

ALERT SERVICE BULLETIN

AERONAUTICAL ACCESSORIES, INC.
P.O. BOX 3689 • BRISTOL, TENNESSEE 37625-3689

ASB NO. 94045 REV. D • DATE: DECEMBER 20 1995 • PAGE 1 OF 11

SUBJECT: **CROSSTUBE ASSEMBLY;**
P/N 206-321-001 and -002 (High Skid
and Lightweight Float Crosstubes),
P/N 206-320-101 and -102 (Low Skid
Crosstubes), and P/N 206-329-001 and
-002 (Pan Style Float Crosstubes),
INSPECTION AND OR MODIFICATION OF.

HELICOPTERS AFFECTED: All Bell 206A and 206B 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 Part III Steps 11,13	6
B	4-17-95	SAW	Revised Compliance Date	1
C	10-24-95	RAS	Added alternate Clamp to Modification kits	10
D	12-20-95	RAS	Added Log of Revisions Page	2

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.
- Part III: Crosstubes with rivet-on Supports.

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.
- Part III: Approximately six (6) manhours.

REFERENCES:

- Aeronautical Accessories, Inc. Crosstubes Inspection and Maintenance Instructions, Report Number AA-94022.

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

- Part I: • Clear Lacquer or equivalent.
- Part II & Part III • 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 Doubler.

CROSSTUBE PART NUMBER	DESCRIPTION	CROSSTUBE SERIAL NUMBERS	REQUIRED MODIFICATION KIT PART NUMBER
206-320-101	FWD CROSSTUBE ASSEMBLY LOW SKID GEAR	3040, 3042, 3044 thru 3046, 3048, 3049, 3051, 3053, 3054, 3056 & SUBSEQUENT.	N/A
206-320-102	AFT CROSSTUBE ASSEMBLY LOW SKID GEAR	4023, 4037, 4038, 4040 thru 4044, 4047 thru 4050, 4052, 4054, 4056, 4058 & SUBSEQUENT.	N/A
206-321-001	FWD CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	1299, 1315, 1342, 1354, 1356 & SUBSEQUENT.	N/A
206-321-002	AFT CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	2310, 2333, 2336 thru 2340, 2342, 2343, 2349, 2351 & SUBSEQUENT.	N/A
206-329-001	FWD CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	2579, 2583 thru 2585, 2589.	N/A
206-329-002	AFT CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	3438 thru 3441, 3444.	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-94022, 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-94022.
4. Reinstall landing gear to aircraft per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022 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
206-320-101	FWD CROSSTUBE ASSEMBLY LOW SKID GEAR	1 thru 3039, 3041, 3043, 3047, 3050, 3052, 3055.	206-319-101
206-320-102	AFT CROSSTUBE ASSEMBLY LOW SKID GEAR	1 thru 4022, 4024 thru 4036, 4039, 4045, 4046, 4051, 4053, 4055, 4057.	206-319-103
206-321-001	FWD CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	1153 thru 1298, 1300 thru 1314, 1316 thru 1341, 1343 thru 1353, 1355.	206-319-101
206-321-002	AFT CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	2153 thru 2309, 2311 thru 2332, 2334, 2335, 2341, 2344 thru 2348, 2350.	206-319-103
206-329-001	FWD CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	2500 thru 2578, 2580 thru 2582, 2586 thru 2588, 2590 & SUBSEQUENT.	206-319-101
206-329-002	AFT CROSSTUBE ASSEMBLY PAN STYLE FLOAT LANDING GEAR	3400 thru 3437, 3442, 3443, 3445, 3456 & SUBSEQUENT.	206-319-103

1. Remove fairings, if installed.
2. Remove landing gear from the helicopter per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, paragraph 1.7.
3. Inspect crosstube per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, 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-94022, paragraph 1.3 and 1.4.
- 10. Install coated Support, P/N 601-025-005-B (forward), and P/N 601-025-003-B (aft) in accordance with Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, paragraph 1.6.
- 11. Reinstall landing gear to aircraft per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022 paragraph 1.8.
- 12. Reinstall fairings, if applicable.
- 13. Make appropriate aircraft log book entry.

PART III

Part III is mandatory for the following crosstubes which are equipped with riveted-on Supports.

CROSSTUBE PART NUMBER	DESCRIPTION	CROSSTUBE SERIAL NUMBERS	REQUIRED MODIFICATION KIT PART NUMBERS
206-321-001	FWD CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	1001 thru 1152.	206-319-101
206-321-002	AFT CROSSTUBE ASSEMBLY HIGH SKID & LIGHTWEIGHT FLOAT GEAR	2001 thru 2152.	206-319-103

- 1. Remove fairings, if installed.
- 2. Remove landing gear from the helicopter per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, paragraph 1.7.
- 3. Inspect crosstube per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, paragraph 1.3(b). If crosstube is serviceable proceed with step 4.

