022-1	Hanger	10
100-048-5-6	Pin	15
100-048-5-3	Pin	20
140-001-11	Washer	30
MS35489-118	Grommet	2
M7885/6-4-03	Rivet	150
M7885/6-4-04	Rivet	150
NAS1474S3	Dome nuts	15

Notes:

1. The combination of all 3 supports including the fittings P/N 206-031-311-001 (Qty. 2) and the plates P/N 206-030-330-001 (Qty.2) already assembled can be ordered from BHT-Approved spares as a unit. This assembly is available under P/N 206-031-301-101S.
2. Alternate shim can be used and manufactured locally using Al Alloy material, 2024T3, of appropriate thickness.

Consumable Material:

The following material is required to accomplish this bulletin, however this material is considered consumable (bench stock) material and may not require ordering depending on the operators 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>
AMS-S-8802 PT	Sealant	1	C-308(Note 1)
MIL-PRF-81733 (8 OZ)	Sealant	1	C-392 (Note 2)
ACETONE GALLON	Acetone (per Q-A-51)	1	C-316 (Note 3)
MIL-P-85582, TY1, CL2	Primer	1	C-204 (Note 4)
472,BLK,3.00 WIDE	Tape	1	C-456
MIL-C-81706 1 QT	Chemical film (Alodine)	1	C-100

Note:

1. Formerly MIL-S-8802 type of sealant.
2. Formerly MIL-S-81733 type of sealant.
3. As an alternative, use Methyl Ethyl Ketone (C-309).
4. As an alternative, use MIL-P-23377.

SPECIAL TOOLS:

Offset blind rivet (Cherrrymax) puller head # H763-456 or equivalent.
Lifting clevis T101897 or equivalent.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

Illustrated Parts Book BHT-206-SERIES-IPB
Structural Repair manual BHT-206-SRM-1
Standard Practices Manual BHT-ALL-SPM
Maintenance Manual BHT-206A/B-SERIES-MM-1
Service Instructions BHT-206-SI-94

PUBLICATIONS AFFECTED:

Illustrated Parts Book BHT-206-SERIES-IPB

ACCOMPLISHMENT INSTRUCTIONS:

- NOTE -

BHT recommends that all the parts making the improved aft crosstube tunnel structure be installed when damage to a component on your helicopter requires replacement.

PART I: PREPARATION:

1. Refer to BHT-206A/B-SERIES-MM. Defuel the aircraft.
2. Disconnect battery.
3. Remove both aft passengers doors.
4. Remove aft passenger seats and upholstery.
5. Remove the fuel cell and associated components from the fuel cell cavity.

6. Remove the tailboom assembly.
7. Attach lifting clevis or equivalent tool to the top of the mast. Lift aircraft and move the landing gear assembly away from the reworked area. Install both of the fuselage support work aids as described by the applicable 206 Structural Repair Manual.

PART II: REMOVAL OF THE EXISTING AFT CROSSTUBE SUPPORT STRUCTURE:

1. Remove from the baggage compartment area the following items:
 - a. Remove the baggage compartment door from the fuselage.
 - b. The right wall protective panel.
 - c. The aft fuselage bulkhead cover.
 - d. The drain lines from the right outboard corner of the compartment area.
 - e. Disconnect the wire harness located in the right side corner going to the electrical drain switch and the electric components.

CAUTION

It is recommended to use a drill-stopper to prevent drilling into the lower fairing when drilling fasteners attached to the baggage compartment floor.

- NOTE -

The preferred method to get access to the fasteners securing the aft crosstube tunnel components to the bulkhead located at Station 125.00 is by removing the baggage compartment floor. The recommended procedure described here, Step 2 through 7, uses this method,. An alternate method is to remove the lower fairing assembly from the aft fuselage, but it is not covered by this document. Refer to BHT-206-SRM-1 SECTION 1 or BHT-206A/B-SERIES-MM CHAPTER 6 for station diagram.

2. At the right section of frames 206-031-303 (Sta. 142.33) and 206-031-304 (Sta. 154.66) drill and remove the following rivets;
 - a. The 20 rivets located vertically above W.L. 29.47 attaching each frame to the right fuselage skin(s).

- b. The rivets securing each frame lower clips (Sta. 142.33 and 154.66) to the baggage compartment floor panel.
3. Drill the rivets and remove the clip angle located between the two frames at Sta. 155.66 and 167.00. Retain the angle for installation later.
4. Drill the rivets and remove the angle securing the lower right section of the frame at Station 167.00 to the baggage compartment floor. Retain angle for installation later.
5. Drill and remove the remaining rivets attaching the baggage compartment floor to the fuselage.

- NOTE -

Ensure to not damage the frames.

6. Move the lower portion of each frame (Ref. Sta. 142.33 and 154.66) forward and secure in place to give clearance for removal of the baggage compartment floor.
7. Use a warm thin blade putty knife to break the sealant used at the riveted joints between the floor and the fuselage components. Lift the left outboard edge of the floor panel and work gently out of the fuselage;
 - a. Inspect the floor panel for damage and condition.
 - b. Carry out a tap test on any suspected area of the floor panel.
 - c. Replace panel if damaged beyond repairable limit.
8. Refer to Figure 1, View B and remove all the fasteners below W.L. 29.47, which attach the two tee fittings (7) and the cargo hook support (6) to the aft support (2).

- NOTE -

Fuel cell lacing hangers 70-022-1 are installed on aircraft prior to S/N 2326.

- NOTE -

Refer to Service Instruction 206-94 for reference to installation of cargo hook support (6) on ship S/N 4 through S/N 913.

