

Aircraft Conditional Inspection

TABLE OF CONTENTS

Paragraph Number	Title	Effectivity	Page Number
K-1	Transportation	TH57B / C	K-2
K-2	ACI Requirements	TH57B / C	K-2
K-3	Procedures	TH57B / C	K-2
K-4	Discrepancies	TH57B / C	K-3
K-5	Reports	TH57B / C	K-3
K-6	Material.....	TH57B / C	K-4
K-7	Weighing of Aircraft.....	TH57B / C	K-4

K-1. TRANSPORTATION

Aircraft will be flown to the selected facility to perform the ACI.

K-2. ACI REQUIREMENTS

1. All work shall be performed in accordance with Bell Helicopter Maintenance Manual BHT-206A/B-Series-MM-1, Bell Helicopter Corrosion Control Guide CSSD-PSE-87-001, Bell Helicopter Standard Practices Manual BHT-ALL-SPM, Bell Helicopter Structure Repair Manual BHT-206-RM-1, Bell Helicopter Process Specification BPS 4357 Removal of Organic Finishes, And Navy Technical Manual Supplements.
2. All work shall be accomplished by a licensed FAA Repair Facility Certified to perform these requirements. Facility shall be a certified Bell Service center.

K-3. PROCEDURES

1. Seal the fuselage and strip paint and primer from the aircraft exterior fuselage using Bell Helicopter Process Specification BPS 4357 – Removal of Organic Finishes or Bell Helicopter Standard Practices Manual BHT-ALL-SPM. Prepare stripped aircraft fuselage exterior for painting in accordance with Bell Helicopter Control Guide CSSD-PSE-87-001. As part of the proposal, the Contractor must provide a step-by-step description of the stripping processes and type of application. Stripping processes shall be environmentally safe. The Customer prefers plastic-media blasting. The Customer shall approve stripping application and stripping agents. The Contractor will describe methods for masking, equipment removal and other

measures to be taken to protect equipment and surfaces not to be stripped.

2. Perform surface evaluation inspection and repair corrosion damage using the requirements of Bell Helicopter Maintenance Manual BHT-206A/B-SERIES-MM-1, Bell Helicopter Maintenance Corrosion Control Guide CSSD-PSE-87-001, Bell Helicopter Standard Practice Manual BHT-ALL-SPM, and Bell Helicopter Structural Repair Manual BHT-2060-SRM-1.
3. Apply Corrosion X Aviation II (MIL-C-81309) with special spray equipment to interior of tail boom and airframe.
4. Drill #40 Drain holes in forward landing gear fitting (P/N 206-030-104) as per instructions and apply Corrosion X Aviation II (MIL-C-81309).
5. Coat tail rotor bell crank support casting (magnesium) P/N 206-033-173-*** with Tectyl 891 (MIL-C-16173E).
6. Drill 3/16” drain holes in transmission dzus rail.
7. Pro-seal (MIL-S-8802) position lights on stabilizer after painting.
8. Apply Tectyl 891 (MIL-C-16173E) on tail rotor hardware.

9. Apply pro-seal sealant (MIL-S-8802) around edge of tail rotor pedal support (magnesium casting) Apply Mastinox sealant p/n 6856-K (MIL-P-8116) to ends of cross tube before installing into skids and apply pro-seal sealant (MIL-S-8802) to all the hardware after painting.
10. Apply pressure tape to tail boom at horizontal stabilizer attach area.
11. Install chafe tape on all dzus rails.
12. Paint fuel vent tube and install fuel vent decal.
13. Apply pressure tape to inside of tail rotor gearbox cowling.
14. Apply pressure tape below tach generator wire harness on transmission deck.
15. Modify intake cowling for tracking wire harness.
16. Replacing of MS27039 screws with AN3 bolts.
17. Install extra dzus on dog house cowling.
18. Pro-seal around rotor brake master cylinder.
19. Pro-seal around windshields, chin bubbles, and sky lights after painting.
20. Remove interior trim from doors and re-paint matching color scheme.
21. Prepare stripped aircraft fuselage exterior for painting in accordance

with Bell Helicopter Corrosion Control a Guide CSSD-PSE-87-001 and Bell Helicopter Standard Practices Manual BHT-ALL-SPM.

22. Prime and paint the Helicopter exterior fuselage in accordance with Bell Helicopter Standard Practice Manual BHT-ALL-SPM. Match the original Naval paint scheme including command markings, MODEX numbers and installation of exterior decals as shown in Naval Technical Manual Supplement. On some helicopters the word "NAVY" has been replaced with "MARINES" ON THE TAIL cone. The windshield center post fairing exterior on the TH-57B is painted 17875 gloss white and on the TH-57C is painted 12197 international orange.

K-4. DISCREPANCIES

Minor discrepancies found during ACI shall be considered basic to this effort. Major discrepancies will be forwarded to Program Management Office for approval. All discrepancies shall be noted whether they are worked at the Contractor or not.

K-5. REPORTS

At a minimum, the Contractor will provide weekly status reports, incident reports and accident reports. The Contractor shall provide a letter type report documenting the results of the surface evaluation inspection and any repair action required on each aircraft undergoing ACI. The report shall include aircraft bureau number, airframe time and ACI completion date.

K-6. MATERIAL

1. Materials must meet specifications established in Bell Helicopter Maintenance Manual BHT-206A/B-Series-MM-1, Bell Helicopter Corrosion Control Guide CSSD-PSE-87-001, Bell Helicopter Standard Practices Manual BHT-ALL-SPM, Bell Helicopter Structural Repair Manual BHT-206-SRM-1, Bell Helicopter Process Specification BPS 4357 Removal of Organic Finishes, and Navy Technical Manual Supplements.
2. The Contractor must provide MSDS for all chemicals, paints and solvents used in the ACI process. The MSDS must be contained in the Contractor's proposal.

K-7. WEIGHING OF AIRCRAFT

1. Aircraft shall be weight after completion of ACI.
2. Use calibrated equipment, and copies of current calibration certificate. Calibration of calibrated scales must be traceable to the National Institute and technology with ANSI/NCSL Z 540-1-1994, American Standard for Calibration.
3. Calculate center of gravity, weigh and balance to 115.75" or AFT.
4. Use Bell approved ballast for CG adjustments.
5. Complete weight and balance forms and certify with original signatures.