

**TECHNICAL BULLETIN**  
**Bell Helicopter** **TEXTRON**

A Subsidiary of Textron Inc.

No. 407-01-34

Date 12-19-01

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DATE
REV

**MODEL AFFECTED:** 407

**SUBJECT:** **PYLON SIDE BEAMS 407-010-201-105 AND 407-010-203-105, INSTRUCTION FOR RETURNING TO SERVICE.**

**HELICOPTERS AFFECTED:** All Model 407 Helicopters.

**COMPLIANCE:** **Part I**

Applies to pylon side beams 407-010-201-105 and 407-010-203-105 that have been previously removed due to airworthiness limitation of 1000 hrs/5500 RIN. Do this inspection prior to returning the side beams to service.

**Part II**

Applies to pylon side beams 407-010-201-105 and 407-010-203-105 with less than 1000 hours and 5500 RIN that are currently installed on the aircraft.

**Part III**

Introduces new recurring inspection procedures to all pylon side beams 407-010-201-105 and 407-010-203-105.

**DESCRIPTION:**

The airworthiness limitation of pylon side beams 407-010-201-105 and 407-010-203-105 has been extended from 1000 hrs/5500 RIN to 5000 hrs/17000 RIN. This bulletin gives inspection procedures to return to service subject side beams that have been previously removed due to airworthiness limitation of 1000 hrs/5500 RIN. Do this inspection prior to returning the side beams to service.

**APPROVAL:**

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

**MANPOWER:**

No additional man-hours are required to accomplish this bulletin when complied concurrently with removal or installation of pylon side beams.

**MATERIALS:**

**Required Material:**

None required.

**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>Reference</u>
MIL-P-85582,TYI,CL2	Epoxy Polyamide Primer	C-204 (NOTE 1)
MILC85285,TYI,16440	Paint, Light Gull Gray	C-245 (NOTE 2)

**NOTES:**

1. Epoxy Polyamide Primer MIL -P-23377 (C-246) can be used as an alternative.
2. Acrylic Lacquer MIL-L-81352 can be used as an alternative.

**SPECIAL TOOLS:**

None required

**WEIGHT AND BALANCE:**

Not affected

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-407-MM-1, Rev. 14

Chapter 4, Mandatory Retirement.

