

DATE
REV

**MODEL AFFECTED:** 206L SERIES

**SUBJECT:** TACH GENERATOR 206-375-202-101 and 206-076-373-001, SPLINES INSPECTION.

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

206L-1 Helicopters serial number 45154 through 45790.

206L-3 Helicopters serial number 51001 through 51612.

206L-4 Helicopters serial number 52001 and subsequent.

**COMPLIANCE:** Within the next 300 hours/6 months after receipt of this bulletin and every 600 hour/12 month inspection and lubrication interval thereafter.

**DESCRIPTION:**

Bell Helicopter has become aware that the Tach Generators 206-076-373-001 and 206-375-202-101 could wear excessively due to lack of lubrication. This condition could lead in loss of hydraulic pressure.

This bulletin introduces a recurring 600 hours/12 months inspection and lubrication of tachometer generator input shaft splines.

**APPROVAL:**

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

**WARRANTY:**

There is no warranty credit applicable for parts or labor associated with 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>	<u>Notes</u>
206-375-202-101	TACH GENERATOR	A/R	1,2,3
35D698	RETAINER CLIP	1	4
5D4407	INPUT SHAFT	A/R	5
9A1424	INPUT SHAFT	A/R	6

**NOTES:**

1. Current production configuration. (Post TB 206L-03-211). Accomplishment of TB 206L-03-211 is recommended.
2. Tach Generator 206-076-373-001 can be used as an alternate on 206L series up to serial number 52263 (Pre TB 206L-03-211).
3. Tach Generator P/N 206-076-373-001 cannot be upgraded to 206-375-202-101.
4. Reusable if not damaged. Used on Tach Generator 206-076-373-001 and 206-375-202-101.
5. Used on Tach Generator 206-375-202-101 (Post TB 206L-03-211).
6. Used on Tach Generator 206-076-373-001 (Pre TB 206L-03-211).

**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>
MB1913	THIXOGREASE	C-561 (Note 1)

NOTE:

1. PLASTILUBE#3 (C-012) and grease P/N MILG81827 14OZ (C-525) can be used as alternate.

- NOTE -

The C REF. NO. above is a cross-reference to the consumables list found in the Standard Practices Manual.

**SPECIAL TOOLS:**

None required.

Work aids #1 and #2 shown in Figure 1 can be locally manufactured.

**ELECTRICAL LOAD DATA:**

Not affected.

**REFERENCES:**

BHT-206L-MM, Maintenance Manual

BHT-206L1-MM, Maintenance Manual

BHT-206L3-MM, Maintenance Manual

BHT-206L4-MM Maintenance Manual

**PUBLICATIONS AFFECTED:**

BHT-206L-MM-1, Chapters 12 and 66.

BHT-206L1-MM-1, Chapters 12 and 66.

BHT-206L3-MM-2, Chapters 12

BHT-206L3-MM-6, Chapters 63.

BHT-206L4-MM-2, Chapters 12

BHT-206L4-MM-6, Chapters 63.

BHT-206L-SERIES-IPB, Chapter 29

**ACCOMPLISHMENT INSTRUCTIONS:**

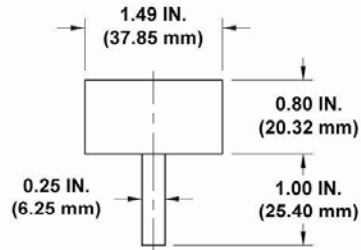
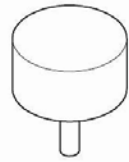
**600 hour/12 month Inspection and lubrication interval**

1. Prepare workaids (#1 and #2, Figure 1).
2. Remove the Tach Generator (1, Figure 2). Refer to the applicable Maintenance Manual.