9. Remove all the fasteners above W.L. 29.47, which attach the two supports (1, 2), the fuel cell lacing hangers, if applicable, (8 places, refer to note 4) and the forward angles (19, View G-G) attached to the bulkhead (13) which support the front edge of the baggage compartment floor.
 - a. Use a warm thin blade putty knife or equivalent tooling to break the sealant at the riveted joints. Remove the baggage compartment floor supporting angles (19). Retain the angles for installation later.
10. Refer to View E-E. Drill and remove the six rivets (2 places), which secure each extremity of the forward support (1) to each of the outboard angles (8).
11. Drill and remove all the rivets securing the lower flange of the forward support (1) and the dome nuts (17) to the lower shell (9).
12. Refer to View B. Drill and remove all the rivets securing the lower flange of the aft support (2) and the nutplates (14) to the aft fairing (10).
13. Refer to View C. Disconnect the electric harness from the standoff bracket (15) located on the forward support (1).
 - a. Move the rubber grommets (16) away from each support (1,2).
 - b. Pull electric harness through each support (1,2) and let rest inside fuel cell cavity.
14. Refer to Figure 1, sheet 1 of 7. Drill and remove three rivets (4 places) at each outboard end of the stiffeners (18) installed at each extremity under the lower face of the forward support (1);
 - a. Use cutter pliers to cut the vertical flange of each stiffener (18) inboard of the most inboard rivet that was removed on each stiffener (18).
 - b. Use regular pliers and bend each de-riveted section of the stiffener (18) away from under the angles (8).
15. Use a warm thin blade putty knife or equivalent tooling to break the sealant between the riveted joints of the forward support (1) and the following locations;
 - a. Between the upper flange of the forward support (1) and the bulkhead (13).
 - b. Between each left and right support (3, 4) and the aft support (2).
 - c. Between the fittings (11) and the aft support (2).
 - d. Between each extremity of the forward support (1) and both left and right angles (8).

- CAUTION -

Make sure that the blade of the putty knife or the equivalent tool being used does not puncture the core bevel of the lower shell.

- e. Between the forward lower flange of the support (1) and the lower shell (9) aft flange.

- NOTE -

The forward support assembly (1) will not come out of the fuel cell cavity until aft support (2) is removed from the airframe.

- 16. With the left and right supports (3,4) and fittings (11) still attached to the forward support (1), reach with your arm inside the aft crosstube tunnel and push upward, the forward support assembly (1), until it becomes free from the airframe.
 - a. Move the support assembly forward to rest inside the fuel cell cavity.
- 17. Use a warm thin blade putty knife or equivalent tooling to separate the aft support (2) from the airframe as follows;

- CAUTION -

Ensure that the blade of the putty knife or the equivalent tool being used does not puncture the core bevel of the aft fairing.

- a. Separate the lower flange of the support (2) from the aft fairing (10) forward flange.
 - b. Separate the support (2) from the vertical tee fittings (7).
 - c. Separate the support (2) from the cargo hook support (6).
 - d. Separate the upper edge of the aft support (2) from the bulkhead (13).
- 18. Move the lower portion of the support (2) forward and pull the support (2) down and out of the airframe cavity.
 - 19. Remove the forward support (1) along with the supports (3, 4), fittings (11) and wear plates (12) as a unit from fuel cell cavity by pulling it through the seat back cover opening.
 - 20. Place the forward support assembly (1) on a workbench. Drill and remove the rivets securing the supports (3, 4) and the fittings (11) to the forward support (1).

- a. Use a warm thin blade putty knife or equivalent tool to separate the forward support from each assembly. Discard the removed support (1).
 - b. Remove the fasteners securing each wear plate (12) and fitting (11) to their mating support (3, 4). Use a warm thin blade putty knife or equivalent tool to separate each part. Discard the removed supports (3,4).
21. Inspect each fitting (11) and wear plate (12) for damage and condition. Wear exceeding 10% of the component thickness is caused for replacement of the affected part.
 22. Inspect the aft edge of the lower shell (9) for damage. Repair damaged edge as required in accordance with the applicable Structural Repair Manual (SRM). Re-drill affected holes in the proper location before installing the forward support (1) in place.
 23. Inspect the forward edge of the aft lower fairing (10) for damage. Repair damaged edge as required in accordance with SRM. Re-drill affected holes in the proper location before installing the support (2) in place.

PART III: INSTALLATION OF THE AFT CROSSTUBE TUNNEL STRUCTURE:

1. Clean all the sealant residues from the fuselage structure and the salvaged components.

- NOTE -

Reference marks (lines) made on the flanges and edges will help align the parts with airframe and determine if acceptable location and edge distance for each rivet holes can be obtained before you drill for final installation.

-NOTE-

The forward support assembly (1) cannot be installed through fuel cell access hole if aft support (2) is installed.

2. Refer to Figure 1,View B. Place the new aft support (2) in position in the airframe at Station 130.00. Check for best fit as follows;
 - a. While you maintain the proper position and alignment of edges and flanges, make sure that you have adequate edge distance for all rivet holes to be drilled. Refer to chapter 3 of the SRM manual for acceptable tolerances for holes with low edge distance.

- b. Verify for gaps between the lower flange of the aft support (2) and the contours of the lower fairing (10). Gaps less than 0.020 inch (0.508 mm) are acceptable and will be filled with sealant during final assembly. For gaps in excess of 0.020 inch (0.508 mm), fabricate tapered shims, using BHT material specification P/N 120-098-05B480 as required or fabricate the shims locally using Al Alloy material, 2024T3, of the appropriate thickness. The shims can be tapered to 0.005 inch (0.127 mm) minimum thickness and must be secured in place between the mating flanges of the support (2) and the lower fairing (10) by a minimum of two rivets or more.
- c. Position the applicable shims in place and install clamps to temporarily secure the lower flange of the aft support (2) to the forward flange of the lower fairing (10).

