

TECHNICAL BULLETIN

206-15-208  
12 January 2015

**MODEL AFFECTED:** 206B3

**SUBJECT:** SEAT BACK, SEAT BOTTOM CUSHION  
REUPHOLSTERING, INTRODUCTION OF

**HELICOPTERS AFFECTED:** Serial numbers 3567 to 4690.

[As a prerequisite, Model 206B3 helicopters S/N 3567 through 4597 must have Technical Bulletin 206-15-207 accomplished prior to or concurrently with this bulletin. S/N 4598 to 4690 must have Alert Service Bulletin ASB 206-11-128 accomplished prior to or concurrently with this bulletin.]

**COMPLIANCE:** At customer's option.

**DESCRIPTION:**

Bell Helicopter Product Support Engineering receives numerous customer requests to obtain replacement frames for seat repairs. This bulletin introduces spare seat frames and provides limited instructions concerning the seat build process.

**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:**

Manpower will vary depending on the extent of work required.

**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>	<u>Note</u>
206-072-212-107	Frame, bottom crew seat	As required	(1)
206-072-333-101	Frame, bottom crew seat	As required	(2)
206-072-213-101	Frame, back crew seat	As required	(3)
206-072-217-135	Frame, bottom passenger seat	As required	(4)
206-072-218-101	Frame, back passenger seat	1	(1)
2640-10781-00	Covering, LGT fabric (15473)	1	(5)

**Notes:**

- (1) Useable with Deluxe and Custom Deluxe Seat Kits, crew seat frames post ASB 206-11-128 for S/N 4598 through 4690 and post TB 206-15-207 for S/N 3567 to 4597.
- (2) Crew Comfort Seat Kit bottom cushion used with Service Instruction BHT-206-SI-126 needs to accomplish TB 206-15-207 prior to reinstalling the seat bottom cushions.
- (3) Frame crew seat back useable with Deluxe, Custom Deluxe, and Comfort Seat Kit. No modification required.
- (4) Frame passenger seat bottom useable with Deluxe, Custom Deluxe, and Comfort Seat Kit requires that **Part II**, **Part III**, **Part IV**, and **Part V** of TB 206-15-207 be accomplished prior to reinstalling the seat bottom cushions.
- (5) The P/N 2640-10781-00 Covering LGT Fabric (15473) is procurable in multiples of 5 square feet (4645 cm<sup>2</sup>).

**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 (1)</u>	<u>Qty</u>	<u>Reference *</u>
2000-06022-00	ADHESIVE,PASTE-PINT - 299-947-107 TYPE-1	1 pint	C-324

**Note:** Equivalent to 299-947-107 Type 1, Class 1

\* 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 25  
BHT-206-MM Maintenance Manual, Chapter 25  
BHT-206-SI-126 Comfort Seat Kit  
IL GEN-04-98  
ASB 206-11-128  
TB 206-15-207

**PUBLICATIONS AFFECTED:**

BHT-206-IPB Illustrated Parts Breakdown, Chapter 25

## ACCOMPLISHMENT INSTRUCTIONS:

Two options are available:

**Option A:** Send the seats to Bell Customer Property Return (CPR) for seat frame replacement or reupholstering. Refer to Gen-04-98 Information Letter.

**Option B:** Have the seats repaired by a facility specializing in seat refurbishment and approved by local aviation regulatory authorities.

1. If Option A is chosen, proceed as follows:
  - a. Contact Bell CPR for shipping instructions, including the details of the scope of work required on the seat assemblies.
2. If Option B is chosen, proceed as follows:
  - a. Send the seat to an approved repair facility as noted in Option B.

