

# ALERT SERVICE BULLETIN

AERONAUTICAL ACCESSORIES, INC.  
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ASB NO. 94046 REV. E • DATE: DECEMBER 4, 1996 • PAGE 1 OF 10

**SUBJECT:** **CROSSTUBE ASSEMBLY;**  
P/N 206-323-all dash numbers (High Skid and Lightweight Float Crosstubes), P/N 206-325-all dash numbers (Low Skid Crosstubes), and P/N 206-328-all dash numbers (Pan Style Float Crosstubes), **INSPECTION AND OR MODIFICATION OF.**

**HELICOPTERS AFFECTED:** All Bell 206L, L-1, L-3, L-4 model helicopters equipped with subject crosstubes.

**COMPLIANCE:** This alert service bulletin shall be complied with within the next 300 hours but not later than July 31, 1995.

**DESCRIPTION:** To ensure continuation of the excellent service of Aeronautical Accessories, Inc. crosstubes, this alert service bulletin provides procedures for inspection and or modification of existing crosstubes.

**ECCN**  
**9E991**

IF OWNERSHIP OF AIRCRAFT HAS CHANGED PLEASE FORWARD TO NEW OWNER

LOG OF REVISIONS

REVISION	DATE	BY	DESCRIPTION	PAGES AFFECTED
A	12-30-94	EFD	Revised format	All
B	4-17-95	SAW	Revised Compliance Date	1
C	10-24-95	RAS	Added alternate Clamp to Modification kits	9
D	12-20-95	RAS	Added Log of Revisions Page	2
E	12-3-96	JLC	Added crosstube support	6,10

Accomplishment procedures are as follows:

- Part I:           Crosstubes with clamp-on Supports with Nylatron Doublers.
- Part II:           Crosstubes with clamp-on Supports without Nylatron  
                  Doublers.

**FAA APPROVAL:**

The design engineering aspects of this bulletin are FAA approved.

**CROSSTUBE IDENTIFICATION:**

See Appendix A for crosstube identification.

**MANPOWER:**

- Part I:           Approximately one-half (0.5) manhour.
- Part II:           Approximately six (6) manhours.

**REFERENCES:**

- Aeronautical Accessories, Inc. Crosstubes Inspection and Maintenance Instructions, Report Number AA-94023.

The following consumable materials are required to comply with this bulletin and may be procured locally.

- Part I:   • Clear Lacquer or equivalent.
- Part II   • Isopropyl Alcohol.  
          • Epoxy Primer (i.e. Epoxy Polyamide, Super Koropon).  
          • Paint (to match aircraft).  
          • Clear Lacquer or equivalent.  
          • Proseal (MIL-S-8802 TY 2 CL B2 or equivalent).

A modification kit has been created for each affected crosstube. One kit is required to modify each crosstube. Kits may be procured from Aeronautical Accessories, Inc. See Appendix B for kit parts breakdown.

## PART I

Part I is mandatory for the following crosstubes which are equipped with clamp-on Supports and Nylatron Doublers.

CROSSTUBE PART NUMBER	DESCRIPTION	CROSSTUBE SERIAL NUMBERS	REQUIRED MODIFICATION KIT PART NUMBER
206-323-001	FWD CROSSTUBE ASSEMBLY HIGH SKID GEAR & LIGHTWEIGHT FLOAT GEAR	2130, 2133 thru 2135, 2137, 2138, 2143 thru 2145, 2147, 2148, 2152, 2154.	N/A
206-323-002	AFT CROSSTUBE ASSEMBLY HIGH SKID GEAR & LIGHTWEIGHT FLOAT GEAR	3120, 3136, 3138, 3140, 3141, 3149.	N/A
206-323-005	FWD CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	5000 & SUBSEQUENT.	N/A
206-323-006	AFT CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	3150 & SUBSEQUENT.	N/A
206-323-013	FWD CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	1001 & SUBSEQUENT	N/A
206-323-014	AFT CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	2002 & SUBSEQUENT	N/A
206-325-007	FWD CROSSTUBE ASSEMBLY LOW SKID GEAR	1001 & SUBSEQUENT	N/A
206-325-008	AFT CROSSTUBE ASSEMBLY LOW SKID GEAR	1001 & SUBSEQUENT	N/A
206-328-002	AFT CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	2050, 2051, 2055 thru 2063	N/A
206-328-003	FWD CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	1060 & SUBSEQUENT	N/A
206-328-004	AFT CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	2066 & SUBSEQUENT	N/A

1. Remove fairings, if installed.

**NOTE**

Removal of crosstubes from helicopter is  
not required for crosstube visual inspection.