- NOTE -

It is acceptable on some aircraft to drill four additional holes in the cargo hook support (6) and the support (2), below W.L. 29.47, to meet the quantity of fasteners shown under View B.

- d. Transfer all holes from the forward flange of the lower fairing assembly (10) into the lower flange of the aft support (2) and the shims (if applicable). Install Clecos.
- e. Transfer the rivet holes from the bulkhead (13) above WL 29.47 to the upper edge of the support (2). Transfer the fuel cell hanger attachment holes (8 places), if applicable. Install Clecos.
- f. Refer to View B. Transfer all the fastener holes from the left and right tee fittings (7) and from the cargo hook support assembly (6) into the aft support (2). Install Clecos.

- NOTE -

Reference marks (lines) made on the flanges and edges will help align the parts with airframe and determine if acceptable location and edge distance for each rivet holes can be obtained before you drill for final installation.

- 3. Refer to Figure 1, sheet 1. Remove the clecos above W.L. 29.47, which secure the aft support (2) to the bulkhead (13). Place the new forward support (1) in position in the airframe at Station 125.00.

4. Maintain the support (1) against the vertical bulkhead (13) and the two angles (8) located at each extremity of the forward support (1).
 - a. Transfer all the rivet holes from the aft support (2) and the bulkhead (13) into the upper flange of the forward support (1). Transfer the fuel cell hanger attachment holes (8 places, refer to note 4), if applicable. Install Clecos.
 - b. Transfer the six rivets from each angle (8) into each extremity of the forward support (1) and install Clecos.
5. Position each fitting (11) against the aft support (2) and install clecos through the tee fitting (7) to get their proper vertical position
6. On a bench, prepare the new supports (3,4) for installation as follows;
 - a. Refer to View E-E, locate and drill the 7 holes at the center of the upper flange. Refer to View C, locate and drill the 10 rivet holes at the center of the forward flange on each support (3, 4). Do not drill holes in the aft flange of the supports (3,4) at this time. This will be done later.
 - b. Deburr holes in supports (3,4)
7. Refer to View B, install each support (3,4) inside the crosstube tunnel and clamp into position against each fitting (11) which are already temporarily secure to the aft support (2).
8. Make sure the supports (3,4) are tight against the aft support (2). Transfer the 10 rivet holes from each tee fittings (7) into the aft flange of each support (3,4). Install Clecos.
9. Use a square to align the forward flange of supports (3,4) and the fittings (11) at 90 degrees with the aft face of the forward support (1). Draw a vertical reference line onto the forward support (1) beside each support (3,4) for future reference.
10. Maintain the forward support (1) tight against the two supports (3,4) and the fittings (11);
 - a. Refer to View E-E, transfer the 7 rivet holes from upper flange of each support (3,4) into the horizontal web of the forward support (1). Install Clecos.
 - b. Refer to View C, transfer the 10 rivet holes from the forward flange of each support (3,4) into the vertical web of the forward support (1). Install Clecos.
 - c. Transfer the 4 holes from each forward flange of the fittings (11) into the horizontal web of the forward support (1). Install Clecos.

11. Verify the fit of the forward support (1) with the lower shell (9) as follows;

- a. Verify for gaps between the lower flange of the forward support (1) and the contours of the lower shell (9). Gaps of less than 0.020 inch (0.508 mm) are acceptable and will be filled with sealant during final assembly. For gaps in excess of 0.020 inch (0.508 mm), fabricate tapered shims, using BHT material specification P/N 120-098-05B480 as required or fabricate the shims locally using Al Alloy material, 2024T3, of the appropriate thickness. The shims can be tapered to 0.005 inch (0.127 mm) minimum thickness and must be secured in place between the mating flanges of the support (1) and the lower shell (9) by a minimum of two rivets or more.
- b. Position the applicable shims in place. Transfer all the holes from the lower flange of the lower shell (9) into the lower flange of the forward support (1). Install Clecos.

-NOTE-

Some aircraft may have fewer Hi-Lok fasteners than seen in View G-G. For these aircraft, drill and install the additional fasteners in each support (3,4) and fitting (11) to meet the quantity of fasteners shown under View G-G.

12. Refer to View G-G. Transfer the 5 solid rivet holes (located above wear plate (12) and the 7 the Hi-Lok fasteners holes from each fitting center web into the mating support (3,4). Install Clecos. Mark excessive material existing on each support (3,4) to be trimmed in order to get the 0.090 inch (2.29 mm) clearance as shown.

13. Identify the location of each added shim, if applicable. Remove the forward support (1), the left and right supports (3, 4), the two fittings (11) and the aft support (2) and all applicable shims from the tunnel. Deburr all parts.

14. If applicable, trim the extra material on each affected support (3, 4) as was marked in Step 12;

- a. Refinish all bare metal surfaces (C-100) and apply primer (C-204) as required.

15. Refer to View G-G. With parts on bench, apply sealant (C-392) to the faying surfaces of supports (3,4), each fitting (11) and the forward support (1). Assemble all mating parts together using rivets and fasteners shown in Figure 1, sheet 1 and sheet 4. Install all applicable fasteners wet with sealant (C-392). Do not install the 5 Hi-Lok fasteners common to each wear plates (12) at this time. This will be done later.

