



A Textron Company

TECHNICAL BULLETIN

206-23-212

14 July 2023

MODEL AFFECTED: 206A/B

SUBJECT: SEGMENTED TAIL ROTOR DRIVESHAFTS,
RETROFIT OF.

HELICOPTERS AFFECTED: Serial numbers 4 through 1251.

[Serial number 1252 and subsequent had the intent of this bulletin accomplished prior to delivery.]

COMPLIANCE: At customer's option.

DESCRIPTION:

This Technical Bulletin provides instructions to install segmented tail rotor drive shaft assemblies on helicopters originally equipped with a one-piece tail rotor drive shaft (long shaft). Bell is aware that some operators have already modified their helicopters. Existing field modifications that meet the intent of this Technical Bulletin would be considered approved by Bell engineering.

NOTE: This bulletin is compatible with components already installed under Service Instructions 206-SI-80 (Allison 250-C20 Turbo-jet engine, Airframe Retrofit Kit) and/or Service Instructions 206-SI-112 (Retrofit Kit-Engine Assembly 250-C20B).

PREREQUISITES TABLE (Ref. Appendix A, Table A-1):

The Prerequisites Table A-1 found in Appendix A lists all the Alert Service Bulletins (ASB), the Technical Bulletins (TB) and Service Instructions (SI) that are mandatory and must be accomplished prior to or in conjunction with this bulletin. The modifications listed in Table A-1 are mandatory and supplement the instructions listed herein.

APPROVAL:

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

CONTACT INFO:

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MANPOWER:

Approximately 40.0 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:

Required Material:

Material listed below will upgrade the helicopters affected by this bulletin to a tail rotor drivetrain and airframe configuration equivalent to the basic configuration manufactured for 206B serial number (S/N) 1252. Subsequent part numbers to those listed below and indicated as replacement spares approved by Bell engineering are identified under Appendix B, Table B-2. Customers can also refer to the current Illustrated Parts Catalog for Bell approved replacement parts applicable to 206B S/N 1252 and subsequent.

The following material is required for the accomplishment of this bulletin to meet the configuration of Bell S/N 1252.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty (Note)</u>
206-040-329-003	Washers(radiused)	74
32721-1	Disc	4
NAS1149D0316J	Washers	22
AN174-7A	Bolt	28
NAS9926-4L	Nut	32
206-031-004-095	Tailboom assy.	1(1)
206-033-420-001	Fairing half (lower)	1(1)
206-033-420-003	Fairing half (upper)	1(1)
206-031-332-019	Retainer (Fairing, L/H side)	1
206-031-332-027	Retainer (Fairing, R/H side)	1

206-061-808-067	Fairing assembly	1(1)
206-020-113-011	Vertical fin assembly	1(1)(2)
206-040-930-007	Shaft and bearing hanger assy. (Fwd.)	1(1)(4)
206-040-930-005	Shaft and bearing hanger assy. (Aft)	4(1)(4)
206-020-120-011	Spar	1(7)
206-020-123-003	Stabilizer assy.	1(7)
206-020-123-004	Stabilizer assy.	1(7)
206-040-400-011	Tail Rotor gearbox assy.	1(3)(9)
AS3209-110	Packing	2
(Alt: MS29561-110)		
AN3-3A	Bolt	18(8)
AN3-4A	Bolt	4(8)
NAS1149D0332J	Washer	22(8)
20-057-6-22	Bolt	1
NAS6606-22	Bolt	1(5)
20-057-6-19	Bolt	2
NAS6606-25	Bolt	1(5)
NAS6606-29	Bolt	1(5)
EB-064	Nut (Double Ex)	4
MS20002C6	Washer	4
NAS1149F0463P	Washer	32
NAS1149G0663P	Washer	4
MS20470AD4-()	Rivet	46
MS20426AD4-()	Rivet	2
MS20426AD3-()	Rivet	8
140-029-4	Washer	2
140-029-5	Washer	2
NAS9301B4-02	Rivet	2(6)
NAS9301B-5-02	Rivet	2(6)
NAS1149D0416J	Washer	4

NOTES

1. Use of one of the replacement part numbers listed in Appendix B, Table B-1 is permitted.
2. Verify that the configuration of fin and upper fairing will be suitable if an antenna is installed.
3. The tail rotor gearbox can be upgraded (Ref. Technical Bulletin 206-99-168).
4. The riveted tail rotor driveshafts can be installed in accordance with maintenance manual (BHT-206A/B-SERIES-MM).
5. Omit one tailboom attachment bolt NAS6606-22 and use bolt NAS6606-25 or NAS6606-29 for the upper left attachment fitting location; refer to Table B-1 to determine the correct bolt part number applicable to the helicopter based on the Technical Bulletin status.
6. See Table A-12 in BHT-ALL-SRM, Appendix A for alternates.

