

TECHNICAL BULLETIN

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

NO 206L-00-201

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REV.

MODELS AFFECTED: 206L Series

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

HELICOPTERS AFFECTED: 206L, S/N 45004 through 45153, and 46601 through 46617.
206L1, S/N 45154 through 45790.
206L3, S/N 51001 through 51612.
206L4, S/N 52001 through subsequent.

SWASHPLATE AND SUPPORT ASSEMBLIES AFFECTED:

SWASHPLATE AND SUPP. ASSY. P/N	NOTES	PRODUCTION EFFECTIVITY
206-010-450-007	(1)	206L, 45004 through 45026
206-010-450-011	(1)	206L, 45027 through 45153 46601 through 46617
206-010-450-011	(1)	206L1, 45154 through 45790
206-010-450-113	(1)	206L3, 51001 through 51307
206-010-450-125	(1)	SPARES
206-010-450-129	(2)	SPARES
206-010-450-117	(1)	206L3, 51308 through 51515
206-010-450-119	(1)	206L3, 51516 through 51612
206-010-450-127	(1)	SPARES
206-010-450-131	(3)	SPARES
206-010-450-101	(1)	206L4, 52001 through 52226
206-010-450-123	(1) (4)	206L4, 52227 through subsequent

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 206L, S/N 45004 through 45153 and 46601 through 46617; 206L-1, S/N 45154 through 45790 and 206L-3, S/N 51001 through 51307, provided you have not completed Technical Bulletin 206L-91-153 Mod. B.

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3. The swashplate and support assembly /-131 is the stocked spare swashplate and support assembly that you can use on 206L3 S/N 51308 through 51612. Also it can be used on all 206L, 206L-1 and 206L-3 S/N 51001 through 51307 provided that you have completed technical Bulletin 206L-91-153 Mod. B.
4. The swashplate and support assembly /-123 is the current production configuration and the stocked spare swashplate and support assembly that you can use on 206L-4, S/N 52001 through subsequent.

COMPLIANCE:

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

DESCRIPTION:

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

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 INSTRUCTIONS. 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 206L Series Component Repair & Overhaul Instruction Manual, Chapter 62.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-206L-CR&O, 18 June 1993.

Chapter 62, Main Rotor.

T.B. 206L-79-25 SWASHPLATE PIVOT SLEEVE ASSEMBLY
P/N 206-010-454-001 AND /-005, MODIFICATION OF.

A.S.B. 206-93-89, Rev B SWASHPLATE SUPPORT ASSEMBLY
206-010-452-001/-005/-009, INSPECTION OF.

A.S.B. 206L-00-116 COLLECTIVE LEVER ASSEMBLY 206-010-467-001,
MODIFICATION AND NEW COLLECTIVE LEVER
ASSEMBLY /-105, INTRODUCTION OF.

BHT-206L-SERIES-IPB, 01 December 1996, Rev. 1, 02 February 1998.

Chapter 62, Main Rotor.

PUBLICATIONS AFFECTED:

BHT-206L-CR&O, 18 June 1993.

Chapter 62, Main Rotor.

BHT-206L-SERIES-IPB, 01 December 1996, Rev. 1, 02 February 1998.

Chapter 62, Main Rotor.

ACCOMPLISHMENT INSTRUCTIONS:

1. Swashplate and support assembly, disassembly and assembly instructions.
 - For disassembly and assembly instructions, refer to the BHT-206L-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 correct configuration dash number that you defined in Step 2.
 - 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~~-123 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 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 the Technical Bulletin is completed.

NOTES

1. Replaced by swashplate and support assembly 206-010-450-011.
2. Replaced by swashplate and support assembly 206-010-450-113.
3. Replaced by swashplate and support assembly 206-010-450-125.
4. Replaced by swashplate and support assembly 206-010-450-129. Refer to swashplate and support assemblies affected block for correct usage.
5. Replaced by swashplate and support assembly 206-010-450-119.
6. Replaced by swashplate and support assembly 206-010-450-127.
7. Replaced by swashplate and support assembly 206-010-450-131. Refer to swashplate and support assemblies affected block for correct usage.
8. Replaced by swashplate and support assembly 206-010-450-123. Refer to swashplate and support assemblies affected block for correct usage.
9. Replaced by support assembly 206-010-452-005.
10. Refer to ASB 206L-93-89 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 206-010-452-001, /-005, and /-109 installed on 206-010-450-007, /-005, and /-113 swashplate and support assembly respectively.
11. Support Assemblies 206-010-452-001 and /-005 have a hard anodized-surface.
12. Replace by support assembly 206-010-452-109.
13. Replaced by support assembly 206-010-452-113.
14. Support Assemblies 206-010-452-109/-113 and 206-010-445-105/-113 have a tungsten carbide surface that offers a better life in service.
15. Replaced by support assembly 206-010-445-105 if T.B. 206L-91-153 Modification B is accomplished.
16. Replaced by support assembly 206-010-445-113.

17. Replaced by inner ring assembly 206-010-451-109.
18. 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 206-010-451-005 cannot be modified to a /-109 inner ring assembly.
19. Replaced by outer ring assembly 206-010-453-113.
20. 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 206-010-453-009 cannot be modified to /-113 outer ring assembly.
21. Replaced by sleeve assembly 206-010-454-005.
22. 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 Kg to 14.53 Kg).
23. Replaced by sleeve assembly 206-010-454-107.
24. Replaced by sleeve assembly 206-010-454-109.
25. The 206-010-454-107 sleeve assembly was installed on 206L4, S/N 52001 through 52197 only. The 206-010-454-107 sleeve assembly is the same as the /-109 sleeve assembly except that the identification "206L4" is vibroetched on it.
26. The 206-010-454-107 and the /-109 sleeve assemblies have a tungsten carbide surface that offers a better life in service. When you have the 206-010-454-107 or the /-109 sleeve installed, the swashplate friction should be adjusted between 15 to 32 lbs (6.82 Kg to 14.53 Kg).
27. Replaced by inner cap 206-010-455-103.
28. Inner cap 206-010-455-001 has a hard anodized surface.
29. Inner cap 206-010-455-103 has a tungsten carbide surface that offers a better life in service.

30. Replaced by bearing set 206-010-440-001.
31. Replaced by lever assembly 206-010-467-105.
32. Replaced by lever assembly 206-010-447-109.
33. Lever assembly 206-010-447-105 was installed on 206L-4 S/N 52001 through 52176. Some serial numbers have 1200 hours retirement life. Refer to ASB 206L-98-110.
34. Lever assembly 206-010-447-109 was installed on 206L-4 S/N 52177 through subsequent.
35. Replaced by idler link assembly 206-010-446-105.
36. Idler link assembly 206-010-446-105 was installed on 206L-4 S/N 52001 through 52176. Some serial numbers have 1200 hours retirement life. Refer to ASB 206L-98-110.
37. Replaced by idler link assembly 206-010-446-107.
38. Idler link assembly 206-010-446-107 was installed on 206L4 S/N 52177 through subsequent.
39. Refer to ASB 206L-00-116 COLLECTIVE LEVER ASSEMBLY 206-010-467-001, MODIFICATION AND NEW COLLECTIVE LEVER ASSEMBLY /-105 INTRODUCTION OF.