16. Refer to View C. Locate the electrical standoff bracket (15) on aft face of the support (1) at the location shown and drill two holes using drill #30 drill (0.1285 inch (3.26 mm) diameter;

- a. Deburr all holes.
- b. Apply sealant (C-308) to the faying surface of the electrical standoff bracket (15) and install on aft face of the forward support (1). Install rivets MS20470AD4 wet with sealant (C-308). Ensure the head of each rivet is towards fuel cell cavity.

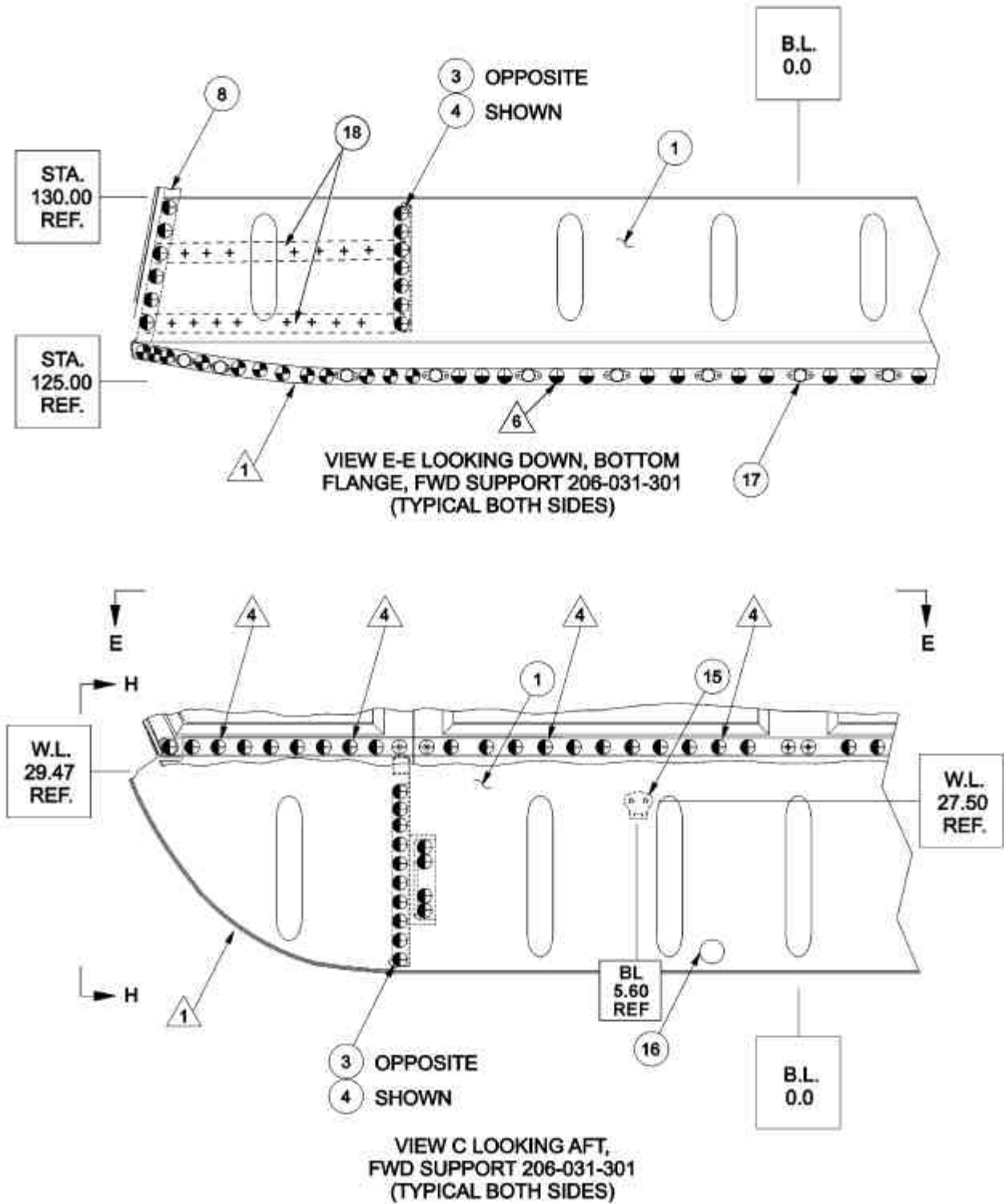
-NOTE-

The forward support assembly (1) cannot be installed through fuel cell access hole if aft support (2) is installed.

17. Slide the forward support through the fuel cell cavity access hole. Let the forward support rest inside the fuel cell cavity for the time being.
18. Apply sealant (C-392) to the faying surfaces of the aft support assembly (2) and all the applicable shims, the left and right tee fittings (7), the cargo hook support (6), and the lower fairing (10);
 - a. Position and temporarily secure the support (2) to the lower fairing (10), the tee fittings (7) and the cargo hook fitting (6) with Clecos. Do not install Clecos above W.L. 29.47 at this time.
19. Apply sealant (C-308) to the faying surfaces of the forward support assembly (1), and all the applicable shims, the aft face of the supports (3, 4), the fittings (11) and each angle that will support the forward edge of the baggage compartment floor. Move the forward support assembly (1) against the bulkhead, the aft support (2), the two angles (8) and the lower shell (9). Install clecos.
20. Secure each part permanently to the fuselage using the appropriate fasteners wet with sealant (C-392). Make sure new fuel cell hangers P/N 70-022-1 (8 places, refer to note 4), if applicable, are installed back inside the fuel cell cavity above W.L. 29.47. Install hangers with rivet MS20470AD3 and washers P/N 140-001-11 (2 each, refer to Note 4).
21. Install the 14 dome nuts (17) inside the fuel cell cavity.
22. Install new grommets (16) in each of the support (1, 2).
23. Run the electric harness through the support (1). Clamp harness to the standoff bracket (15).
24. Run the harness through the aft support and connect electric leads to the electric drain valve and other applicable items.

