



TECHNICAL BULLETIN

206L-23-258

13 June 2023

MODEL AFFECTED: 206L-1, 206L-3, and 206L-4

SUBJECT: SNOW DEFLECTOR, MODIFICATION OF

HELICOPTERS AFFECTED: Serial numbers 45154 through 45790, 51001 through 51612 and 52001 through 52453 that have been modified by TB 206L-18-255.

[Serial number 52454 and subsequent will have the intent of this bulletin accomplished prior to delivery.]

COMPLIANCE: At customer's option.

DESCRIPTION:

This bulletin provides instructions to modify the snow deflector assemblies 206-064-226-001/-002 in order to fit on helicopters modified by TB 206L-18-255. 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 - Light Helicopters
Tel: 1-450-437-2862 / 1-800-363-8023 / productsupport@bellflight.com

MANPOWER:

Approximately 10 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:**

The following material is required for the accomplishment of this bulletin and may be obtained through your Bell Supply Center.

<u>Part Number</u>	<u>Nomenclature</u>	<u>Qty (Note)</u>
407-704-034-109	Kit-mod 206 snow deflector	1 (1)
	Consisting of:	
206-064-226-119	Chafing strip	1
206-064-226-121	Chafing strip	1
206-064-226-123	Chafing strip	1
206-064-226-125	Chafing strip	1
110-076-1-07-0	Rubber extrusion	2

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>
407-704-034-119	Kit-consumable	1(1)	
	Consisting of:		
2000-09182-01	Adhesive (299-947-100, Ty II, CL2)	50 grams	C-317
2000-06022-00	Adhesive, paste (299-947-107, Ty 1, CL1)	1 Pint	C-324
2010-00216-00	Fairing compound (299-947-072, TYI)	13.5 OZ	C-323
2000-06013-01	Silicone adhesive (299-947-152, Ty I, CL1)	1 OZ	C-300
2620-06050-00	Glass cloth (AMS-C-9084, CL2, TYIIIA)	12"X12"	C-404
2620-06280-00	Glass cloth (AMS-C-9084, CL2, TYIII)	12"X12"	C-560
2000-11948-00	Adhesive (299-947-100, Ty II, CL 3)	50 grams (2)	C-363

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

NOTES:

1. If required, order this kit to complete the 407-704-034-109 snow deflector modification. Available on special order only.
2. Not included in 407-704-034-119 kit. To be ordered separately.

SPECIAL TOOLS:

None required.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

BHT-206L-SERIES-IPB, Illustrated Parts Breakdown
BHT-206L1-MM, Maintenance Manual
BHT-206L3-MM, Maintenance Manual
BHT-206L4-MM, Maintenance Manual
BHT-ALL-SRM, Structural Repair manual

PUBLICATIONS AFFECTED:

None affected.

ACCOMPLISHMENT INSTRUCTIONS:

1. Prepare the helicopter for maintenance.
2. Remove and discard the existing edging (11, Figure 1, Detail E) and the existing chaffing strips (View B, 2 through 5) from the snow deflectors (1, View A).
3. Remove paint and primer from the rework area (View B and Section C-C).
4. Position the snow deflector (1) on a helicopter equipped with a 407-064-004 inlet cowling. Install the four bolts on the forward edge and the two bolts on the bottom edge (View A).
5. Using a fine tipped non-corrosive ink marker or equivalent, draw line L1 (View B) matching the contour of the 407-064-004 inlet cowling on the protruding edge of the snow deflector (1).

6. Remove the snow deflector (1) from the helicopter.
7. Draw line L2 (view B) at 3.0 inches (76 mm) from the line L1. Line L2 must be parallel to line L1.
8. Draw two more lines (L3 and L4) in 0.50 inch (13 mm) increments from line L2. Both lines must be parallel to line L2.

-NOTE-

Repair doublers shall be dimensioned as indicated in steps 8 through 10.