7. Applicable to S/N 4 through 913 only but not required if both original horizontal stabilizers 206-020-119-ALL were modified per TB 206-01-73-3 and ASB 206-01-73-7. See Appendix B, Table B-1 for applicable replacement spar and horizontal stabilizer assemblies as a unit.
8. Required for new gearbox fairing halves installation.
9. If Service Instruction 206-SI-112 was accomplished, use the gearbox assembly as applicable by the Service Instruction and comply with tail rotor flight controls rigging accordingly.

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>
2000-00713-00	Tape (1" wide)	1 Roll (1)	C-454
2230-00425-00	Primer, Epoxy Polyamide	1 Pt (1)	C-204
2010-12763-01	Sealant, Corrosion Inhibitor	1 Qt (1)	C-251
2400-00175-00	Grease, High Pressure	15.5 Oz (1)	C-561

* 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.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

It is recommended to reweigh the helicopter following the accomplishment of this Technical Bulletin.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

- BHT-206A/B-SERIES-IPB, Illustrated Parts Breakdown
- BHT-206A/B-SERIES-MM, Maintenance Manual
- BHT-206A/B/L-SERIES-CR&O, Component Repair and Overhaul Manual
- BHT-206B3-CR&O, Component Repair and Overhaul Manual
- BHT-206A/B-M&O, Maintenance and Overhaul Instructions
- BHT-ALL-SPM, Standard Practices Manual

BHT-ALL-SRM, Structural Repair Manual
BHT-206-SRM-1, Structural Repair Manual
BHT-ELEC-SPM, Electrical Standard Practices Manual
206-01-73-3, Alert Service Bulletin
206-01-73-5, Alert Service Bulletin
206-01-73-7, Alert Service Bulletin
206-04-74-1, Alert Service Bulletin
206-75-1, Alert Service Bulletin
206-76-12, Alert Service Bulletin
206-76-9, Alert Service Bulletin
206-77-9, Alert Service Bulletin
206-91-60, Alert Service Bulletin
206-91-64, Alert Service Bulletin
206-92-69, Alert Service Bulletin
206-95-86, Alert Service Bulletin
206-06-107, Alert Service Bulletin
206-06-110, Alert Service Bulletin
206-09-119, Alert Service Bulletin
206-12-129, Alert Service Bulletin
206-19-136, Alert Service Bulletin
206-20-139, Alert Service Bulletin
206-19-136, Alert Service Bulletin
206-01-73-2, Technical Bulletin
206-01-73-3, Technical Bulletin
206-76-5, Technical Bulletin
206-77-7, Technical Bulletin
206-77-12, Technical Bulletin
206-78-11, Technical Bulletin
206-79-29, Technical Bulletin
206-85-112, Technical Bulletin
206-85-114, Technical Bulletin
206-88-128, Technical Bulletin
206-92-143, Technical Bulletin
206-94-146, Technical Bulletin
206-96-164, Technical Bulletin
206-00-174, Technical Bulletin
206-99-168, Technical Bulletin
206-12-199, Technical Bulletin
BHT-206-SI-80, Allison 250-C20 Turbo-Jet Engine, Airframe Retrofit Kit
BHT-206-SI-112, Retrofit Kit- Engine Assembly 250-C20B

PUBLICATIONS AFFECTED:

BHT-206A/B-SERIES-IPB, Illustrated Parts Breakdown
BHT-206A/B-SERIES-MM, Maintenance Manual

ACCOMPLISHMENT INSTRUCTIONS:

1. Prepare the helicopter for maintenance.
2. Disconnect the battery (BHT-206A/B-SERIES-MM, Chapter 96).
3. Review the helicopter records and compare with the list of pre-requisites found in Appendix A, Table A-1 to determine the mandatory modifications required. Refer to the listed document(s) to find the accomplishment instructions and the parts required for those that are not already incorporated. Accomplish the modification(s) as necessary to meet all the prerequisites of Table A-1.
4. Refer to the maintenance manual (BHT-206A/B-SERIES-MM) as applicable and remove the following components.

-NOTE-

Refer to Appendix B, Table B-1 to identify which of the removed components will be re-installed, if determined to be serviceable after inspection.