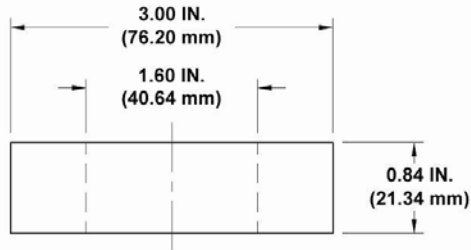
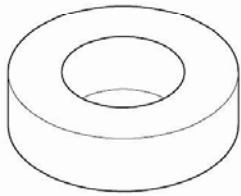
**CAUTION**

**DO NOT USE HYDRAULIC PRESS TO REMOVE THE INPUT SHAFT. EXCESSIVE PRESSURE CAN DO DAMAGE TO THE TACH GENERATOR HOUSING.**

3. Using an arbor press or equivalent, remove the Tach Generator input shaft (2) as shown on Figure 2. The clip (3) can be reused if serviceable.
4. Inspect the splines using the inspection criteria provided on Figure 3.
  - a. If the Tach Generator splines are damaged beyond limits, the Tach Generator can be sent to Bell Helicopter for repair. Refer to IL GEN-04-98.
  - b. If the input shaft splines are damaged beyond limits, replace the input shaft (2, Figure 2).
5. Install the Tach Generator input shaft (2) as follows:
  - a. Install the clip (3) on the input shaft (2).
  - b. Lubricate the input shaft splines with grease (C-561).
  - c. Insert the input shaft (2) in the Tach Generator (1).
6. Install the Tach Generator (1). Refer to the applicable Maintenance Manual.



