

TECHNICAL BULLETIN
Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc.

No. 212-06-205

Date OCT 18, 2006

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DATE
REV

MODEL AFFECTED: 212

SUBJECT: CENTER ENGINE DECK MODIFICATION FOR USE ON OTHER AIRCRAFT

HELICOPTERS AFFECTED: Model 212 helicopters serial number 30502 through 30999, 31101 through 31311, 32101 through 32142 and 35001 through 35103.

COMPLIANCE: At customer's option, upon replacement of center engine deck.

DESCRIPTION:

When the center engine deck is damaged beyond repair and needs replacement, Bell Helicopter recommends the titanium sheetmetal engine deck be installed (ref. SI 212-92) as a permanent solution. If this upgrade is not desired or possible, certain composite engine decks are suitable as spare replacements. This bulletin lists the acceptable part numbers and the work required to reconfigure them for use on other aircraft.

APPROVAL:

The engineering design aspects of this bulletin are FAA/DER approved.

MANPOWER:

Approximately 6.0 man-hours are required to complete step 2 of this bulletin, when accomplished at time of center engine deck replacement. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

WARRANTY:

There is no warranty provided for 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>Step</u>
80-011-P5F1-9	Plug	16	2
80-011-P5C1-9	Plug	3	2
80-011-S5F08-9	Sleeve	19	2

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>Quantity</u>	<u>Reference</u>
299-947-100TY2CL2PT ¹	Adhesive	A/R	C-317
299-947-152, TY III ²	Adhesive	A/R	C-314

Note 1: Magnobond 6398 may be used as an alternate

Note 2: RTV-730 (White) may be used as an alternate

SPECIAL TOOLS:

None required

WEIGHT AND BALANCE:

Not affected

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-212-IPC Illustrated Parts Breakdown
 BHT-MED-SRM-1 Structural Repair Manual
 Service Instruction 212-SI-92 Engine Deck Installation Kit
 Technical Bulletin 212-88-106 Main Beam Cap 205-030-186-005 Inspection and Replacement With Main Beam Cap 205-030-186-101

PUBLICATIONS AFFECTED:

None affected

ACCOMPLISHMENT INSTRUCTIONS:

1. Verify configuration and use acceptable replacement part number in Table 1. Comply with appropriate note(s) applicable to the center engine deck being used.

Table 1

Aircraft S/N	Deck Assy 212-030-009			
	-007	-097	-115	-119
30502 - 30596 30604 - 30610	✓	✓	(1)	(3)
30597 - 30603 30611 - 30999 31101 - 31304 32101 - 32142	X	✓	(1)	(3)
31305 - 31311 35001 - 35103	X	(2)	(1)	✓

(✓): Usable without modification

(X): Not usable

Note 1: Reconfigure in accordance with step 2 of this bulletin.

Note 2: Install in accordance with Technical Bulletin 212-88-106 rev. A (or later).

Note 3: Usable on aircraft modified per TB 212-88-106 rev. A (or later).

2. If required, reconfigure center engine deck P/N 212-030-009-115 as follows:

Note

As an alternate method, insert locations may be transferred from the existing engine deck to the replacement deck using a template made of 2024T3 aluminum.

- a. Refer to Figure 1 for the following instructions. Mark a line through the center of existing inserts for the center and forward firewalls and using dimensions shown on Figure 1, mark locations of (qty 19) inserts. Drill pilot holes for inserts. Install inserts as per Structural Repair Manual instructions using adhesive (C-317).
 - b. Using a permanent ink felt pen, re-identify this Engine Deck to P/N 212-030-009-097FM.
3. After installation of replacement engine deck, apply adhesive (C-314) to clips and reinstall (see Section A-A)
4. Make an entry in the helicopter records indicating compliance with this Technical Bulletin.

