

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

A Subsidiary of Textron Inc.

No. 407-05-72

Date Oct 17, 2005

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DATE
REV

**MODEL AFFECTED:** 407

**SUBJECT:** Bearing Support 407-030-009-103,  
407-030-010-101, 407-030-831-105 and  
407-030-832-101, Primer- Application of

**HELICOPTERS AFFECTED:** Model 407 helicopters serial number 53555 through 53640.

[Model 407 helicopters serial number 53641 and subsequent will have the intent of this bulletin accomplished prior to delivery]

**COMPLIANCE:** At customer's option, but recommended at the next inspection.

**DESCRIPTION:**

It has been determined that primer applied on bearing supports 407-030-009-103, 407-030-010-101, 407-030-831-105 and 407-030-832-101, could affect the bearing 407-340-339-107 alignment procedure.

This bulletin gives instructions to remove only the primer that is in contact with the bearing hangers 407-040-322-103.

**APPROVAL:**

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

**MANPOWER:**

Approximately 8 man-hours are required to complete this bulletin. Man-hours are based on hands-on time, and may vary with personnel and facilities available.

**Consumable Material:**

Refer to the Standard Practices Manual (BHT-ALL-SPM) for the material 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.

**SPECIAL TOOLS:**

None required

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-407-MM-5, REV. 18, 29 August 2003  
Chapter 53, Fuselage

BHT-407-MM-7, REV. 18, 29 August 2003  
Chapter 65, Tail Rotor Drive

BHT-ALL-SPM, reissue, 23 May 2000  
Chapter 3, Chapter 4

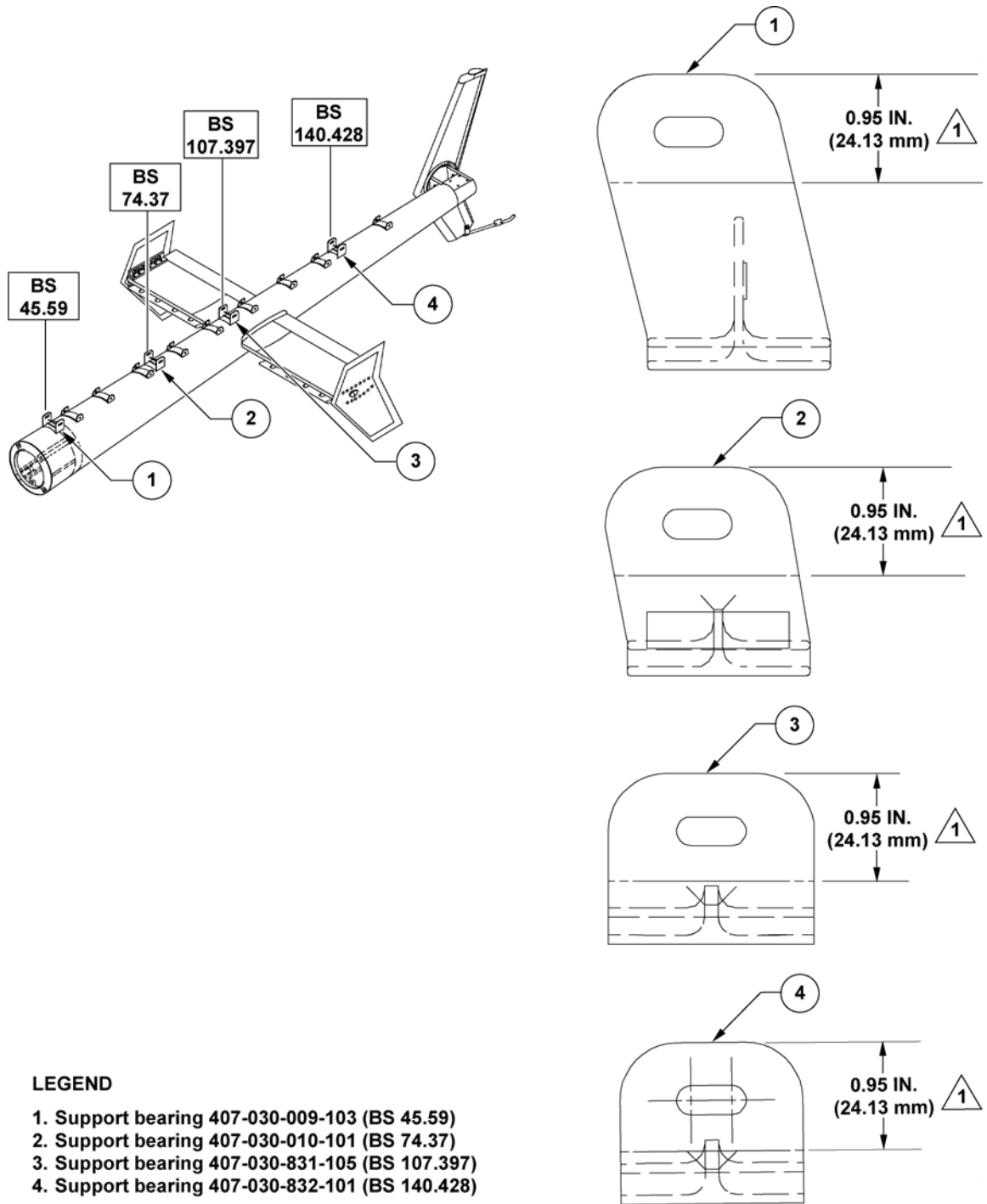
**PUBLICATIONS AFFECTED:**

None

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Remove the Aft Engine Fairing Assembly, the Tail Rotor Drive Shaft Assemblies and the Tail Rotor Gearbox Fairing Assemblies. Refer to BHT-407-MM-5, Chapter 53.
2. Remove the Aft Short Shaft Assembly and the Tail Rotor Drive Shaft Segmented Assemblies. Refer to BHT-407-MM-7, Chapter 65.


3. Remove primer at specific location only on bearing supports (1,2,3,4, figure 1). Refer to BHT-ALL-SPM, Chapter 3, Plastic Media Blasting or Chapter 4, Paint Remover and Strippers.
4. Install the Aft Short Shaft Assembly and the Tail Rotor Drive Shaft Segmented Assemblies. Refer to BHT-407-MM-7, Chapter 65.
5. Install the Aft Engine Fairing Assembly, the Tail Rotor Drive Shaft Assemblies and the Tail Rotor Gearbox Fairing Assemblies. Refer to with BHT-407-MM-5, Chapter 53.
6. Annotate the aircraft technical records to indicate that this Technical Bulletin has been accomplished.



**LEGEND**

1. Support bearing 407-030-009-103 (BS 45.59)
2. Support bearing 407-030-010-101 (BS 74.37)
3. Support bearing 407-030-831-105 (BS 107.397)
4. Support bearing 407-030-832-101 (BS 140.428)

**NOTE**

 Remove organic finish as indicated, both sides of flanges and slots over entire area, 2 places.

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**Figure 1 Area on bearing support where the primer is to be removed  
 (sheet 1 of 1)**