

**TECHNICAL BULLETIN**  
**Bell Helicopter** **TEXTRON**  
A Subsidiary of Textron Inc.

No. 206L-05-220

Date Aug 16, 2005

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DATE
REV

**MODEL AFFECTED:** 206L Series

**SUBJECT:** TAILBOOM ASSEMBLY 206-033-004-ALL,  
MODIFICATION FOR INCREASED  
INTERCHANGEABILITY

**HELICOPTERS AFFECTED:** Model 206L serial number 45004 through  
45153 and 46601 through 46617.

Model 206L1, serial number 45154 through  
45790.

Model 206L3, serial number 51001 through  
51612.

Model 206L4, serial number 52001 through  
52245.

[Model 206L4 helicopters serial number 52246  
and subsequent will have the tailboom  
assembly 206-033-004-199 or later installed  
prior to delivery and are not affected by this  
bulletin until tailboom is sent for repair].

**TAILBOOM AFFECTED:** 206-033-004-003, /-011, /-103, /-045, /-143, /-  
175, /-177, /-181, /-199, ALL field modified  
(FM) configurations.

**COMPLIANCE:** At customer's option or when the tailboom is  
repaired in a BHT-Approved tailboom fixture.

**DESCRIPTION:**

Bell Helicopter Textron recently released a set of drawings to accomplish repair to the 206L series tailbooms to its Customer Service Facility (CSF) network. As a result it is possible to upgrade any tailboom to an equivalent to tailboom 206-033-004-199. This tailboom is then useable on all 206L Series aircraft. Major repairs

to tailbooms /-181 and /-199 or equivalent requiring a fixture are covered in this package. These proprietary drawings are intended only for CSFs equipped with BHT-Approved fixtures. These drawings will get updated as needed to reflect further improvements to the 206L4 production tailboom.

**NOTE**

Tailbooms that did not comply with TB 206L-96-191 must have the intent of that bulletin included as part of the upgrade.

**NOTE**

BHT does not approve partial upgrade of the tailboom. BHT approves only tailbooms repaired by BHT-Approved Customer Service Facilities network. Tailbooms repaired outside of the BHT-Approved CSF network are not considered legitimate BHT products.

Modified tailbooms 206-704-727-101, /-103, /-105 meet the intent of ASB 206L-87-47, ASB 206L-97-107, ASB 206L-99-115, TB 206L-90-150, and TB 206L-96-191.

Refer to Table 1 to upgrade any previous tailboom to a -199 configuration, and Table 2 to repair any tailboom already equivalent to a -199.

**TABLE 1 - LIST OF MODIFICATION AND APPLICATION FOR UPGRADE**

<b>PART</b>	<b>MODIFICATION STATUS</b>	<b>APPLIES TO TAILBOOM</b>	<b>HIGHLIGHTS OF CHANGE</b>
<b>A</b>	<b>206-704-727-101</b>	- Prior to 206-033-004-177 (1)  - 206-033-004-177 or equivalent (1)	- Upgrade to /-199 configuration.  - Both upper and lower skins, and hanger bearing brackets replacement
<b>B</b>	<b>206-704-727-107</b>	- 206-033-004-181 (1)	- Upgrade to /-199 configuration.  - Hanger bearing brackets replacement

TABLE 2 - LIST OF MODIFICATION AND APPLICATION FOR REPAIR

PART	MODIFICATION STATUS	APPLIES TO TAILBOOM	HIGHLIGHTS OF CHANGE
<b>C</b>	<b>206-704-727-101</b>	- 206-033-004-199 (1)	- Upper and lower skin replacement
<b>D</b>	<b>206-704-727-103</b>	- 206-033-004-199 (2) - 206-704-727-101 (4) - 206-704-727-105 (5)	- Upper skin replacement
<b>E</b>	<b>206-704-727-103 and 206-704-727-107</b>	- 206-033-004-181 (1)	- Upper skin and hanger bearing brackets replacement
<b>F</b>	<b>206-704-727-105</b>	- 206-033-004-199 (3) - 206-704-727-101 (4) - 206-704-727-103 (6)	- Lower skin replacement
<b>G</b>	<b>206-704-727-105 and 206-704-727-107</b>	-206-033-004-181 (1)	-Lower skin and hanger bearing brackets replacement