**PUBLICATIONS AFFECTED:**

None affected

**ACCOMPLISHMENT INSTRUCTIONS:**

**PART I: Inspection procedures prior to returning to service.**

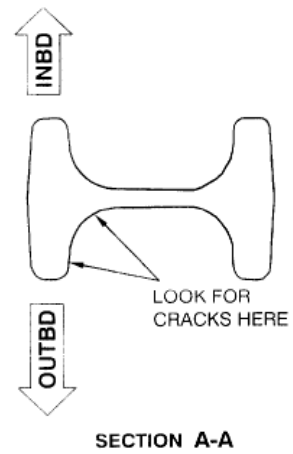
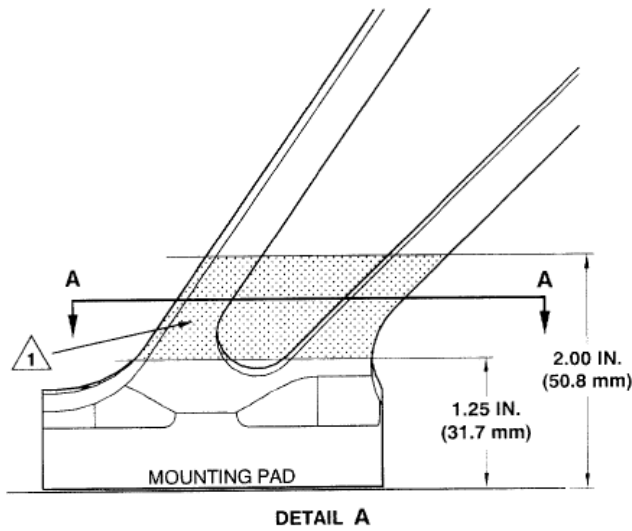
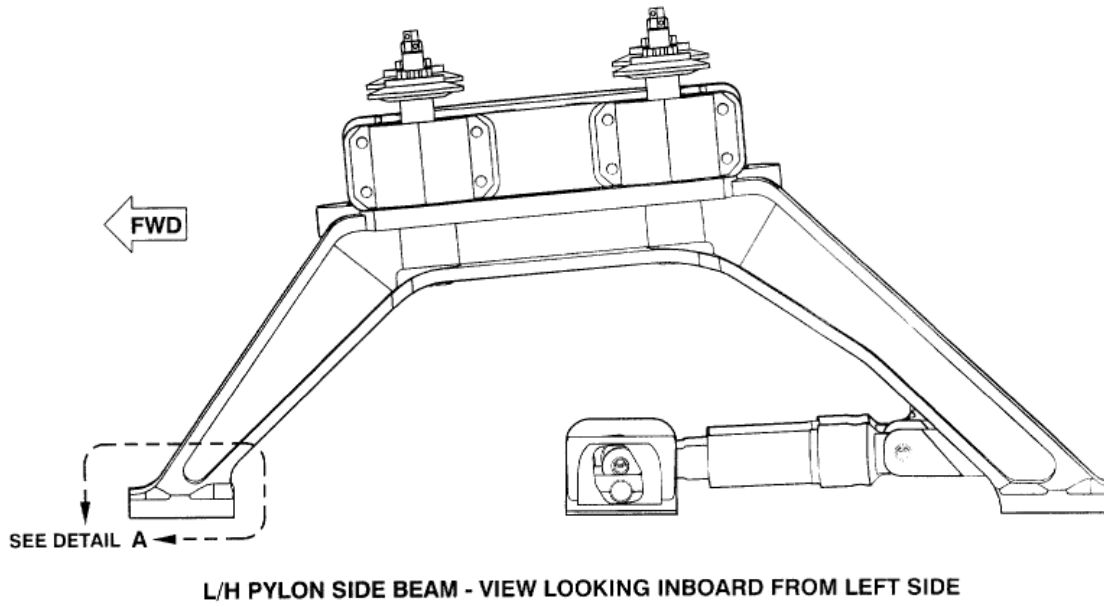
1. Remove paint and primer mechanically (BHT-ALL-SPM, Chapter 3) or chemically (BHT-ALL-SPM, Chapter 4).
2. Inspect the shaded areas with Fluorescent Penetrant (Figure 1, Detail A and B).
3. Apply Primer (C-204) and topcoat (C-245) per Figure 2.
4. Revise the Component Historical Records to reflect the new retirement life of the side beams (BHT-407-MM-1, Chapter 4, Table 4-1).
5. Make an entry in the Helicopter and the Component Historical Records to show that this Technical Bulletin is completed.
6. Do the recurring inspection per Part III.

**PART II: Side beams currently installed on the aircraft.**

1. Revise the Component Historical Records to reflect the new retirement life of the side beams (BHT-407-MM-1, Chapter 4, Table 4-1).
2. Do the recurring inspection per Part III.

