



July 14, 2009

TO: All Owners/Operators of Bell 206L-1 AND 206L-3 Helicopters

**SUBJECT: REVISION "A" TO TECHNICAL BULLETIN 206L-09-233:
(206-705-420-101, AIRFRAME MODIFICATION FOR UPGRADE)**

Revision "A" to this bulletin changes the COMPLIANCE section to remove the word "or" from the first sentence of the text. The intent of the bulletin was not to make it a requirement to perform the intent of this bulletin if the airframe was installed in a Bell approved fixture, but to make it at the customer's option if it does.

TECHNICAL BULLETIN

Bell Helicopter

A Textron Company

No. 206L-09-233

Date June 12, 2009

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DATE July 14, 2009

REV A

MODEL AFFECTED: 206L-1 AND 206L-3

SUBJECT: 206-705-420-101, AIRFRAME MODIFICATION FOR UPGRADE

HELICOPTERS AFFECTED: Model 206L-1, helicopters serial number 45154 through 45790.

Model 206L-3, helicopters serial number 51001 through 51612.

COMPLIANCE: At Customer's Option when the airframe is installed in a Bell Approved fixture. Mandatory for upgrading 206L-1 to 206L-1+ or 206L-3 to 206L-3+ in accordance with BHT-206-SI-2052.

DESCRIPTION:

This Technical Bulletin is issued as additional information to the Bell Helicopter drawing kit 206-705-420-101 released to our Customer Service Facility (CSF) network to accomplish the modification and upgrade of the 206L-1 and 206L-3 airframe. These proprietary drawings are intended only for approved CSFs equipped with BHT-Approved fixtures and having hot dimpling capability. As a result, it is possible to upgrade the airframe of subject models to the equivalent of the 206L-4 currently in production.

Any 206L-1 and 206L-3 non-destroyed airframe can be upgraded. The limitations and operations of the 206L-1 and 206L-3 having only this TB accomplished remain unchanged, however it may benefit from the 206L-4 performance when BHT-206-SI-2052 is accomplished in addition to this TB.

This TB is a prerequisite to accomplish the BHT-206-SI-2052 (Increased Gross Weight Kit).

A

-NOTE-

BHT does not approve partial airframe upgrade or partial accomplishment of this TB. Only the BHT Customer Service Facilities listed in Table 2 of this Technical Bulletin are authorized to perform the airframe upgrade. Approved CSF must have special tooling as listed in this bulletin and the latest drawing revisions as provided by Bell Helicopter.

-NOTE-

Tailboom assemblies 206-033-004-175 or equivalent with ASB 206L-99-115 accomplished is the minimum configuration accepted for this upgrade. Tailboom 206-033-004-199 or equivalent, and any subsequent configuration is preferred.

-NOTE-

Accomplishment of this technical bulletin will make the helicopter compliant with the following bulletins: ASB 206L-80-16, ASB 206L-81-23, ASB 206L-87-47, ASB 89-62, ASB 206L-91-73, ASB 206L-92-84, ASB 206L-97-107, ASB 206L-98-114, ASB 206L-99-115, TB 206L-79-33, TB 206L-79-34, TB 206L-79-41, TB 206L-80-59, TB 206L-82-77, TB 206L-82-88, TB 206L-83-110, TB 206L-87-139, TB 206L-90-150, TB 206L-93-164, TB 206L-95-179, TB 206L-96-191, TB 206L-00-203, TB 206L-05-220, TB 206L-07-226

TABLE 1 – LIST OF STRUCTURAL MODIFICATIONS, HELICOPTER MODEL APPLICABILITY AND FIXTURE REQUIREMENTS

Modification number	Nomenclature	Helicopter Applicability	Fuselage fixture required
206-530-131-101	CONSOLE	206L-1 , 206L-3	Yes – Note 1
206-530-132-101	BULKHEAD STA 73.04	206L-1 , 206L-3	Yes
206-530-133-101	CENTER POST	206L-1 , 206L-3	No
206-530-134-101	AFT FUSELAGE SKIN & FRAME	206L-1 , 206L-3	Yes – Note 2
206-530-135-101	BULKHEAD STA 155.00 (UPPER)	206L-1 , 206L-3	Yes – Note 2
206-530-135-103	BULKHEAD STA 155.00 (LOWER)	206L-1 , 206L-3	Yes – Note 2

