



AERONAUTICAL ACCESSORIES, INC.

P.O. BOX 3689

BRISTOL, TENNESSEE 37625-3689

TELEPHONE: 423-538-5151 800-251-7094

TELEFAX: 423-538-8469 E-MAIL: aero-access.com

TECHNICAL BULLETIN

TB No. AA-01163

SUBJECT:

Flitestep® Kits:
P/N 412-300-150 and 412-300-300

HELICOPTERS AFFECTED:

Bell 205A, 205A-1, 205B, 212, 412, 412EP,
and Restricted Type Certificate UH-1H with the
subject Flitestep® Kits installed.

DESCRIPTION:

ECCN
9E991

This technical bulletin is being issued in response to an incidence of water being retained inside of the Clamp Assemblies mounted to the helicopter's forward and aft crosstubes, used to support the Flitestep®. This trapped water is suspected in causing corrosion of the internal fastener which retains the Yoke portion of the Clamps. This document details the procedure to add a drain hole to the upper Clamp Assembly to allow trapped water to escape.

MANPOWER:

Approximately 1.0 hour.

(IF OWNERSHIP OF AIRCRAFT HAS CHANGED, PLEASE FORWARD THIS BULLETIN TO NEW OWNER.)

MATERIAL:

Available from local sources:
Alodine
Epoxy Polyamide Primer (MIL-P-23377)
Touch up paint to match existing Helicopter finish
A light Teflon based lubricant
Loctite 49504 adhesive

Available from AAI:
(Optional) Replacement Pad Kit (P/N 412-300-250)

TOOLS:

Screw Driver (Philips head)
Drill with ¼" drill bit
Flashlight

WEIGHT AND BALANCE:

Negligible

PUBLICATIONS AFFECTED:

None

ACCOMPLISHMENT INSTRUCTIONS:

(For subassembly parts breakdown, see Instructions for Continued Airworthiness of Flitestep® Kits, Report No. AA-98049.)

1. Remove the eight screws and washers from each of the lower Clamp Assemblies and retain.
2. At this point the Flitestep® will be loose from the forward and aft crosstubes except for the glue used to bond the rubber pads to the Clamp Assemblies and the crosstubes. Carefully loosen the pads from the crosstubes using a plastic scraper and remove the Flitestep® Assembly from the helicopter. **DO NOT** scratch or damage the crosstubes during the removal process.

WARNING

Do not use a metal tool such as a putty knife to remove the Clamp Assembly.

NOTE

The lower Clamp Assemblies do not have to be removed from the crosstubes for this modification and will help in relocating the Flitestep® Assemblies if undisturbed. If the lower Clamp Assemblies are to be removed, it will be necessary to use a grease pencil to mark their installation locations on the crosstubes prior to removal or refer to Report No. AA-98049 for detailed installation Instructions.

PROPRIETARY INFORMATION

NOTE

If the rubber pads used to isolate the Clamp Assemblies from the crosstubes are damaged during this modification, contact AAI for Replacement Pad Kit (412-300-250).

3. Peel rubber Pad away from the lower portion of the Clamp Assembly. Using a flash light, if required, inspect the condition of the Nut, Bolt, and Cotter Pin located inside of the Clamp Assembly. Replace any damaged or corroded hardware as required. (See Report No. AA-98049 for replacement procedures).
4. Drill a ¼" (.249"- .255" diameter) drain hole, horizontal with the ground, at the lowest point of the internal space which is retaining water as shown in Figure 1. Deburr both sides of the hole after the drilling process is complete.
5. Spot Alodine the hole and allow to dry.
6. Apply two coats of Epoxy Polyamide (MIL-P-23377) to the hole after alodining and touch up the paint in the modified areas to match existing paint finish.
7. Spray a light Teflon based lubricant (used as a corrosion inhibitor) to all surfaces inside of the Clamp Assembly. Avoid spraying the surfaces where the rubber Pad will be re-bonded in the next step.
8. Re-bond the rubber Pad (or a replacement) to the Clamp Assemblies using Loctite 49504 adhesive.

WARNING

Follow manufacturer's safety guide lines while using adhesive.

9. Lightly abrade the contacting surfaces of the crosstube and rubber Pads. **DO NOT REMOVE PRIMER.** Wipe surfaces clean with MEK or alcohol. Check the fit of the Flitestep® Assembly with Clamp Assemblies located back on the crosstubes in their former positions (see step 2).

NOTE

If lower Clamp Assembly has been removed and its location was not marked, refer to Report No. AA-98049, Instructions for Continued Airworthiness of Flitestep® Kit, for detailed Flitestep® Installation Instructions.

