



A Textron Company

TECHNICAL BULLETIN

407-11-95
15 December 2011

MODEL AFFECTED: 407

SUBJECT: STARTER-GENERATOR 206-062-200-141,
INTRODUCTION OF

HELICOPTERS AFFECTED: Serial numbers 53000 through 53900, 53911
through 53999, and 54000 and subsequent.

COMPLIANCE: At customer's option.

DESCRIPTION:

Bell Helicopter has introduced the 206-062-200-141 starter-generator to supersede the 206-062-200-123 starter-generator, and can be used in conjunction with Installation Instruction BHT-407-II-31. As well, the 206-062-200-141 starter-generator is provided as an alternate to the basic 206-062-200-113 starter-generator. Part I of this bulletin provides instructions to modify the existing starter-generator cooling duct to allow proper fit of the new 206-062-200-141 starter-generator. The modified cooling duct may be used with the 206-062-200-113 and 206-062-200-123 starter-generators. Part II of this bulletin introduces starter-generator 206-062-200-141 and details any changes required when installing the new starter-generator.

APPROVAL:

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

CONTACT INFO:

For any questions regarding this bulletin, please contact:

Bell Helicopter Product Support Engineering - Light Helicopters
Tel: 450-437-2862 / 1-800-363-8023 / pselight@bellhelicopter.textron.com

MANPOWER:

Approximately 2 man-hours are required to accomplish Part I of this bulletin. No additional man-hours are required to accomplish Part II of this bulletin when done in conjunction with the overhaul requirement of the starter-generator. This estimate is 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.

MATERIAL:**Required Material:**

The following material is required for the accomplishment of Part II of this bulletin and may be obtained through your Bell Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty</u>
206-062-200-141	Starter-generator	1

Consumable Material:

The following material is required to accomplish Part I of this bulletin, but may not require ordering, depending on the operator's consumable material stock levels. This material may be obtained through your Bell Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty</u>	<u>Reference *</u>
299-947-100TY2CL3 25G	Adhesive, Epoxy Base, Heat Resistant, Wet Layup	2 (Note 1)	C-363
AMS-C-9084,CL2TYIII	Glass Cloth, 0.005 inch thick	98 inch ² (Note 2)	C-560

* C-XXX numbers refer to the consumables list in BHT-ALL-SPM Standard Practices Manual

NOTES:

1. Adhesive sold in 25 gram packets.
2. Glass cloth is sold in 3 square foot increments and is 38 inches wide.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-407-IPB Illustrated Parts Breakdown Chapter 71 and Chapter 96
BHT-407-MM-5 Maintenance Manual Chapter 53
BHT-407-MM-9 Maintenance Manual Chapter 71
BHT-407-MM-10 Maintenance Manual Chapter 95
BHT-ALL-SRM Structural Repair Manual Chapter 4
BHT-ALL-SPM Standard Practices Manual Chapter 13

PUBLICATIONS AFFECTED:

BHT-407-IPB Illustrated Parts Breakdown Chapter 71 and Chapter 96
BHT-407-MM Maintenance Manual Chapter 71
Installation Instruction BHT-407-II-31 - Increased Starter/Generator Load Kit
BHT-407-FM-2 Flight Manual
BHT-407-FMS-31.1 Flight Manual Supplement

ACCOMPLISHMENT INSTRUCTIONS:

PART I: MODIFICATION OF COOLING DUCT

1. Prepare helicopter for maintenance.
2. Gain access to the right side of engine compartment (BHT-407-MM-5 Chapter 53).
3. Remove the starter-generator cooling duct (4, Figure 1) as follows:
 - a. Remove the two screws (6) and the washers (5). Disconnect the duct assembly (4) from the support assembly (7).
 - b. Loosen the band clamp (3). Remove the duct assembly (4) and the spacer (2) along with the band clamp (3) from the starter-generator (1).
4. Mark an index line along the duct to ensure proper alignment is achieved during re-attachment of the duct halves (Figure 2).
5. Rework the starter-generator cooling duct in accordance with Figure 2. Refer to BHT-ALL-SRM Chapter 4 for cutting, surface preparation and wet layup procedures of glass or carbon fiber reinforced composite parts. The wet layup bagging process is optional.

6. Using a permanent ink marker, add the letter "A" at the end of the Bell part number on the cooling duct as follows:

206-064-203-101A

7. Install starter-generator (1, Figure 1), if previously removed, and reworked duct assembly (4) (BHT-407-MM-9 Chapter 71).
8. Make an entry in helicopter historical service records indicating compliance with Part I of this Technical Bulletin.

