

TECHNICAL BULLETIN
Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc.

No. 212-06-203

Date Jun 13, 2006

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DATE
REV

MODEL AFFECTED: 212

SUBJECT: INSTALLATION OF MISSING RIGGING RIVETS

HELICOPTERS AFFECTED: Spare Tailbooms P/N 212-030-100-203 or -229, serial number PZ-1001 through PZ-1053.

[The following Tailbooms will have the intent of this bulletin accomplished prior to delivery:

PZ-1010, PZ-1015, PZ-1016, PZ-1017, PZ-1024, PZ-1029, PZ-1030, PZ-1031, PZ-1040, PZ-1041, PZ-1042, PZ-1043, PZ-1045, PZ-1046, PZ-1047, PZ-1049, PZ-1050, PZ-1051, PZ-1052, PZ-1054 and subsequent]

COMPLIANCE: Prior to installation of the tailboom on a Model 212 helicopter.

DESCRIPTION:

It was recently brought to Bell Helicopter's attention that some tailbooms were missing three reference rivets used to rig the elevators. Although these rivets have no use on Model 412 & 412EP, they are necessary when the affected tailbooms are installed on Model 210 or 212 helicopters. This Technical Bulletin shows how and where to install these rivets. Only serial numbers with prefix PZ are affected.

APPROVAL:

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

MANPOWER:

Approximately 0.5 man-hour is 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.

MATERIALS:

Required Material:

The following material is required for the accomplishment of this bulletin and may be obtained through your Bell Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
NAS9304B-4-01	Rivet	3

SPECIAL TOOLS:

None required

WEIGHT AND BALANCE:

Not affected

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-212-MM Maintenance Manual

PUBLICATIONS AFFECTED:

None affected

ACCOMPLISHMENT INSTRUCTIONS:

1. Make helicopter ready for maintenance.
2. Remove both lower access doors on tailboom belly. Remove RH elevator.
3. Locate position for rivets as follows (refer to Figure 1):
 - a. From inside of tailboom structure, measure distance between center of rivets and bulkhead at BS 164.28. Transfer dimension on outside of tailboom structure and add 0.040" for bulkhead thickness. Repeat at two other locations to allow the tracing of a vertical line (Line A) at station 164.28 (aft face of bulkhead).
 - b. Using a construction square, mark a line (Line B) perpendicular to station 164.28 and passing through the center of elevator horn hole at station 110.35.
 - c. Locate holes for rivets as shown on Figure 1. Drill and deburr holes (#27 size) for all 3 rivets, as shown on Figure 1. Hole for rivet "S" may interfere with nearby stringer. If such interference exists, remove enough rivets to insert a small protective sheet of CRES between stringer and skin. Using a 1/4" diameter router bit, remove minimum amount of metal from stringer to clear rivet tail. Deburr, remove protective sheet and reinstall rivets attaching stringer.
4. Install rivets "P", "R" and "S" (P/N NAS9304B-4-01), as shown on Figure 1. Apply primer to rivet tails and stringer. Touch up exterior paint.
5. Reinstall RH elevator and close access door.
6. Make an entry in helicopter historical records indicating compliance with this technical bulletin.

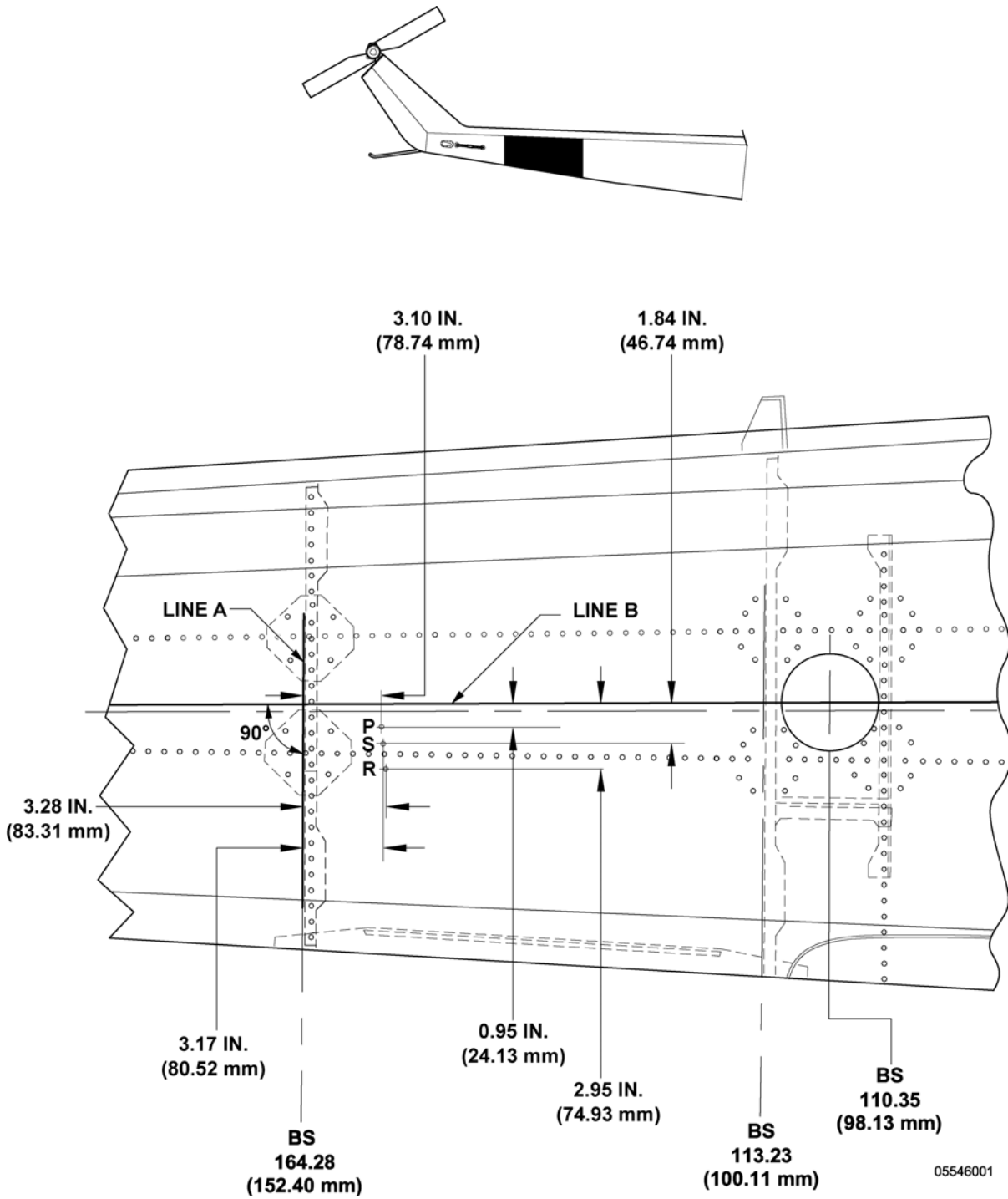


Figure 1
Rigging Rivet Installation