



## AERONAUTICAL ACCESSORIES, INC.

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# TECHNICAL BULLETIN

## TB No. AA-01066

- SUBJECT:** **SKID TUBE ASSEMBLY L/H:**  
P/N 412-320-105/-107/-115/-117/-119 Skid Tubes  
manufactured prior to April 2001 with BHT Power  
Step Kit installed.
- HELICOPTERS AFFECTED:** All Bell 212, 412, 412EP and Agusta AB412,  
AB412EP Helicopters equipped with subject Skid  
Tube Assemblies and BHT Power Step Kit  
installed.
- COMPLIANCE:** This bulletin should be complied within 30 days of  
receipt.
- DESCRIPTION:** This Technical Bulletin is being issued to  
recommend a one time modification of the two aft  
skid tube holes used with the BHT Power Step Kit.  
Without the modification, the Power Step will not  
sit completely flush with the Skid Tube in the  
retracted position.
- MANPOWER:** Approximately 2.0 hours.

IF OWNERSHIP OF AIRCRAFT HAS CHANGED PLEASE FORWARD THIS BULLETIN TO NEW OWNER

**MATERIAL:**

The following kit is required to comply with this Bulletin and is available from Aeronautical Accessories, Inc.:

412-319-001      Skid Tube Retrofit Kit

The following consumable material is required to comply with this Bulletin and may be procured locally:

Brush Alodine  
Adhesive (Magnobond 6398 A&B)  
Sealant (MIL-S-8802 Type 2, Class B1/2)  
Masking Tape  
Primer (Epoxy Polyamide per MIL-P-23377 or Super Koropon)  
Paint (match existing skid tube color)

**TOOLS:**

21/64" Drill Bit  
19/32" Drill Bit  
25/32" Spotface Drill Bit with 19/32" Dowel Pin (or equivalent)  
Drill  
Hole Punch  
Hammer  
Torque Wrench

**WEIGHT AND BALANCE:**

Negligible.

**PUBLICATIONS AFFECTED:**

None affected.

**ACCOMPLISHMENT INSTRUCTIONS:**

1. With the Power Step Kit in the upright position, remove the existing screws attaching the two aft legs of the Power Step Kit to the Skid Tube Assembly L/H.
2. Using the Masking Tape, tape the two aft legs of the Power Step Kit out of the way of the attaching holes in the Skid Tube Assembly L/H.

- Using the 21/64" Drill Bit, drill through the head of the two Rivnuts previously used to attach the aft legs of the Power Step Kit. Use the Hole Punch and Hammer to push the remainder of the Rivnut through the hole into the Skid Tube Assembly L/H.

**WARNING**

Be careful not to apply too much pressure when drilling, as this could cause the Rivnut to spin inside of the hole resulting in possible skid tube damage.

- Using the 19/32" Drill Bit, drill a hole .125" aft of the existing holes centerline. Once the new hole is drilled it should be used as a guide for the 25/32" Spotface Drill Bit with 19/32" Dowel Pin (or equivalent). Repeat process for both sides of the Skid Tube Assembly L/H. See Figure 1.

**CAUTION**

Apply pressure gently when drilling the Spotface on the Skid Tube. Only remove enough material to allow the Bushing (412-319-121) to fit flush against the Skid Tube. Refer to dimensional requirements of Figure 1.

- Deburr the two holes and Brush Alodine. Allow Brush Alodine to cure until it turns iridescent gold in color.
- Install the two Bushings (412-319-121) using Adhesive (Magnobond 6398 A&B). Allow Adhesive to cure for at least 24 hours at room temperature. Apply one coat of Primer (Epoxy Polyamide per MIL-P-23377 or Super Koropon) and one coat of Paint to the Bushings and Adhesive.

**NOTE**

Mask off all areas of the Skid Tube Assembly L/H at risk of primer/paint overspray.

- After the Primer and Paint have cured, remove the masking and the tape used to hold the Power Step Kit legs.
- Re-install the Power Step Kit legs as shown in Figure 2. Torque bolt to 15-20 in-lbs.

