

TECHNICAL BULLETIN  
**Bell Helicopter**

A Textron Company

No. 429-10-01

Date Feb 11, 2010

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DATE
REV

**MODEL AFFECTED:** 429

**SUBJECT:** ADDITION OF PACKINGS TO THE P/N 429-380-001-107 INTERGRATED HYDRAULIC MODULE (IHM) FILTER BOWLS.

**HELICOPTERS AFFECTED:** Model 429 helicopters S/N's 57003, 57006 and 57008

**COMPLIANCE:** Bell Helicopter recommends accomplishment of this bulletin.

**DESCRIPTION:** This bulletin introduces the addition of a packing to the hydraulic pressure and return filter bowls designed to prevent static leakage.

**APPROVAL:**

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

**MANPOWER:**

Approximately 2.0 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:**

All A/C will be under warranty.

**MATERIALS:**

**Required Material:**

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

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>
M83461/1-029	Packing	4

**Consumable Material:**

The following material is 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.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Quantity</u>	<u>Reference</u>
MS20995C32	Lockwire	As req'd	C-405

**SPECIAL TOOLS:**

None required

**WEIGHT AND BALANCE:**

Not affected

**ELECTRICAL LOAD DATA:**

Not affected

**REFERENCES:**

BHT-429-IPB Illustrated Parts Breakdown  
BHT-429-MM Maintenance Manual

**PUBLICATIONS AFFECTED:**

BHT-429-IPB Illustrated Parts Breakdown  
BHT-429-MM Maintenance Manual

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Remove the applicable forward cowling assemblies (600CL) and (600CR).
2. At the applicable integrated hydraulic module deplete the pressure from the system (chapter 12).
3. Cut the lockwire and remove both the pressure and return filter bowls.
4. Lubricate the packing with MIL-H-87257 and carefully install it in the under cut area of both pressure and return filter bowls as shown in figure 1. Verify the packing is flat against the flange.
5. Lubricate the filter bowl pilot areas with MIL-H-87257 hydraulic fluid and fill the filter bowl half full with MIL-H-87257 hydraulic fluid prior to installation.
6. Install both pressure and return filter element and filter bowls, torque to 130 to 150 in lbs. above running torque. The running torque includes the torque required to compress the packing so that no gap exists between the housing and the filter bowl. Total torque should not exceed 250 in lbs.
7. Secure the filter bowl to the IHM housing with lockwire (C-405).
8. Using a permanent marker mark "DV1911" on the data plate Mod block and re-identify P/N 429-380-001-107 as a -109.
9. Repeat steps 2 through 8 for the remaining hydraulic system.
10. Install applicable forward cowlings.
11. Annotate the helicopters technical records to reflect accomplishment of this bulletin.

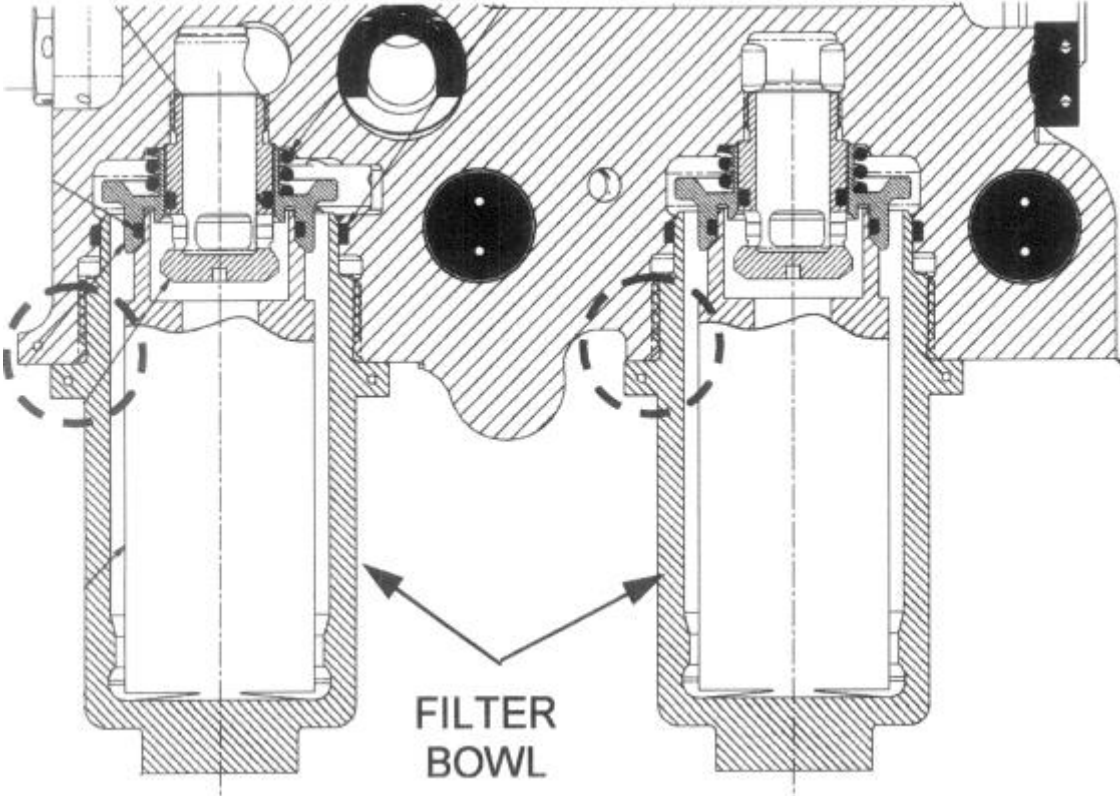


FIGURE 1