- a. Remove the aft fairing (Chapter 71).
- b. Remove the tail rotor driveshaft cover (Chapter 53).
- c. Remove the 3-piece tail rotor gearbox fairing (Chapter 53).
- d. Remove the vertical fin assembly (Chapter 53).
- e. Remove the long shaft assembly (Chapter 65).
- f. Remove the disc assemblies (Chapter 65), inspect, and replace as required.
- g. Remove the two adapters (Chapter 65), inspect, and replace as required.
- h. Remove the aft short shaft assembly (Chapter 65), inspect, and replace as required.
- i. Remove the tail rotor hub and blades assembly (Chapter 64), inspect, and replace as required.
- j. Remove the tail rotor pitch change mechanism from the tail rotor gearbox assembly (S/N 4 through 497 pre-TB 206-94-146) (Chapter 67). For S/N 4 through 497 Post TB 206-94-14 and S/N 498 through 1251, inspect and replace parts as required.

- k. Remove the tail rotor gearbox assembly (Chapter 65). Upgrade the gearbox (Ref. TB 206-99-168) or replace as required.

-NOTE-

For S/N 4 through 913 only, if the existing spar 206-020-120-001/-007 and/or one of the horizontal stabilizers 206-020-119-ALL is found with damage and needs replacement, then a combination of improved spar/stabilizers as indicated in Appendix B, Table B-1 shall be installed. No intermixing of installations is approved.

- l. Remove the two horizontal stabilizers and the spar assembly (Chapter 53). Inspect all parts and replace as one assembly as required. Refer to Appendix B, Table B-1 for a list of applicable and approved spar/horizontal stabilizers combinations applicable for this modification.
 - m. Remove the electrical installation (Chapter 96, BHT-ELEC-SPM), inspect, repair, or replace as required.
 - n. Remove the pivot bellcrank assembly and long control tube assembly (Chapter 67), inspect, and replace as required.
 - o. Remove the tailboom assembly (1, Figure 1) (Chapter 53). Discard the attachment hardware.
 - p. For S/N 4 through 637 only, verify the helicopter records to confirm if the oil cooler blower shaft 206-040-320-007 has been modified and installed as per Part V of ASB 206-76-12. If not, remove the oil cooler blower assembly and install the shaft assembly 206-040-320-011 (or approved replacement as per Appendix B, Table B-1) into the oil cooler blower assembly (BHT-206B3-CR&O-4).
5. Replace the two aft fuselage oil cooler fairing retainers (1, and 10, Figure 2) as follows:
 - a. Record the type, the size and the location of the rivets securing existing left and right oil cooler fairing retainers (1, and 10) on the aft end of fuselage.
 - b. Drill out all the rivets and remove the retainers (1, and 10).
 - c. Drill out the 3/32 rivets and remove the nutplates, inspect and replace as required.

-NOTE-

Make sure equal distance exists between centerline of aft fuselage and each vertical flange of new retainers (2, and 11).

- d. Temporarily fit and secure in place the new retainers (2, and 11) and the new aft fairing assembly.
 - (1) Latch the fasteners of the fairing mating with the aft engine firewall.
 - (2) Clamp each vertical flange of the retainers (2, and 11) to the wall making the aft aperture of the fairing.
- e. Mark the center position of the retaining Dzus fastener holes common with the vertical flange of each retainer (2, and 11).

-NOTE-

The different shape of the new retainers (2, and 11) will leave four existing rivet holes (5 and 7) in aft fuselage top skin unused. Those must be plugged.

- f. Except for one rivet hole (13) in lower flange of each new retainers (2, and 11), all other rivets that will be drilled must have a 2D minimum edge distance (ED).
 - (a) Transfer all rivet holes from aft fuselage top skin to the lower flange of each retainer (2, and 11), including the hole that will have low ED.
 - (b) Drill two additional rivet holes (12) through retainers (2, and 11) and the aft fuselage skin, one on each side where trimming will occur at the rivet low ED (13). Maintain 2D edge distance and 4D pitch with existing rivet holes to secure new retainers (2, 11).
- g. Remove the aft fairing and the two retainers (2 and 11).
 - (1) Trim the lower flange of the retainer where the rivet low ED (13) exists to maintain proper clearance with the aft fuselage top skin plugging rivet.
 - (2) Deburr all holes in retainers (2, and 11).
- h. Drill 0.467/0.474-inch (11.86/12.03 mm) diameter holes required in the vertical flange of the retainers (2 and 11).
 - (1) Drill 3/32 rivets holes for the Dzus fasteners receptacles.

- (2) Deburr all holes. Install the Dzus fasteners receptacles using rivets MS20426AD3.
- i. Coat the lower faying surfaces of the new retainers (2, and 11) with sealant (C-251) and install in place on the aft fuselage with the rivets (3, 4, 8 and 9).
 - j. After installation of the new retainers (2, and 11), install anti-chaffing tape (C-454) on vertical flange of both retainers (2, and 11).