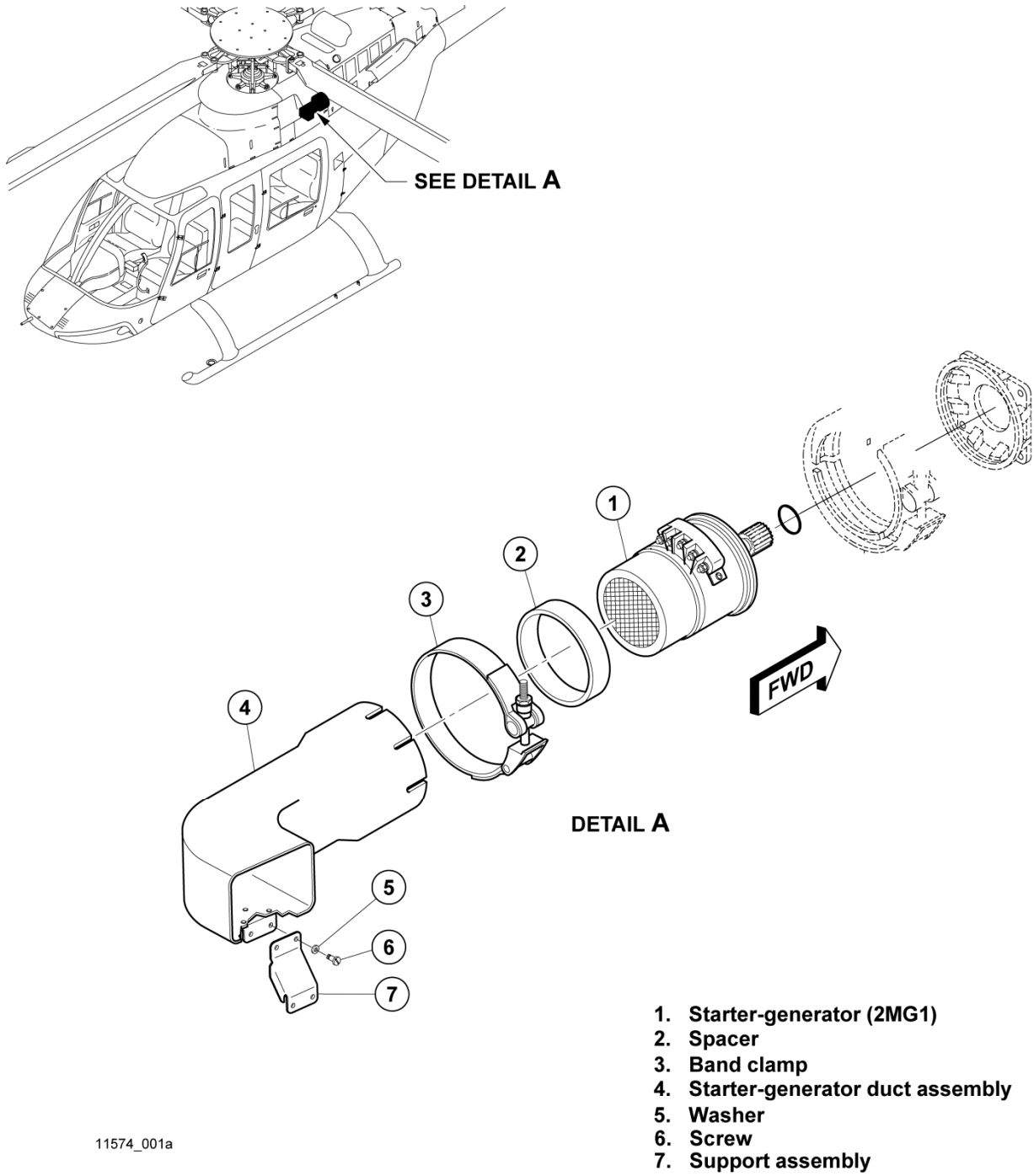
PART II: INTRODUCTION OF 206-062-200-141 STARTER-GENERATOR

1. Accomplishment of Part I of this Technical Bulletin is required prior to accomplishing Part II.

-NOTE-

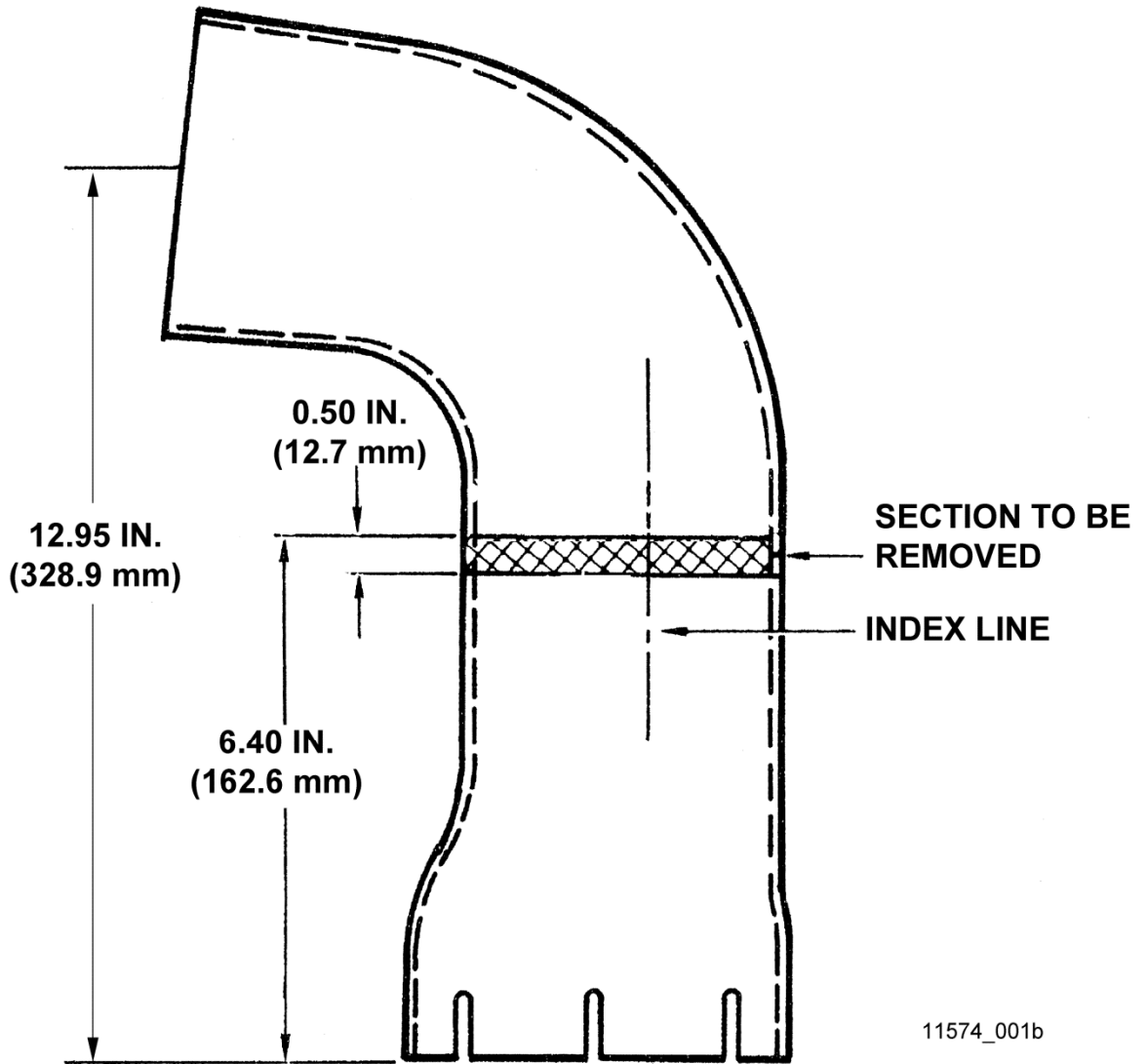
The 206-062-200-141 starter-generator requires the 206-062-200-121 Quick Attach/Detach (Q.A.D) kit.

2. Removal, inspection and installation procedures remain identical to those specified in the BHT-407-MM-9 Chapter 71.
3. Remove starter-generator 206-062-200-113 or 206-062-200-123 (BHT-407-MM-9 Chapter 71).
4. Install starter-generator 206-062-200-141 (BHT-407-MM-9 Chapter 71).
5. Make an entry in helicopter historical service records indicating compliance with Part II of this Technical Bulletin.