(MATERIAL: ALUMINUM)  
WORKAID NO. 1



(MATERIAL: ALUMINUM)  
WORKAID NO. 2

06603-003

Figure 1. Workaids

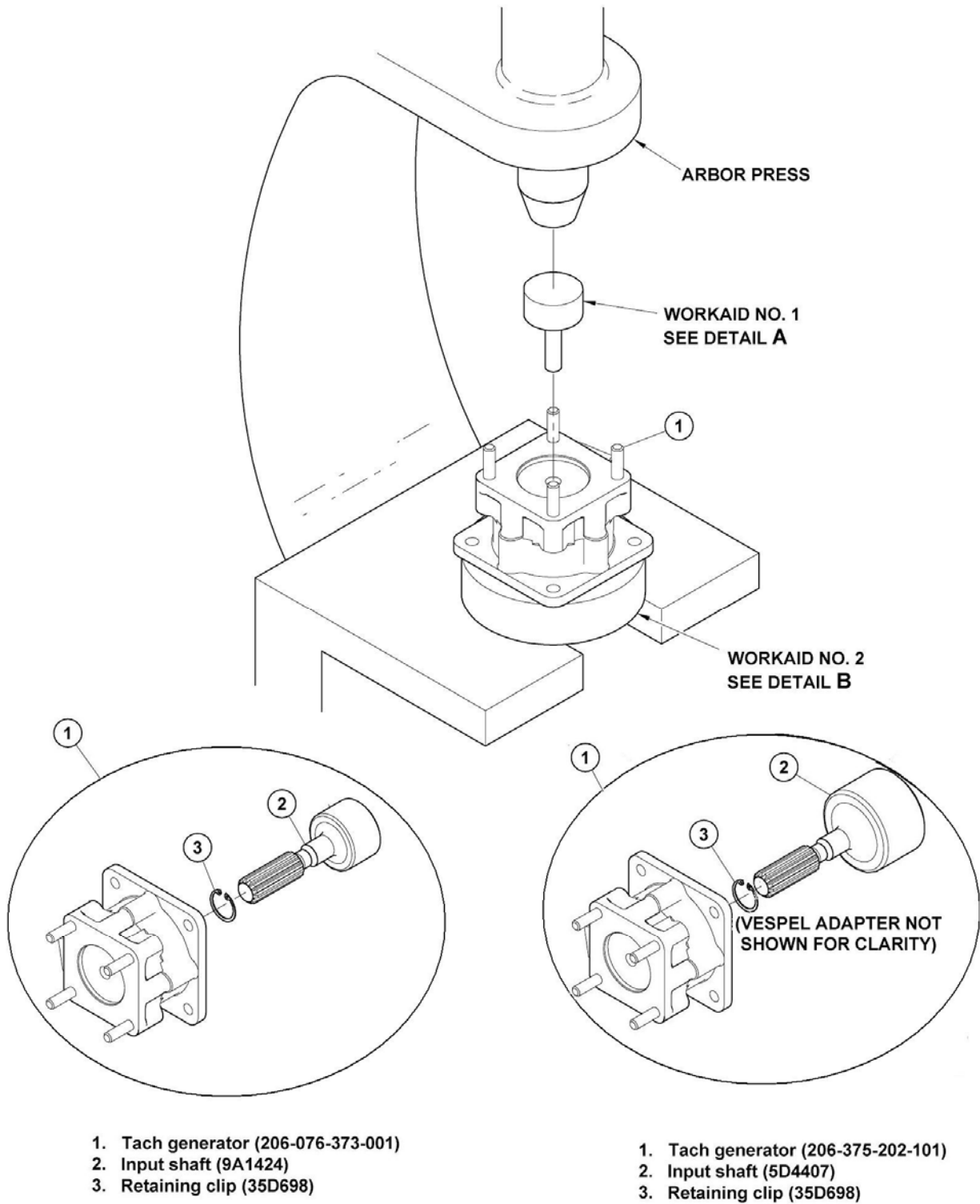
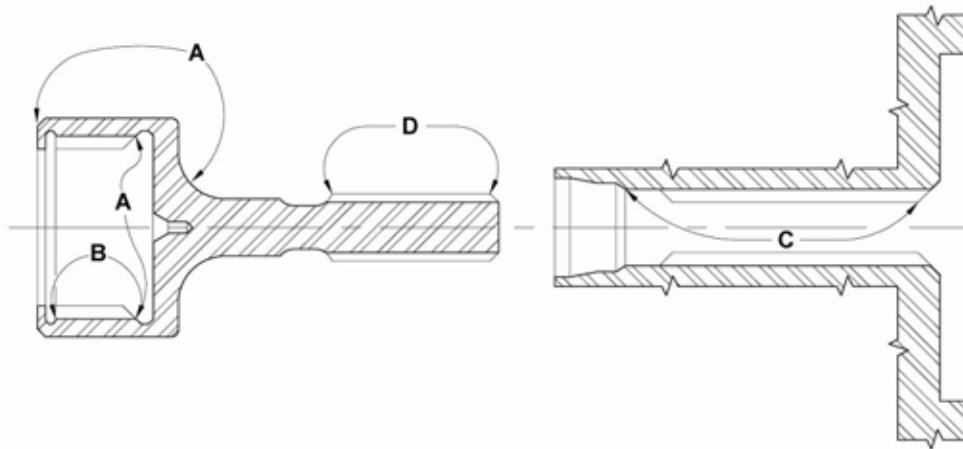


Figure 2. Input Shaft - Removal/Installation



TACH-GENERATOR 206-076-373-001 AND 206-375-202-101

NO.	REF LTR	CHARACTERISTIC	INSPECTION METHOD	LIMIT
1.	A	Corrosion/mechanical	Visual/measure	0.005 inch (0.1 mm) maximum depth.
2.	B	Corrosion/mechanical	Visual/measure	0.002 inch (0.05 mm) maximum depth.
3.	B	Spline wear	Visual/measure	Permitted if damage or wear <sup>1</sup> cannot be felt with a 0.020 inch (0.508 mm) spherical radius probe.
4.	C	Corrosion/mechanical	Visual/measure	0.002 inch (0.05 mm) maximum depth.
5.	C	Corrosion/mechanical	Measure between 0.0360 inch (0.9144 mm) diameter pins.	0.2258 inch (5.7353 mm) <sup>1</sup> maximum.
6.	D	Corrosion/mechanical	Visual/measure	0.002 inch (0.05 mm) maximum depth.
7.	D	Corrosion/mechanical	Measure between 0.040 inch (1.016 mm) diameter pins.	0.3192 inch (8.1076 mm) minimum.

**NOTE**

<sup>1</sup> Nicks on ends of the splines not exceeding 0.010 IN. (0.2 mm) deep may be polished smooth with a fine India stone.

06603-001

Figure 3. Input Shaft - Inspection