25. Refer to View G-G. Apply sealant (C-392) between faying surfaces of wear plates (12) and mating fittings (11). Secure the plates (12) to their mating fitting (11) using the fasteners shown wet with sealant (C-392).
26. Apply chemical film (C-100) and primer (C-204) to all bare metal surfaces.
27. Apply paint finish to aft crosstube support structure as required.
28. Make sure all loose debris are removed from the baggage compartment area. Coat the faying surfaces of the baggage compartment floor, the clips and the frames (Sta. 142.33 and 154.66) with sealant (C-308) and install back at their original place. Use rivets M7885/6/4 at all inaccessible locations and MS20470AD4 at all accessible locations wet with sealant (C-308).
29. Install the following items back in place at the baggage compartment area;
 - a. The drain lines from the right outboard corner of the compartment area.
 - b. The right wall protective panel.
 - c. The aft fuselage bulkhead cover.
 - d. The baggage compartment door from the fuselage.
30. Support the weight of the aircraft with a suitable hoist and the lifting clevis T101897 or equivalent tool.
31. Remove both of the fuselage supports work aids.
32. Install the landing gear under the fuselage.
33. Disconnect the hoist and remove the lifting clevis T101897 or the equivalent tool.
34. Install the tailboom assembly.
35. Remove all debris from the fuel cell cavity. Cover all the visible fasteners inside the fuel cell cavity with sealant (C-308) and let cure.
36. Apply new protective tape (C456) over affected areas inside fuel cell cavity.
37. Install the fuel cell and associated components.
38. Install aft passenger seats and upholstery.
39. Install both aft passengers doors.

40. Connect the battery.
41. Fuel the aircraft and verify for leaks.
42. Annotate the aircraft technical records to indicate that the compliance with this bulletin was completed.



03505001

Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 1 of 7)