-NOTE-

The installation of washers (6 and 14) and rivets (5 and 13) shall not interfere with the aft fuselage hidden structure nor with the lower flange of the new retainers (2, 11). It is acceptable to trim the lower flange of the retainers (2, and 11) to eliminate any interference from the washers/rivet's installation (14, and 13).

- k. Enlarge the diameter of the two unused forward rivet holes in aft fuselage top skin using a #27 drill bit for installation of 1/8 oversize diameter blind rivets (13) and washers (14).
 - (1) Deburr holes.
 - (2) Coat the shank of the rivets (13) and the faying surface of the washers (14) with sealant (C-251) and install to plug the four unused rivet holes on aft fuselage top skin.
 - l. Enlarge the diameter of the two unused aft rivet holes in aft fuselage top skin using a # 16 drill bit for installation of 5/32 oversize blind rivets (5) and washers (6).
 - (1) Deburr holes.
 - (2) Coat the shank of the rivets (5) and the faying surface of the washers (6) with sealant (C-251) and install to plug the four unused rivet holes on aft fuselage top skin.
6. Refer to the applicable section of the maintenance manual (BHT-206A/B-SERIES-MM) to install the following components and comply with applicable servicing.

-NOTE-

The parts listed in the REQUIRED MATERIAL section of this bulletin reflect the configuration of 206B Serial Number 1252 when manufactured. Refer to Appendix B, Table B-1, for a list of approved replacement parts.

- a. Prepare the replacement tailboom assembly (1, Figure 1) as follows:
 - (1) Install the pivot bellcrank assembly and the long control tube assembly (Chapter 67).
 - (2) Install the electrical harness previously removed from removed tailboom (Chapter 96, BHT-ELEC-SPM).

-NOTE-

The proper tailboom attachment hardware must be installed based on the tailboom assembly part number (see Table B-1). It is recommended to install new hardware. All nuts must be in safety (one to three threads showing) after the final installation and the torque sequences are completed. It is acceptable to vary the bolt grip length by one dash number longer or shorter from those indicated to achieve proper safety.

- b. Install the replacement tailboom assembly (1, Figure 1) (Chapter 53) on the fuselage assembly, using new attachment hardware. Pay particular attention to the upper left bolt location, in relation to the tailboom assembly part number is being installed (BHT-206A/B-SERIES-IPB, Chapter 53).
- c. Install the spar and the two horizontal stabilizer assemblies (Chapter 53).
- d. Install the replacement tail rotor gearbox assembly (2) (Chapter 65).
- e. Install the pitch change mechanism onto the gearbox assembly (2) (Chapter 67).
- f. Service the gearbox with the proper oil quantity (Chapter 12).

-NOTE-

Improved driveshafts with riveted adaptors instead of bonded adaptors are recommended.

CAUTION

All bonded tail rotor segmented driveshafts assemblies must comply with the intent of Alert Service Bulletin ASB 206-20-139 prior to their installation.

- g. Install the aft short shaft assembly (5, Figure 1) and connect to the oil cooler and blower assembly (Chapter 65).
- h. Install the forward shaft and bearing hanger assembly (4) and the four aft shaft and bearing hanger assembly (3) on the tailboom (1) (Chapter 65).
- i. Service all tail rotor driveshaft bearings using Mobil 28 grease (C-001) (Chapter 12).
- j. Install the tail rotor hub and blade assembly. (Chapter 64). Service Hub & Blade assembly with applicable grease (C-001 or C-172) (Chapter 12, TB 206-13-206).

-NOTE-

The vertical fin assembly must be compatible with the installation of the upper antenna installation when used.

- k. Install the replacement "Type 3" vertical fin assembly (Chapter 53) with correct hardware (BHT-206A/B-SERIES-IPB, Chapter 53). Confirm the retaining bolt threads are in safety after installation.
- 7. Rig and connect the tail rotor flight controls (BHT-206A/B-SERIES-MM, Chapter 67).
 - 8. Reconnect the battery (BHT-206A/B-SERIES-MM, Chapter 96).
 - 9. Prepare the helicopter and perform post segmented Tail Rotor Driveshaft installation ground run and Tail Rotor Gearbox operational check (BHT-206A/B-SERIES-MM, Chapter 65).
 - 10. Perform tail rotor balance verification (BHT-206A/B-SERIES-MM, Chapter 18).
 - 11. Once the ground run is completed, install anti-chaffing tape (C-454) on tailboom assembly in the areas in line with the mating surfaces of the gearbox fairing halves.
 - 12. Install the replacement tail rotor gearbox fairing halves (BHT-206A/B-SERIES-MM, Chapter 53).
 - 13. Install anti-chaffing tape (C-454) on tailboom assembly in the areas in line with the mating surfaces of the replacement tail rotor driveshaft cover. Install the tail rotor driveshaft cover (BHT-206A/B-SERIES-MM, Chapter 53).

