

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS  
AND EQUIPMENT MAINTENANCE MANUAL  
FOR OXYGEN BOTTLE MOUNT

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**REPORT NUMBER**  
**HF-206-ICA-OXYGEN BOTTLE MOUNT-1**

THIS MANUAL IS PREPARED TO PROVIDE INFORMATION, INSTRUCTIONS FOR CONTINUED AIRWORTHINESS, MAINTENANCE INSTRUCTIONS AND REPAIR PROCEDURES FOR EQUIPMENT MANUFACTURED BY HELIFAB THAT MAY BE INSTALLED ON THE 206 HELICOPTER. ENSURE THAT THIS MANUAL IS USED FOR ONLY HELIFAB EQUIPMENT.

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**CHAPTER 1 - INTRODUCTION**

**1.1 Introduction**

A. Scope of the aircraft maintenance manual.

- (1) The equipment maintenance manual Document No. HF-206-ICA-OXYGEN BOTTLE MOUNT-1) describes the required procedures for maintaining continued airworthiness for the Bell 206 L series aircraft with the HeliFab oxygen bottle mount installation.

This manual only includes information for servicing, maintenance, inspection and repair within the scope of an appropriately rated mechanic or repair station.

B. Changes to the Equipment Maintenance Manual:

- (1) The current revision of this ICA may be obtained online at [www.ArrowAviationCo.com](http://www.ArrowAviationCo.com). It is the responsibility of the owner/ operator that only the current issue of the Equipment Maintenance Manual is used.

- (2) Changes to the equipment maintenance manuals are to be incorporated.

- (3) Changes are identified as follows:

- (a) Revised or extended text, inserted pages with new text contents or new figures are identified with black marginal bars or referenced symbols.

- (b) When text is relocated, resulting possibly in a renumbering of pages or task, or in case of printing error corrections, no markings are provided.

- (c) Changed pages are provided with the issue date of the change.

- (4) Equipment manufacturer's manuals;

- Upon initial installation of the HeliFab oxygen bottle mount installation, HeliFab will provide any installation or operators manuals that are included with the purchase of the new equipment.

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C. Items of special emphasis

**WARNING** IS USED WHEN UNQUALIFIED PERFORMANCE OR  
NEGLECT OF INSTRUCTIONS MAY LEAD TO INJURIES  
OR DEADLY ACCIDENTS.

**CAUTION** IS USED WHEN UNQUALIFIED PERFORMANCE OR  
NEGLECT OF INSTRUCTIONS MAY LEAD TO EQUIPMENT  
DAMAGE

**NOTE** IS USED WHEN A PARTICULAR ITEM NEEDS TO BE  
EMPHASIZED

D. Abbreviations

EMM	Equipment Maintenance Manual	Y	Years
MIL	US Military Specification	TSN	Time Since New
HF	HeliFab	N/C	No Change
FH	Flight Hours		
Mo.	Months		

**1.2 General**

- A. Any special tools required will be defined in the text of this document.
- B. Torque Values. Unless specified otherwise, the following torques will be used.
- |             |                        |                  |
|-------------|------------------------|------------------|
| <u>Size</u> | <u>Type</u>            | <u>Torque</u>    |
| 10/32       | Screws, nuts and bolts | 20 to 25 in-lbs. |

**1.3 Consumable Materials**

- A. Explanation  
Consumable materials are noted throughout this manual and on referenced drawings, only those material are to be used. Helifab, the STC holder, can be contacted to approve alternate or equivalent materials.

**STC Holder:**

Helifab, Inc.  
1318 Smede Hwy.  
Broussard, La, 70518  
Telephone: 337-364-4357  
Web: [www. ArrowAviationCo.com](http://www.ArrowAviationCo.com)

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**CHAPTER 4 - AIRWORTHINESS LIMITATIONS**

There are no overhauls, time limits, or airworthiness limitations associated with this type design change.

The Airworthiness Limitations section is FAA approved and specifies inspections and other maintenance required under Secs. 43.16 and 91.403 of the Federal Aviation Regulations unless an alternative program has been FAA approved.