-NOTE-

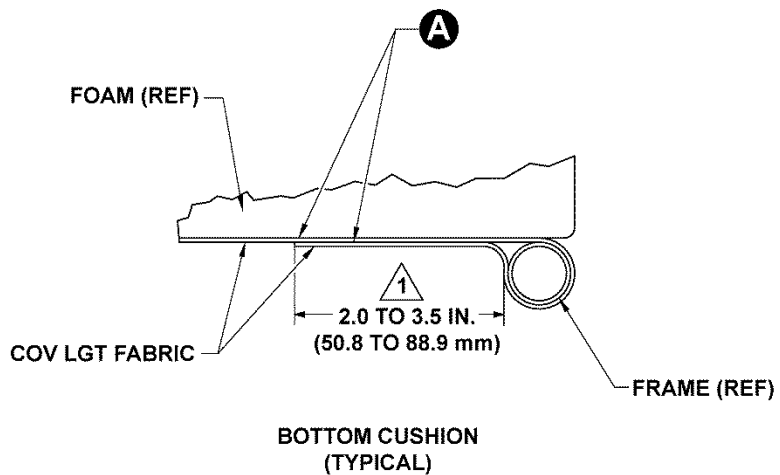
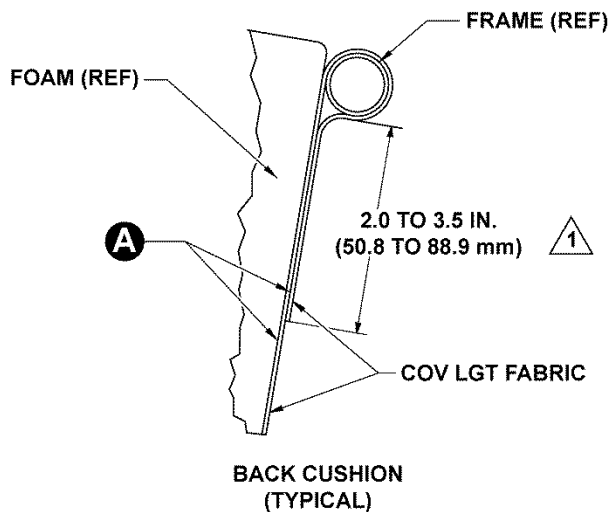
This technical bulletin does not provide complete step by step instructions to disassemble and rebuild seat cushion assemblies, headrests, or armrests. The following instructions are to be used as guidelines by approved repair facilities during seat refurbishments.

3. Disassemble the seat assembly as follows:
  - a. Remove the seat outer material. Keep the material for reuse or as a guide template.
  - b. If required, remove the foam from the seat frame. Keep the foam for reuse or as a guide template.
  - c. If required, remove the covering LGT fabric from the seat frame. Keep the material for reuse or as a guide template.
4. Inspect the seat frame for damage. The damage is limited to 0.005 inch (0.13 mm) deep measured and compared to an unworn section of the seat frame once all the nicks, dents, and scratches have been blended out. Frames are nonrepairable and need to be replaced if found damaged beyond this established limit.

**WARNING**

Final seat assembly approval remains the responsibility of the owner/operator. Make sure that all of the latest aviation regulations pertaining to the replacement of foam and/or seat outer covering materials used are met, with particular attention being given to the requirements set forth in FAR Part 27.853.

5. Reassemble the seat assembly as follows (Figure 1):
  - a. If the covering LGT fabric was removed from the seat frame, reinstall the covering LGT fabric or install a new cut-out as follows:
    - (1) Position the covering LGT fabric around the seat frame until taut and bond into place with adhesive (C-324).
    - (2) The fabric must be wrinkle free and provide a suitable cushion support.
  - b. If the foam was removed from the seat frame assembly, reinstall the removed foam or the replacement foam of choice. Bond with adhesive (C-324).
  - c. Reinstall the removed seat outer material or install a replacement seat outer material of choice. Bond sides with adhesive (C-324).
6. Match the headrest or armrest outer material as necessary.
7. Upon reinstallation of the seats, it is the responsibility of the owner/operator to provide traceability to ensure conformity of the reworked seats.
8. Make an entry in the helicopter logbook historical service records indicating compliance with this Technical Bulletin.



**A** ADHESIVE (C-324)

**NOTE**

$\triangle 1$  Typical overlap of COV LGT fabric all around frames.

09753\_001

**Figure 1: Seat Assembly Reference**