

Service Letter

FAA-DER APPROVED

Service Letter: No. 336

Subject: Bell 412 Air Conditioner Receiver Drier Upper Support Bracket

Date: 6 August, 2001

Applicability: Bell Helicopter Model 412

Reference: F.A.A. / S.T.C. SR00066DE

Compliance: At the discretion of the operator

Background: We have received a report from the field that the current configuration of the Bell 412 air conditioner receiver drier support clamps may allow the top of the Receiver Drier assembly to shift. This shift may cause the fittings to leak or crack, causing the system refrigerant to leak.

The following instructions are provided to allow the operator in the field to install a bracket and clamp arrangement that will help prevent further occurrence of this problem.

Approval: The Technical aspects of this Service Letter are FAA / DER approved.

Bill of Materials of Item to be **removed**:

Item	Part Number	Description / Nomenclature	Remove
1	AN525-10R6	Screw	1

Bill of Materials of item to be **Installed**:

Item	Part Number	Description / Nomenclature	Install
1	412AC-2508-2	Bracket	1
2	MS21919WCH-40	Clamp	1
3	AN525-10R6	Screw	1
4	AN960-10L	Washer	1
5	MS21042L3	Nut	1
6	AN525-10R8	Screw	1

Contact the ACC Service Department to obtain the parts listed above to complete this Service Letter at: Phone 303-440-4075, or Fax 303-440-6355.

**I. Removal:**

1. Remove the upper transmission cowling to gain access to the air conditioner Condenser / Receiver Drier Assembly. (See figure 1-1)

**NOTE**

It is **not** necessary to discharge the refrigerant from the air conditioning system to accomplish this Service Letters Instructions.

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**Removal Continued:**

2. Remove one (1) each of a AN525-10R6 Screw, from the lower R/H forward corner of the Condenser Enclosure Assembly. (See Fig. 1-2, View A-A)

**II. Installation:**

1. Align the 412AC-2508-2 Bracket with the Screw Hole left vacant from the removal of the AN525-10R6 Screw in the lower R/H forward corner of the Condenser Enclosure Assembly, and match drill using a .1890 Dia drill bit. (See Fig. 1-2 View A-A)

**NOTE**

Remove all sharp edges for match drilled hole in 412AC-2508-2 Bracket.

2. Install one each AN525-10R8 Screw to attach the 412AC-2508-2 Bracket to the Condenser Enclosure Assembly.
3. Install one each of the MS21919WCH-40 Clamp on the upper portion of the 804-297 Receiver Drier Bottle. Rotate Clamp to align with the aft surface of the 412AC-2508-2 Bracket, and mark location of hole. (See Fig. 1-2, View Y-Y).

**NOTE**

Insure that the Receiver Drier Bottle remains in a "relaxed" position, as not to put a pre-load on the connecting refrigerant lines.

4. Match drill using a .1890 Dia drill bit in out-board section of 412AC-2508-2 Bracket, and install the MS21919WCH-40 Clamp, AN525-10R6 Screw, AN960-10L Washer, and MS21042L3 Nut as shown in View Y-Y.
5. Reinstall the upper transmission cowling.

**III. Weight and Balance:**

There are no Weight and Balance considerations with the installation of this hardware, as the weight change is negligible.

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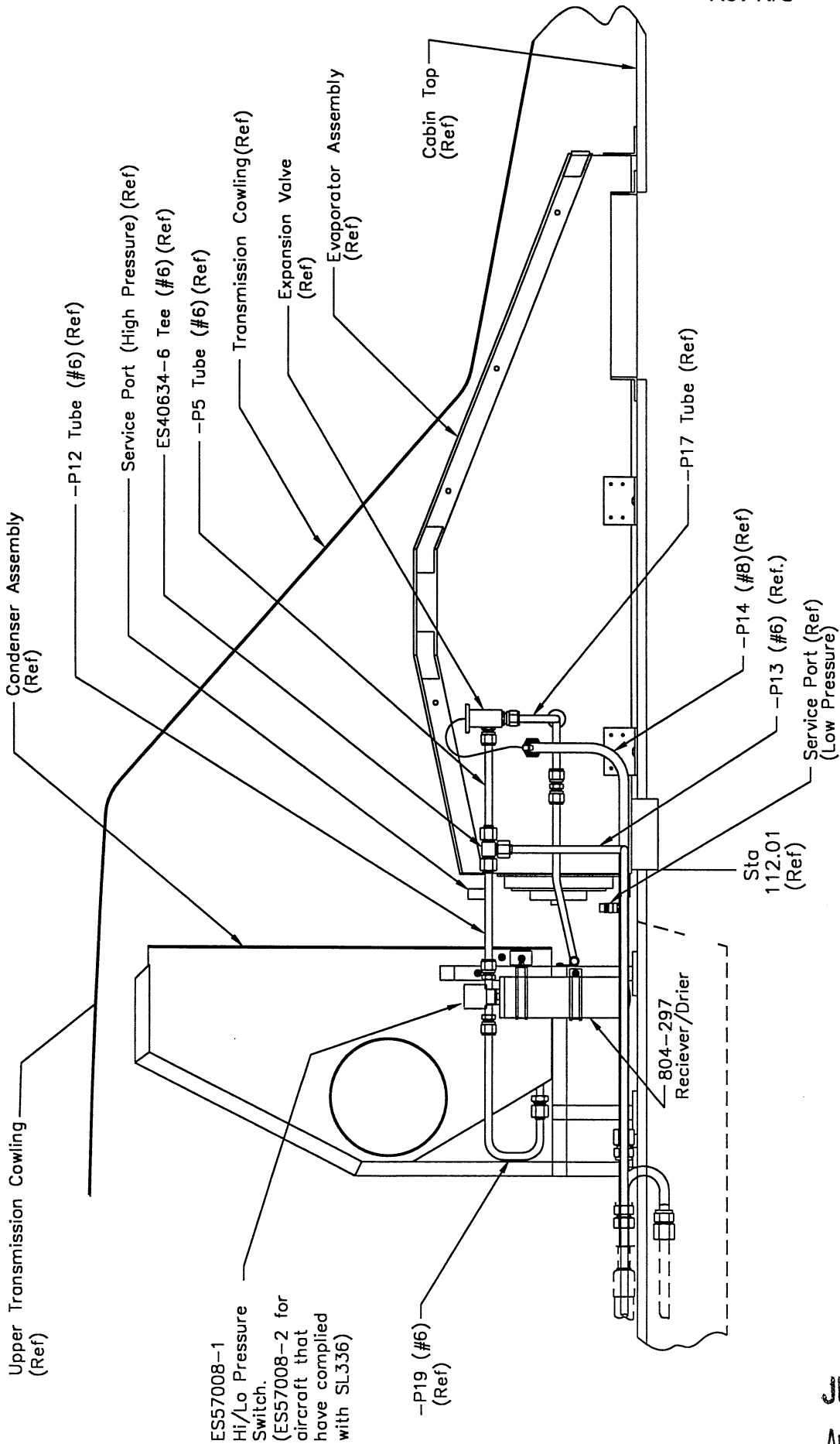