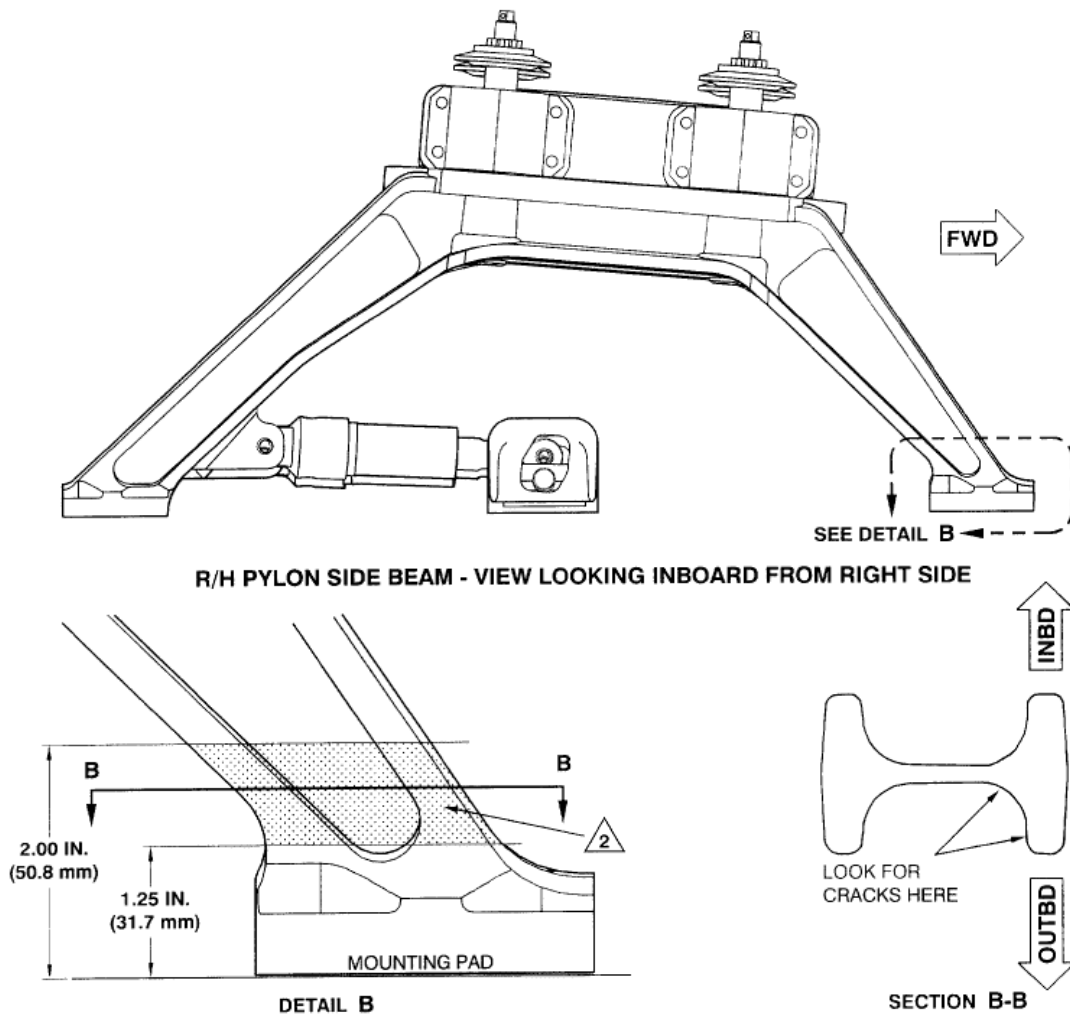
**PART III: Inspection.**

1. Refer to the publication BHT-407-MM, Chapter 4, Table 4-2.



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Figure 1. Pylon Side Beams (P/N 407-010-201-105/407-010-203-105) Inspection  
(Sheet 1 of 2)



R/H PYLON SIDE BEAM - VIEW LOOKING INBOARD FROM RIGHT SIDE

NOTES



1 2 Inspect the upper outboard flange and flange/web area for cracks. Inspect the area between 1.25 inches (31.7 mm) and 2.0 inches (50.8 mm) above the mounting pad.

