



TECHNICAL BULLETIN

429-24-71
28 February 2024

MODEL AFFECTED: 429

SUBJECT: 429-010-108-101 and -105 GRIP ASSEMBLY
CORROSION PROTECTION

HELICOPTERS AFFECTED: Serial numbers 57001 and subsequent.

COMPLIANCE: At customer's option.

DESCRIPTION:

Bell was made aware of damage to the tungsten carbide coating on the down stop surface of the grip assembly on helicopters operating in corrosive environments. The damage is caused by corrosion occurring underneath the coating resulting in bubbling or flaking of the tungsten carbide. This bulletin provides instructions to apply an organic finish on the tungsten carbide coating as preventative maintenance on grip assemblies that do not exhibit any corrosion damage.

Applicability of this bulletin to any spare part shall be determined prior to its installation on an affected helicopter.

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 Product Support Engineering
Tel: 1-450-437-2862 / 1-800-363-8023 / productsupport@bellflight.com

MANPOWER:

Approximately 4 man-hours are required to complete this bulletin. 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:**Consumable Material:**

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

| <u>Part Number</u> | <u>Nomenclature</u> | <u>Qty (Note)</u> | <u>Reference *</u> |
|--------------------|--|-------------------|--------------------|
| 2230-00559-00 | Epoxy polyamide Primer | 8 Oz (1) | C-204 |
| 2230-00316-00 | Polyurethane Coating, Light Gull Grey | 2 Gal (1) | C-245 |
| 2100-00061-00 | Acetone | 1 Gal (1) | C-316 |

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

NOTE 1: Quantity indicated is the format that the product is delivered in. Actual quantity required to accomplish the instructions in this bulletin may be less than what has been delivered.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

ALL-SPM, Standard Practices Manual

PUBLICATIONS AFFECTED:

429-MM, Maintenance Manual
429-CMM, Component Maintenance Manual

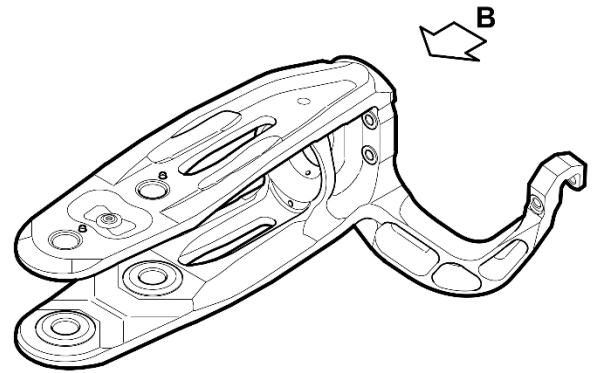
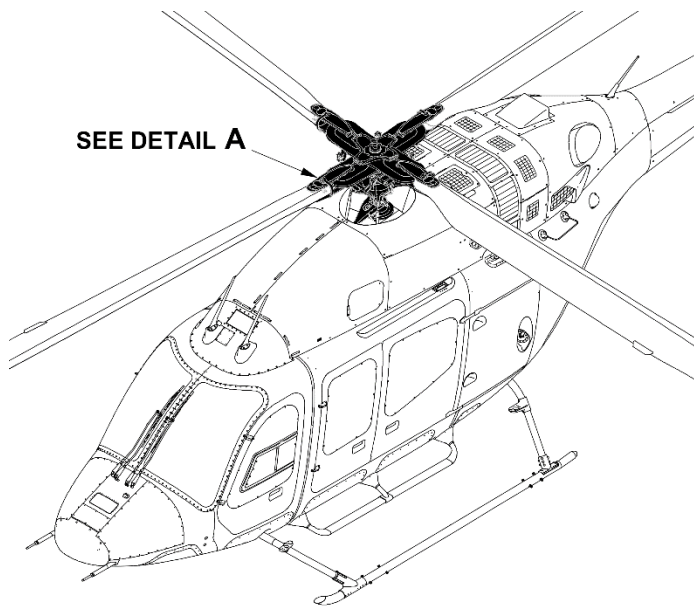
ACCOMPLISHMENT INSTRUCTIONS:

1. Prepare the helicopter for maintenance.

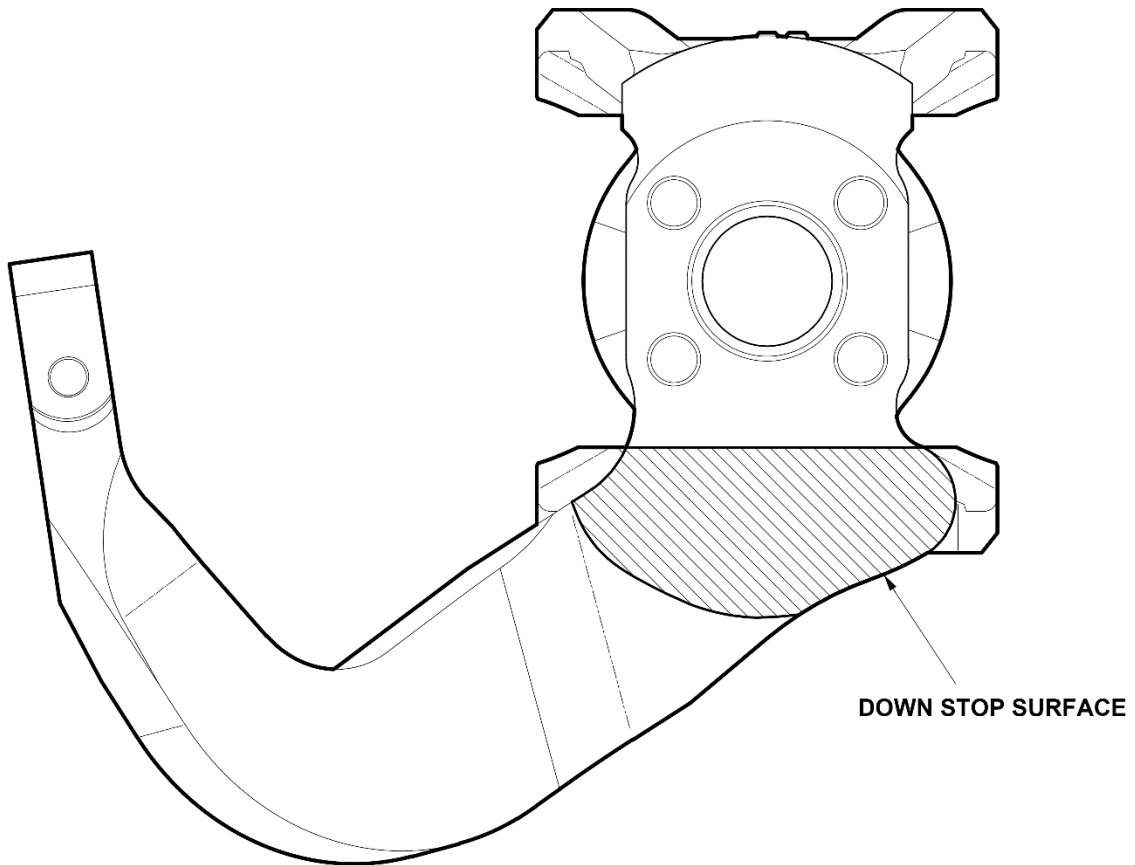
-NOTE-

The application of paint to the tungsten carbide coating is optional and limited to new pitch horns or pitch horns that are not exhibiting any damage to the tungsten carbide coating. Painting of the surface is highly recommended when operating in a corrosive environment.

2. Thoroughly clean the grip assembly down stop surface (Figure 1, View B) with a cloth dampened with acetone (C-316) or equivalent.
3. Apply one coat of primer (C-204).
4. Apply two coats of polyurethane coating (C-245) Light Gull Gray #16440.
5. Make an entry in the helicopter logbook and historical service records indicating compliance with this Technical Bulletin.



DETAIL A



VIEW B

23546_001

Figure 1 – Main Rotor Grip Down Stop Surface