**NOTES:**

- (1) Upgraded tailbooms will be identified as **206-704-727-101**.
- (2) Repaired tailbooms will be identified as **206-704-727-103**.
- (3) Repaired tailbooms will be identified as **206-704-727-105**
- (4) Repaired tailboom 206-704-727-101 will keep the same part number even if subsequently modified in accordance with Parts D or F.
- (5) Tailboom 206-704-727-105 modified in accordance with 206-704-727-103 will be reidentified as **206-704-727-101**.
- (6) Tailboom 206-704-727-103 modified in accordance with 206-704-727-105 will be reidentified as **206-704-727-101**.

**APPROVAL:**

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

**MANPOWER:**

Approximately 125.0 man-hours are required to complete Part A described in Table 1.  
Approximately 15.0 man-hours are required to complete Part B described in Table 1.  
Approximately 125.0 man-hours are required to complete Part C described in Table 2.  
Approximately 110.0 man-hours are required to complete Part D, E, F or G described in Table 2. Man-hours are based on hands-on time, and may vary with personnel and facilities available and initial configuration of the tailboom.

**MATERIALS:**

**Required Material:**

Required material will vary depending on condition and initial configuration of the tailboom. Contact one of the CSFs listed in Table 3 of this bulletin to obtain an estimate.

**NOTE**

The list of the approved CSFs shown in Table 3 is accurate at the released date of this document. In the future, refer to your Bell Helicopter Customer Support and Services Directory.

**SPECIAL TOOLS:**

A BHT-Approved 206L series tailboom fixture holding a valid certificate is required to complete this bulletin.

**WEIGHT AND BALANCE:**

Bell Helicopter Textron recommends that the aircraft be reweighed after installation of modified tailboom 206-704-727-101, 206-704-727-103 or 206-704-727-105.

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-206-SRM-1 Structural Repair Manual  
BHT-206L-SERIES-IPB Illustrated Parts Breakdown  
BHT-ALL-SPM Standard Practices Manual  
BHT-206L-MM-1 Maintenance Manual  
BHT-206L1-MM-1 Maintenance Manual  
BHT-206L3-MM-1 Maintenance Manual  
BHT-206L4-MM-1 Maintenance Manual

**PUBLICATIONS AFFECTED:**

BHT-206L-SERIES-IPB Illustrated Parts Breakdown

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Remove the driveshaft cover from the tailboom assembly to get access to the tailboom data plate. Record the part number and the serial number of the tailboom installed on your aircraft.
2. Consult the aircraft technical records to confirm which Alert Service Bulletin and Technical Bulletins have been accomplished on your tailboom assembly. Make a list to determine the current configuration. Refer to Table 1 and 2 to determine applicability and modification required.
3. Contact one or more of the BHT-Approved Structural CSF. Provide the details recorded in Step 1 and Step 2 to get quotations, lead-time and price for repair or upgrade in accordance with drawings 206-530-127 and 206-704-727. Refer to Table 3.
4. Send the tailboom to the selected CSF for modification or repair.
5. Install serviceable tailboom on aircraft, review the aircraft Weight & Balance and adjust as required.
6. Annotate the aircraft technical records accordingly.