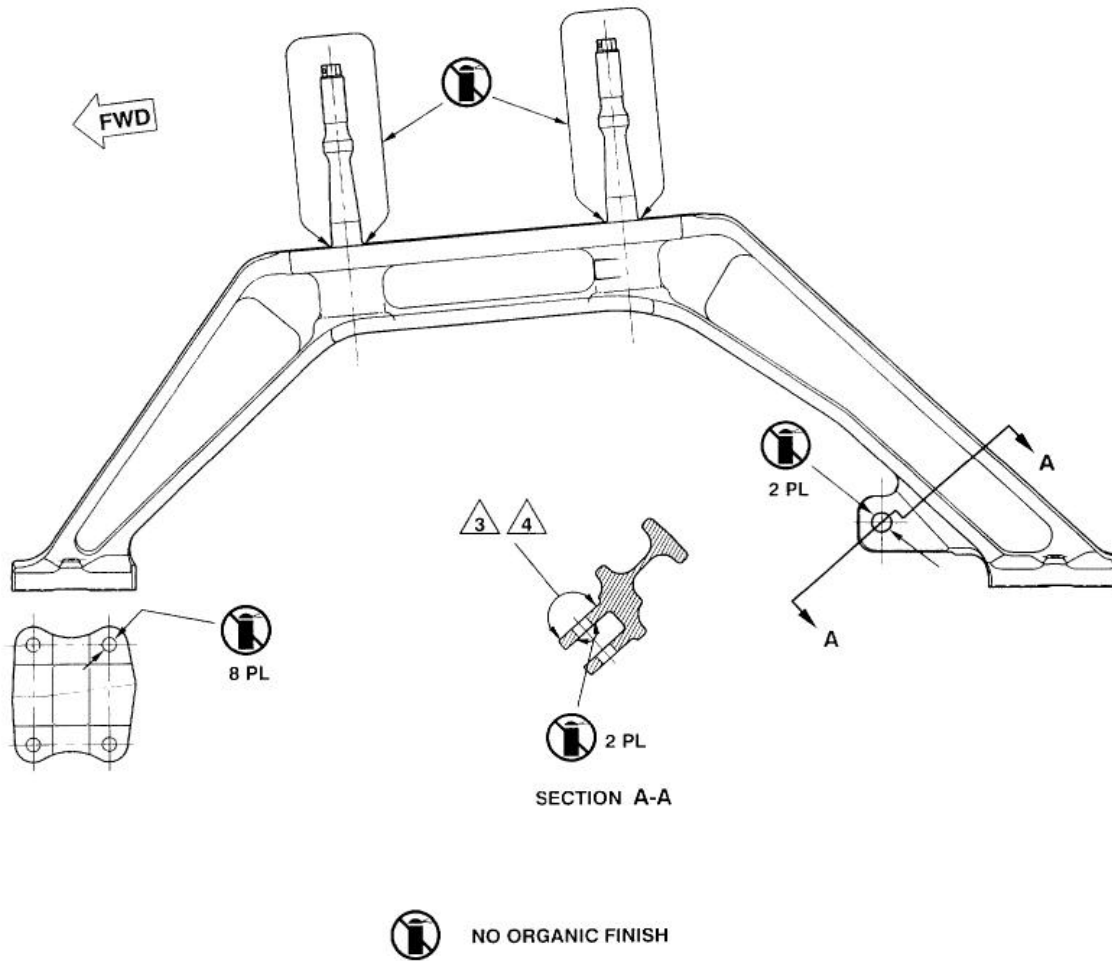
- 3. If a crack is found in a pylon side beam, replace before the next flight and contact Product Support Engineering at the following numbers:

Bell Helicopter Textron  
Product Support Engineering  
Light Helicopters

Tel: 1-800-243-6407 (Continental USA and Canada)  
Tel: 1-800-363-8023 (Continental USA)  
Tel: 1-800-361-9305 (Within Canada)  
Tel: 1-450-437-2682 (All other areas - call collect)  
Fax: 450-433-0272 Internet: pselight@bellhelicopter.textron.com

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Figure 1. Pylon Side Beams (P/N 407-010-201-105/407-010-203-105) Inspection (Sheet 2)



NOTES

1. Apply Polyamide Epoxy primer MIL-P-23377 Ty I Class 3 or MIL-P-085582 Ty I Class 2 (C-204).
2. Apply topcoat MIL-C-85285 Ty I, FED-STD-595 color 16440 (light grey).
3. On beam (407-010-201) apply topcoat Imron Blue color No. 44543U to the left of the lug.
4. On beam (407-010-203) apply topcoat Imron White color No. 44916U to the right of the lug.

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Figure 2. Pylon Side Beam Painting