

TECHNICAL BULLETIN
Bell Helicopter
A Textron Company

No. 407-09-87

Date Sep 21, 2009

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DATE
REV

MODEL AFFECTED: 407

SUBJECT: INLET COWL DOOR HINGE PIN, CRIMPING OF.

HELICOPTERS AFFECTED: 407 Helicopters serial number 53835 through 53900 and 53911 through 53929.

[407 helicopters serial number 53000 thru 53834, and 53930 through subsequent will have the intent of this bulletin accomplished prior to delivery]

COMPLIANCE: Recommended

DESCRIPTION:

Bell Helicopter found that a number of helicopters may have been delivered with the L/H and R/H inlet cowl door hinges crimped at the lower end only. This bulletin provides instructions for crimping the upper end of the hinge to secure the hinge pin in place.

APPROVAL:

The engineering design aspects of this bulletin are Transport Canada Civil Aviation (TCCA) approved.

MANPOWER:

Approximately 0.2 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:

No material required

SPECIAL TOOLS:

None required

WEIGHT AND BALANCE:

Not affected

ELECTRICAL LOAD DATA:

Not affected

REFERENCES:

No reference

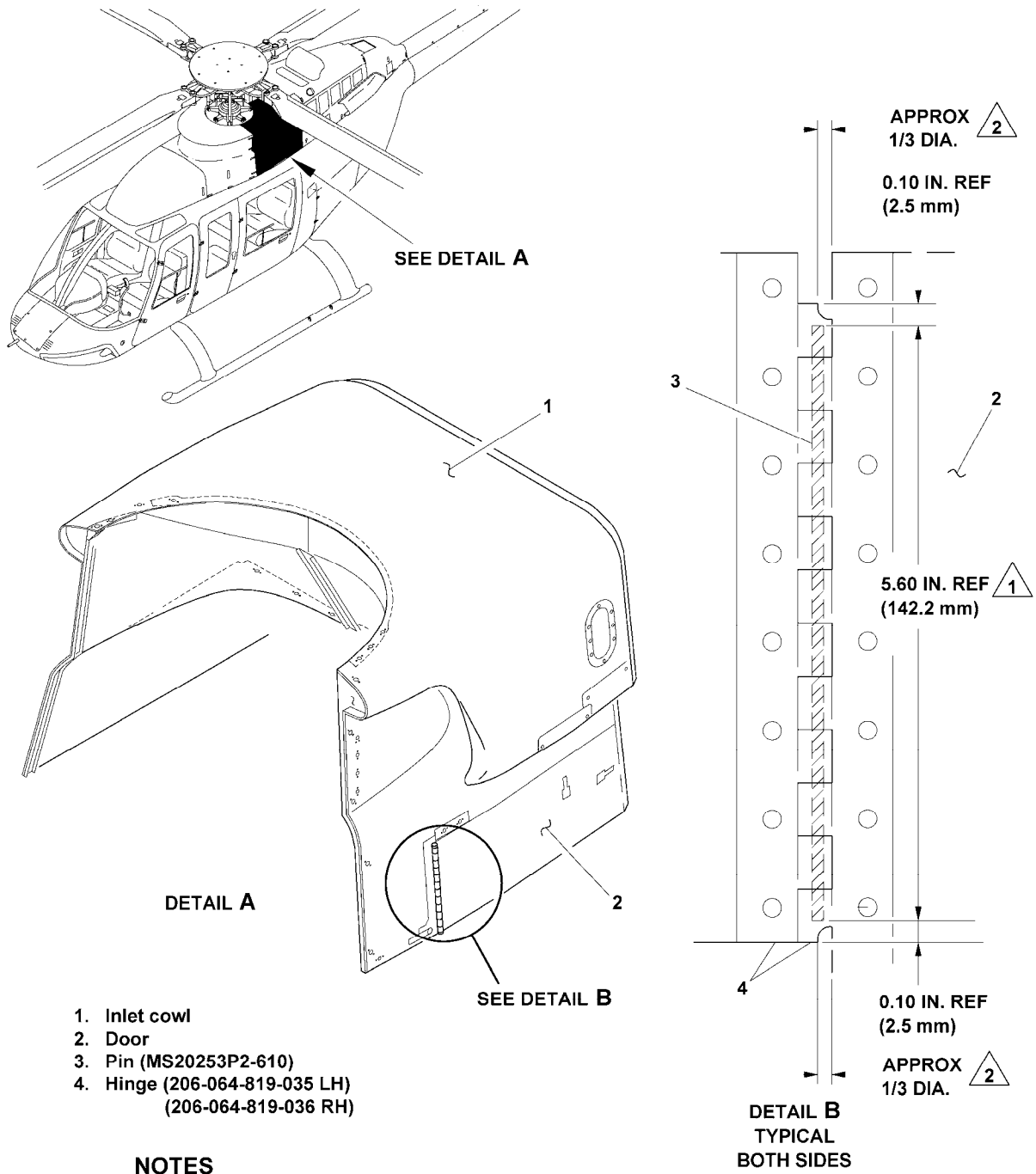
PUBLICATIONS AFFECTED:

Not affected

ACCOMPLISHMENT INSTRUCTIONS:

1. Refer to figure 1. Gain access to L/H and R/H inlet cowl door hinges (4).
2. Inspect hinges for proper crimping at the upper end. Proper crimped hinge will have the upper end deformed in a way that the pin (3) cannot be removed.
3. If the hinge has the upper end crimped properly, make an entry in the helicopter records to show that this bulletin has been accomplished.
4. If the upper end of the hinge is not crimped, proceed as follows:
 - a. Remove pin (3) from hinge (4).
 - b. Using a cutting wheel or equivalent, cut pin 0.20 inch shorter than the total length of the hinge. This will allow approximately 0.10 inch hinge crimping at each end.
 - c. Refer to Detail B. Insert pin (3) through hinge (4). Using pliers, crimp upper end of the hinge (4) to ensure that the pin (3) is secured in place.

- d. Verify that doors (2) operate freely and correctly.
5. Make an entry in the helicopter records to show this technical bulletin has been accomplished.



NOTES

- $\triangle 1$. Remove pin and cut 0.20 inches (5 mm) shorter than total length of the hinge.
- $\triangle 2$. Using pliers, crimp ends of the hinge by deforming approximately $\frac{1}{3}$ of the diameter.

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Figure 1. Crimping of inlet cowl door hinge pin