



## **TECHNICAL BULLETIN**

**412-24-250**  
31 October 2024

**MODEL AFFECTED:** 412EP

**SUBJECT:** BLEED AIR DUCT CLAMP, REPLACEMENT OR REWORK OF

**HELICOPTERS AFFECTED:** Serial numbers 37002 through 37999 and 39101 through 39130.

[Serial number 39131 and subsequent will have the intent of this bulletin accomplished prior to delivery.]

**COMPLIANCE:** At customer's option. Recommended within the next 12 months after release of this bulletin.

### **DESCRIPTION:**

Bell has discovered that clamps NAS1922-0350-1, used in the bleed air duct installations 412-060-918-101/-102, are too large and in some cases the "tail" of the clamp failed in service due to vibration causing a possible foreign object debris (FOD) condition. This technical bulletin provides instructions to either trim the excess material or replace the existing clamps with smaller clamp NAS1922-0275-1.

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 FAA approved.

**CONTACT INFO:**

For any questions regarding this bulletin, please contact:

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

**MANPOWER:**

Approximately 2.0 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:**

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>
NAS1922-0275-1	Clamp	8 (1)

**NOTE 1:** Total used per helicopter, quantity required may be less.

**SPECIAL TOOLS:**

None required.

**WEIGHT AND BALANCE:**

Not affected.

**ELECTRICAL LOAD DATA:**

Not affected.

## REFERENCES:

BHT-412-IPBS-EPI, Illustrated Parts Breakdown Supplement  
BHT-412-MMS-EPI, Maintenance Manual Supplement  
BHT-412-IPBS-EPX, Illustrated Parts Breakdown Supplement  
BHT-412-MMS-EPX, Maintenance Manual Supplement  
BHT-412-MM, Maintenance Manual  
Pratt & Whitney Canada PT6T-9 Engine Maintenance Manual

## PUBLICATIONS AFFECTED:

BHT-412-IPBS-EPI, Illustrated Parts Breakdown Supplement  
BHT-412-IPBS-EPX, Illustrated Parts Breakdown Supplement

## ACCOMPLISHMENT INSTRUCTIONS:

1. Prepare the helicopter for maintenance.

-NOTE-

Figure 1 shows the LH duct installation 412-060-918-101, RH duct installation 412-060-918-102 is similar.

2. Gain access to the LH duct installation 412-060-918-101 (Refer to Figure 1).
3. Inspect the four existing clamps NAS1922-0350-1 for excess material, more than 0.25 inch (6.35 mm), beyond the clamp screw mechanism.
  - a. If the clamp has excess material:
    - (1) Either cut off the excess material and trim the sharp edges or replace with smaller clamp NAS1922-0275-1.
  - b. If any of the existing clamps NAS1922-0350-1 excess material has broken off:
    - (1) Inspect the engine compartment for the broken off material.

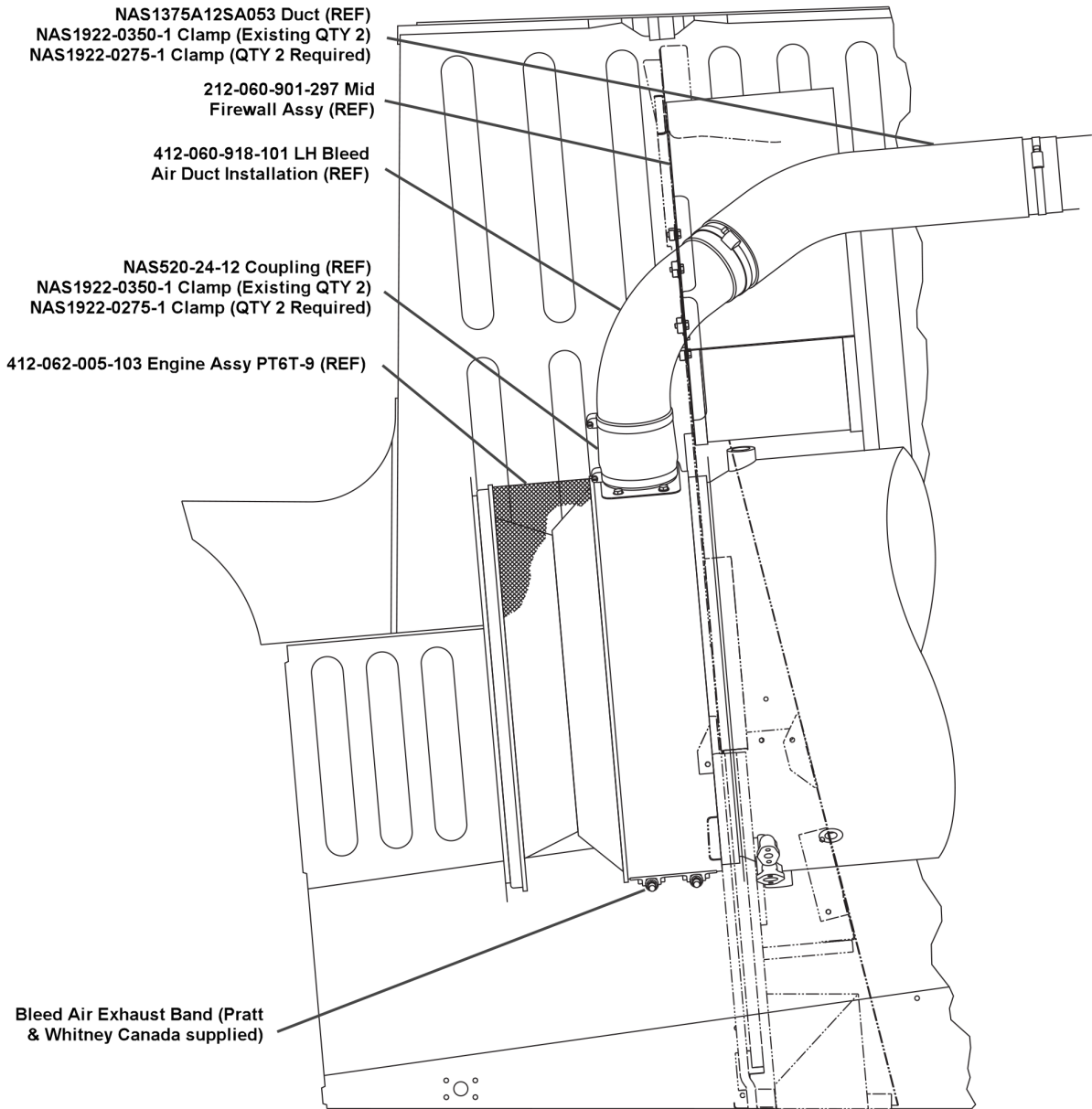
-NOTE-

The following step is only applicable to the clamps forward of the mid firewall assembly 212-060-901-297.

(2) If the excess material cannot be located inspect the engine compressor in accordance with the Pratt & Whitney Canada PT6T-9 Engine Maintenance Manual.

(3) Either trim the sharp edges or replace with smaller clamp NAS1922-0275-1.

4. Gain access to the RH duct installation 412-060-918-102 (Refer to Figure 1).
5. Repeat step 3.
6. Make an entry in the helicopter logbook and historical service records indicating compliance with this Technical Bulletin.



**View Looking Inboard, LH Side**

**Figure 1  
 Bleed Air Duct Installation**