14. Install the replacement aft fairing (BHT-206A/B-SERIES-MM, Chapter 71).
15. Make an entry in the helicopter logbook and the historical service records indicating the compliance with this Technical Bulletin.

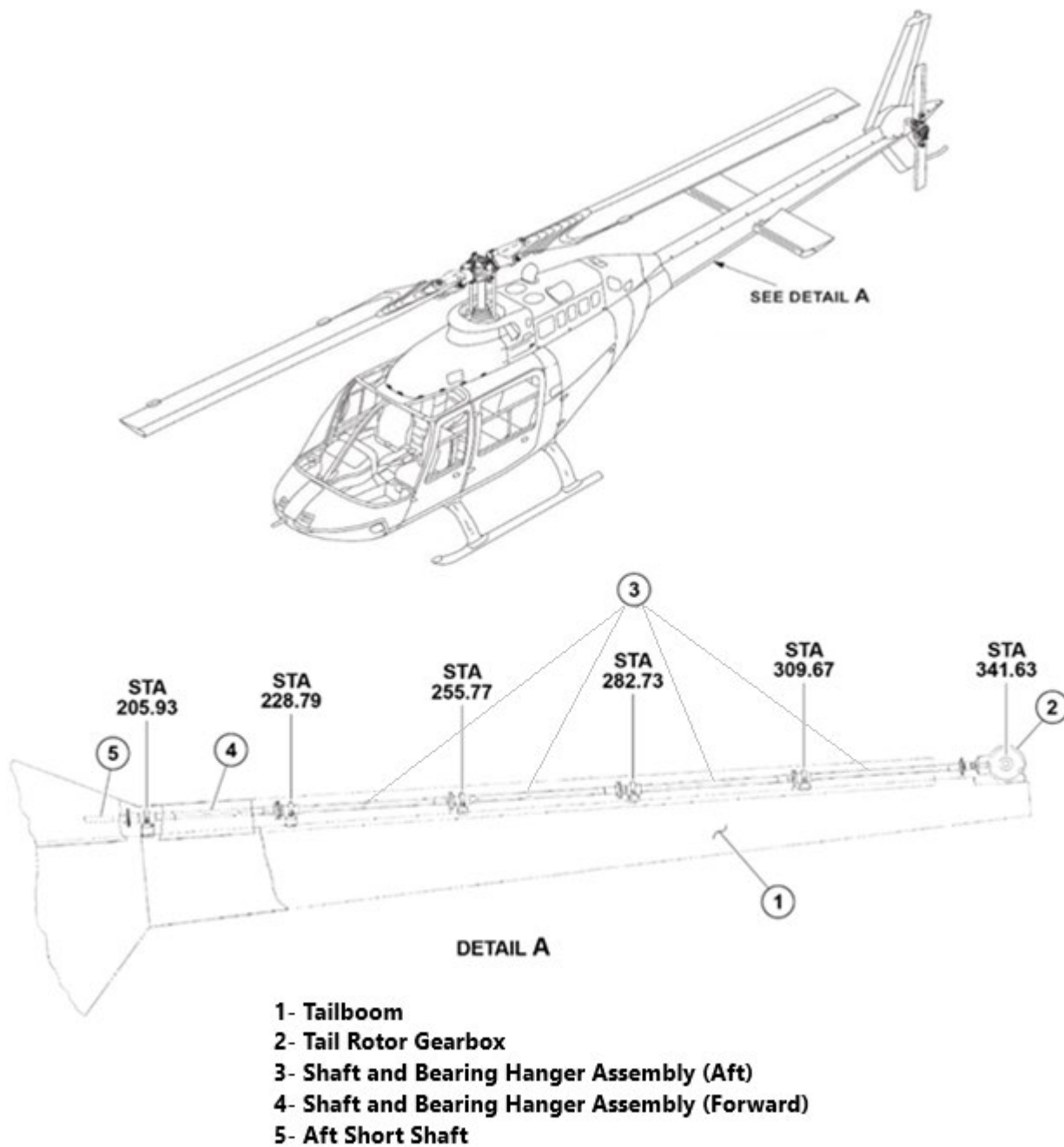
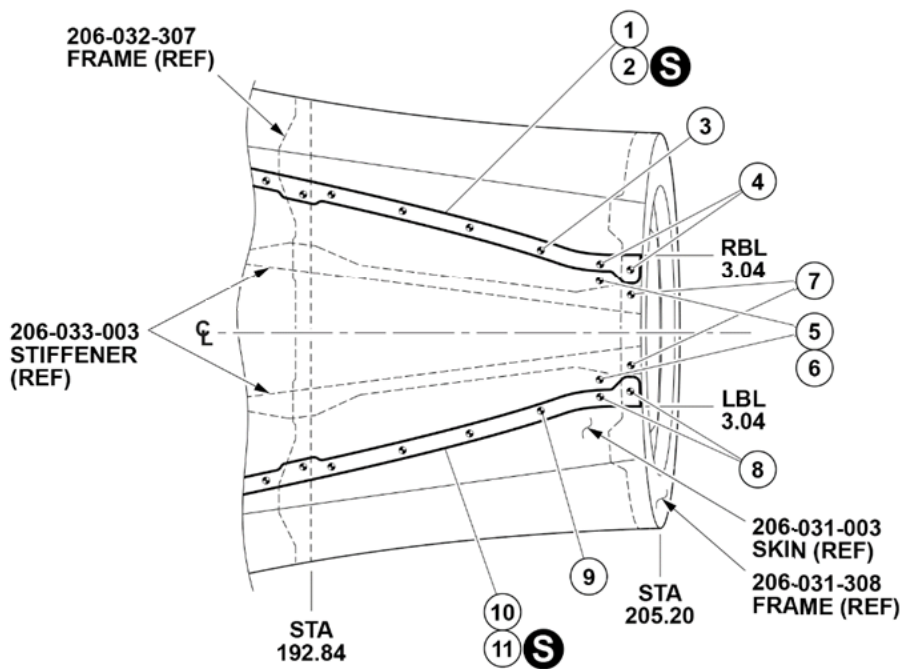
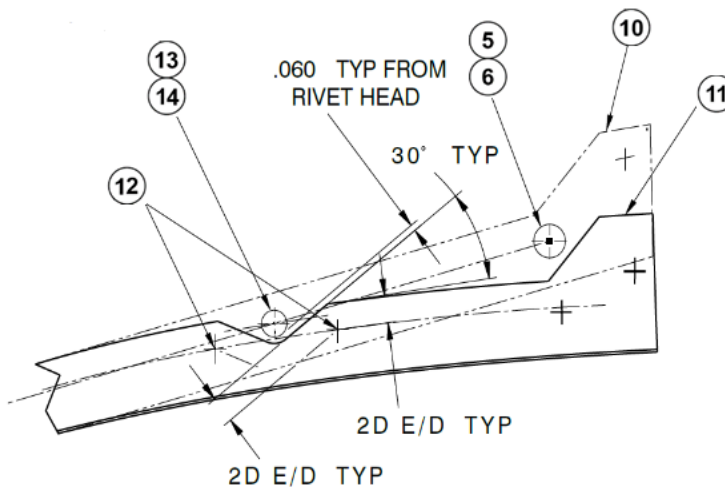


