

Service Bulletin

Service Bulletin: SB407-300; Bell 407 Air Conditioner Drive Pulley Bevel Washer Replacement.

Subject: Tail Rotor Driveshaft Bevel Washer Replacement.

Date: 15 April, 2004

Applicability: Bell Helicopter Model 407 series equipped with the Air Comm Corporation air conditioner system.

Reference:

1. F.A.A./S.T.C. #SR00222DE, Bell Helicopter 407 Series Air Conditioning System.
2. Compressor Installation Drawing #: 407EC-300 Rev N
3. Bell Helicopter Technical Bulletin (TB) TB407-99-18
4. Obsoleted ACC Service Bulletin SB407-201

Compliance: Shall be in conjunction with the compliance of Bell Helicopter TB407-99-18 (Installation of Disk Pack 407-340-340-101).

I. Discussion:

This bulletin supersedes the obsoleted Air Comm SB407-201 Service Bulletin.

Due to the implementation of TB407-99-18, it has become necessary to replace the tail rotor drive shaft Bevel Washers (S-3526EC-2) located between the Tail Rotor Flywheel assembly and the Driveshaft Coupling Disc Pack.

TB407-99-18 requires replacement of the original 406-040-340-101 Disk Pack with the new 407-340-340-101 after determination that the original Disc Pack need to be replaced.

It has come to our attention that contact between the new Disc Pack and the flywheel can occur on aircraft equipped with the Air Comm Air Conditioner. This has shown to result in slight scouring of the flywheel hub.

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I. Discussion: (cont'd)

This bulletin provides instructions for installation of new bevel washers. The effect of this change is to increase the spacing between the disc pack and the flywheel by .021 inches. The location of the drive coupler is unchanged.

II. Approval:

The Technical aspects of this Service Bulletin have been FAA / DER approved.

III. Purpose:

This change will provide the proper clearance between the Disc Pack and the Flywheel assembly.

IV. Bill of Materials:

Item	Part Number	Description	Qty.
1	S-3526EC-4	Bevel Washer (.035 thick)	4
2	S-3526EC-5	Bevel Washer (.077 thick)	2

Contact the Air Comm Corporation Service to obtain replacement washers.

Replacement instructions for Disc Pack P/N 406-040-340-101

1. Remove mounting hardware for Disc Pack P/N 406-040-340-101, which includes washers P/N S-3526EC-2 (.055 thick). Upon removal of Disc Pack, discard washers (6 each).
2. Installation of new Disc Pack P/N 407-340-340-101 includes washers P/N S-3526EC-4 (4 each) and washers P/N S-3526EC-5 (2 each). When installing the new disc pack, install washers (P/N S-3526EC-4) between the existing washer P/N AN960-516 (existing washer is against the nut) and disk pack on all 4 mounting bolts. Install washers (P/N S-3526EC-5) on 2 mounting bolts, between disk pack and flywheel.
3. Torque application is: torque on nuts must be minimum of the run-on-tare torque plus 150 inch-lbs to a maximum of the run-on-tare torque plus 180 inch-lbs.

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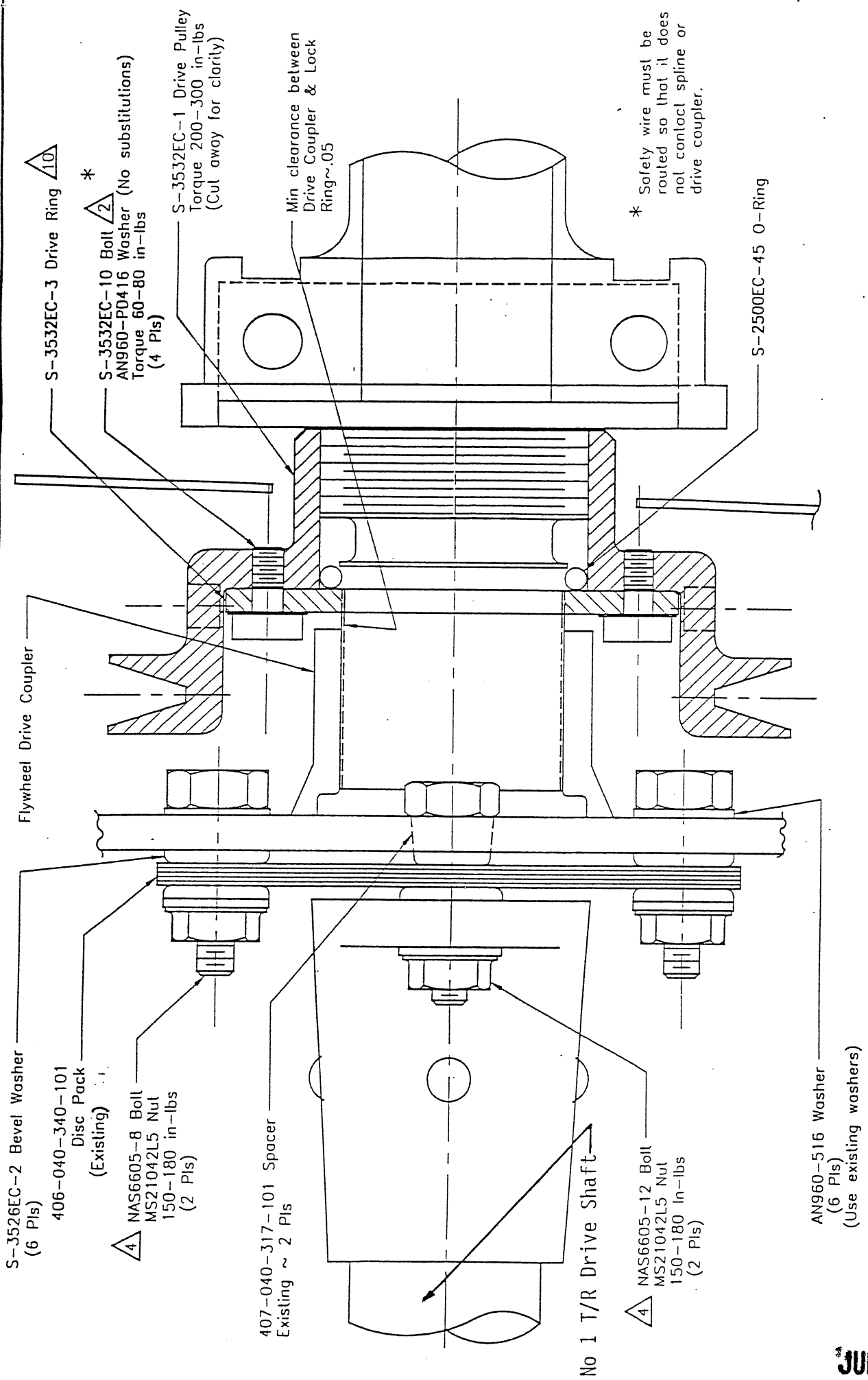