206-530-136-101	ROOF BEAM	206L-1 , 206L-3	Yes
206-530-137-101	ROOF SHELL	206L-1 , 206L-3	No
206-530-138-101	HORIZONTAL STABILIZER	206L-1	No
206-530-138-103	TAILBOOM	206L-1 , 206L-3	No
206-530-138-105	TAILBOOM	206L-1 , 206L-3	No
206-530-139-101	FRAME STA 167.33	206L-1 , 206L-3	No
206-530-139-103	FRAME STA 192.00	206L-1 , 206L-3	No
206-530-139-105	FRAME STA 217.84	206L-1 , 206L-3	No
206-530-139-107	FRAME STA 230.76	206L-1 , 206L-3	Yes –Note 3
206-530-140-101	AFT CABIN CLOSURE	206L-1 , 206L-3	Yes – Note 2
206-530-141-101	BULKHEAD PASS. SEAT BACK	206L-1	No
206-530-142-101	UPPER LONGERONS	206L-1 , 206L-3	Yes
206-530-143-101	LOWER LONGERONS	206L-1 , 206L-3	No
206-533-002-101	AFT L/G FITTINGS	206L-1 , 206L-3	Yes – Note 2
206-533-002-103	FWD L/G FITTINGS	206L-1	No
206-572-002-101	MARKINGS	206L-1 , 206L-3	No

Note 1: As an alternate, a fuselage support per BHT-206-SRM-1 Appendix B-1 and all jacking points permanently stabilized can be used in conjunction with a work aid locally manufactured to locate and stabilize the nose console using the battery shelf for attaching point.

Note 2: As an alternate, a fuselage support per BHT-206-SRM-1 Appendix B-1 and all jacking points permanently stabilized can be used if this modification is not done simultaneously with any other modification.

Note 3: As an alternate, a drill plate per TB 206L-07-226 can be used if only the aft bulkhead is replaced.

-NOTE-

Once this TB is accomplished, the following kits are no longer compatible for the listed helicopter models:

Service Instruction	Kit Number	Nomenclature	Helicopter Applicability
BHT-206-SI-2008 (Note 1)	206-706-140	Air distribution	206L-1
BHT-206-SI-2009 (Note 1)	206-706-142	Cabin heater	206L-1 , 206L3
BHT-206-SI-2010 (Note 1)	206-706-143	ECS	206L-1 , 206L-3

Note 1: Heating kit may be installed on 206L-1+ and 206L3+ in accordance with BHT-206-SI-2023 (Bleed Air Heater)

APPROVAL:

The engineering design aspects of this bulletin are Transport Canada Civil Aviation (TCCA) approved.

MANPOWER:

Approximately 600.0 man-hours are required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available. Man-hours will also vary based on configuration and condition of the airframe.

WARRANTY:

Owners / Operators of Bell Helicopters who comply with the instructions in this Technical Bulletin will be eligible to receive a 1000-hours / 12-months warranty from time of installation for all of the parts detailed in the kit number 206-705-420-101A.

MATERIALS:

Required Material:

The following material is required for the accomplishment of this bulletin and may be obtained through your Bell Helicopter Textron Regional Sales Manager. Kit **206-705-420-101A** for 206L-1 or 206L-3, is a detail of kit 206-706-530-101 (SI-2052).

Parts furnished in this kit are for any 206L-1 and 206L-3. The current configuration and condition of the aircraft will dictate which parts are required to meet the drawings requirement. Due to parts already installed on the airframe, it is possible that you will have extra parts remaining that Bell Helicopter will not refund.

This technical bulletin is listing all the parts included in the kit 206-705-420-101A. A distinct column show if the part could be required for the 206L-1 or the 206L-3 to facilitate the logistic of the upgrade.

The column identified "Ref. document" is to help customer to determine if a part may have been previously installed in accordance with the document in reference.

The following parts are required for the 206L-1 or 206L-3 and are all included in the kit 206-705-420-101A:

Part Number	Nomenclature	Qty	206L-1	206L-3	Ref. Document
20-065-06028	BOLT	1	X	X	
206-064-109-003	SHIM	4	X	X	
206-530-131-101	CONSOLE –MOD-	REF			
120-098-05A07	SHIM	2	X	X	
206-031-210-669	DOUBLER	1	X	NO	
206-031-210-683S	COVER	2	X	NO	
206-031-210-687S	SUPPORT	1	X	X	
206-031-478-125S	SUPPORT ASSY	1	X	X	
206-031-478-126S	SUPPORT ASSY	1	X	X	
206-031-478-129S	SUPPORT	1	X	X	
206-031-478-130S	SUPPORT	1	X	X	
206-031-478-139S	BULKHEAD	1	X	X	
206-031-478-143S	DOOR	1	X	X	
206-031-478-144S	DOOR	1	X	X	
206-031-478-145S	ANGLE	1	X	X	
206-031-478-147S	WEB	1	X	X	
206-031-478-148S	WEB	1	X	X	
206-031-478-167S	DOUBLER	1	X	X	
206-031-478-169S	SKIN	1	X	X	
206-031-478-170S	SKIN	1	X	X	
206-530-131-105	CLIP	1	X	X	
206-530-131-106	CLIP	1	X	X	
206-530-131-115	SHIM	2	X	X	
206-530-132-101	BULKHEAD 73.06	REF			
120-098-04A30	SHIM	1	X	X	
20-042-18-4	RADIUS BLOCK	4	X	X	
206-033-106-217S	DOUBLER (BONDED)	1	X	X	
206-033-106-218S	DOUBLER (BONDED)	1	X	X	
206-033-106-345	FILLER	1	X	X	
206-033-106-373	FILLER	1	X	X	
206-033-106-377	SHIM	1	X	X	
206-033-106-379	SHIM	1	X	X	
206-033-106-381	SHIM	1	X	X	
206-033-106-385	SHIM	1	X	X	
206-033-147-105B	SUPPORT ASSY	1	X	X	
206-033-154-055	RESTRAINT UPPER	1	X	X	
206-033-154-065	BACK STOP	1	X	X	
206-033-154-067	BACK STOP	1	X	X	
206-033-154-125	BACK STOP	1	X	X	
206-033-154-131	SHIM	1	X	X	
206-033-154-133	SHIM	1	X	X	
206-033-602-213	SHIM	2	X	X	
206-072-624-001	STUD	6	X	NO	
206-530-132-103S	POST ASSY L/H	1	X	X	

Part Number	Nomenclature	Qty	206L-1	206L-3	Ref. Document
206-530-132-105S	POST ASSY R/H	1	X	X	
206-530-132-113	SPACER	1	X	X	
206-530-132-115	HEADREST	1	X	X	
206-530-132-123	SPACER	2	X	X	
206-530-132-143	DOUBLER	1	X	X	
206-530-132-145	DOUBLER	1	X	X	
206-530-132-147	SHIM	2	X	X	
206-530-132-149	DOUBLER	1	X	X	
2000-00713 (206-530-132-151)	TAPE	1 Roll	X	X	
206-530-132-153	ANGLE L/H	1	X	X	
206-530-132-154	ANGLE R/H	1	X	X	
206-530-133-101	CENTER POST	REF			
100-048-5-3	PIN	6	X	X	
100-048-5-5	PIN	2	X	X	
20-042-18-16	RADIUS BLOCK	2	X	NO	
20-042-2-14	RADIUS BLOCK	2	X	X	
206-033-110-196S	STIFFENER	1	X	X	
206-033-110-197S	STIFFENER	1	X	NO	
206-033-110-235S	STIFFENER	1	X	NO	
206-033-110-236S	STIFFENER	1	X	NO	
206-033-110-237	FILLER	2	X	NO	
206-033-110-239S	STIFFENER	1	X	NO	
206-033-110-241S	STIFFENER	1	X	NO	
206-033-110-243S	SPACER	2	X	NO	
206-033-110-353S	STIFFENER	1	X	X	
206-033-110-354S	STIFFENER	1	X	X	
206-033-110-355A	DOOR ASSY	1	X	X	
206-530-133-115	STIFFENER	1	X	NO	
206-530-133-117	STIFFENER	1	X	X	
206-530-133-119	STIFFENER	1	X	NO	
30-015-5	COLLAR	8	X	X	
206-530-134-101	AFT SKIN	REF			
206-033-003-105S	SKIN	1	X	NO	
206-033-003-107S	SKIN	1	X	NO	
206-033-003-109S	SKIN	1	X	NO	
206-033-003-149A	SKIN	1	X	X	
206-033-003-153S	SKIN	1	X	X	
206-530-134-115	DOUBLER	1	X	NO	
206-530-135-103	BULKHEAD 155.00 – MOD LOWER	REF			
206-530-135-119	DOUBLER	2	X	X	
206-530-135-121	DOUBLER	2	X	NO	
80-011-S11F06-0	SLEEVE	8	NO	X	
80-011-P11F3-0	PLUG	8	NO	X	
80-011-S14F06-0	SLEEVE	8	X	NO	
80-011-P14F3-0	PLUG	8	X	NO	