Figure 1 – Tail Rotor Driveshaft Installation



FAIRING REMOVED FOR CLARITY

1. Support 206-031-332-008
2. Support 206-031-332-027
3. Rivet MS20470AD4 (Qty. 22)
4. Rivet MS20470AD4 (Qty. 2)
5. Rivet NAS9301B-5 (Qty. 2)
6. Washer 140-029-5 (Qty. 2)
7. Rivet MS20470AD4 (Qty. 2)
8. Rivet MS20470AD4 (Qty. 2)
9. Rivet MS20470AD4 (Qty. 22)
10. Support 206-031-332-007
11. Support 206-031-332-019
12. Rivet MS20470AD4 (Qty. 4)
13. Rivet NAS9301B-4 (Qty. 2)
14. Washer 140-029-4 (Qty. 2)



S SEALANT (C-251)

20970 003

Figure 2 – Fairing Retainer Installation and Modification

APPENDIX A

PRE-REQUISITES

TABLE A-1			
BULLETIN TYPE AND NO.	DESCRIPTION	S/N APPLICABILITY	PART(S) AFFECTED
ASB 206-01-73-3	Removal of metal plug buttons.	914 through 1251	206-020-123-003 206-020-123-004
ASB 206-01-73-5	Vertical fin support, inspection and replacement of.	4 through 1097	206-031-417-(all) 206-031-418-(all)
ASB 206-01-73-7	Horizontal stabilizers, Inspection, and rework of.	4 through 1251	206-020-119-(all) 206-020-123-003 206-020-123-004
ASB 206-04-74-1	Tail rotor driveshaft bearing hanger screws, P/N 206-040-323-1, mandatory replacement of.	4 through 913	206-040-323-001 Replaced by 206-040-323-003
ASB 206-75-1	Tail rotor drive installation, inspection of.	4 through 497 499 through 1173 1175 through 1191 1193 through 1251	206-040-338-005 206-040-345-009 206-040-346-009
ASB 206-76-12 Replaces ASB 206-76-9	Installation of bearings 206-040-339-009.	4 through 412 (PART I MODIFIED) 414 through 913 (PART II) 914 through 1251 (PART III) PART V MANDATORY TO ALL	206-040-336-001 206-040-335-001 206-040-331-001 206-040-339-001 206-040-320-007
ASB 206-77-9	Replacement of tail rotor drive shaft clamp type bearing hangars with shims.	414 through 913 (4 through 413 with shimmed hanger installed)	206-040-338-001 206-040-345-005 206-040-346-005
ASB 206-91-60	PART I: Vertical Fin supports P/N 206-031-417 and 206-031-418, inspection and modification of. PART II: Vertical fin assembly P/N 206-020-113-5/-7/-9/-107 inspection for gaps and addition of mounting spacers, if required.	4 through 1163	206-031-417-(all) 206-031-418-(all)
ASB 206-91-64	Horizontal stabilizers spar assembly P/N 206-020-120-011, removal from service	4 through 913	206-020-120-011