CAUTION

Use a drill stop to prevent drilling into the far side of the crosstube.

- 4. Center punch the countersunk rivets retaining the Support. Drill off the locking collar of the CherryMAX countersunk rivet using a #29 drill. Using a 3/32" diameter punch and hammer, punch the mandrel stem out of the rivets.
- 5. Drill out the countersunk rivets using a #10 drill. Ensure that the drill bit is perpendicular to the Crosstube as you drill out the countersunk rivets.

6. Use a plastic scraper to remove the bead of sealant from edges of Support.

WARNING

Do not use scribe to mark on crosstube.

7. Using a grease pencil (china marker) and a straight edge, mark the center point of the top of the Support. Extend the center of Support mark along the top of the crosstube. This is required to properly align the coated Support during installation.

WARNING

Do not use putty knife to remove Support.

8. Use a Heat Gun to heat the Support/Sealant. If necessary use a block of wood and hammer to strike the abutment of Support in an upward motion to remove Support as shown in Figure 2. **CAUTION** Support could be hot!
9. Remove remaining sealant and clean with isopropyl alcohol.
10. Inspect Crosstube Support mounting area for mechanical or corrosion damage using a 10 power magnifier, giving extra care to the inspection of the rivet holes. **CAUTION: ANY SIGN OF CRACKING IN THE SUPPORT AREA IS CAUSE FOR REJECTION.** If necessary, repair in accordance with Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022.
11. Deburr rivet holes. Clean area with isopropyl alcohol, brush alodine and reprime with epoxy polyamide.
12. Plug rivet holes using Plug P/N 103RR (provided) to prevent contaminants from entering the inside of the crosstube. Install plug flush with the outer surface of the crosstube. Trim plug flush as required. Seal the top of the forward and aft plugs with sealant (Proseal or Equiv.).
13. Install coated Support, P/N 601-025-005-B (forward), and P/N 601-025-003-B (aft) in accordance with Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022, section 1.6.
14. Reinstall landing gear to aircraft per Aeronautical Accessories, Inc. Inspection and Maintenance Instructions report number AA-94022 paragraph 1.8.
15. Reinstall fairings, if applicable.
16. Make appropriate aircraft log book entry.