Part Number	Nomenclature	Qty	206L-1	206L-3	Ref. Document
206-530-135-105	BULKHEAD 155.00 – MOD UPPER	REF			
100-048-5-4	PIN	6	X	X	
120-098-08C11	SHIM	4	X	X	
120-098A05E08	SHIM	2	X	X	
206-031-629-103	FITTING	2	X	X	SRM 5-1-4
206-033-302-039S	CLIP	1	X	X	
206-033-302-040S	CLIP	1	X	X	
206-530-135-115	DOUBLER	1	X	X	
206-530-135-117	DOUBLER	1	X	X	
30-015-5	COLLAR	6	X	X	
HL220-6-4	PIN (1/32 O/S)	2	X	X	
HL64PB6-4	PIN (1/64 O/S)	2	X	X	
HL87-6	COLLAR (1/64 O/S)	2	X	X	
HL93-6	COLLAR (1/32 O/S)	2	X	X	
206-530-136-101	ROOF BEAM	REF			
120-098-06D41	SHIM	1	X	X	
120-098-20D46	SHIM	7	X	X	
206-033-210-029S	SKIN	1	X	NO	
206-033-210-047	SHIM	4	X	X	
206-033-210-049	SHIM	4	X	X	
206-033-210-051	SHIM	4	X	X	
206-033-210-053	SHIM	4	X	X	
206-033-210-055	SHIM	2	X	X	
206-033-210-057	SHIM	2	X	X	
206-033-210-059	SHIM	4	X	X	
206-033-210-061	SHIM	4	X	X	
206-033-210-119S	STRAP	4	X	X	
206-033-210-123S	SKIN	1	X	X	
206-530-137-101	ROOF SHELL	REF			
100-047-5-6	PIN	1	X	X	
100-048-5-6	PIN	3	X	X	
120-098-06B70	SHIM	1	X	NO	TB 206L-79-41
120-098A10F28	SHIM	2	X	X	
140-001-1	WASHER	7	X	X	
206-033-201-167S	STIFFENER	2	X	X	SRM 5-1-4
206-033-201-263S	PANEL ASSY	1	X	NO	ASB 206L-81-20
206-033-201-289S	PAN	1	X	X	
206-033-201-291	SKIN (TITAN)	1	X	X	
206-033-201-297S	SUPPORT - LH	1	X	X	
206-033-201-298S	SUPPORT - RH	1	X	X	
206-033-201-299S	STIFFENER	1	X	X	
206-033-201-301	SUPPORT	1	X	X	
206-033-201-303S	SUPPORT - RH	1	X	X	
206-033-201-305S	SUPPORT - LH	1	X	X	
206-530-137-103	TUBE ASSY	1	X	X	
206-530-137-117	EDGING	1	X	NO	
206-530-137-121	SPACER	1	X	NO	TB 206L-79-41

Part Number	Nomenclature	Qty	206L-1	206L-3	Ref. Document
206-530-137-123	SPACER	1	X	NO	TB 206L-79-41
30-015-5	COLLAR	4	X	X	
206-530-139-101	FRAME STA.167.33	REF			
206-032-303-119S	CLIP	1	X	X	PSE letter
206-032-303-120S	CLIP	1	X	X	PSE letter
206-033-670-103S	FITTING	1	X	X	PSE letter (Note 1)
206-033-670-104S	FITTING	1	X	X	PSE letter (Note 1)
206-530-139-105	FRAME STA. 217.84	REF			
206-031-307-103S	ANGLE	1	X	X	TB 206L-87-139
206-033-003-141A	SUPPORT	1	X	X	TB 206L-87-139
206-530-139-107	FRAME STA. 230.76	REF			
100-048-6-7	PIN	2	X	X	
30-015-6	COLLAR	2	X	X	
407-030-027-103	FRAME	1	X	X	TB 206L-07-226
206-530-140-101	CLOSURE INSTL	REF			
206-031-117-439S	SPLICE	1	X	X	
206-031-117-441S	SKIN L/H	1	X	X	
206-031-117-443S	SKIN R/H	1	NO	X	
206-530-140-119S	SKIN RH (thicker)	1	X	NO	
206-530-141-101	AFT SEAT BLKD INSTL	REF			
206-530-141-115	DOUBLER	1	X	NO	
206-530-141-117	DOUBLER	1	X	NO	
206-530-141-119	DOUBLER	1	X	NO	
206-530-142-101	UPPER LONGERON	REF			
206-031-314-103S	DOUBLER FWD R/H	1	X	NO	
206-031-314-123S	CHANNEL FWD L/H	1	X	X	
206-031-314-125S	CHANNEL FWD R/H	1	X	X	
206-031-314-217B	LONGERON UPPER L/H	1	X	X	TB 206L-07-226 PSE Letter (Note 2)
206-533-002-101	AFT FITTINGS	REF			
100-048-8-22	PIN	8	NO	X	
30-015-8	COLLAR	8	NO	X	
206-033-109-001	FITTING ASSY	2	X	NO	
206-033-667-101	SUPPORT	2	X	X	
206-033-683-101	SUPPORT	2	NO	X	
206-033-683-103	SUPPORT	2	X	NO	
MS20002C5	WASHER	12	X	X	
MS21042L5	NUT	12	X	X	
NAS1149G0563P	WASHER	8	X	NO	
NAS6204-12	BOLT	4	X	X	
NAS6204-28	BOLT	4	X	X	
NAS6605-11	BOLT	4	X	X	
NAS6605-26	BOLT	8	X	NO	