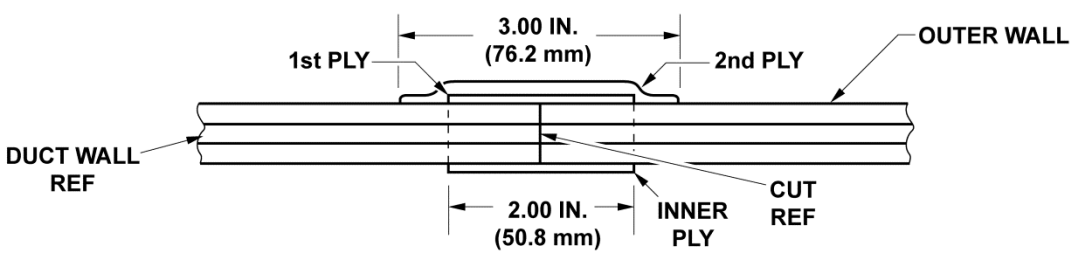
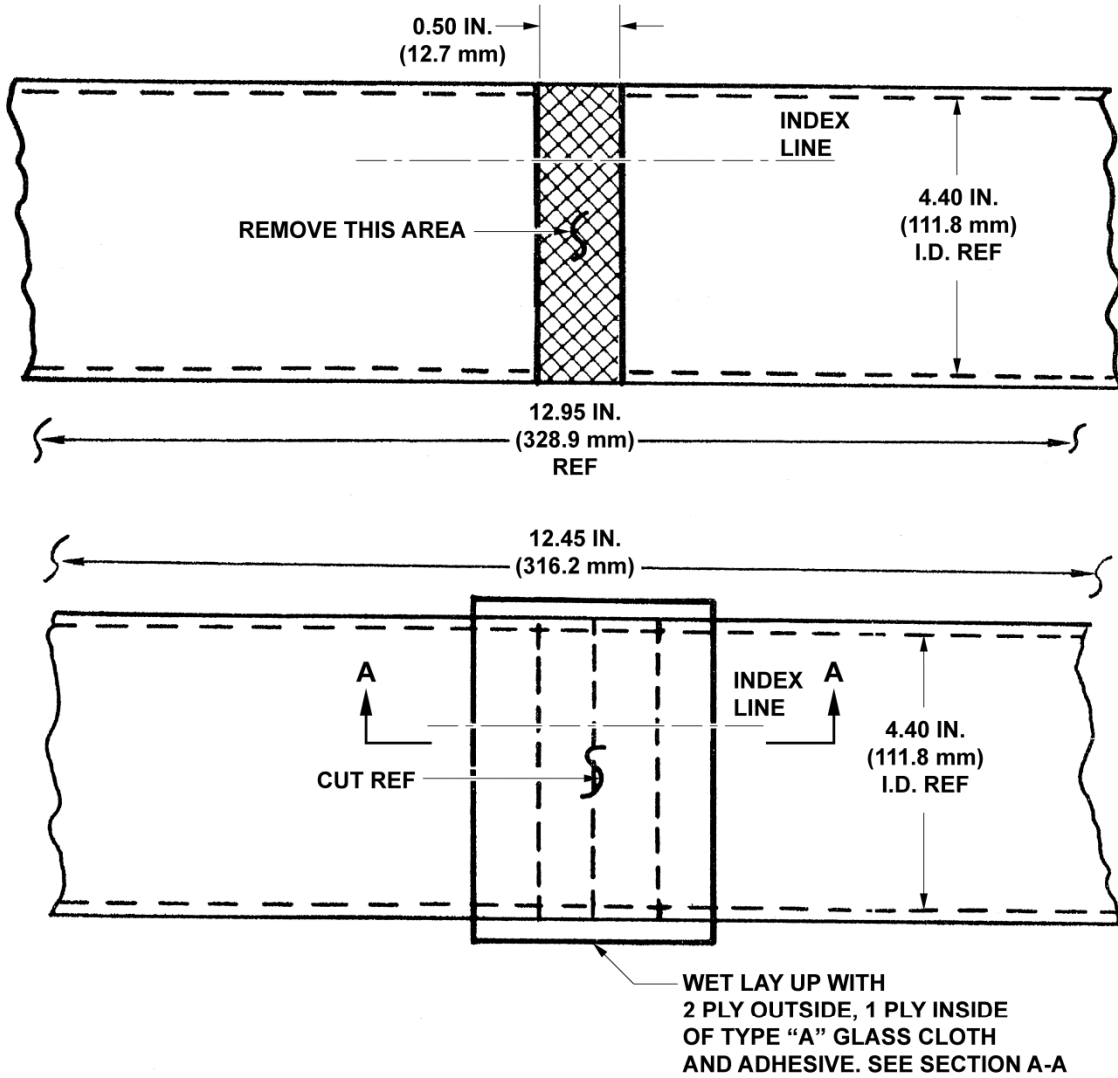
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Figure 1. Duct removal



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Figure 2. Duct modification (sheet 1 of 2)



SECTION A-A

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Figure 2. Duct modification (sheet 2 of 2)