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

BHT-APPROVED CUSTOMER SERVICE FACILITY	ADDRESS	
<b>USA</b>		
AIR LOGISTICS, INC	4605 Industrial Drive New Iberia, Louisiana, USA 70560 Tel: (337) 365-6771 Fax: (337) 364-8222	
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 STRUCTURAL & MAINTENANCE, INC	Tampa North Aero Park (X-39) 4241 Birdsong Blvd Lutz, Florida, USA 33549-6294 Tel: (813) 973-3703 Fax: (813) 973-2692	
HELICOPTER STRUCTURES, INC	R T #1, Box 460 Cushing, Oklahoma, USA 74023 Tel: (918) 225-4224 Fax: (918) 225-0094	
ARROW AVIATION CO. LLC	1318 Smede Hwy (Hwy 92) Broussard, Louisiana 70518 Tel: (337) 364-4357 Fax: (337) 364-4186	
ACROHELIPRO GLOBAL SERVICES USA, INC	2000 W. Bakerview Road Hangar D Bellingham, Washington, USA 98226 Tel: (360) 734-3532 Fax: (360) 734-3193	21839 Bill Benton Lane, P.O.Box 1711 Andalusia OPP Airport Andalusia, Alabama 36420 Tel: (334) 222-1277 Fax: (334) 222-1954
PETROLEUM HELICOPTERS, INC	2001SE Evangeline Thruway Lafayette, Louisiana, USA 70508 Tel: (337) 235-2452 Fax: (337) 235-1351	
ROTORCRAFT SUPPORT, INC	Van Nuys Airport 16425 Hart Street Van Nuys, California, USA 91406 Tel: (818) 997-7667 Fax: (818) 997-1513	
<b>CANADA</b>		
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 <sup>th</sup> 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 3 is accurate at the released date of this document. In the future, refer to your Bell Helicopter Customer Support and Services Directory.

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

<b>CANADA (Cont'd)</b>	
EAGLE COPTERS MAINTENANCE, LTD	Calgary International Airport 823 McTavish Road N.E. Calgary, Alberta, Canada T2E 7G9 Tel: (403) 250-7370 Fax: (403) 250-9276
CHINOOK AVIATION, INC	542 Hurricane Dr. Calgary, Alberta, Canada T3Z 3S8 Tel: (403) 247-2498 Fax: (403) 247-3740
ACROHELIPRO GLOBAL SERVICES - LANGLEY	#101B – 5947 206A Street Langley, British Columbia, Canada V3A 8M1 Tel: (604) 514-0388 Fax: (604) 514-0389
USCAN AVIATION SALES, LTD	R.R. # 4 Alliston, Ontario, Canada L9R 1V4 Tel: (705) 435-4468 Fax: (705) 435-4485
<b>SOUTH AFRICA</b>	
NATIONAL AIRWAYS CORP, (PTY) LTD	Hangar 7, Rand Airport 1419 Germiston Johannesburg, South Africa Tel: 27-11-345-2632 Fax: 27-11-827-5164
<b>AUSTRALIA</b>	
HELITECH PTY, LTD	Brisbane Heliport 777 Macarthur Avenue Central Pinkenba Brisbane, Queensland, Australia 4008 Tel: 61-7-3632-7000 Fax: 61-7-3260-1616
<b>SINGAPORE</b>	
SINGAPORE TECHNOLOGIES AEROSPACE, LTD	540 Airport Road Paya Lebar, Singapore 539938 Tel: 65-6287-1111 Fax: 65-6280-8213
<b>SWEDEN</b>	
PATRIA OSTERMAN AERO AB	Helikoptervagen 1, P.O Box 116 Stockholm - Arlanda Sweden, SE-190-46 Tel: 46-8-593-787-00 Fax: 46-8-593-787-90
<b>COLOMBIA</b>	
HELICENTRO, LTDA	Autopista Medellin Km 2 Carrera 7 No. 83-73 Santafe de Bogota, Colombia Tel: (571) 433-5970 Fax: (571) 433-5988
<b>TAIWAN R.O.C.</b>	
AIR ASIA COMPANY, LTD	Tainan Airfield Tainan, Taiwan R.O.C. 70205 Tel: 886-6-268-8947 Fax: 886-6-267-3424