2. Visually inspect the crosstube for signs of damage or corrosion per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.3. If no corrosion or damage is found, proceed to step 5.

3. If the crosstube shows any sign of corrosion or damage which has penetrated the finish coat, the primer or the aluminum surface, remove the crosstube from the aircraft and repair or replace per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023.
4. Reinstall landing gear to aircraft per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023 paragraph 1.8.
5. Reinstall fairings, if applicable.
6. Make appropriate aircraft log book entry.

## PART II

Part II is mandatory for the following crosstubes which are equipped with clamp-on Supports without Nylatron Doubler.

CROSSTUBE PART NUMBER	DESCRIPTION	CROSSTUBE SERIAL NUMBERS	REQUIRED MODIFICATION KIT PART NUMBER
206-323-001	FWD CROSSTUBE ASSEMBLY HIGH SKID GEAR & LIGHTWEIGHT FLOAT GEAR	2025 thru 2129, 2131, 2132, 2136, 2139 thru 2142, 2146, 2149 thru 2151, 2153, 2155 & SUBSEQUENT	206-319-111
206-323-002	AFT CROSSTUBE ASSEMBLY HIGH SKID GEAR & LIGHTWEIGHT FLOAT GEAR	3025 thru 3119, 3121 thru 3135, 3137, 3139, 3142 thru 3148, 3150 & SUBSEQUENT	206-319-113
206-325-001	FWD CROSSTUBE ASSEMBLY LOW SKID	1001 thru 1005, 1007 thru 1027	206-319-111
206-325-002	AFT CROSSTUBE ASSEMBLY LOW SKID	3001 thru 3006, 3008 thru 3022, 3027, 3030, 3032 & SUBSEQUENT	206-319-113
206-328-001	FWD CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	1050 thru 1059	206-319-111
206-328-002	AFT CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	2052 thru 2054, 2064, 2065	206-319-113

1. Remove fairings, if installed.
2. Remove landing gear from the helicopter per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.7.
3. Inspect crosstube per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.3(b). If crosstube is serviceable proceed with step 4.
4. Remove two (2) T-Bolt Band Clamps from each Support.
5. Use a plastic scraper to remove the bead of sealant from edges of Support.

**WARNING**

**Do not use scribe to mark on crosstube.**

6. Using a grease pencil (china marker) mark the outline of the existing crosstube Supports. This is required to properly align the coated Supports during installation.

**WARNING**

**Do not use putty knife to remove Support.**

7. Use a Heat Gun to heat the Support/Sealant and remove the Clamp-On-Support. If necessary use a block of wood and hammer to strike the Support abutment in an upward motion to remove Support as shown in Figure 1. **CAUTION:** Support could be hot!
8. Remove remaining sealant and clean with isopropyl alcohol.
9. Visually inspect Crosstube Support mounting area for mechanical or corrosion damage using a 10 power magnifier and repair (if required) in accordance with Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.3 and 1.4.
10. Install coated Support, P/N 601-025-005-B (forward), and P/N 601-030-123 or 601-025-007-B (aft) in accordance with Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.6.
11. Reinstall landing gear to aircraft per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94023, paragraph 1.8.
12. Reinstall fairings, if applicable.
13. Make appropriate aircraft log book entry.

