

TECHNICAL BULLETIN
Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc.

No. 212-03-191

Date May 16, 2003

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DATE
REV

MODEL AFFECTED: 212

SUBJECT: TRANSMISSION DEBRIS COLLECTOR
ASSEMBLY P/N 212-040-146-001 TO -101FM,
MODIFICATION OF.

HELICOPTERS AFFECTED: All model 212 helicopters.

COMPLIANCE: At Customer's Option

DESCRIPTION:

Bell Helicopter has received reports regarding the planetary chip detector in the transmission assembly fouling against the collector assembly causing false chip indications.

The intent of this technical bulletin is to enlarge the chip detector hole in the debris collector assembly to eliminate possible interference between collector assembly and chip detector.

APPROVAL:

The engineering design aspects of this bulletin are FAA/DER approved.

MANPOWER:

Approximately 0.5 man-hours are required to complete this bulletin when accomplish during normal overhaul. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

MATERIALS:

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>
MIL-C-81706 1 QT	Alodine 1200 or 1201	A/R	C-100
TT-N-95,TYII 1GAL	Aliphatic Naptha	A/R	C-305

SPECIAL TOOLS:

None required

WEIGHT AND BALANCE:

Not affected

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-212-IPC Illustrated Parts Breakdown
BHT-212-CR&O Component Repair and Overhaul

PUBLICATIONS AFFECTED:

BHT-212-IPC Illustrated Parts Breakdown, Chapter 63.

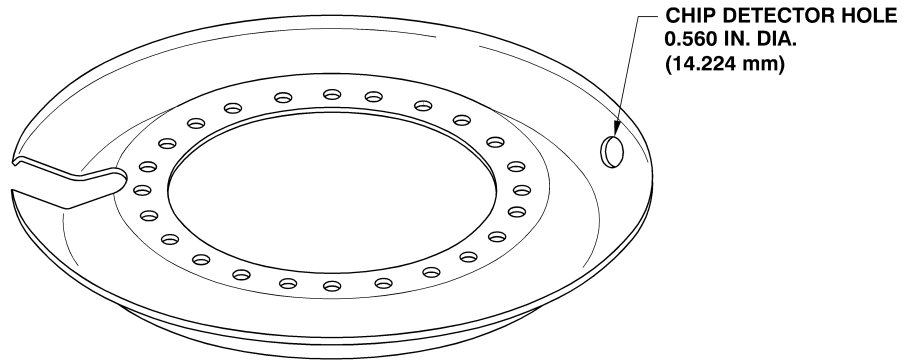
ACCOMPLISHMENT INSTRUCTIONS:

1. Locate the chip detector hole on the debris collector pan P/N 212-040-146-001.

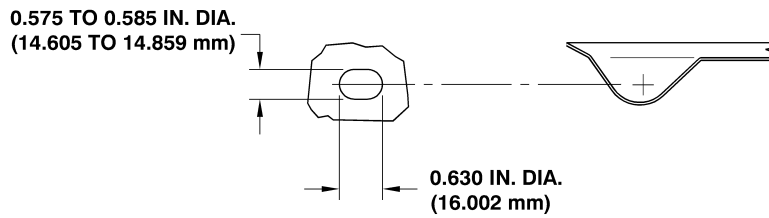
-NOTE-

The debris collector pan is made from aluminum. Use the proper rotary file on your pencil grinder.

2. With a pencil grinder or equivalent, remove .035 inch (.889 mm) of material from each side of the hole. Refer to figure 1.
3. Remove .007 to .014 inch (.177 to .355 mm) of material from the top and bottom of the hole.
4. Polish all sharp edge.
5. Treat reworked area with Alodine (C-100)
6. Install debris collector pan in transmission as per BHT-212-CR&O.
7. Make entry in the helicopter historical records indicating the transmission debris collector assembly P/N 212-040-146-001 has been modified to P/N 212-040-146-101FM.



DEBRIS COLLECTOR PAN
(212-040-146-001)



REWORK HOLE TO THESE DIMENSIONS

Figure 1
Debris collector pan modification