Part Number	Nomenclature	Qty	206L-1	206L-3	Ref. Document
206-533-002-103	FWD FITTING	REF			
206-033-108-001	SUPPORT	2	X	NO	
140-007-16-17B4	WASHER	12	X	NO	
140-009C16C48	WASHER	4	X	NO	
NAS6604-5	BOLT	8	X	NO	
NAS6604-11	BOLT	4	X	NO	
206-572-002-101	MARKINGS	REF			
100-071-7	IDENT. PLATE	1	X	X	
206-070-692-001	DECAL	2	X	X	
206-070-693-001	DECAL	2	X	X	
31-004-30	DECAL	1	X	X	
31-006-372	DECAL	1	X	X	
31-043-10EHP	DECAL	1	X	X	
31-043-5EHP	DECAL	1	X	X	

Note 1: Fittings 206-033-670-101S and 206-033-670-102S installed per PSE letter are acceptable and does not require replacement.

Note 2: Longeron and fitting assembly 206-031-314-157A installed per PSE letter are acceptable and does not require replacement.

Hardware Material:

The following table gives the hardware required for the accomplishment of this bulletin. This material is not included in the kit 206-705-420-101A. It must be ordered separately and may be obtained through your Bell Helicopter Textron Supply Center.

Part Number	Nomenclature	Qty
110-164-1	RIVET	4
110-195-3C	RIVET	AR (Note 1)
140-001-1	WASHER	7
140-007-16-17B4	WASHER	12
140-009C16C48	WASHER	4
50-008R2	RECEPTACLE	3
60-003-2N36	GROMMET	1
AN970-5	WASHER	4
M7885/6-4	RIVET	AR (Note 1)
M7885/6-5	RIVET	AR (Note 1)
M7885/7-4	RIVET	AR (Note 1)
MS20426E4	RIVET	AR
MS20426AD3	RIVET	AR (Note 1)
MS20426AD3-9	RIVET	16
MS20426AD4	RIVET	AR (Note 1)
MS20426AD5	RIVET	AR (Note 1)
MS20426E4	RIVET	AR (Note 1)

Part Number	Nomenclature	Qty
MS20427M3C	RIVET	AR (Note 1)
MS20427M4C	RIVET	AR (Note 1)
MS20427M5	RIVET	AR (Note 1)
MS20470AD3	RIVET	AR (Note 1)
MS20470AD4	RIVET	AR (Note 1)
MS20470AD5	RIVET	AR (Note 1)
MS20470AD6	RIVET	AR (Note 1)
MS20600AD4W	RIVET	AR (Note 1)
MS20600AD5W	RIVET	AR (Note 1)
MS20601AD4W	RIVET	AR (Note 1)
MS20615-3M	RIVET	AR (Note 1)
MS20615-3MP	RIVET	AR (Note 1)
MS20615-4M	RIVET	AR (Note 1)
MS20615-5M	RIVET	AR (Note 1)
MS20615-5MP	RIVET	AR (Note 1)
MS20615-6M	RIVET	AR (Note 1)
MS20615-6MP	RIVET	AR (Note 1)
MS20615-M3	RIVET	AR (Note 1)
MS20615-M5	RIVET	AR (Note 1)
MS21042L3	NUT	4
MS21042L4	NUT	4
MS21042L5	NUT	4
MS21059L3	NUTPLATE	11
MS21059L3K	NUTPLATE	5
MS21059L4	NUTPLATE	1
MS21061L3	NUTPLATE	AR
MS21061L3K	NUTPLATE	4
MS21061L4	NUTPLATE	4
MS21069L3	NUTPLATE	13
MS21073L3	NUT	4
MS21075L3N	NUTPLATE	48
MS21075L4N	NUTPLATE	4
MS24693-S277	SCREW	25
MS27039-0811	SCREW	2
MS27039-1-05	SCREW	4
MS27039-1-08	SCREW	8
MS27039-1-09	SCREW	31
MS90354-0805	BLIND BOLT	40
MS90354-1005	BLIND BOLT	32
MS90354-1006	BLIND BOLT	8
MS90354S05	RIVET	AR (Note 1)
MS90354S06	RIVET	AR (Note 1)
NAS1054-6	RIVET	AR (Note 1)
NAS1097AD3	RIVET	AR (Note 1)
NAS1097AD4	RIVET	AR (Note 1)
NAS1097AD5	RIVET	AR (Note 1)
NAS1149C0332R	WASHER	6
NAS1149C0432R	WASHER	2
NAS1149D0332J	WASHER	4
NAS1149D0316K	WASHER	31
NAS1149D0463J	WASHER	8

