

DATE
REV

MODEL AFFECTED: 230

SUBJECT: TAIL ROTOR BLADE P/N 222-016-001-123, -123M, -131 AND -139M REWORKED PER ASB 230-04-31, INSPECTION OF

HELICOPTERS AFFECTED: Model 230 helicopters serial number 23001 through 23038 equipped with reworked blades P/N 222-016-001-123, -123M, -131 and -139M and all spare blades

COMPLIANCE: Bell Helicopter recommends accomplishment of this bulletin at next blade feathering bearings replacement

DESCRIPTION:

Bell Helicopter has been informed that feathering bearings may be incorrectly positioned in tail rotor blade P/N 222-016-001-123, -123M, -131 and -139M reworked per ASB 230-04-31. Investigation revealed that during the rework process, certain blades had their root block machined down to clean up corrosion pits under the flange of the bearing sleeves. Therefore, after installation of new sleeves, the original sleeve flange to flange dimension of 0.708 -0.722 inch is reduced to 0.668 to 0.682 inch.

Using roll staking tool P/N RST 2087 or RST 4307 to install either 222-312-753-103 or 222-312-761-101 bearing in a reworked blade could position the bearing up to 0.020 inch from its normal centered position.

This bulletin introduces instructions to clearly identify the reworked tail rotor blades and provides modified procedure to install feathering bearings in those blades.

APPROVAL:

Not required.

MANPOWER:

No additional man-hours required when this bulletin is performed during normal feathering bearing(s) replacement.

WARRANTY:

There is no warranty credit applicable for parts or labor associated with this bulletin.

MATERIALS:

None required

SPECIAL TOOLS:

None required

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

BHT-230-MM-7, Chapter 64

BHT-230-CR&O-3, Chapter 64

ASB 230-04-31, tail rotor blades p/n 222-016-001-123, -123m, -131 and -139m, inspection and rework of

TB 230-06-40, tail rotor blades 222-016-001-139 and tail rotor yoke assembly 222-012-702-113 and -117, introduction of

PUBLICATIONS AFFECTED:

BHT-230-MM-7, Chapter 64

BHT-230-CR&O-3, Chapter 64

ACCOMPLISHMENT INSTRUCTIONS:

-NOTE-

Specific inspection of tail rotor blades reworked per ASB 230-04-31 is not required by this bulletin.

-NOTE-

Evaluation of reworked tail rotor blade with bearings installed up to 0.020 inch of center confirms that this condition does not affect the blade and/or the operation of the aircraft.

1. Insert BHT-230-CR&O-3, Chapter 64, Revision 6, dated April 15, 2009 in Component Repair and Overhaul manual.
2. At next tail rotor blade feathering bearings replacement, install bearings in accordance with revised procedure listed in BHT-230-CR&O-3, Chapter 64.
3. This bulletin introduces revised procedure in BHT-230-CR&O manual to correctly install bearings in the tail rotor blade. Therefore, there is no requirement to annotate accomplishment of this bulletin in aircraft records or tail rotor blade historical card.