Any questions regarding this bulletin should be addressed to:

**AERONAUTICAL ACCESSORIES, INC.**  
**PRODUCT SUPPORT**  
**1-800-251-7094**

**AERONAUTICAL ACCESSORIES, INC.**

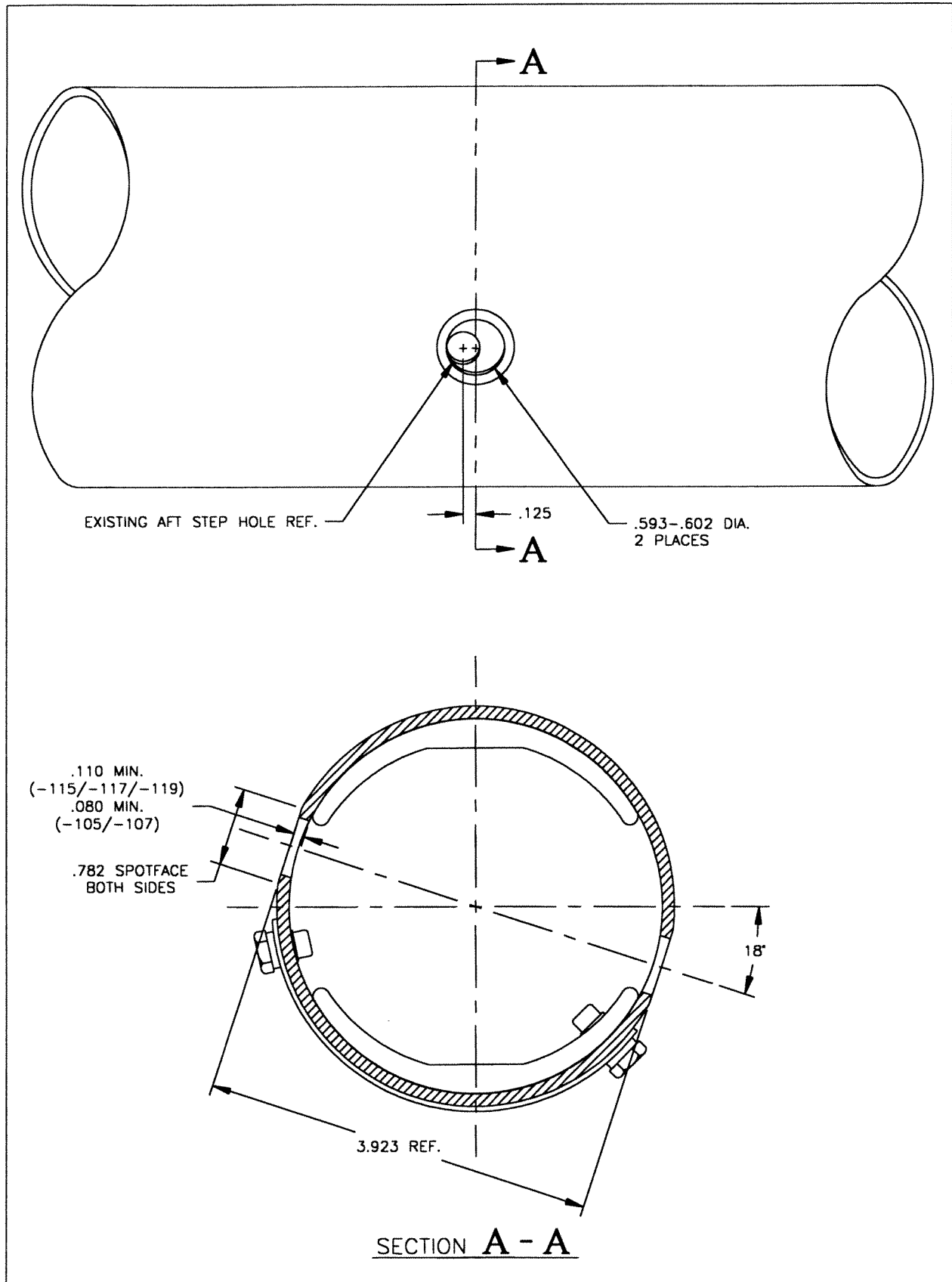