Part Number	Nomenclature	Qty
NAS1149D0516J	WASHER	4
NAS1169-10	WASHER	25
NAS1200M4	RIVET	AR (Note 1)
NAS1329A3K80	NUT	2
NAS1738M4	RIVET	AR (Note 1)
NAS1738MW4	RIVET	AR (Note 1)
NAS1738MW5	RIVET	AR (Note 1)
NAS1739MW4	RIVET	AR (Note 1)
NAS1739MW5	RIVET	AR (Note 1)
NAS1789-3	NUTPLATE	AR (Note 1)
NAS528-A6	COLLAR	AR (Note 1)
NAS9301B-4	RIVET	AR (Note 1)
NAS9301B-5	RIVET	AR (Note 1)
NAS9303B-4	RIVET	AR (Note 1)
NAS9304B-4	RIVET	AR (Note 1)
NAS9304B-5	RIVET	AR (Note 1)
NAS9304B-6	RIVET	AR (Note 1)
NAS9307M-4	RIVET	AR (Note 1)
NAS9308M-4	RIVET	AR (Note 1)
NAS9311M-5-03	BLIND BOLT	4

Note 1: Quantity and rivet length to be determined at installation

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 is not included in the kit 206-705-420-101A. This material may be obtained through your Bell Helicopter Textron Supply Center.

Part number	Nomenclature	Qty	Reference
299-947-100TY2CL2PT	ADHESIVE	1	C-317
299-947-125 TYPE 1	ADHESIVE	1	C-331
299-947-125TY2CL2	ADHESIVE	1	C-397
3950 SCOTCHCAL	EDGE SEALER	1	C-349
472,BLK,3.00 WIDE	FUEL CELL TAPE #472	1	C-453
ACETONE GALLON	CLEANER	1	C-316
AMS3276 1 PT	SEALANT	1	C-559
AMS3284, TY I, CLB2	LOW ADHESION SEALANT	1	C-328
AMS3374/1 6OZ	FIREWALL SEALANT	1	C-353
AMS-S-8802 QT	SEALANT	1	C-308
METHYL ETHYL KETONE	MEK	1	C-309
MIL-C-81706 1 QT	CHEMICAL FILM PROTECTION	1	C-100
MILC85285,TYI,37038	PAINT	1	C-245
MIL-PRF-23377T1,CLC	EPOXY PRIMER	1	C-204
MILS81733TY II-2 PT	SEALANT	1	C-251
TT-1735 ISOPROPYL	ISOPROPYL ALCOHOL	1	C-385
TT-N-95,TYII 1GAL	ALIPHATIC NAPHTA	1	C-305

SPECIAL TOOLS:

- 1- A BHT-Approved 206L airframe fixture holding a valid BHT approved certificate.
- 2- Hot dimpling portable equipment such as Zephyr ZT2409 or equivalent

WEIGHT AND BALANCE:

Approximately 12.0 pounds is added to the total airframe weight, however Bell Helicopter recommends that the aircraft be reweighed after modification of the airframe