ASB 206-92-69	Bracket, bearing support P/N 206-030-407-007/-009 and 206-030-433-005/-007/-011/-013/-015 and -017, one time inspection.	4 through 1251	206-030-407-007 206-030-407-009 206-030-433-005 206-030-433-007 206-030-433-011 206-030-433-013 206-030-433-015 206-030-433-017
ASB 206-95-86	Tail rotor driveshaft hanger assembly and spring, inspection of	4 through 1251	206-040-346-009 206-040-346-017 206-040-345-009 206-040-355-001 206-040-338-005 206-040-338-009
ASB 206-06-107	Vertical fin supports 206-031-417-003/-007 and 206-031-418-001/-005, inspection of.	4 through 1251	206-031-417003 206-031-417-007 206-031-418-001 206-031-418-005
ASB 206-06-110	Upper left hand tailboom attachment hardware, inspection of.	4 through 1251	407-030-750-103 (Cres attachment fitting installed)
ASB 206-09-119	Vertical fin assembly 206-020-113-231, inspection of.	4 through 1251	206-020-113-231
ASB 206-12-129	Vertical fin supports P/N 206-031-417-ALL and 206-031-418-ALL, inspection of.	4 through 1251	206-031-417-(all) 206-031-418-(all)
ASB 206-19-136	Tail rotor driveshaft disc pack coupling nuts, replacement of.	4 through 1251	MS21042L4
ASB 206-20-139	Segmented tail rotor driveshafts with bonded adapters, proof load test of.	4 through 1251	206-040-330-003 206-040-330-101 206-040-931-009 206-040-931-011 206-040-931-101 206-040-931-103 206-040-365-101 206-040-365-105 206-040-365-121 206-040-365-123
TB 206-01-73-2	Reinforcement of 206-031-303-031 frame assembly L/R hand sides.	4 through 1033	Clips 206-031-337-001 206-031-337-002 replaced by Fittings 206-031-377-003 206-031-337-004
TB 206-01-73-3	Modification of horizontal stabilizer 206-020-119-1/-9/-13.	4 through 913	206-020-120-001 206-020-120-007 (Installation of new ribs with clamps)

TB 206-76-5	Rework of bellcrank assembly, P/N 206-001-756-1 to P/N 206-001-756-5.	4 through 1251 equipped with bellcrank	Bellcrank 206-001-756-001
TB 206-77-7	Model 206A/B tail rotor driveshaft clamp type bearing hangers with shims, P/N 206-040-345-5, 206-040-346-5 and 206-040-338-1.	414 through 913 4 through 413 equipped with shimmed hangers.	206-040-345-005 206-040-346-005 206-040-338-001
TB 206-77-12	Rework of bellcrank, P/N 206-001-756-5, to P/N 206-001-756-9.	4 through 1251 equipped with bellcrank assembly 206-001-756-005	Bellcrank 206-001-756-005
TB 206-79-29	Frame, P/N 206-031-303, modification of engine mount attachment.	4 through 1251	Installation of improved fittings 206-031-266-001 206-031-266-002
TB 206-85-112	Bearing hanger, P/N 206-040-346 one time inspection.	4 through 1251	206-040-346-(all)
TB 206-85-114	Markings installations, P/N 206-070-604-1,-3,-5,-7,-9,-11,-101,-103,-105, and -107, danger decals, addition of.	4 through 1251	206-070-604-001 206-070-604-003 206-070-604-005 206-070-604-007 206-070-604-009 206-070-604-011 206-070-604-101 206-070-604-107
TB 206-92-143	Cover installation, bulkhead Sta. 192.84	4 through 1251	206-031-634-103 cover
TB 206-94-146	Anti-torque control system hydraulic boost, removal of.	4 through 497	206-031-004-011
TB 206-96-164	Tail rotor gearbox case assembly P/N 206-040-425-ALL, modification of.	4 through 1251	206-040-425-ALL 206-040-400-ALL
TB 206-00-174	Tail rotor gearbox duplex bearing 206-040-410-103, introduction of.	4 through 1251	206-040-410-101

