

Service Bulletin

FAA-DER APPROVED

Service Bulletin: No. 412-200

Subject: Removal and Installation - 412AC-300 Air Conditioning System
Compressor Pivot Bolts.

Date: June 19, 1995

Applicability: Bell Model 412 Helicopters which are equipped with Air Comm
Corporation Cabin Air Conditioning System; serial numbers 33195, 36090
and 36064.

Note: Aircraft serial number 36064 will be upgraded to the ACC drawing
412AC-300 Rev D compressor installation, which will include the changes
listed in this service bulletin.

Reference:

1. STC SR00066DE; Bell 412 Air Conditioning System
2. ACC drawing ~ 412AC-300 Rev C; Installation - Compressor.
3. ACC Maintenance Instructions - Bell 212/412 Air Conditioning System;
Report 412AC-200M.

Background:

It has been determined that the compressor mounting pivot bolt length is too short.
Also a bolt torque callout is required.

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Mandatory Action Required:

Within twenty-five (25) hours of flight:

Remove and replace the existing Compressor Mount Pivot bolts as shown in figure 1.

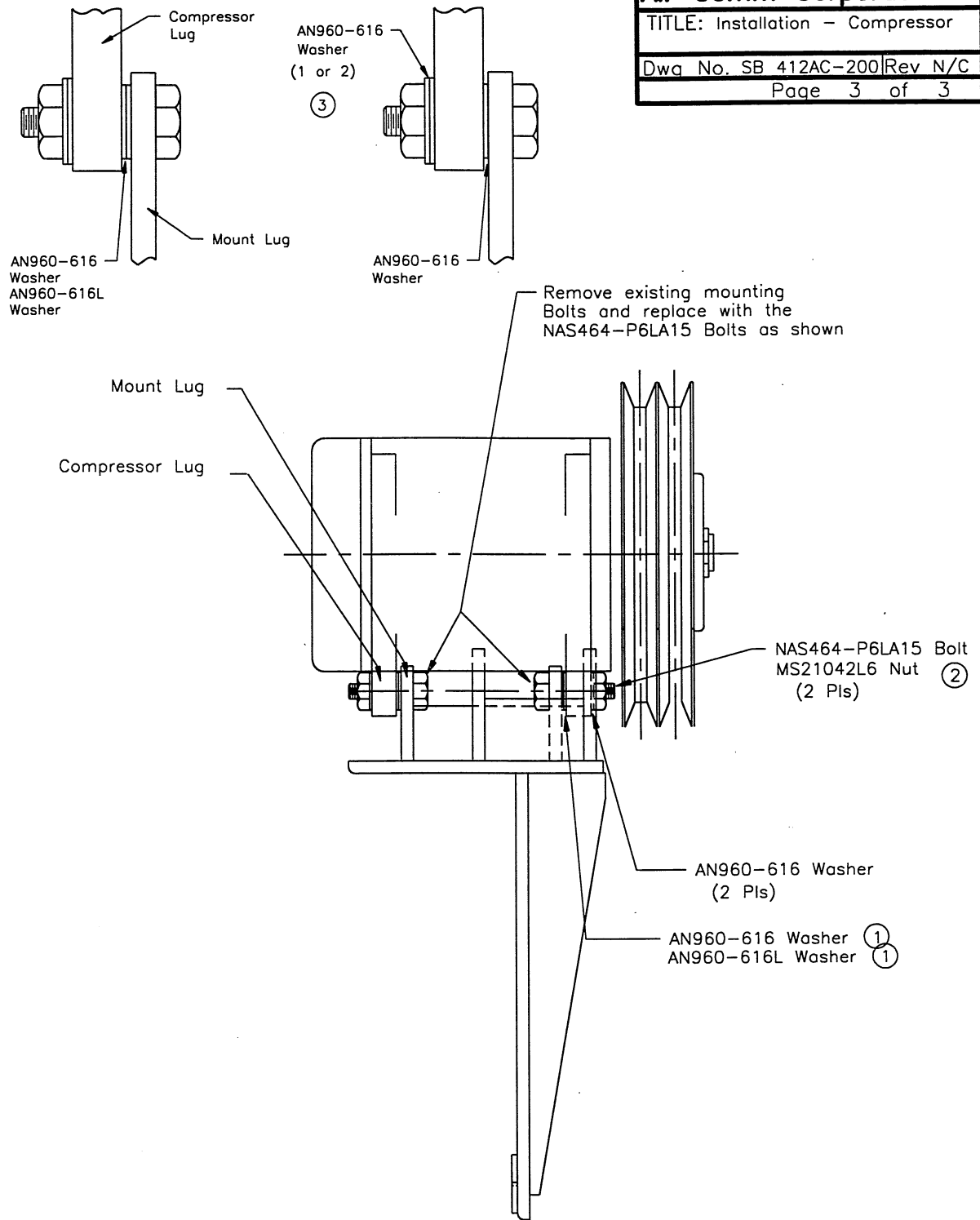
Torque the pivot bolt nuts to the specified torque.

Inspect the compressor lugs and compressor mount for evidence of wear, cracks and overall security.

Product Support Procedures:

ACC will provide the following hardware at no charge.

<u>Item</u>	<u>Qty</u>
NAS464-P6LA15 Bolt	2 ea.
AN960-616 Washer	6 ea.
AN960-616L Washer	4 ea.
MS21042L6 Nut	2 ea.



- ① Install washers if required to fill space between lugs. Normally one AN960-616 AN960-616 Washer on each side will be adequate, but due to the variation in thickness of the washers you may need one AN960-616 and one AN960-616L to fill the space between the lugs and mounting ears, see details.
Note: Due to the variation on thickness of the washers, you may need to try a few AN960-616 Washers to get the best fit. Attempt to make the fit snug so there will be no space between the washer and lugs.
- ② Torque requirement 95 to 110 in-lbs.
- ③ Use 1 or 2 AN960-616 / AN960616L Washers under Nut to ensure it does not bottom out against grip of bolt while allowing at least 1 thread to extend through the nut.

Figure 1. Compressor Pivot Bolt Installation.

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