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## **ALERT SERVICE BULLETIN**

### **ASB No. AA-03121**

**SUBJECT:**

**Fwd & Aft Crosstubes**

P/N 206-321-001 (S/N 1001-1152) High Fwd Crosstube

P/N 206-321-002 (S/N 2001-2152) High Aft Crosstube

**HELICOPTERS AFFECTED:**

All Bell Helicopter Textron (BHT) Model 206A & 206B helicopters with the subject Fwd & Aft Crosstubes installed.

**COMPLIANCE:**

Within 300 flight-hours of receipt of this bulletin, but not later than April 15, 2005.

**DESCRIPTION:**

This Alert Service Bulletin is being issued to advise the user community of the possibility of cracking in the area beneath the crosstube supports. A single instance of cracking emanating from rivet holes occurred on a P/N 206-321-001 crosstube. The rivet-on supports had been removed and replaced with clamp-on supports and the rivet holes had been plugged in accordance with ASB No. 94045, Revision D, dated December 20, 1995.

**MANPOWER:**

Approximately 6.0 man-hours.

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

**MATERIAL:**

None required.

**SPECIAL TOOLS:**

None required.

**WEIGHT AND BALANCE:**

Not affected.

**REFERENCES:**

ASB No. 94045, Rev. D, dated December 20, 1995.

**PUBLICATIONS AFFECTED:**

AA-01147, Instructions for Continued Airworthiness

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Hoist or jack the helicopter for removal of the existing skid gear assembly, using the prescribed procedures.

**NOTE**

Tag and retain all parts including attaching hardware (unless otherwise noted), removed to gain access to work area. Protect parts from damage while removed.

2. Remove the forward and aft landing gear fairings and the four upper crosstube fairings, if applicable.
3. Remove the bolts and straps (left & right sides) which secure the forward and aft crosstubes to the fuselage; observe order of parts removal. Remove skid gear.
4. Inspect crosstube per AAI Instructions for Continued Airworthiness (ICA) report number AA-01147, Revision D or later. If crosstube is serviceable proceed with step 5.
5. Remove the two T-Bolt Band Clamps from each support.
6. Use a plastic scraper to remove the bead of sealant from the edges of the support.

7. Using a grease pencil (china marker) mark the outline of the existing crosstube supports. Marking is required to properly align the supports during reinstallation.

**WARNING**

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

8. Remove the coated supports by peeling the coated support and adhesive strip from the crosstube.

**WARNING**

**Do not use a putty knife to remove support.**

9. Clean affected area to remove sealants and adhesive.
10. Place one skid tube against a wall. Apply pressure against the opposite skid tube to compress the crosstubes approximately 1-2". With the crosstubes compressed, visually inspect the area around the rivet holes for cracking using a 10 power magnifier. If any cracks are identified the crosstube must be replaced. If no cracks exist remove pressure and proceed with step 11.

**NOTE**

Be sure to use an adequate protective barrier against the skid tubes to prevent damage during compression.

11. Visually inspect crosstube support mounting area for corrosion and repair (if required) in accordance with ICA AA-01147, Revision D or later. If crosstube is still serviceable proceed with step 12.
12. Reinstall coated supports as follows;

**NOTE**

Do not reinstall uncoated supports and clamps. Coated supports and clamps must be used for reinstallation. Replace coated supports and clamps if damaged or worn.

13. Scuff the faying surface of the crosstube and supports with 180 grit abrasive paper. Do not remove paint from the crosstube or nylon coating from the supports.
14. Clean the sanding residue from the crosstube and supports using alcohol and a clean cloth.
15. Apply a layer (approximately 1/16" thick) of sealant (AMS-S-8802) to inside surface of the supports.
16. Position coated supports, P/N 601-025-005-B (forward), and P/N 601-025-003-B (aft), using alignment marks on crosstube.

17. Install T-Bolt Band Clamps, P/N 601-025-015 on the forward crosstube, and P/N 601-025-009 or P/N 601-025-015 on the aft crosstube with the bolt in the clamp on top of the support and the threads facing aft.