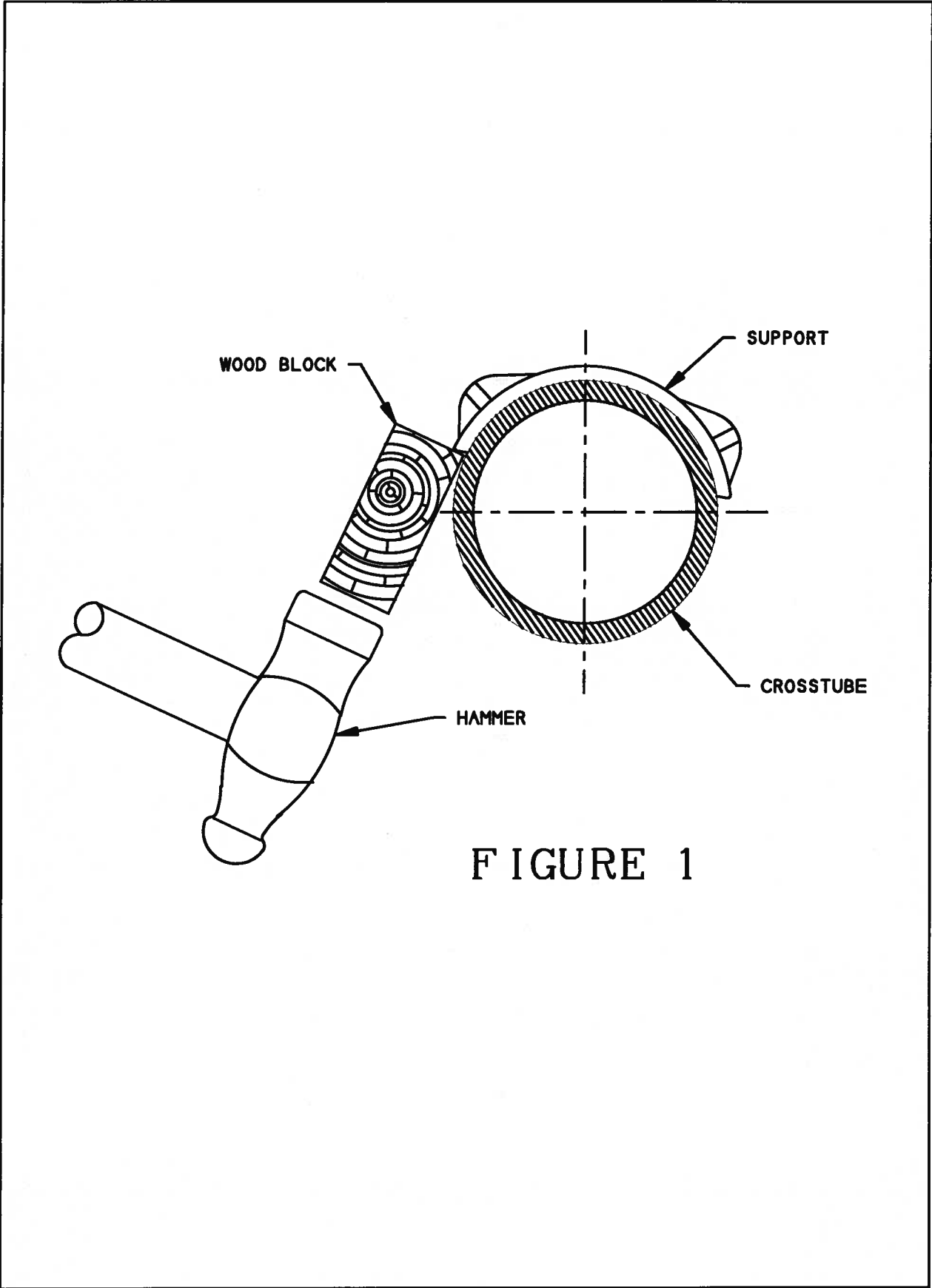


FIGURE 1

## Appendix A

To facilitate the identification of Aeronautical Accessories Inc. crosstubes, please see Figure 2 Detail B, showing serial number location.

Once Aeronautical Accessories Inc. crosstubes are identified, record the serial number(s) and return a list of these numbers to Aeronautical Accessories Inc. We will forward serialized labels to affix, per figure 2 Detail A, to your crosstubes for ease of identification. Aeronautical Accessories, Inc. will add "-M" to the crosstube part number to indicate that this ASB has been complied with.



