

TECHNICAL BULLETIN

206-12-200
24 April 2014

MODEL AFFECTED: 206A/B, TH-67

SUBJECT: AIRFRAME PRODUCTION SHIM RECORDS,
REISSUE OF

HELICOPTERS AFFECTED: Serial numbers 3996 through 4679, as listed in
Table 1. Serial numbers 5134, 5152 and 5232.

COMPLIANCE: At customer's option, but recommended before
May 1st, 2015.

DESCRIPTION:

Transcripts of the applicable airframe production shim records for helicopters built prior to 206B S/N 4559 and TH-67 S/N 5285 are supplied by Bell Helicopter Textron to customers on demand. Helicopters 206B S/N 4559 and sub, and TH-67 S/N 5285 and sub, received a transcript of the airframe production shim records at delivery as part of the helicopter's technical records.

BHT discovered an oversight in the process of transferring the information from the original production records to the blank form used for this matter. This oversight has since been corrected. BHT reviewed all affected shim records issued and none have revealed a safety concern. However, premature wear of drivetrain components may be noted if helicopters remain in service with incorrect shim configurations.

This bulletin provides a list of affected helicopters (as seen in Table 1) for which an incorrect shim record has been delivered. It also provides instructions for maintenance actions in cases where incorrect shim values were installed under engine mounts and/or drivetrain components, using the erroneous shim record values.

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@bh.com

MANPOWER:

Approximately 5.0 man-hours are required to replace the transmission mount and isolating mount shims (6 shims). Approximately 3.5 man-hours are required to replace the engine mount shims (6 places). Approximately 2.0 man-hours are required to replace the oil cooler blower support shims (2 places). 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.

MATERIAL:

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>Qty</u> (Note 1)	<u>Group</u> (Note 2)
206-031-512-001	Peelable Shim (Trans. mount, FWD)	2	1
206-031-512-003	Peelable Shim (Trans. mount, AFT)	2	1
206-031-512-005	Solid 0.040" Spacer (Trans. mount, AFT)	2	1
206-031-512-007	Solid 0.040" Spacer (Trans. mount, FWD)	2	1
120-035-32-8	Peelable Shim (Trans. isolating mount)	4	1
206-061-105-001	Peelable Shim (Engine mount, FWD)	4	2
206-061-105-003	Peelable Shim (Engine mount, AFT)	2	2
206-032-314-001	Peelable Oil Cooler shim (AFT)	2	3
206-032-314-003	Peelable Oil Cooler shim (FWD)	2	3

Note:

1. Use shim and spacer quantity, as required.
2. Refer to Table 1 for affected group definitions.

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 Helicopter Textron Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty</u>	<u>Reference *</u>
2000-09182-01	Adhesive	1	C-317

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

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-206-IPB Illustrated Parts Breakdown, Chapter 53, 63, and 71
 BHT-206-MM Maintenance Manual, Chapter 53, 63, and 71
 BHT-206-SRM-1 Structural Repair Manual
 BHT-ALL-SRM Structural Repair Manual

PUBLICATIONS AFFECTED:

None affected.

ACCOMPLISHMENT INSTRUCTIONS:

-NOTE-

All models 206A/B and TH-67 were delivered with proper shims installed at the factory.

-NOTE-

Helicopters S/N 4559 and subsequent, listed in Table 1, were provided with an inaccurate copy of the shim record at delivery. Shim records for helicopters built prior to S/N 4559 (and for TH-67 5134, 5125, and 5232) were given to customers/operators by demand on a case-by-case basis. The possibility of having the wrong shims installed on the helicopters listed in Table 1 is high since the demand was likely supporting maintenance actions where shim values were to be validated or reset.

1. Review Table 1 to verify if the helicopter is affected.
 - a. If the helicopter is not listed, make an entry in the helicopter logbook and historical service records indicating compliance with this bulletin and that the helicopter is not affected.
 - b. If the helicopter is listed, contact Product Support Engineering to obtain a corrected copy of the shim record and go to step 2.
2. Review the helicopter records to determine if shims may have been replaced or reinstalled at the area(s) shown by the Group numbers in Table 1, indicating where errors occurred.
 - a. If shims were replaced or reinstalled in accordance with the erroneous shim record delivered from the factory, replace the shims in accordance with the latest shim record obtained from PSE in step 1b above.
3. Discard previous shim record that was delivered with the new helicopter or provided by Product Support Engineering.
4. Make an entry in the helicopter logbook and historical service records indicating compliance with this bulletin and that proper shim values have been installed.

-NOTE-

To help research and define applicable maintenance actions, the errors have been grouped per areas affected as found on the erroneous shim records.

Group 1: Transmission
Group 2: Engine
Group 3: Oil Cooler

Table 1 – Affected Helicopters

Helicopter S/N	Error found in group	Helicopter S/N	Error found in group
3996	1	4571	2
4006	1 & 3	4572	2
4112	1 & 2	4576	2
4149	1	4597	2
4170	1	4600	2
4184	1	4606	2 & 3
4223	1 & 2	4608	2
4233	1	4609	3
4265	1	4612	1
4267	1	4615	2
4268	2	4619	2
4306	1	4624	2
4337	1	4636	3
4451	1	4653	2
4513	1	4655	2
4547	1	4672	2
4559	2	4678	2
4560	1	4679	2
4561	1 & 2	5134	2
4564	2	5152	2
4569	2	5232	2
4570	2		