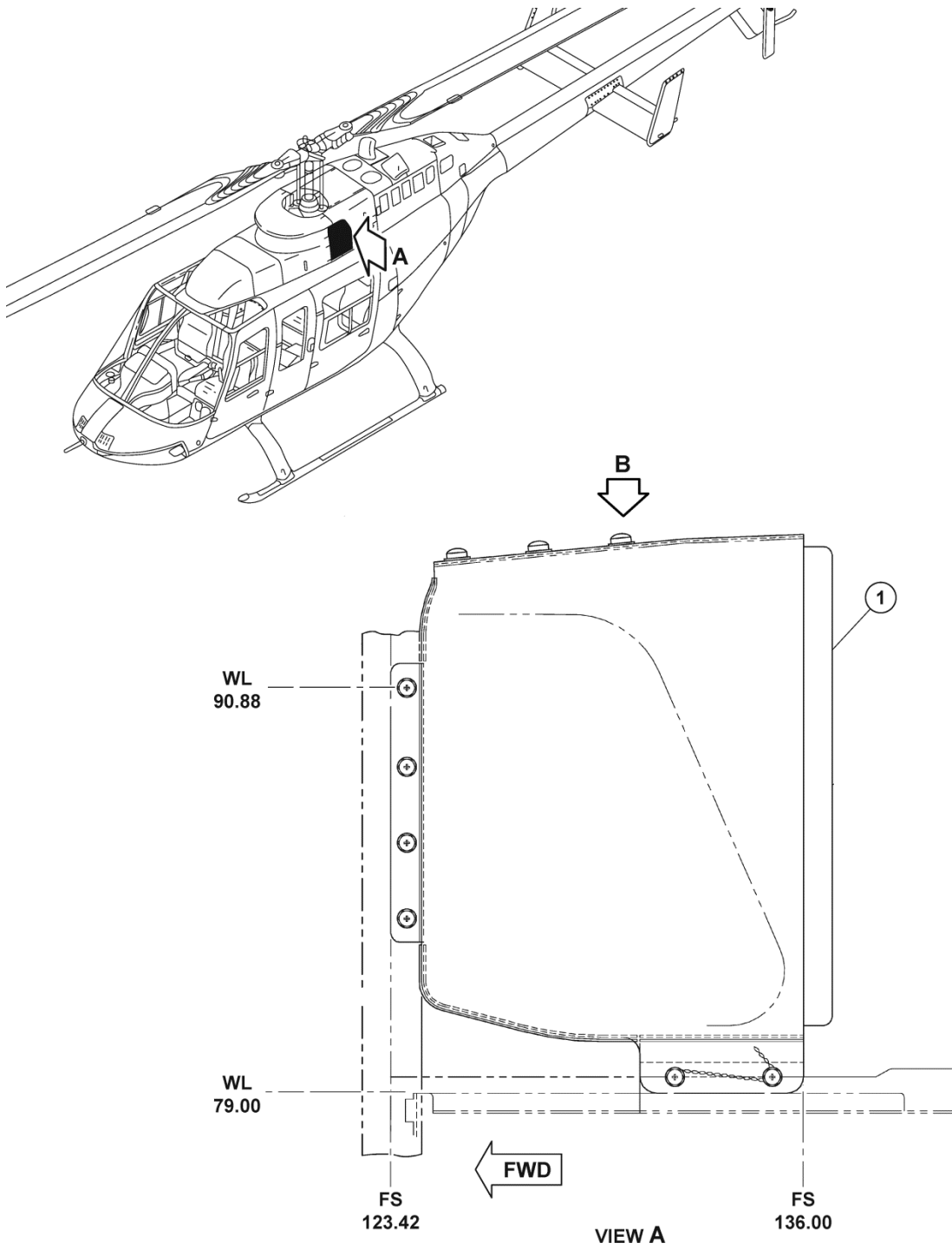
9. Repair doubler P1 (C-404) is to be dimensioned to fit between the edge of part and line L2.
10. Repair doubler P2 (C-404) is to be dimensioned to fit between the edge of part and line L3.
11. Repair doubler P3 (C-560) is to be dimensioned to fit between the edge of part and line L4.
12. Perform lay up as follows:

-NOTE-

Ply orientation is optional.