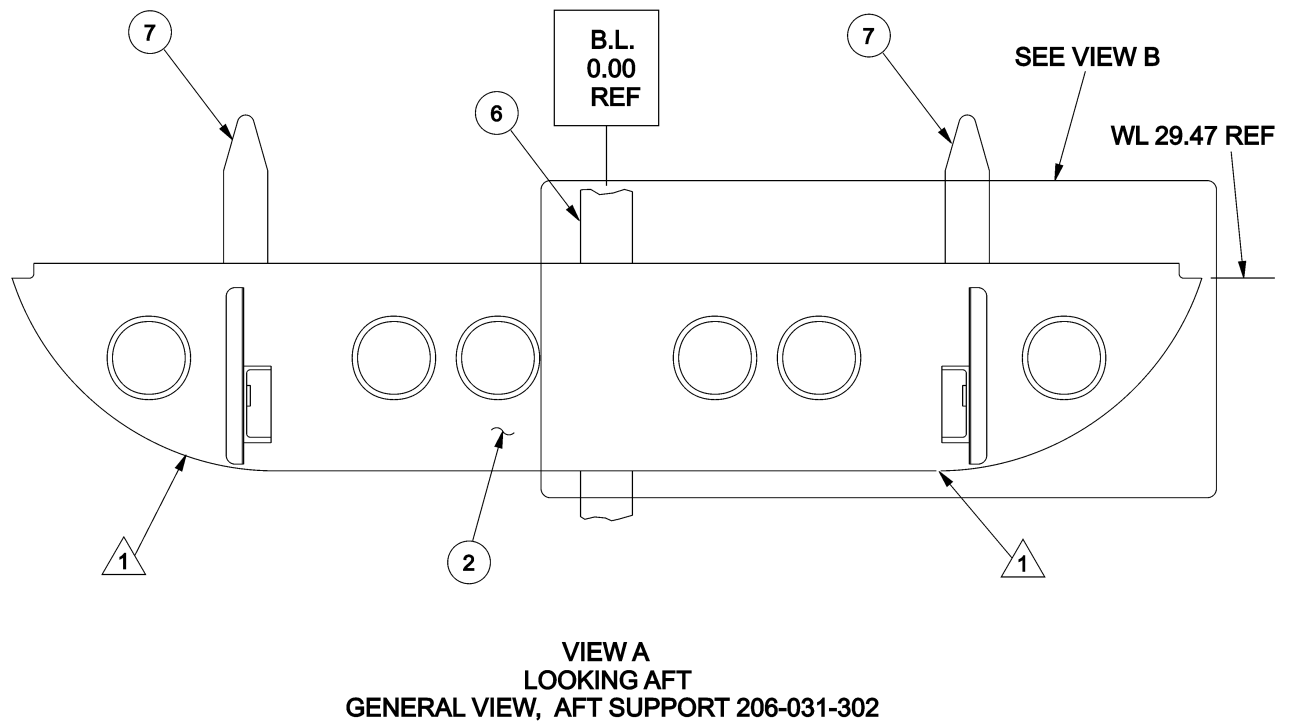
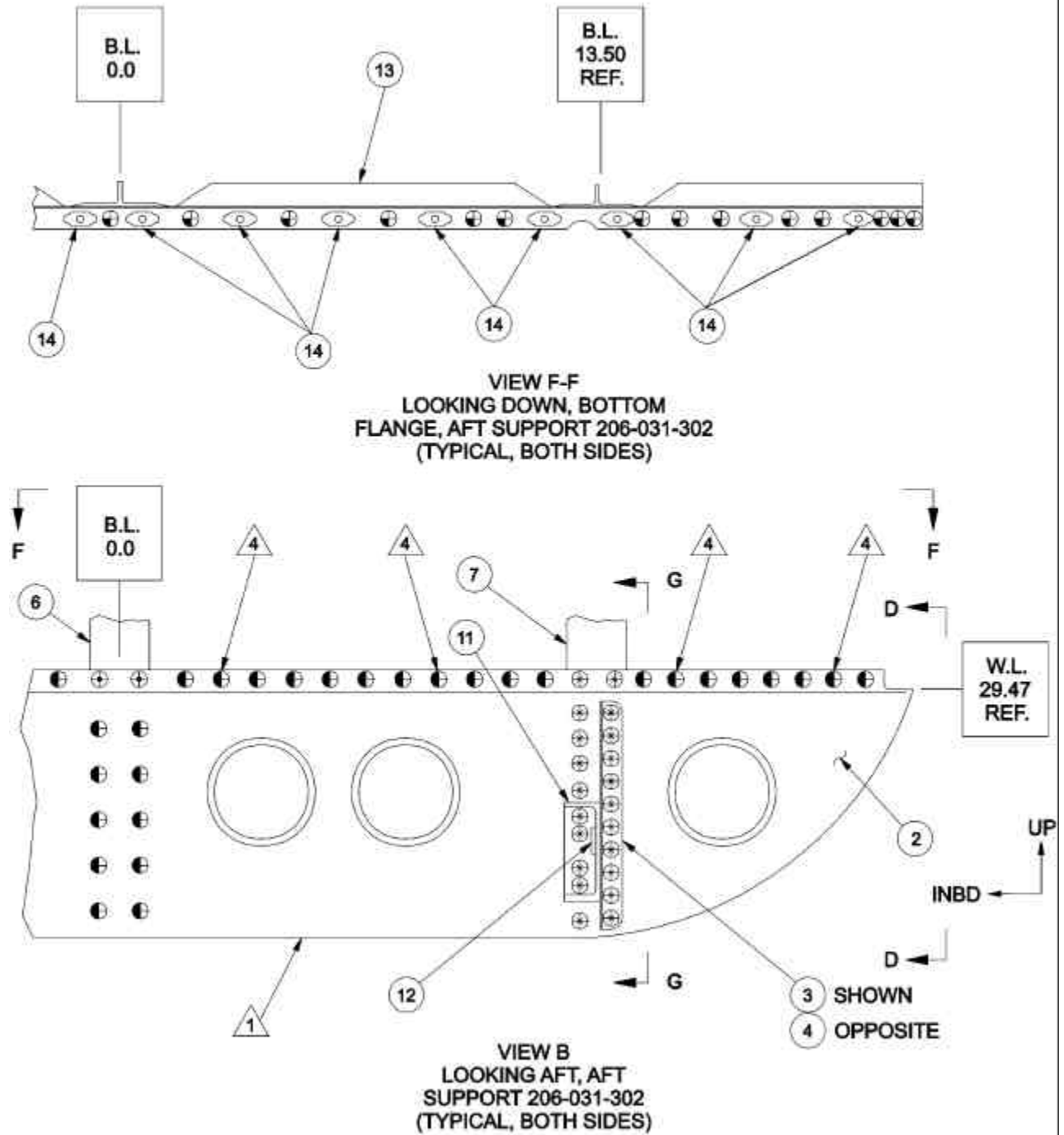


Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 2)



03505303

Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 3)