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**CHAPTER 5 –INSPECTIONS**

**5.1 Conditional Inspections after Operational Incidents**

- A. After any operational incident involving hard landings, sudden stoppage of the drive train or water immersion, the system must not be operated unless all requirements and inspections are performed in accordance with section 5.4 of this EMM.
- B. Notification of incident should be made to the STC holder for additional requirements.

**CHECKS**

**5.2 Preflight Check - Equipment**

Normal pre-flight inspections to be accomplished per Bell Helicopter rotorcraft flight manual. Pre-flight inspections may be performed by the pilot or qualified technician.

**5.3 100 Hour Inspection**

- A. This inspection is to be performed by a qualified technician.
- B. In conjunction with this inspection a complete preflight inspection must be accomplished in accordance with Section 5.2.

DATE:

HELICOPTER S/N:

REGISTRY NO:

TOTAL TIME:

INSPECTION TASK DESCRIPTION	INITIAL MECHANIC
1. Inspect oxygen bottle mount for security and condition.	
2. Inspect quick release pin for condition and proper operation and lanyard for security.	
3. For those mounts equipped with an all stainless steel retaining strap, inspect the retaining strap for cracks, proper operation, and adjustment. Replace retaining strap if there are cracks or if the latch does not function properly.  For those mounts equipped with a nylon webbing retaining strap, inspect the strap and cam buckle for proper operation. Inspect nylon webbing for cuts or chafes exceeding 10 % of the webbing thickness. Inspect stitching for broken or worn stitching. Replace the retaining strap if the cam buckle does not function properly, there are cuts or chafes in the nylon webbing that exceed 10% of the webbing thickness, or there is broken or chafed stitching.	
4. Return aircraft to service and make appropriate entries in aircraft log book	

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**5.4 12 Months/1200 Hour Inspection**

- A. This check is to be accomplished by a qualified technician.
- B. In conjunction with this inspection a complete preflight and 100 hour inspection must be accomplished in accordance with Section 5.2 and 5.3 respectively. .

DATE:

HELICOPTER S/N:

REGISTRY NO:

TOTAL TIME:

INSPECTION TASK DESCRIPTION	INITIAL MECHANIC
1. Inspect hinges and mount structure for cracks. (NO CRACKS ARE ALLOWED)	
2. Inspect the oxygen bottle mount for corrosion. Corrosion may be removed using 320 grit aluminum oxide abrasive paper and alcoholic phosphoric acid solution mixed in 1 part alcoholic phosphoric acid solution and 3 parts demineralized water. Total corrosion cleanup depth can not exceed 10% of original material thickness; thus material thickness after corrosion cleanup can never be less than 90% of the new part thickness.  After corrosion cleanup, prime bare metallic surfaces per MIL-P-23377 and apply finish coat as desired.	
3. Verify that mount decal is legible.	
4. Return aircraft to service and make appropriate entries in aircraft log book	



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**CHAPTER 6 – WEIGHT AND BALANCE**

**6.1 Weight and Balance**

The new empty weight and corresponding C.G. location must be determined and entered in the aircraft permanent records.

The oxygen bottle mount installation weighs 1.5 lbs (not including mounted equipment) and has two allowed installation locations. The CG of the mount in the primary installation location is at STA 118.9, RBL 10.0; the CG of the mount in the alternate installation location is STA 118.9, RBL 8.7. The weight of equipment mounted in the oxygen bottle mount must also be accounted for during weight and balance calculations.

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**CHAPTER 35 – EMERGENCY MEDICAL SYSTEM**

**35.1 Introduction**

This section presents a description of the HeliFab PN HF-206-EMS-5001-1 oxygen bottle mount installation in the 206L series helicopter. This section can be used as a familiarization and be developed into a training program by users of the kit.

**35.2 General Description**

There is a primary and alternate installation location for the oxygen bottle mount. The primary location is shown in figure 1. The alternate location, shown in figure 2, is approximately 1.3 inches inboard of the primary location. Both the primary and alternate installation locations use existing inserts for bottle mount attachment to the fuselage.