APPENDIX B

Major components approved replacements

TABLE B-1			
BASIC PART REQUIRED	Approved replacement		
Tailboom 206-031-004-095 (Note 2)	206-031-004-115 (Note 2)	206-031-004-147 (Note 3)	206-031-004-155 (Note 3)
Vertical Fin 206-020-113-011	206-020-113-207		206-020-113-247
Oil cooler blower shaft 206-040-320-011 (Note 8)	206-040-320-015		206-040-320-103
Driveshaft assy. 206-040-930-005	206-040-930-009		206-040-930-105
Driveshaft assy. 206-040-930-007	206-040-930-011		206-040-930-107
Gearbox fairing half (upper) 206-033-420-003 (Metal)	206-033-420-007 (Metal)	206-033-420-101 (Metal)	206-033-673-103 (Fiberglass) (See Note 1)
Gearbox fairing half (Lower) 206-033-420-001 (Metal)	206-033-420-009 (Metal)	206-033-420-047 (Metal)	206-033-673-105 (Fiberglass) (See Note 1)
Control tube assy. 206-001-059-001	206-001-059-101		
Left/Right stabilizer 206-020-119-003/-004 206-020-119-011/-012 206-020-119-041/-042 206-020-119-049/-050 and Spar 206-020-120-001/-007 (NOTE 4, 5)	Left/Right stabilizer 206-020-123-007/-008 and Spar 206-020-120-011 (NOTE 6)		Left/Right stabilizer 206-020-123-011/-012 and Spar 206-020-120-011 (NOTE 6)

NOTES (Table B-1):

1. Fiberglass upper and lower fairing halves must be installed in pairs.
2. Use bolt NAS6606-22 at upper left attachment fitting location when TB 206-12-199 is not carried out on fuselage side. Use bolt NAS6606-25 at upper left attachment fitting location if TB 206-12-199 is carried out.
3. Use bolt NAS6606-25 at upper left attachment fitting location when TB 206-12-199 is not carried out on fuselage side. Use bolt NAS6606-29 at upper left attachment fitting location if TB 206-12-199 is carried out.
4. Applicable to S/N 4 through 913.
5. If any single part shown needs replacement, it shall be replaced by a complete new generation of stabilizer/spar installation as a unit, using all parts shown as approved replacement.
6. Installation of the combination of parts shown as a unit is applicable only for the intent of the modification described in this TB. Once a helicopter listed in this TB is modified with the approved combination shown in this Table, an operator can then refer to the current illustrated Parts Catalog for single approved part replacement (supersession).

APPENDIX C

Segmented driveshaft assemblies, configuration table

TABLE C-1					
<u>Segmented driveshaft assy.</u> 206-040-930-XXX	<u>Hanger assy.</u>	<u>Bearing</u>	<u>Adapter</u>	<u>Shaft assy.</u>	<u>Plate</u>
-005 (Note 1) (1.00 inch dia. shaft)	206-040-338-005/-009/-101/-103	206-040-339-005/-009	206-040-929-001 (Note 5)	206-040-931-009/-101	206-040-932-001
-007 (Note 2) (1.00-inch (2.54 cm) dia. shaft)	206-040-338-005/-009/-101/-103	206-040-339-005/-009/-101	206-040-929-003	206-040-931-011/-103	206-040-932-001
-009 (Note 3) (1.00 inch (2.54 cm) dia. shaft)	206-040-338-009/-101/-103	206-040-339-009/-101	206-040-929-001 (Note 5)	206-040-931-009/-101	206-040-932-001
-011 (Note 4) (1.00 inch (2.54 cm) dia. shaft)	206-040-338-009/-101/-103	206-040-339-009/-101	206-040-929-003	206-040-931-011-103	206-040-932-001
-105 (1.00 inch (2.54 cm) dia. shaft)	206-040-338-103	206-040-339-009/-101	206-040-929-001 (Note 5)	206-040-931-101	206-040-932-001
-107 (1.0 inch (2.54 cm) dia. shaft)	206-040-338-103	206-040-339-009/-101	206-040-929-003	206-040-931-103	206-040-932-001

NOTES (Table C-1):

- 1- Replaced by 206-040-930-009
- 2- Replaced by 206-040-930-011
- 3- Replaced by 206-040-930-105
- 4- Replaced by 206-040-930-107
- 5- Adapter 206-040-363-001 can be used as an alternate.