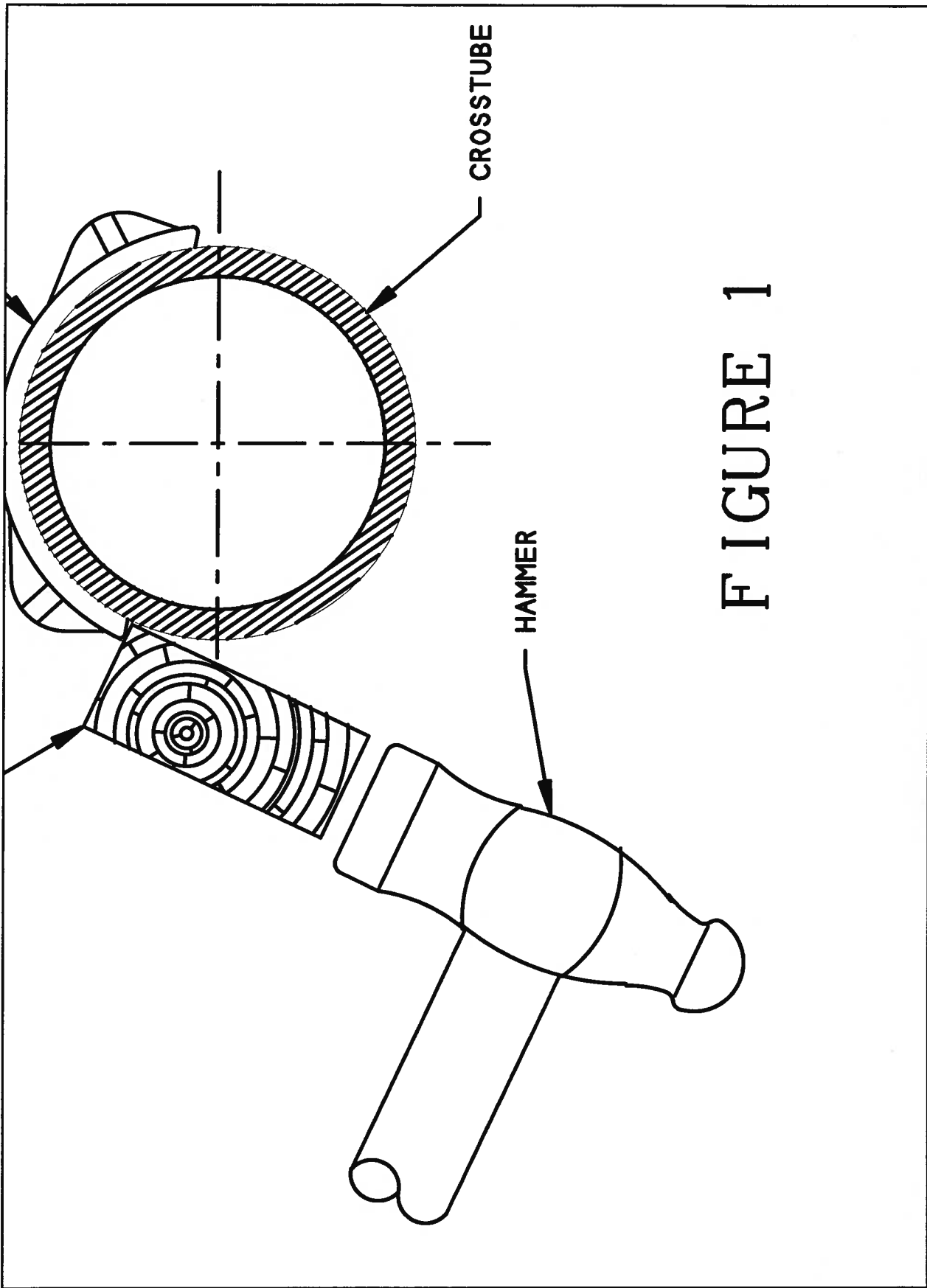


FIGURE 1

Appendix A

To facilitate the identification of Aeronautical Accessories Inc. crosstubes, please see Figure 3 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 3 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.

