

TECHNICAL BULLETIN  
**Bell Helicopter**

A Textron Company

No. 212-08-208

Date Mar 05, 2008

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DATE
REV

**MODEL AFFECTED:** 212

**SUBJECT:** REPLACEMENT OF BLIND RIVETS ON TAILBOOM

**HELICOPTERS AFFECTED:** All Model 212 helicopters with Tailbooms P/N 212-030-100-203 or -229, serial number PZ-1001 through sub.

**COMPLIANCE:** At Customer's Option

**DESCRIPTION:**

It was recently brought to Bell Helicopter's attention that blind rivets used to install Supports P/N 205-030-889-015 & -016 on some tailbooms may be responsible for cracks on the supports and their attaching structure. Future tailbooms will be built with only solid rivets at this location. This technical bulletin shows how to retrofit existing tailbooms by replacing the existing blind oversize rivets with solid oversize rivets. Only tailboom serial numbers with prefix PZ are affected.

**APPROVAL:**

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

**MANPOWER:**

Approximately 7.0 man-hours are required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

**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>
NAS1242AD5-5	Rivet	24

**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>
MIL-PRF-81733 2.5 OZ	Sealant	1	C-392

**SPECIAL TOOLS:**

None required

**WEIGHT AND BALANCE:**

Not affected

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

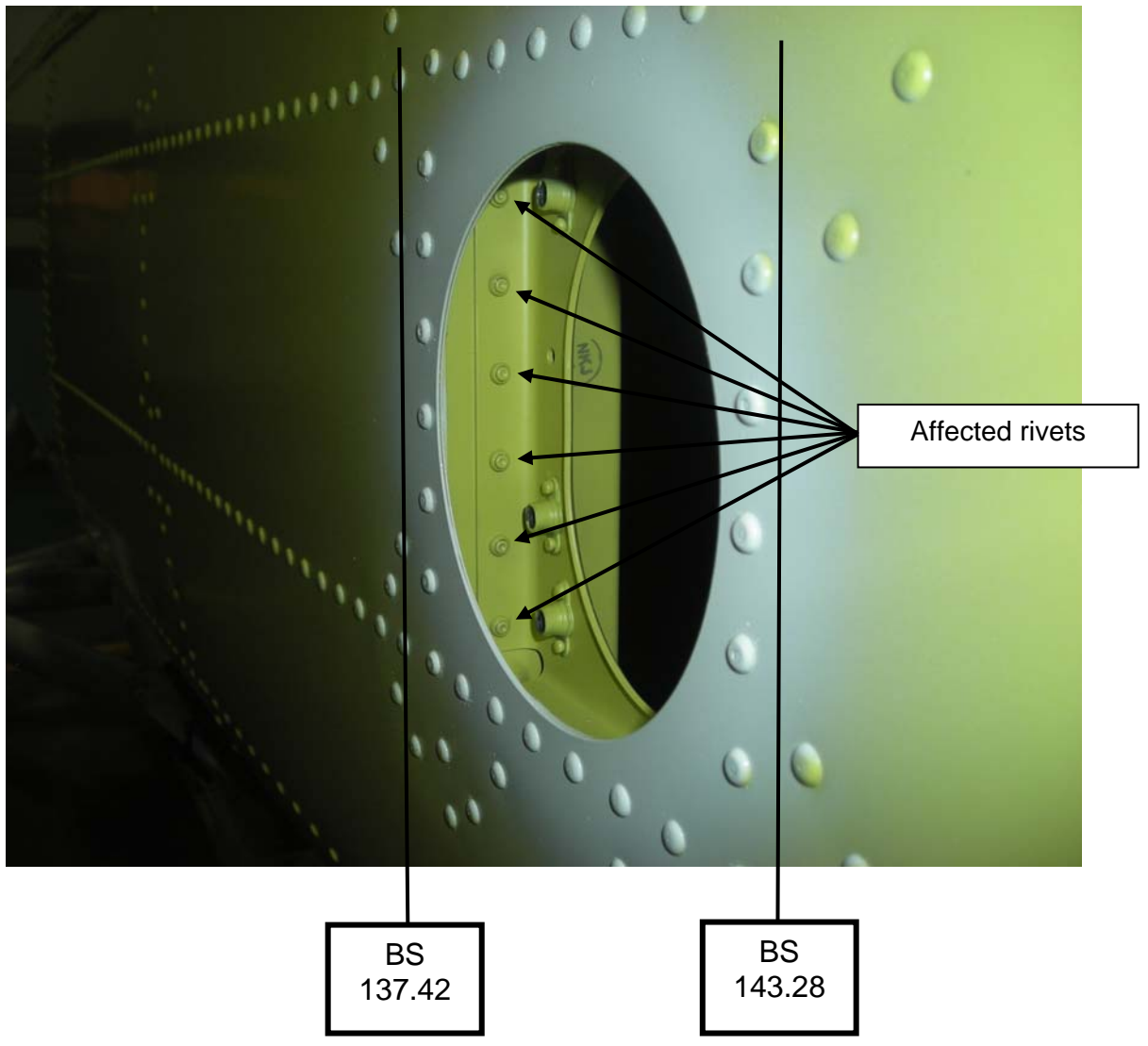
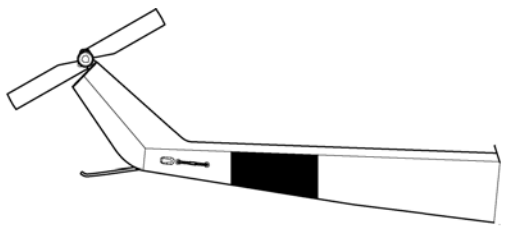
BHT-212-MM Maintenance Manual  
BHT-MED-SRM-1 Structural Repair Manual

**PUBLICATIONS AFFECTED:**

None affected

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Make helicopter ready for maintenance.
2. Confirm presence of blind rivets at the affected location (see Figure 1). If solid rivets are present, this technical bulletin is not required.
3. Remove both lower access doors on tailboom belly. Remove both elevators. Remove Elevator Horn. Refer to Maintenance Manual.
4. Replace rivets (vertical rows only) attaching Supports P/N 205-030-889-015 & -016 as follows (refer to Figure 1):
  - a. There are four rows of rivets affected. Two on each support, of which one is common to the bulkhead at Boom Station (BS) 143.28 and one is common to the rib at BS 137.42. Remove existing blind rivets from one of the rows. Temporarily attach with Cleco fasteners. Wet-install rivets P/N NAS1242AD5-5 in existing holes using sealant (C-392). Refinish.
  - b. Repeat for other three rows (24 rivets total).
5. Reinstall Elevator Horn in accordance with Maintenance Manual.
6. Reinstall both Elevators in accordance with Maintenance Manual.
7. Close access doors and make helicopter ready for flight.
8. Make an entry in helicopter historical records indicating compliance with this technical bulletin.



**Figure 1**  
Affected Rivets  
(Looking Forward and Inboard)