

**TECHNICAL BULLETIN**  
**Bell Helicopter** **TEXTRON**

A Subsidiary of Textron Inc.

No. 407-05-70

Date Aug 03, 2005

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DATE
REV

**MODEL AFFECTED:** 407

**SUBJECT:** NEW FRAHM ASSEMBLY 407-010-150-111,  
INTRODUCTION OF.

**HELICOPTERS AFFECTED:** Bell 407 helicopters serial number 53000  
through 53638 and 53640 through 53655.

[Bell 407 helicopters serial number 53639 and  
53656 and subsequent will have the intent of this  
bulletin accomplished prior to delivery]

**COMPLIANCE:** At Customer's Option

**DESCRIPTION:**

It has been reported that difficulties have been encountered when installing the FRAHM assembly onto the new main rotor hub assembly 407-010-100-123. This new main rotor hub assembly has sealant added between the upper/lower plates and the lead/lag damper. Investigation has revealed that as the hub assembly sealant dries it may displace the lead/lag damper studs and interfere with the installation of the FRAHM.

This bulletin introduces the new FRAHM assembly 407-010-150-111 with the bushing 407-010-154-103 inside diameter reamed to a new dimension. The new FRAHM assembly 407-010-105-111 replaces the 407-010-150-103, /-105, /-109 and /-109FM.

This bulletin also provides instructions to enlarge the inside diameter of the eight bushings 407-010-154-103 installed in the existing FRAHM assembly 407-010-150-105, /-109 and /-109FM.

**APPROVAL:**

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

**MANPOWER:**

Approximately 1.0 man-hour is required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

**MATERIALS:**

None required

**SPECIAL TOOLS:**

None required

**WEIGHT AND BALANCE:**

Not affected

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-407-MM Maintenance Manual

**PUBLICATIONS AFFECTED:**

BHT-407-MM Maintenance Manual  
BHT-407-IPC Illustrated Parts Breakdown

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Remove the FRAHM assembly from the helicopter. Refer to BHT-407-MM-6, Chapter 62.

-NOTE-

For FRAHM assembly configuration (Refer to BHT-407-MM-6, Table 62-2).

2. Ream bushing and identify FRAHM assembly 407-010-150-103, /-105, /-109 and /-109FM as follows:
  - a. Ream each 407-010-154-103 bushing inside diameter to 0.400 to 0.404 inch (10.16 to 10.26 mm). Refer to BHT-ALL-SPM, Chapter 9-13, Step f.
  - b. Identify the data plate with the use of a vibrating stylus. The depth of the vibroetch must not exceed 0.005 inch (0.127 mm).
  - c. Change the last digits of the part number as follows:
    - 1) 407-010-150-~~103~~ 103FM
    - 2) 407-010-150-~~105~~ 105FM
    - 3) 407-010-150-~~109FM~~ 111FM
    - 4) 407-010-150-~~109~~ 111FM
3. Install the FRAHM assembly on the helicopter. Refer to BHT-407-MM-6, Chapter 62.
4. Make an entry in the helicopter records to show that this technical bulletin has been accomplished.