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

- BHT-206L-SERIES-IPB Illustrated Parts Breakdown
- BHT-206L1-MM-1 Maintenance Manual
- BHT-206L3-MM-1 Maintenance Manual
- BHT-206L-CR&O-1 Component Repair and Overhaul
- BHT-206-SRM-1
- BHT-ALL-SPM
- ASB 206L-80-16 Horizontal Stabilizer Assembly, P/N 206-023-119 (all dash), Inspection of
- ASB 206L-81-20 Engine Starter, and Electrical Cables, Replacement of
- ASB 206L-81-23 Horizontal Stabilizer Assembly, Modification or Retirement of
- ASB 206L-87-47 Tailboom, P/N 206-033-004-All, Inspection of
- ASB 206L-89-62 Horizontal Stabilizer Assembly P/N 206-023-119-ALL , inspection for conformity
- ASB 206L-91-73 Shoulder Harness Inertia Reel Support, Replacement of
- ASB 206L-92-84 Bracket, Bearing Support 206-033-412-001/-003/-005/-007 and /-009, One Time Inspection
- ASB 206L-97-107 Tailboom, Modification of, Inspection of
- ASB 206L-98-114 Tailboom 206-033-004-003/-011/-103/-045/-143/-175 and /-177, inspection of
- ASB 206L-99-115 Tailboom 206-033-004-All, Inspection and Modification of
- TB 206L-79-33 Horizontal Stabilizer Assy, P/N 206-023-119-001/-075/-107 and 206-961-439-003, Modification or Replacement of
- TB 206L-79-34 Auxiliary Fin, P/N 206-023-126-001/-002/-009/ and /-010, Special Inspection and Modification
- TB 206L-79-41 Structural Attachment of Center Post Installation, P/N 206-033-110-003 or -005, to Roof Beam Assembly, P/N 206-033-210-001, Inspection and Modification of

TB 206L-80-59	Vertical Fin Assembly, P/N 206-020-113, Replacement of Inserts, Sleeve, P/N 80-011-S12F20-0, and Plug, P/N 80-011-P12F2-0
TB 206L-82-77	Horizontal Stabilizer Assembly, P/N 206-023-119-151, Screws for Assembly and Installation
TB 206L-82-88	Service Kit, Restraint System Crew, Installation of P/N 206-703-003-101/-103 and /-105
TB 206L-83-110	Fuselage Aft Bulkhead, P/N 206-032-308-003, inspection and/or replacement of
TB 206L-87-139	Frame Installation, P/N 206-032-307-029/-101, Door Angle, P/N 206-032-307-031, Replacement of
TB 206L-90-150	Tailboom – Modification for Increased Interchangeability
TB 206L-93-164	Passenger Shoulder Restraint, Installation of
TB 206L-95-179	Passenger Left Hand Aft Facing Seat Back P/N 206-033-155, Modification of
TB 206L-96-191	Tailboom, Modification for Increased Interchangeability
TB 206L-00-203	Horizontal Stabilizer Supports 206-023-131-All, Installation of
TB 206L-05-220	Tailboom Assembly 206-033-004-All, Modification for Increased Interchangeability
TB 206L-07-226	Improved Upper Left Longeron/Fitting Assembly 206-031-314-217B and Aft Fuselage Bulkhead 407-030-027-103, Introduction of

PUBLICATIONS AFFECTED:

BHT-206L-SERIES-IPB Illustrated Parts Breakdown
BHT-206L1-MM-1 Maintenance Manual
BHT-206L3-MM-1 Maintenance Manual

ACCOMPLISHMENT INSTRUCTIONS:

1. Record the serial number of the aircraft.
2. Consult the aircraft technical records to confirm which Alert Service Bulletins and Technical Bulletins have been accomplished on the fuselage and tailboom assembly. Make a list to determine the current configuration.

-NOTE-

Contact Product Support Engineering for any BHT approved repairs previously accomplished on the airframe that may interfere with this upgrade.

Product Support Engineering can be reached at:

Phone 450-437-2862

Phone 1-800-363-8023

Fax 450-433-0272

E-mail pselight@bellhelicopter.textron.com

3. The information recorded in steps 1 and 2 will be necessary when contacting the CSF of your choice for quotation. The level of work required to complete the upgrade will depend on the serial number of the helicopter and its current configuration and condition.
4. Send the airframe to the selected CSF for upgrade. The CSF will refer to Table 1 of this bulletin and the set of drawings given to him to determine applicability and modification required.
5. Once the complete airframe upgrade is accomplished, the drivetrain and engine alignment must be verified and recorded using BHT approved fixture.
6. The CSF will install an identification plate on the R/H side of the console to show that the aircraft has been modified in accordance with the Bell Helicopter Textron drawing 206-705-420-101.

-NOTE-

Helicopters upgraded in accordance with the Bell Helicopter Textron drawing 206-705-420-101 are eligible to have the BHT-206-SI-2052 accomplished.