10. Once satisfied with the fit, apply a thin coat of Loctite 495 adhesive to the rubber pads by removing one Clamp Assembly at a time and then relocating on the crosstube after the adhesive has been applied.

PROPRIETARY INFORMATION

11. Re-install retained hardware (see step 1) between the lower and upper Clamp Assemblies. Torque screws to 20-25 in-lbs.
12. Modification complete.
13. Make entry in aircraft log book to indicate that this Technical Bulletin has been completed.
14. If there are any questions regarding this bulletin please contact:

Aeronautical Accessories, Inc.
Product Support
1-800-251-7094

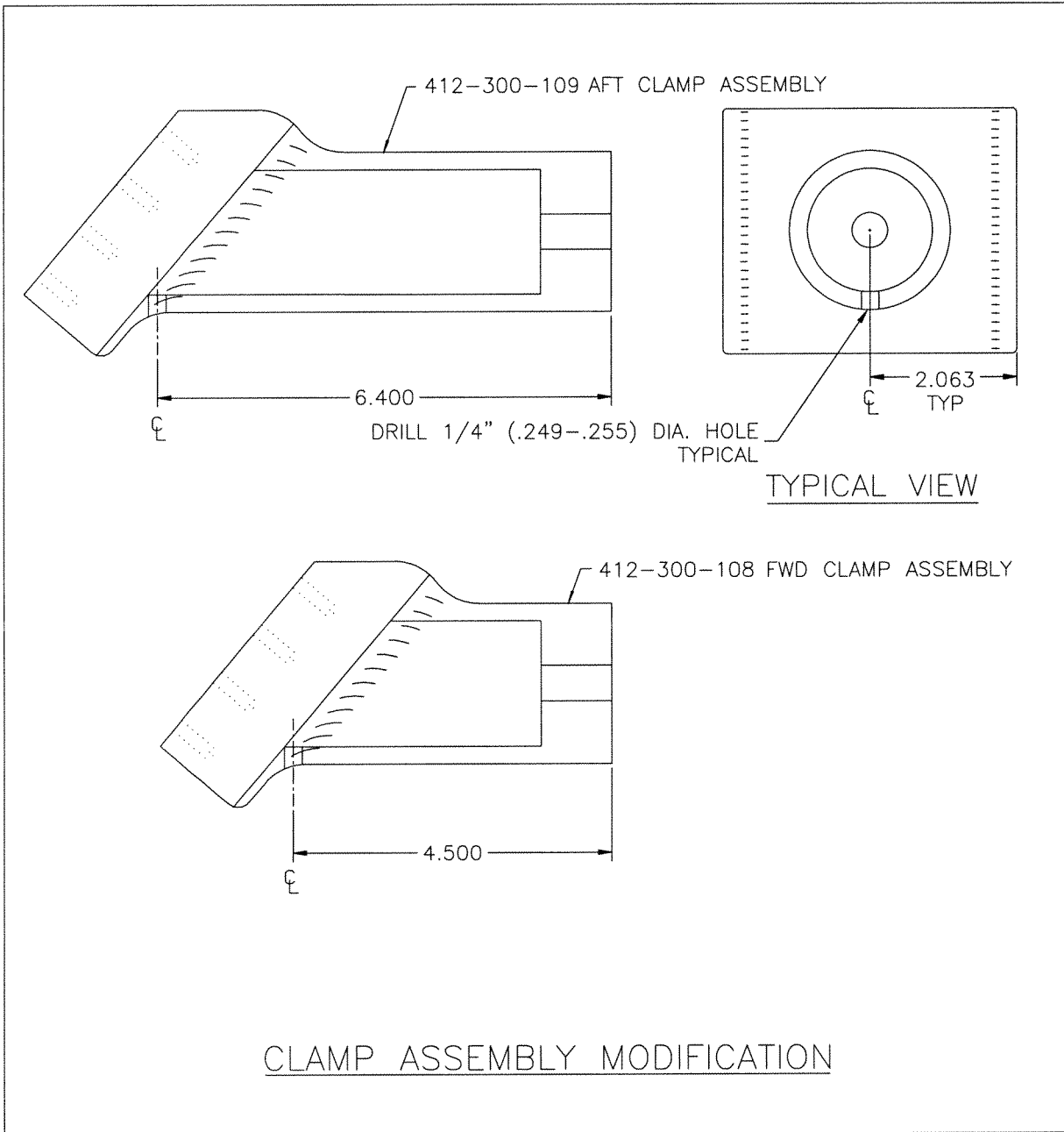


FIGURE 1