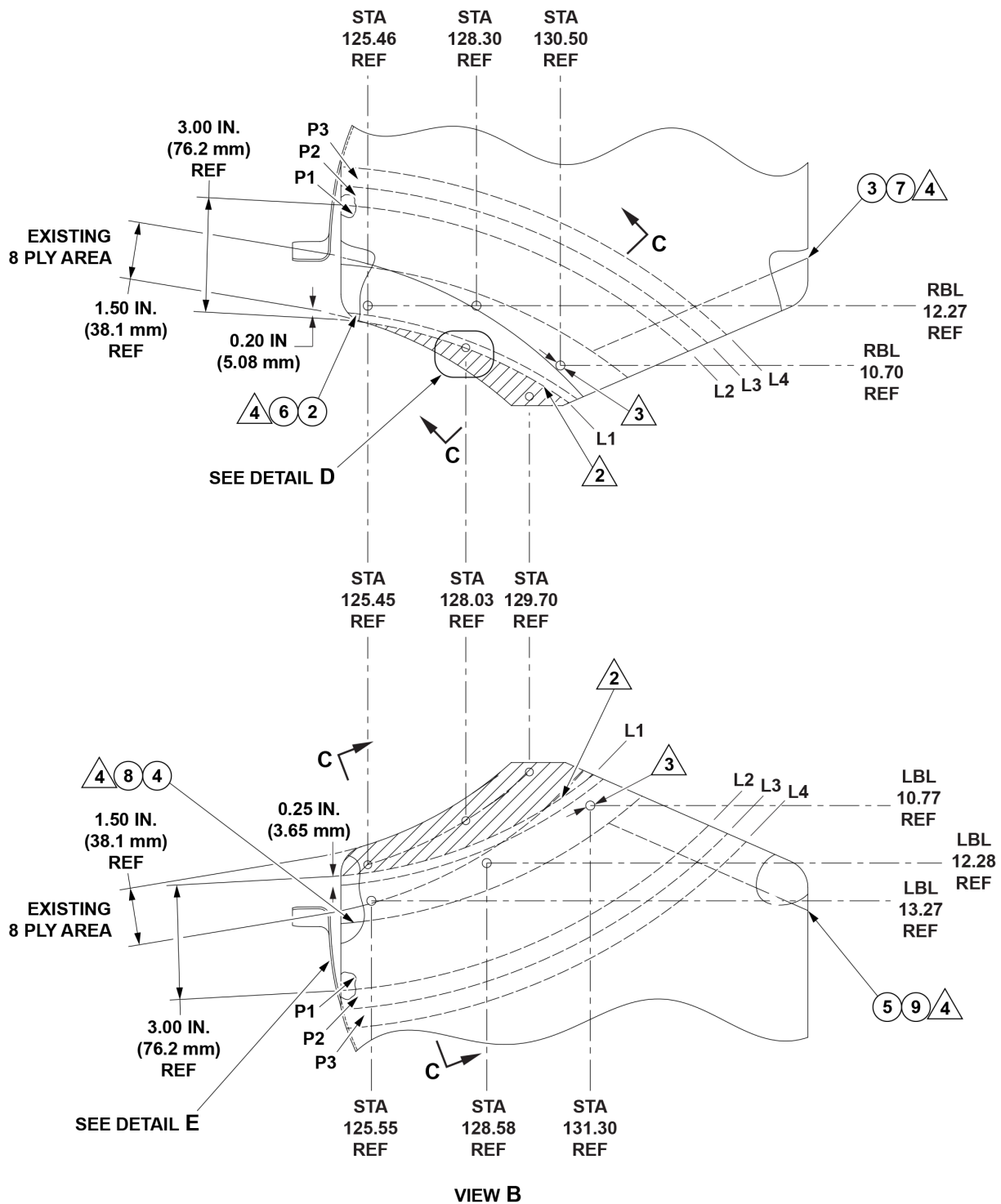
- a. Prepare surfaces for bonding (BHT-ALL-SRM, Chapter 4, Paragraph 4-2-9).
- b. Wet plies using adhesive (C-363).
- c. Lay repair doublers on part as marked previously (Figure 1, View B and Section C-C).
- d. Remove excess adhesive squeeze-out.
- e. Allow to cure at room temperature for 24 hours applying a pressure of 0.5 to 1.0 PSI to repair area. For the alternate high temperature cure, refer to the Table 4-12 (BHT-ALL-SRM, Chapter 4).
- f. Inspect for voids and unbonded area(s). Voids shall not exceed 10 % of the total bonded area. No one void shall exceed 0.025 sq. inches (1.61cm²) in area.
- g. As required, fill and fair with fairing compound (C-323) and sand to contour.

13. Position the snow deflector (1, Figure 1) on a helicopter equipped with a 407-064-004 inlet cowling. Install the four bolts on the forward edge and the two bolts on the bottom edge (View A).
14. Mark and open three 0.233 to 0.239 inch (5.92 to 6.07 mm) diameter holes through top flange of the snow deflector (1). Hole positions should be located from the 407-064-004 inlet cowling (Note 3, View B)
15. Install three bolts on the top flange of the snow deflector (1) (View A).
16. Using a fine tipped non-corrosive ink marker or equivalent, draw a line matching the contour of the 407-064-004 inlet cowling on the protruding edge of the snow deflector (1) (Note 2, View B).
17. Remove the snow deflector (1).
18. Trim the protruding edge of the snow deflector (1) as marked at step 16.
19. Refinish as required.
20. Install the four new chafing strips (6 through 9, View B) using adhesive (C-300).
21. Install the two rubber extrusions (10, Detail E) using adhesive (C-324).
22. Re-identify the L/H snow deflector with P/N 206-064-226-101FM and the R/H snow deflector with P/N 206-064-226-103FM.
23. Make an entry in the helicopter logbook and historical service records indicating compliance with this Technical Bulletin.



