A Textron Company

TECHNICAL BULLETIN **412CF-19-111**

10 September 2019

MODEL AFFECTED: **412CF**

SUBJECT: **SWASHPLATE AND SUPPORT ASSEMBLY, 412-010-402, CONFIGURATION CHANGE AND UPGRADE OF**

HELICOPTERS AFFECTED: **Serial numbers 46400 through 46499.**

COMPLIANCE: At customer's option.

DESCRIPTION:

This bulletin provides information on upgrading the swashplate and support assembly to the latest configuration. Table 1 lists the components which comprise the swashplate and support assembly dash numbered configurations, except for common hardware.

The use of a later dash numbered swashplate and support assembly on an earlier helicopter serial number is authorized. The Helicopters' certified design configuration at time of delivery were as follow:

HELICOPTER SERIEL NUMBER	SWASHPLATE AND SUPPPORT ASSEMBLY PART NUMBER
46400 through 46499	412-010-402-111

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

Approved for public release.

APPROVAL:

The engineering design aspects of this bulletin are FAA approved.

CONTACT INFO:

For any questions regarding this bulletin, please contact:

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

MANPOWER:

Accomplishment of this bulletin during normal overhaul will not require additional man-hours.

WARRANTY:

There is no warranty credit applicable for parts or labor associated with this bulletin.

MATERIAL:

Required Material:

Refer to the accomplishment instructions for the list of material required. Standard parts for overhaul are not included. Components for this bulletin may be obtained through your Bell Supply Center.

Consumable Material:

Refer to the 412 Component Repair and Overhaul Manual for the consumable material required to accomplish this bulletin. This material may be obtained through your Bell Supply Center.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

C-12-146-000/MY-001, Illustrated Parts Breakdown
BHT-412CF-IPB, Illustrated Parts Breakdown
BHT-412-CR&O, Component Repair and Overhaul Manual (C-12-146-000/MP-001)
ASB 412CF-02-17, Swashplate and Support Assembly, Bolt 204-011-463-001 to a -109, Re-identification of
IL 412CF-12-27, Component Retirement Lives, Increase or Elimination of

PUBLICATIONS AFFECTED:

None affected.

ACCOMPLISHMENT INSTRUCTIONS:

1. Table 1 lists the major components of dash numbered configurations but does not contain parts and hardware common to all configurations. Those items are contained in the Illustrated Parts Breakdown.

2. Upgrade swashplate and support assembly in accordance with the 412 Component Repair and Overhaul Manual.

3. Re-identify the data plate and the historical service record to the new part number that the swashplate and support assembly was upgraded to with suffix “FM” to indicate “field modified”. The serial number of a field modified part will not be altered or changed.

-NOTE-

Example: Upgrade the swashplate and support assembly 412-101-402-113 to the -115 configuration. Re-identify the assembly data plate and historical service record 412-010-402-~~113~~ -115FM. Retain existing serial number.

4. Make an entry in the helicopter logbook and historical service records indicating compliance with this Technical Bulletin.

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Table 1 – Swashplate and Support Assembly Configuration

PART NUMBER	ITEM	QTY	CONFIGURATION			NOTES
412-010-402	**Swashplate & Support Assembly**		**-111**	**-113**		1
					-115	
204-010-404-001	GIMBAL ASSY	1	x	x		2
212-010-416-101	GIMBAL ASSY	1			x	
204-011-402-131	INNER RING ASSY	1	x	x	x	
204-011-427-103	INNER CAP	1	x	x	x	
204-011-428-003	COVER	1	x	x	x	
204-011-429-001	SEAL	2	x	x	x	
204-011-430-001	BEARING	1	x	x	x	
204-011-431-001	SHIM	4	x	x	x	
204-011-451-001	TRUNNION ASSY	2	x	x	x	
204-011-457-003	WASHER	4	x	x	x	
204-011-457-105	WASHER	2	x	x	x	
204-011-463-001	BOLT	2	x			3
204-011-463-109	BOLT	2		x	x	4
204-011-463-105	BOLT	2	x	x	x	
412-010-404-101	SHIM	1	x	x	x	
412-010-407-117	OUTER RING ASSY	1	x	x	x	
412-010-453-105	SUPPORT ASSY	1	x	x	x	
540-011-434-111	CAP ASSY	1	x	x	x	

NOTES:

1) Replaced by 412-010-402-115.
2) Replaced by 212-010-416-101.
3) PRE ASB 412CF-02-17.
4) POST ASB 412CF-02-17.

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