Figure 1

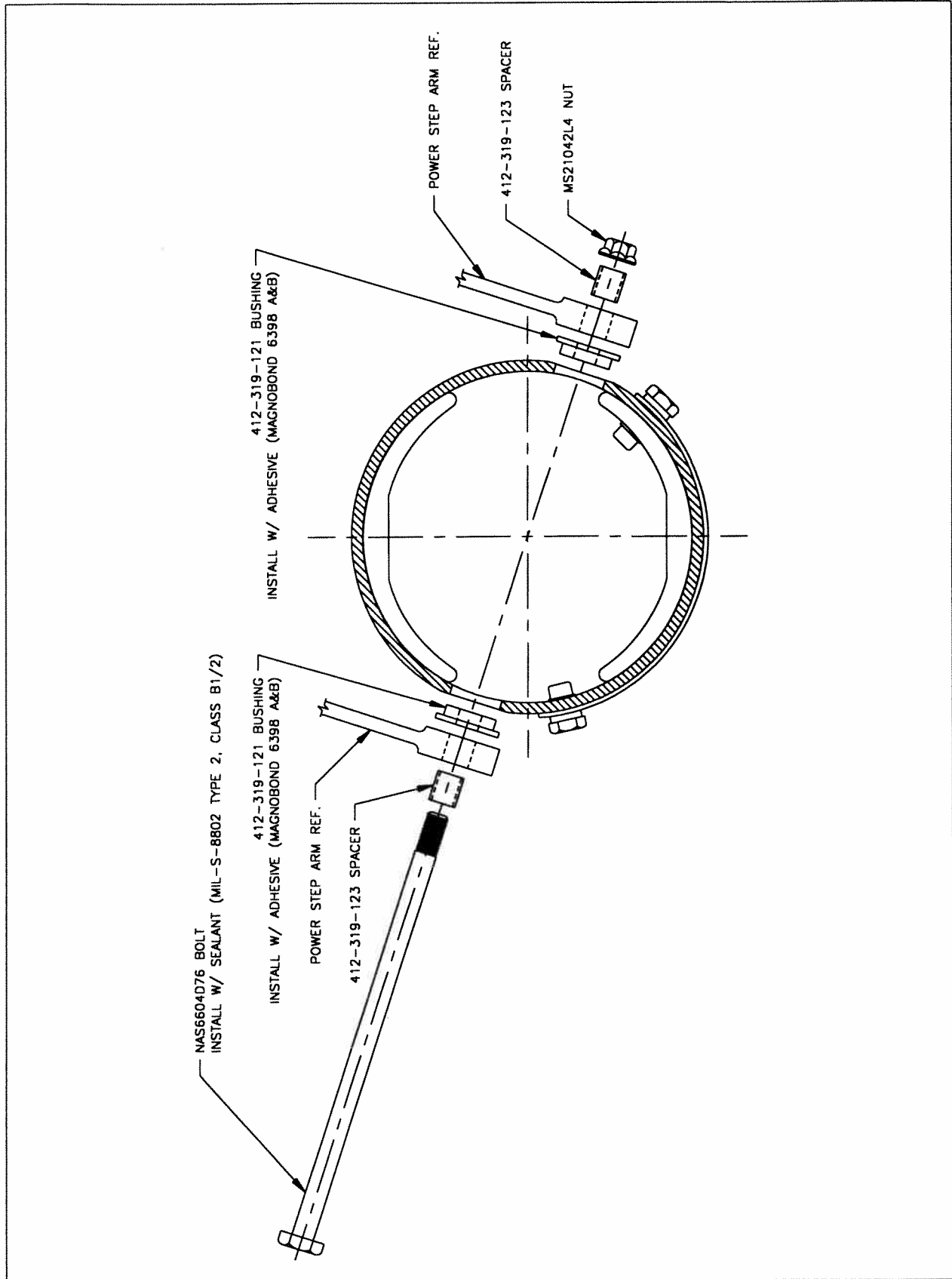


Figure 2

**PARTS LIST**

SKID TUBE RETROFIT KIT  
P/N 412-319-001

-001 Qty.	Part Number	Description
2	412-319-121	Bushing
2	412-319-123	Spacer
1	NAS6604D76	Bolt
1	MS21042L4	Nut