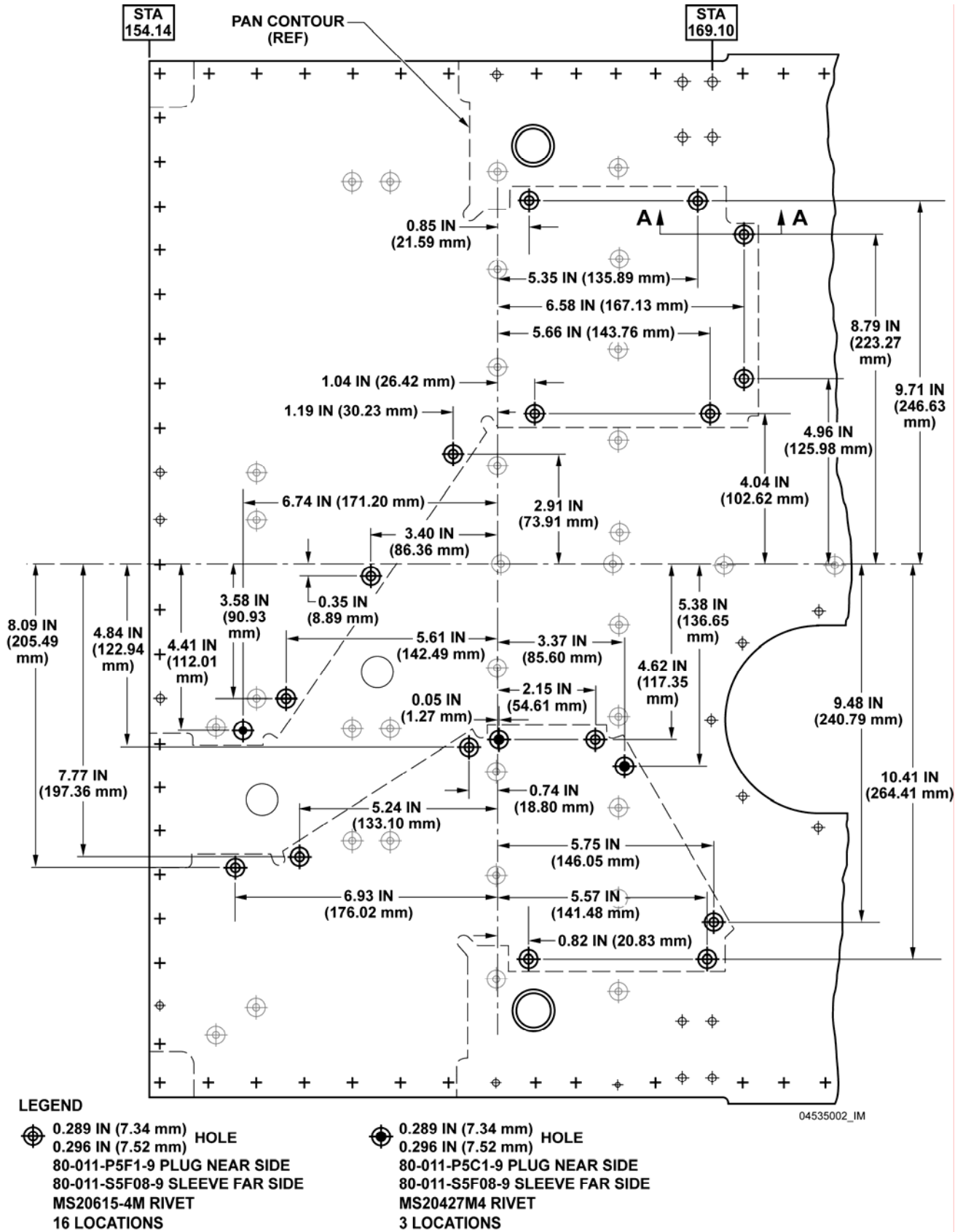
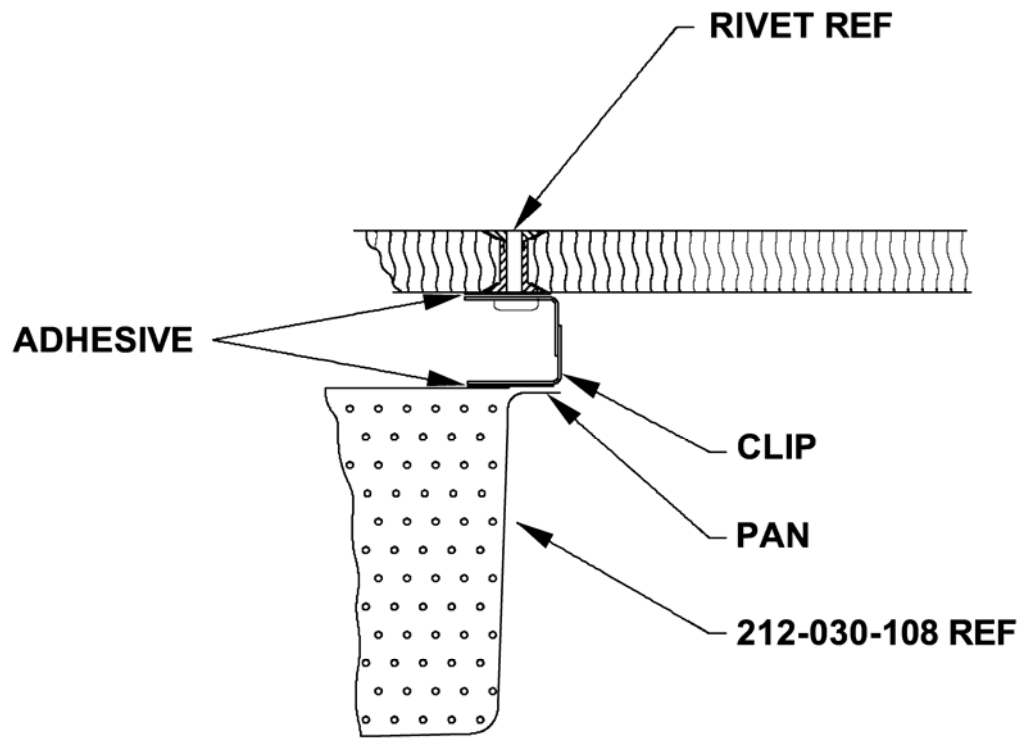


Figure 1 (Sheet 1 of 2)
Insert Installation
(Looking down at engine deck)



SECTION A-A

**Figure 1 (Sheet 2)
Typical Clip Installation**