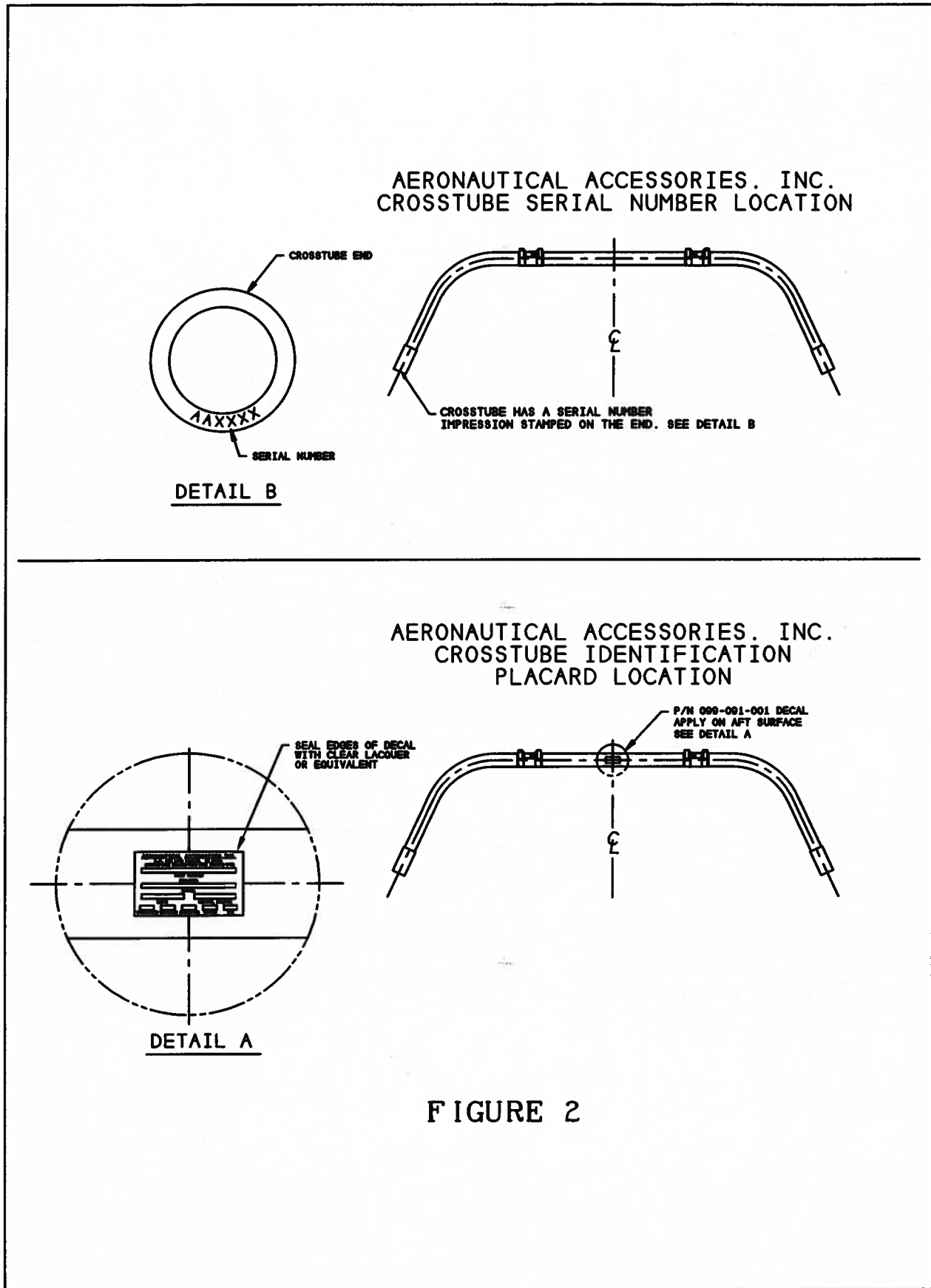


FIGURE 2

## Appendix B

### MODIFICATION KIT PARTS LIST

P/N 206-319

QUANTITY		DESCRIPTION	PART NUMBER
-111	-113		
2		Support	601-025-005-B
	2	Support	601-030-123
			Alt: 601-025-007-B
4		T-Bolt Band Clamp	601-025-009
			Alt: 601-025-015
	4	T-Bolt Band Clamp	601-025-011
			Alt: 601-025-013
8	8	Plug	103RR