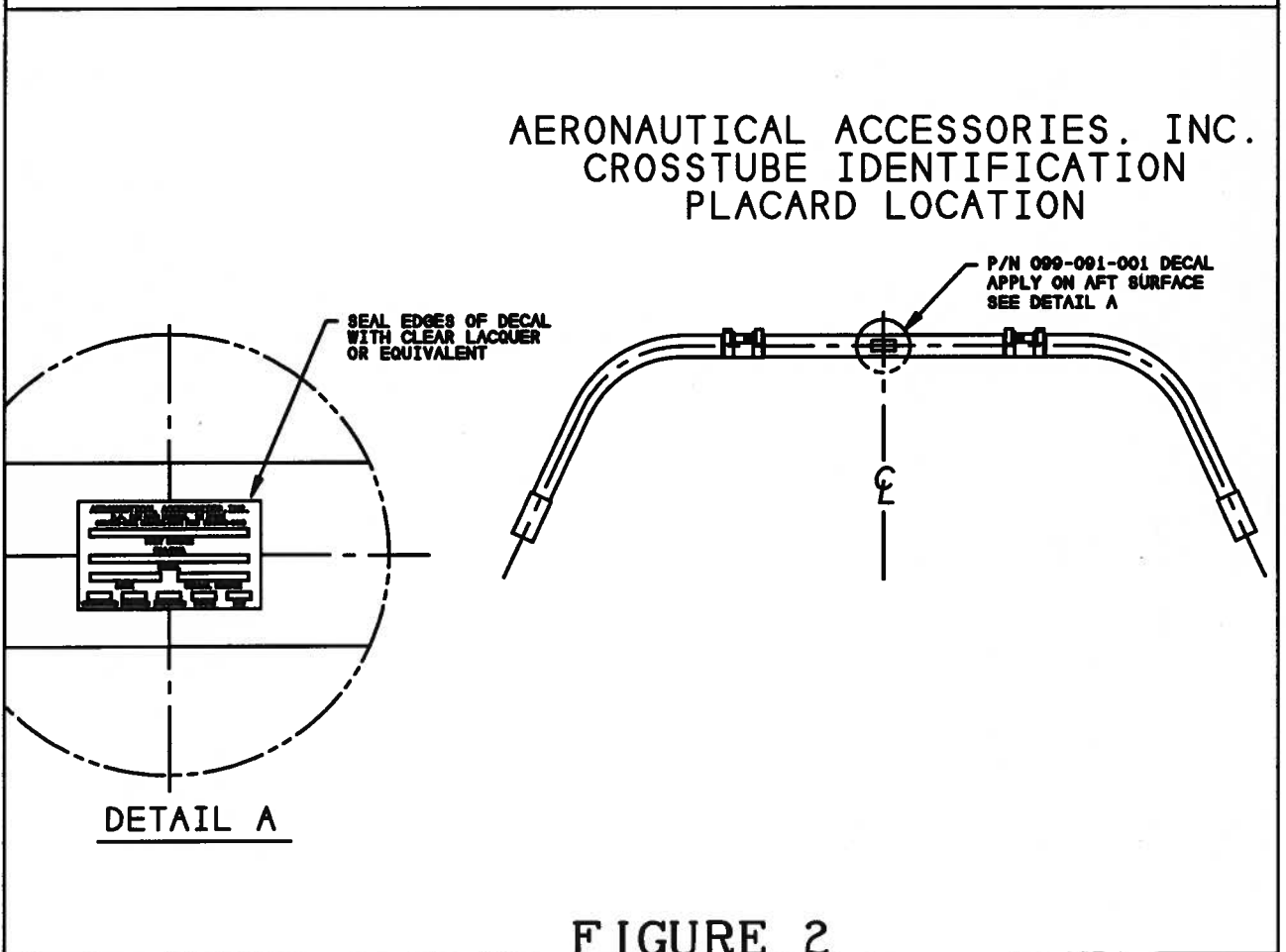
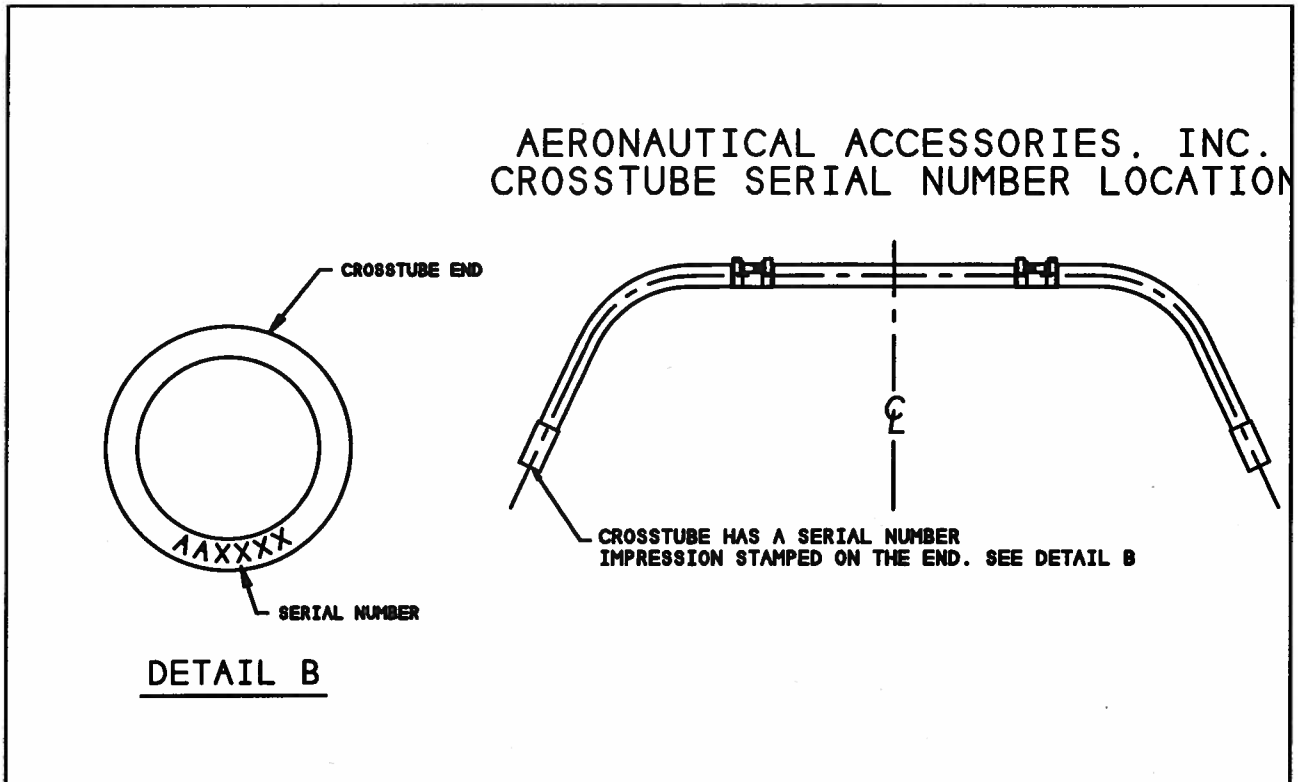


FIGURE 2

Appendix B

MODIFICATION KIT PARTS LIST

P/N 206-319

QUANTITY		DESCRIPTION	PART NUMBER
-101	-103		
	2	Support	601-025-003-B
2		Support	601-025-005-B
4	4	T-Bolt Band Clamp	601-025-009
			Alt: 601-025-015
8	8	Plug	103RR