Figure 1 Original Compressor Drive Sleeve Installed;
 S/N 53000 to 53319

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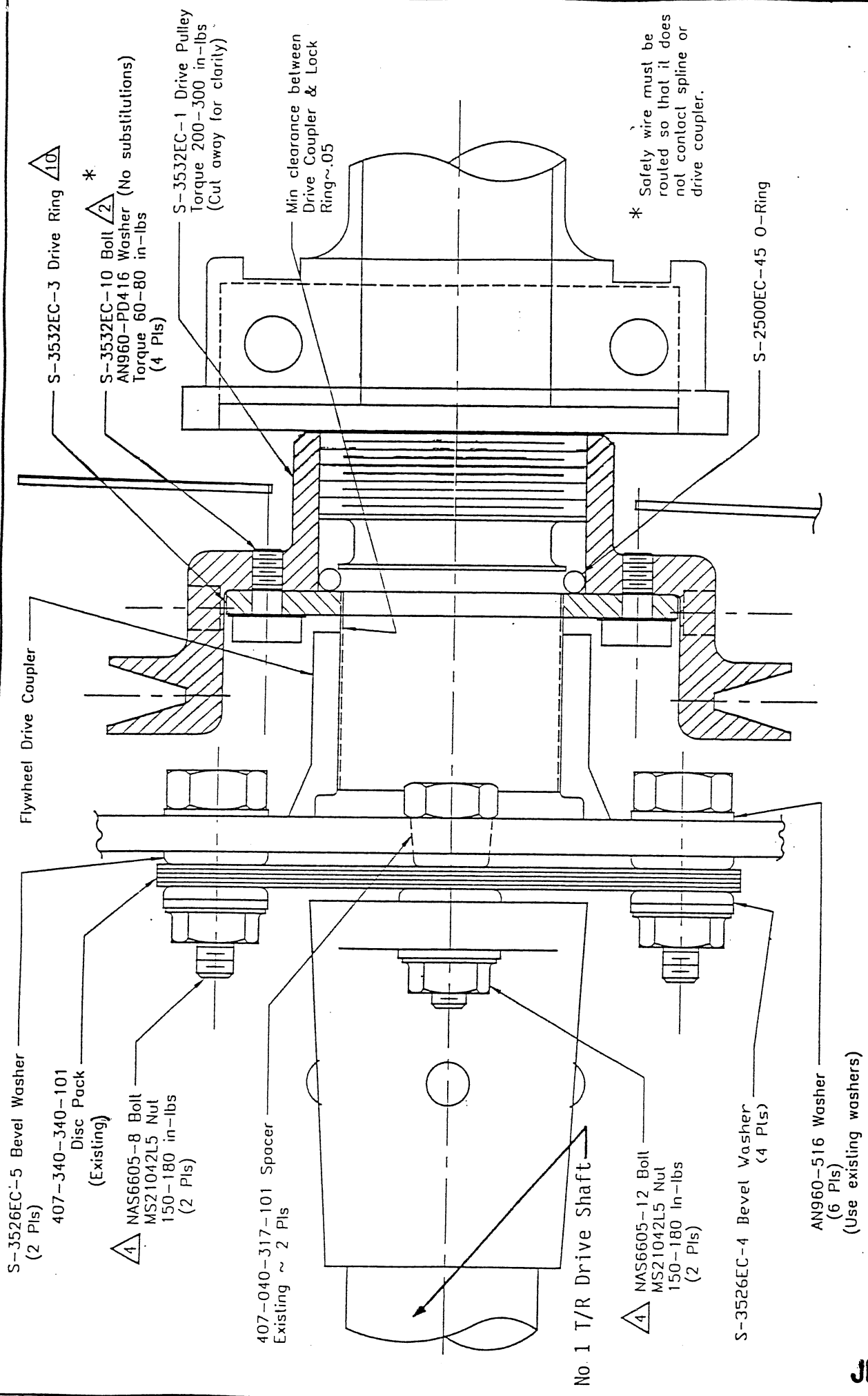


Figure 2 Revised Compressor Drive Sleeve Installed;
 S/N 53320 & Subsequent

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