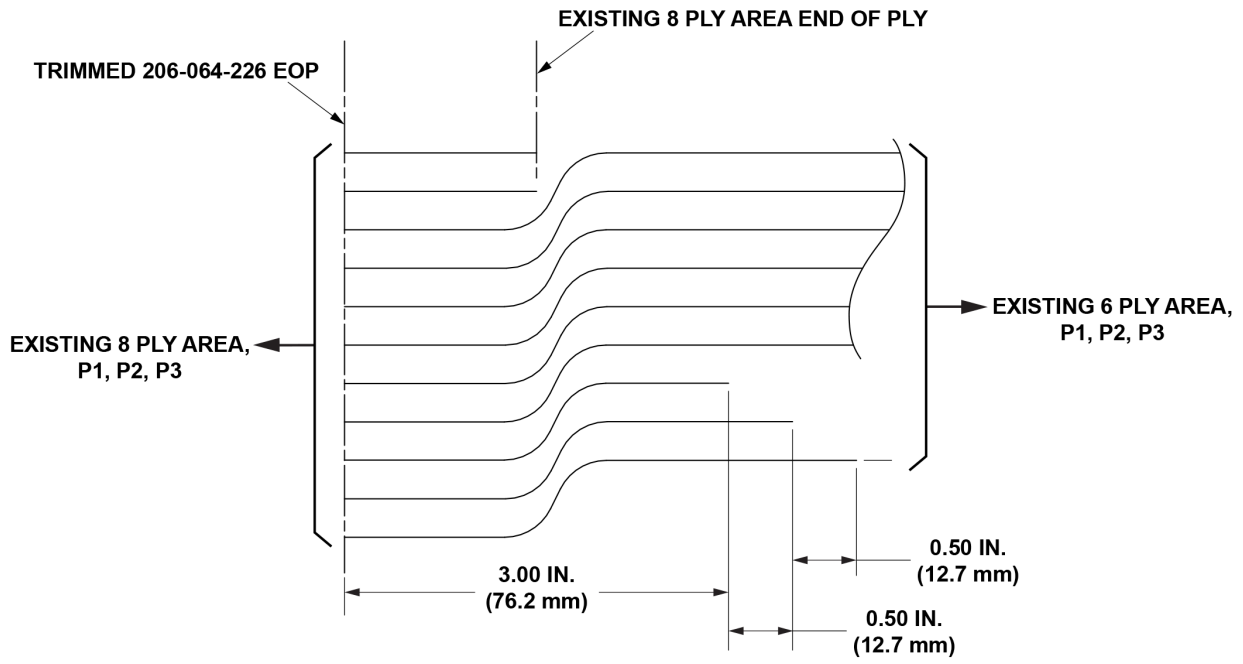
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Figure 1 – Snow Deflector (Sheet 1 of 3)



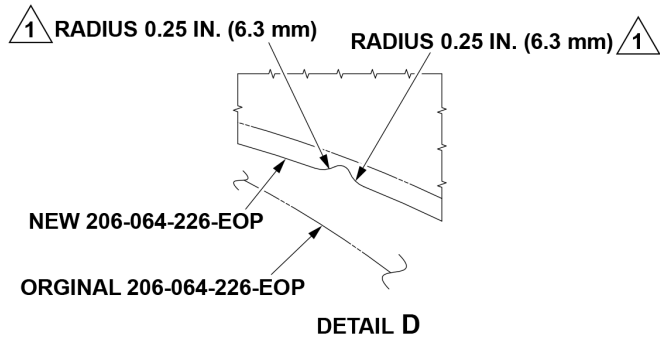
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Figure 1 – Snow Deflector (Sheet 2 of 3)



SECTION C-C

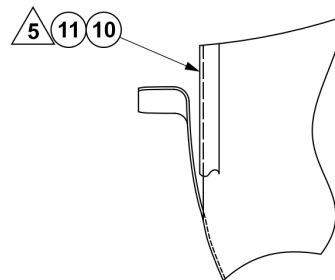
1. Snow deflector (Ref)
2. Chafing strip (Ref)
3. Chafing strip (Ref)
4. Chafing strip (Ref)
5. Chafing strip (Ref)
6. 206-064-226-121 (chafing strip) Qty 1
7. 206-064-226-125 (chafing strip) Qty 1
8. 206-064-226-119 (chafing strip) Qty 1
9. 206-064-226-123 (chafing strip) Qty 1
10. 110-076-1-07-0 (extrusion) Qty 2
11. Edging (Ref) Qty 2



DETAIL D

NOTES

- 1 Blend hole sharp edge to ensure a smooth transition with adjacent surfaces at indicated locations.
- 2 Trim protruding edges of the snow deflector to match the contour of 407-064-004 inlet cowling. Hatched area to be removed.
- 3 \varnothing 0.233 to 0.239 inch (5.92 to 6.07 mm) 3 places, locate from 407-064-004 inlet cowling.
- 4 Bond using silicone adhesive C-300.
- 5 Bond using paste adhesive C-324.



DETAIL E

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Figure 1 – Snow Deflector (Sheet 3 of 3)