

TECHNICAL BULLETIN

Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc

No. 214ST-99-161

Date 05-02-99

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DATE
REV

MODEL AFFECTED:

MODEL 214ST

SUBJECT:

**SPEAKER MOUNT BRACKET ASSEMBLY,
REPLACEMENT OF**

HELICOPTERS AFFECTED:

**Model 214ST S/N 28101 through 28200
with Aft Cabin Speaker Kit installed.**

COMPLIANCE:

At Customer's Option

DESCRIPTION:

The original speaker replacement spare is no longer available. Speaker P/N 5C3FR is now available as a replacement speaker, however a new Bracket Assembly is required to accommodate a difference in the speaker mounting design. The new bracket, P/N 214-077-146-109, replaces bracket 214-077-146-105. This Technical Bulletin provides instructions for the fabrication of the new bracket.

APPROVAL:

The Engineering aspects of this bulletin are FAA approved.

MANPOWER:

Approximately four (4) man-hours will be required to accomplish this Bulletin. Man-hours are based on hands-on time and may vary with personnel and facilities available.

MATERIAL:**Consumable Material:**

The following material is required to accomplish the 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>References</u>
150-021-21C1-2	AL Repair Sheet	1 each	NOTE - 1
MS21059L08	Nut Plate	4 each	
MS20426AD3	Rivet	8 each	
MIL-C-81706 1 Gal	Alodine	1 gallon	C-100
MIL-P-85582, TY1,CL2	Polyamide Epoxy Primer	1 kit	C-204

NOTE – 1

This material is provided in a 12 X 24 inch sheet. This must then be trimmed to a 12.5 X 5.6 inch dimension for this bulletin. Aluminum sheet QQ-A-250/4 TYPE 2024 T-3 0.063 Thick, may also be used.

- NOTE -

The Reference Column above refers to materials listed in the Standard Practice Practices Manual BHT-ALL-SPM.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-214ST-MM CHAP. 97-00-00 MAINTENANCE MANUAL
BHT-214ST-IPB CHAP. 99-99-00 FIG. 99-49 ILLUSTRATED PARTS BREAKDOWN

PUBLICATIONS AFFECTED:

BHT-214ST-IBP CHAP 99-99-00 ILLUSTRATED PARTS BREAK

ACCOMPLISHMENT INSTRUCTIONS:

1. Trim the aluminum plate to 12.5 X 5.6 inches.
2. Refer to Figure 1. Fabricate mounting bracket assembly P/N 214-077-146-109 to the dimensions shown.
3. Prior to installing nutplates, apply ALODINE chem film in accordance with the instruction in the Standard Practice Manual BHT-ALL-SPM, Chapter 3.
4. Install nutplates.
5. Apply epoxy polyamide primer in accordance with the instructions in the Standard Practice Manual BHT-ALL-SPM, Chapter 4.
6. Identify part as P/N 214-077-146-109.

- NOTE -

Mounting bracket assembly P/N 214-077-146-109 is only required if speaker P/N 5C3FR is installed. The bracket assembly is not stocked by Bell Helicopter Textron, but may be ordered from Bell Helicopter Textron, however, shipment is lead time away.

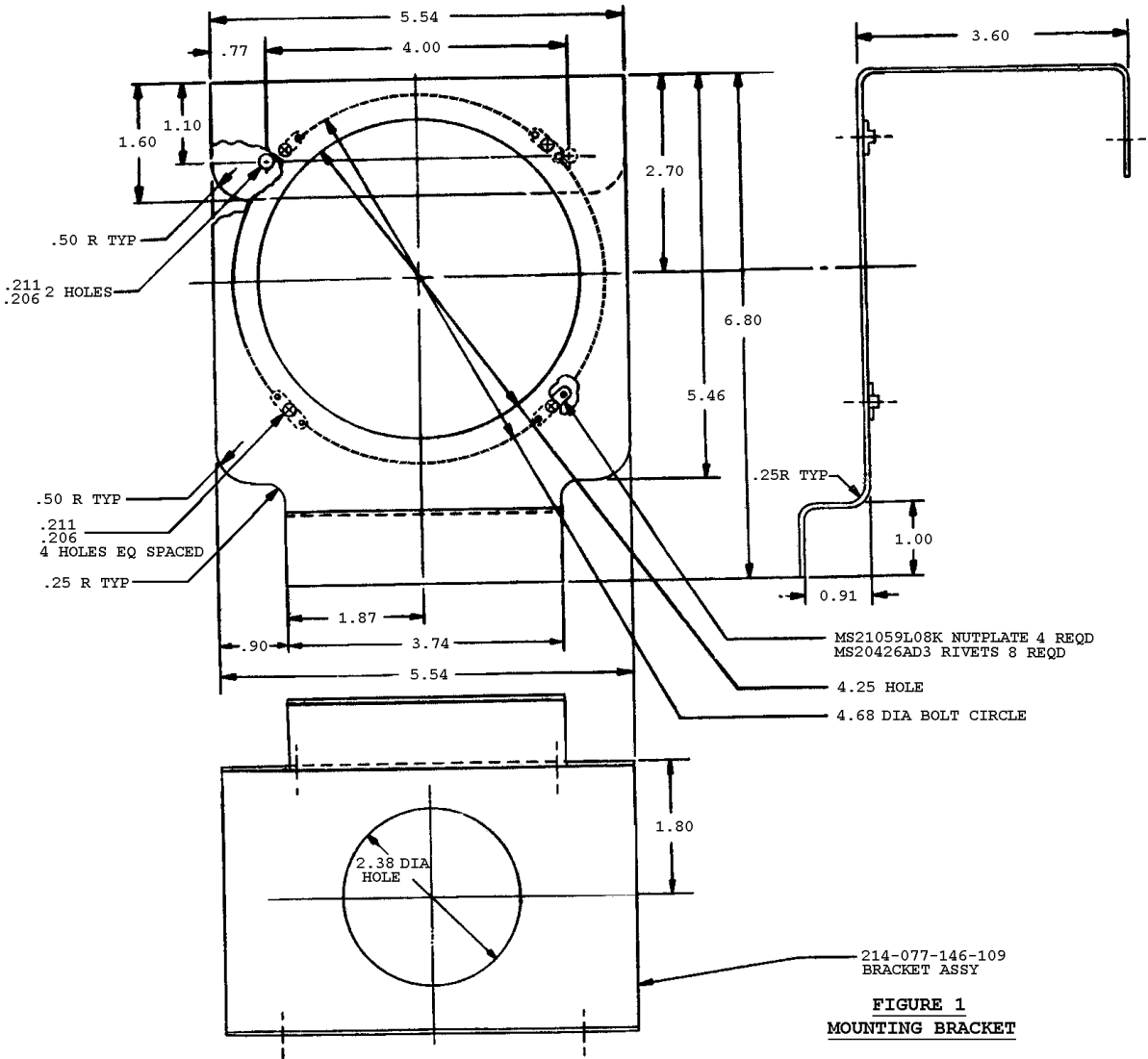


Figure 1
Speaker Mount Bracket