Figure 1-1, Bell 412 Air Conditioner Cabin Roof General Arrangement Drawing

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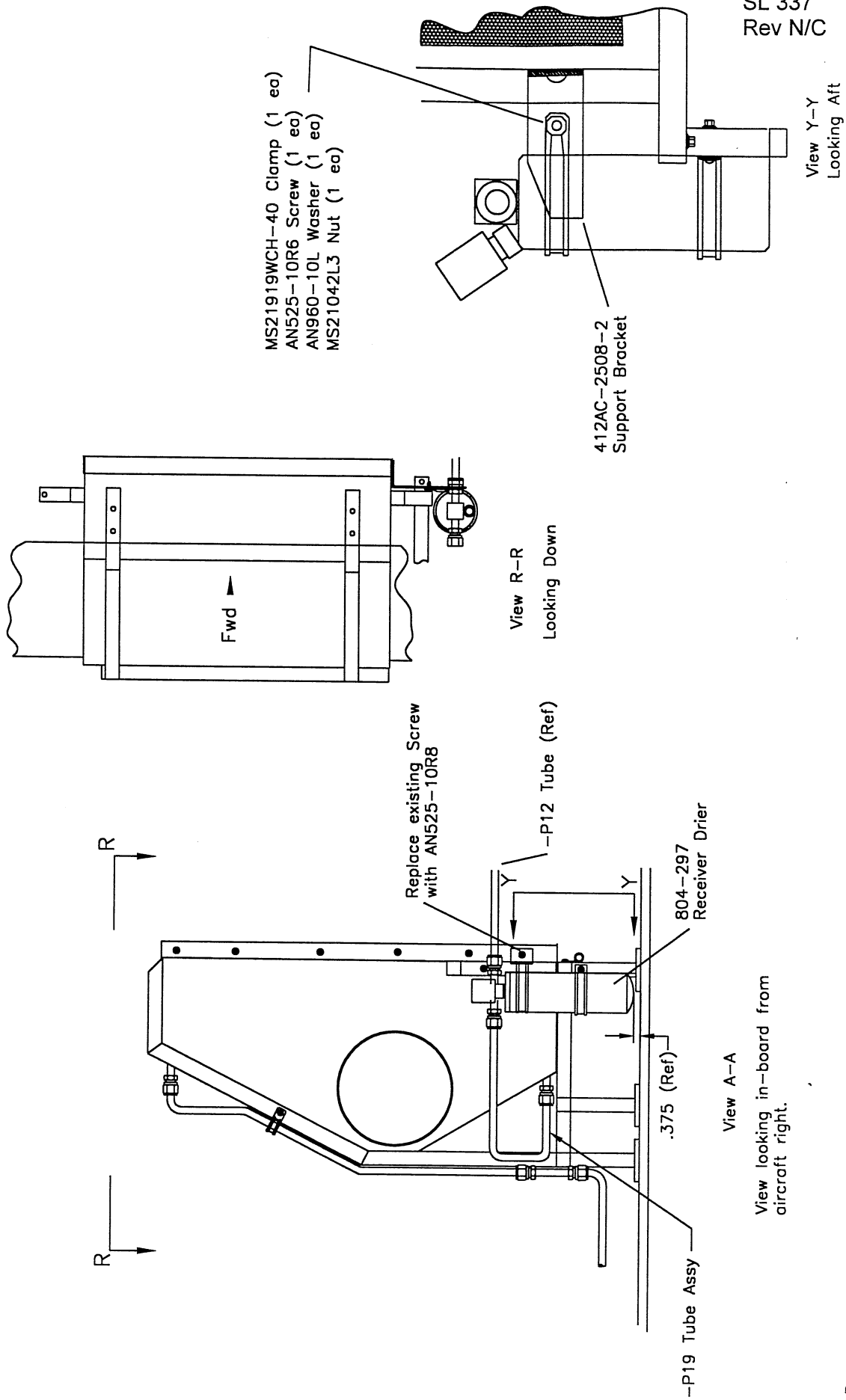


Figure 1-2, Receiver Drier Bottle Support Bracket Mounting

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