7. It is mandatory to contact Product Support Engineering and report in writing the following information to update our database:
 - Confirmation that this bulletin is accomplished
 - Serial number of the aircraft
 - New shim values as recorded in Step 5.
8. Make an entry in the helicopter records to show this Technical Bulletin has been accomplished

TABLE 2 - LIST OF BHT- APPROVED STRUCTURAL CUSTOMER SERVICE FACILITIES (Page 1 of 3):

BHT-APPROVED CUSTOMER SERVICE FACILITY	ADDRESS
USA	
ARROW AVIATION CO. LLC	1318 Smede Hwy (Hwy 92) Broussard, Louisiana 70518 Tel: (337) 364-4357 Fax: (337) 364-4186
HELICOPTER SERVICES (RI)	T.F. Green State Airport 570 Airport Road Warwick, Rhode Island 02886-2461 Tel: (401)-739-0363 Fax: (401) 738-0009
HELICOPTER STRUCTURES, INC	7524N. 49 th Road Cushing, Oklahoma, USA 74023 Tel: (918) 225-4224 Fax: (918) 225-0094
ROTORCRAFT SUPPORT, INC	Van Nuys Airport 16425 Hart Street Van Nuys, California, USA 91406 Tel: (818) 997-7667 Fax: (818) 997-1513
VECTOR AEROSPACE CORP.	22378 Billie Blackmon Road South Alabama Regional Airport Andalusia, Alabama 36421-7734 Tel: (334) 222-1277 Fax: (334) 222-1954
CANADA	
ALPINE AEROTECH, LTD	1260 Industrial Road Kelowna, British Columbia , Canada V1Z 1G5 Tel: (250) 769-6344 Fax: (250) 769-6303
CANADIAN HELI STRUCTURES, LTD	#9, 5525, 216 th Street Langley, British Columbia, Canada V2Y 2N3 Tel: (604) 533-1148 Fax : (604) 533-1517

NOTE

The list of the approved CSFs shown in this Table 2 is accurate at the released date of this document. In the future, refer to your Bell Helicopter Customer Support and Services Directory.

TABLE 2 - LIST OF BHT- APPROVED STRUCTURAL CUSTOMER SERVICE FACILITIES (Page 2 of 3):

CANADA (Cont'd)	
CHINOOK AVIATION, INC	542 Hurricane Dr. Calgary, Alberta, Canada T3Z 3S8 Tel: (403) 247-2498 Fax: (403) 247-3740
USCAN AVIATION SALES, LTD	4536 Sideroad 10, RR#4 Alliston, Ontario Canada L9R 1V4 Tel: (705)-435-4031 Fax: (705)-435-4485
KOREA	
KOREA BELL HELICOPTER COMPANY, LTD	Yesan Plant:#8-10 Hyorim-Ri, Sapkyo-Eup Yesan-Kun, Choongnam, South Korea 340-90 Tel: 82-2-585-1881 Fax: 82-2-587-1881
AUSTRALIA	
SIKORSKY AIRCRAFT AUSTRALIA LTD. DBA HELITECH	Brisbane Heliport 777 Macarthur Avenue Central Pinkenba Queensland, Australia 4008 Tel: 61-7-3632-7000 Fax: 61-7-3260-1616
SINGAPORE	
SINGAPORE TECHNOLOGIES AEROSPACE, LTD	540 Airport Road Paya Lebar, Singapore 539938 Tel: 65-6287-1111 Fax: 65-6280-9713
ISRAEL	
ISRAEL AEROSPACE INDUSTRIES LTD (I.A.I) MATA HELICOPTERS	Ben Gurion International Airport Israel 70100 Tel: 972-3-935-6978 Fax: 972-3-935-3687

NOTE

The list of the approved CSFs shown in this Table 2 is accurate at the released date of this document. In the future, refer to your Bell Helicopter Customer Support and Services Directory.

TABLE 2 - LIST OF BHT- APPROVED STRUCTURAL CUSTOMER SERVICE FACILITIES (Page 3 of 3):

COLOMBIA	
HELICENTRO, LTDA	Autopista Medellin Km 2 Carrera 7 No. 83-73 Santafe de Bogota, Colombia Tel: (571) 433-5970 Fax: (571) 433-5988
TAIWAN R.O.C.	
AIR ASIA COMPANY, LTD	Tainan Airfield Tainan, Taiwan R.O.C. 70205 Tel: 886-6-268-8947 Fax: 886-6-267-3424
PRIVATE COMPANY	
AIR EVAC LIFETEAM (They are not a CSF and they have approval for their own aircraft only)	720 Bratton Avenue West Plains, MO 65775

NOTE

The list of the approved CSFs shown in this Table 2 is accurate at the released date of this document. In the future, refer to your Bell Helicopter Customer Support and Services Directory.