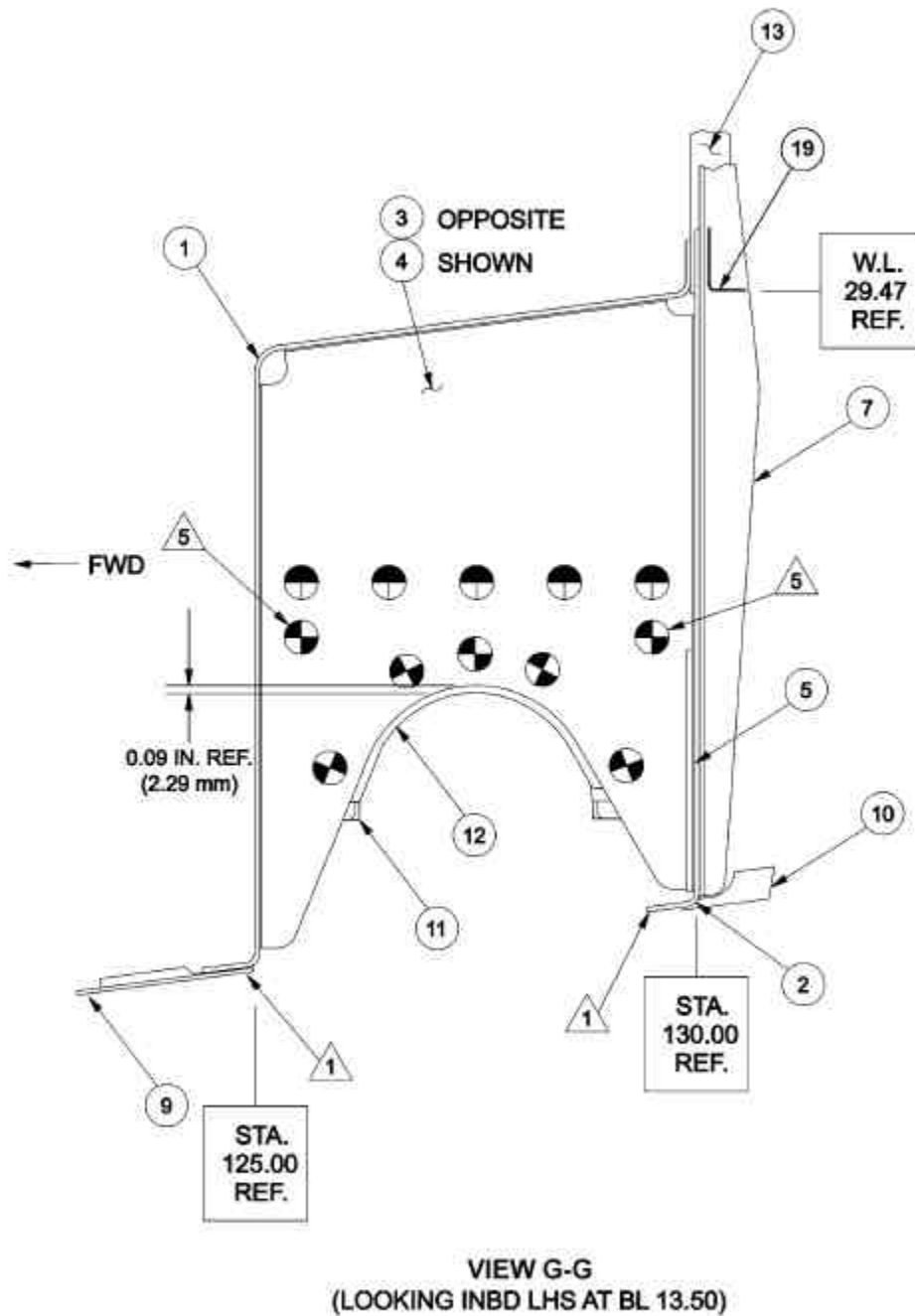
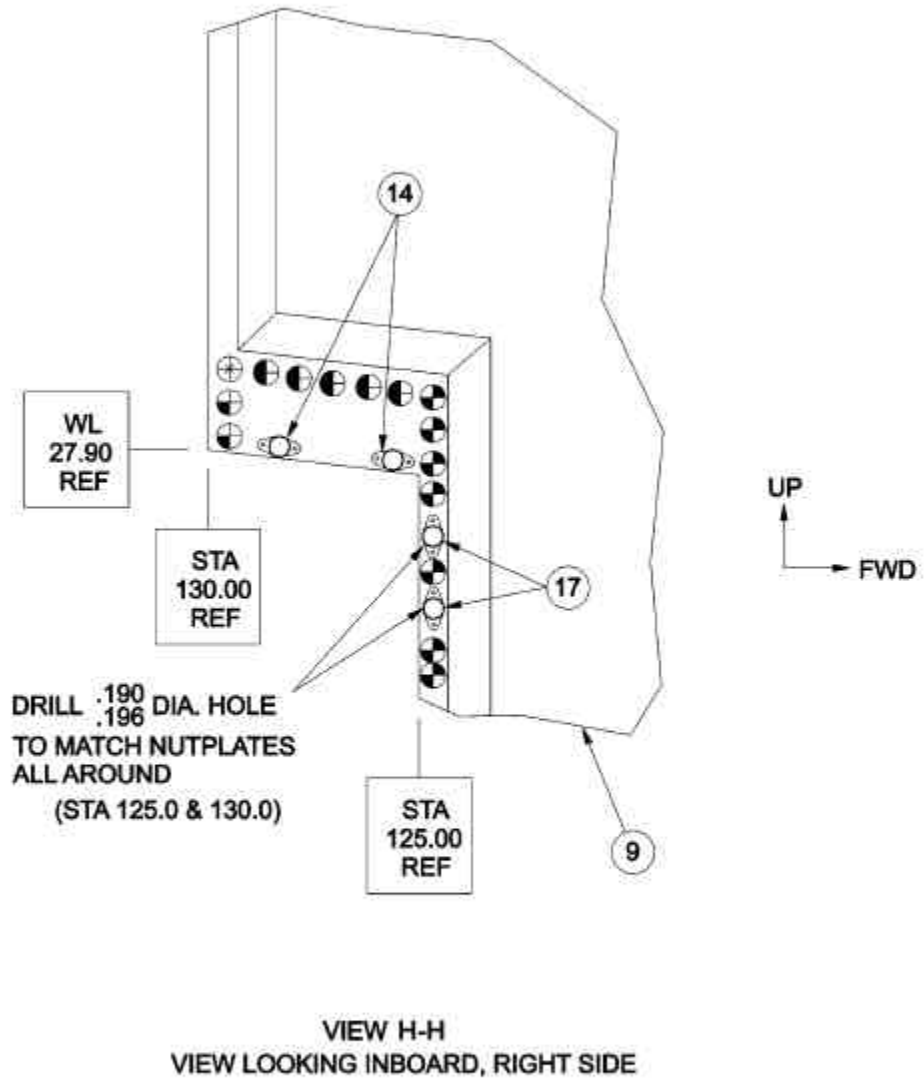
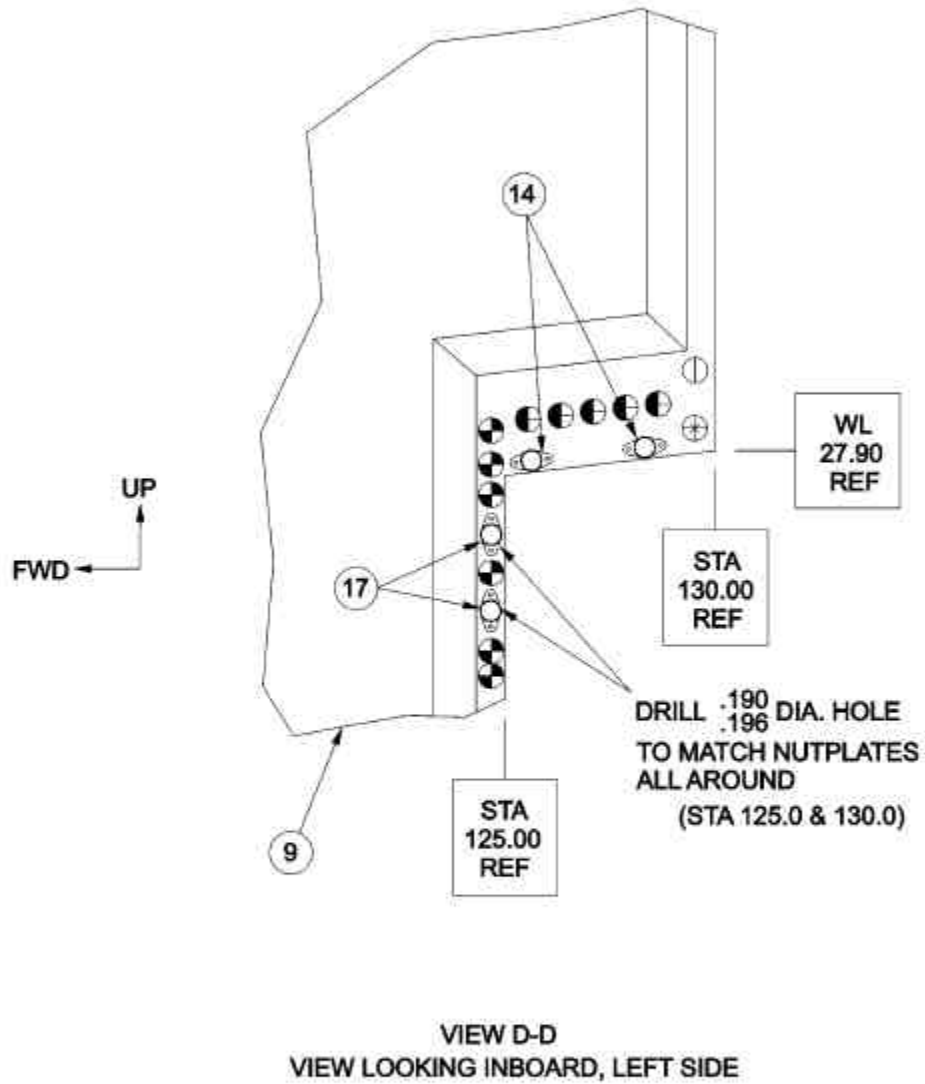


Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 4)



03505002

Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 5)



03505007

Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 6)

LEGEND:

1. Forward support P/N 206-031-301-121S (Ref. Sta. 125.00)
2. Aft support P/N 206-031-302-269S (Ref. Sta. 130.00)
3. Left support assembly P/N 206-031-301-129S (Ref. LBL 13.50)
4. Right support assembly P/N 206-031-301-130S (Ref. RBL 13.50)
5. Hot bonded radius block (Ref.)
6. Cargo Hook support fitting (Ref.)
7. Vertical fittings (tee)(Ref.)
8. Airframe side longeron 206-031-318 (Ref.)
9. Lower shell (Ref.)
10. Aft lower fairing (Ref.)
11. Fitting 206-031-311 (Ref.)
12. Wear plate 206-030-330 (Ref.)
13. Bulkhead assembly (Sta.130.00)(Ref.)
14. Nutplates MS21059L3 and rivets MS20426AD3-4 (Ref.) 20 places
15. Electrical standoff bracket P/N 90-002-1 and Rivets MS20470AD4 (Ref.)
16. Grommet (Ref.) (MS35489-118 and MS35489-6)
17. Dome nuts NAS1474S3 and rivets MS20426AD3-4 (Ref.) 15 places
18. Stiffeners (Ref.)
19. Baggage floor FWD angles (Ref.)

NOTES:

1. Check for gaps above 0.020 inch (0.508 mm) and install permanent shim 120-098-05B480. Taper shim as required and secure in place with a minimum of two or more fasteners.
2. Coat all faying surfaces with sealant (C-392).
3. Install all fasteners wet with sealant (C-392).
4. On ship S/N 4 through 2326, install fuel cell hangers P/N 70-022-1 with washers 140-001-11 and rivets MS20470AD3 back inside fuel cell cavity (8 places).
5. Add these fasteners if not installed originally.
6. MS20426AD4 can be installed in lieu of NAS1097AD4.

RIVET LEGEND

- ⊕ MS20470AD5
- ⊙ MS20470AD4
- ⊙ MS20426AD4
- ⊕ PIN 100-048-5-4 & COLLAR 30-015-5
- ⊙ PIN NAS1054-5 & COLLAR NAS528-A5
- (NOTE: FASTENER SUBSTITUTE CAN BE FOUND IN STRUCTURAL REPAIR MANUAL BHT-206-SRM-1)
- MS20426AD5
- + EXISTING FASTENERS
- ⊙ NAS1097AD5
- ⊙ NAS1097AD4

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Figure 1. Support assembly 206-031-301 and 206-031-302, installation of (Sheet 7)