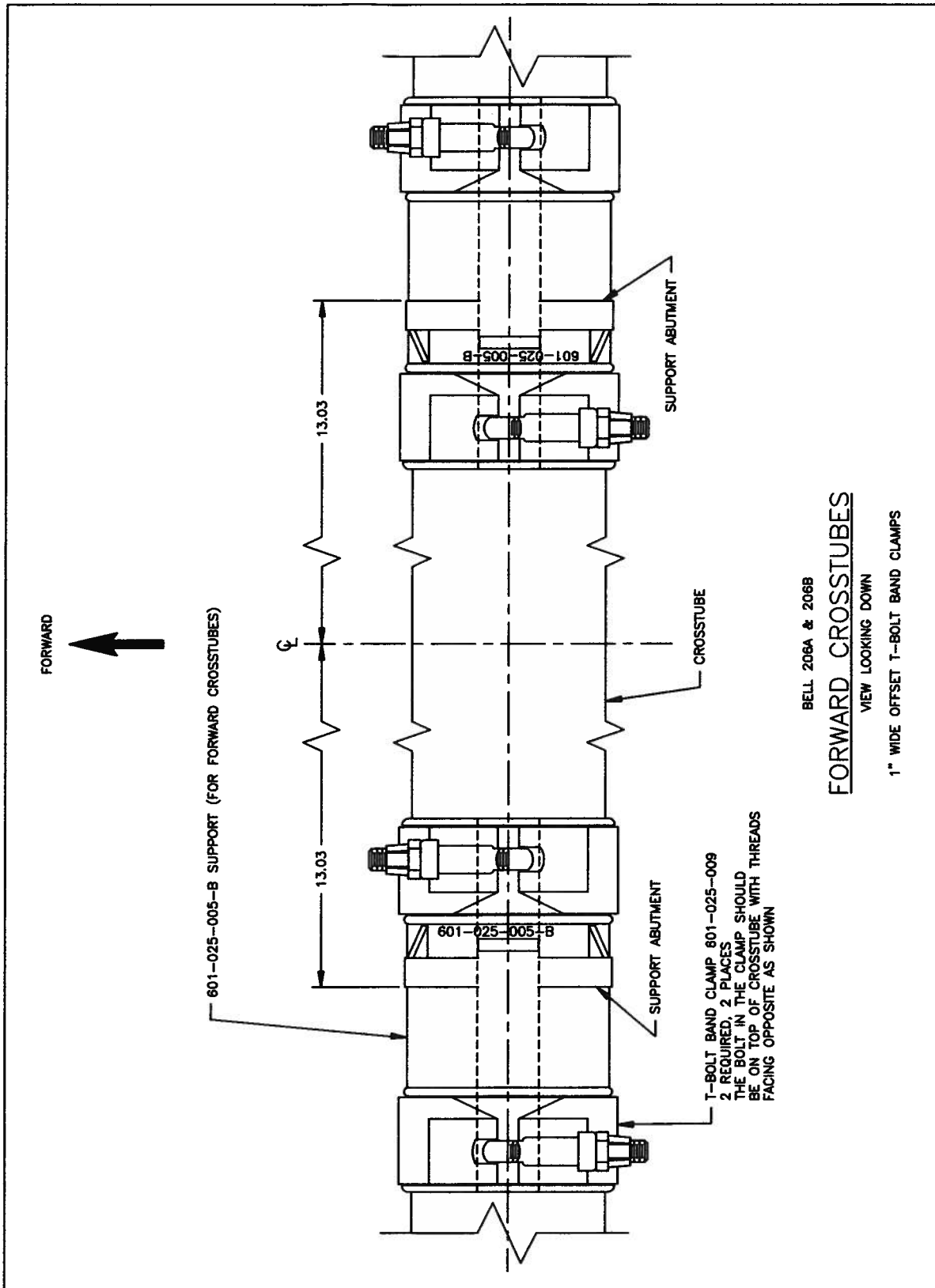
**NOTE**

If installing T-Bolt Band Clamp P/N 601-025-009 on the forward crosstube, position Band Clamps as shown in Figure 1.

18. Tighten T-Bolt Band Clamp initially using minimum torque required until a uniform sealant squeeze-out is noticed on both sides of the clamp. Fair in the sealant squeeze-out, remove excess and wipe clean. Allow to cure for 24 hours.
19. After 24 hours, torque T-Bolt Band Clamp nuts to 40-50 inch-pounds.
20. Fill any gaps between crosstube/support/clamp with sealant. Remove excess and wipe clean.
21. Apply fillet of sealant to crosstube/support/clamp.
22. Check torque on the clamp after the sealant has cured (72 hours at room temperature). Re-torque as required.
23. Prime and paint the supports and clamps to match existing landing gear.
24. After paint has fully cured, reattach skid gear using hardware removed in step 3.
25. Reattach fairings if applicable.

Any questions regarding this bulletin should be addressed to:

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



**Figure 1**

**AERONAUTICAL ACCESSORIES, INC.**