The oxygen bottle mount consists of a mounting bracket, retention strap with latch, and a quick release pin. Two types of retention straps may be used for the bottle mount, one type (PN 5001-02) is constructed of all stainless steel material with a cam buckle for length adjustment and the second type (PN 5001-05) is constructed of 1 inch nylon webbing with a cam buckle for length adjustment and a stainless steel attachment bracket.

**Table 1  
Parts List**

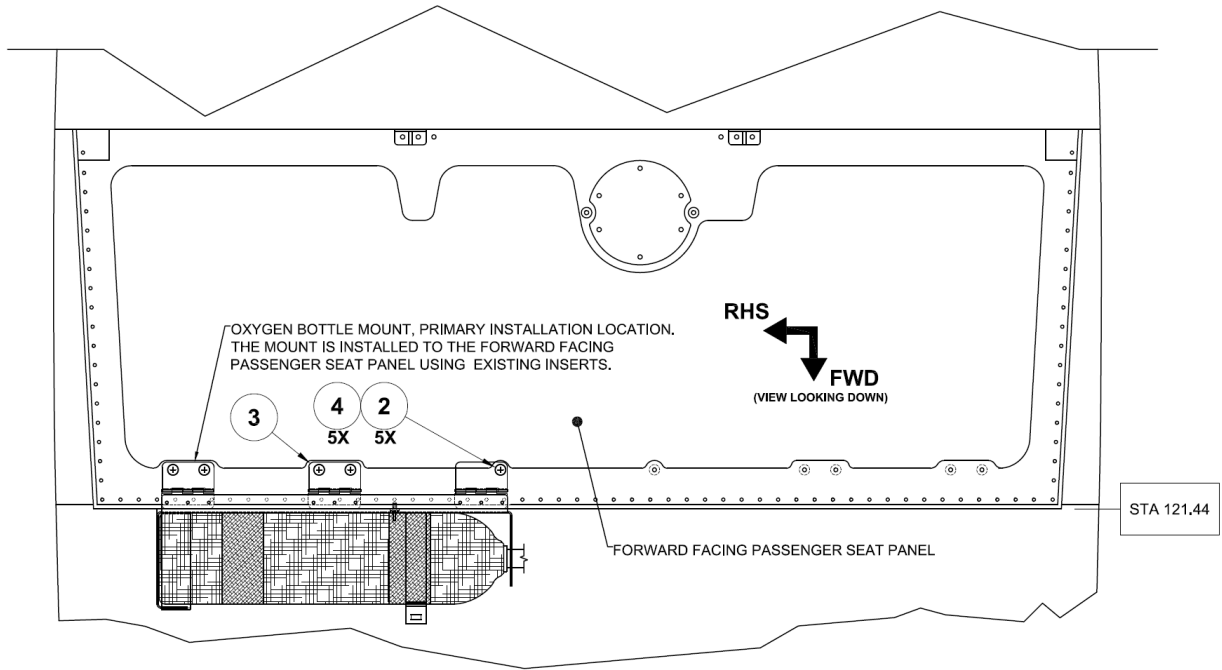
<b>Item Number</b>	<b>Nomenclature</b>	<b>Part Number</b>	<b>Vendor / Manufacturer</b>
1	Pin/Lanyard	5001-109	Helifab, Inc
2	Screw	AN525-10-R6	
3	Portable Oxygen Bottle Mount	5001-1	Helifab, Inc
4	Washer	AN960PD10L	
5	Eyebolt	AN42B-4A	
6	Retaining Strap Assembly	5001-02	Helifab, Inc
7	Decal	5001-108	Helifab, Inc
8	Retaining Strap Assembly	5001-05	Helifab, Inc
9	AN3-5A	Bolt	See Note 4
10	MS21042L3	Nut	See Note 4
11	NSA43HT3-10	Spacer	See Note 4

Notes:

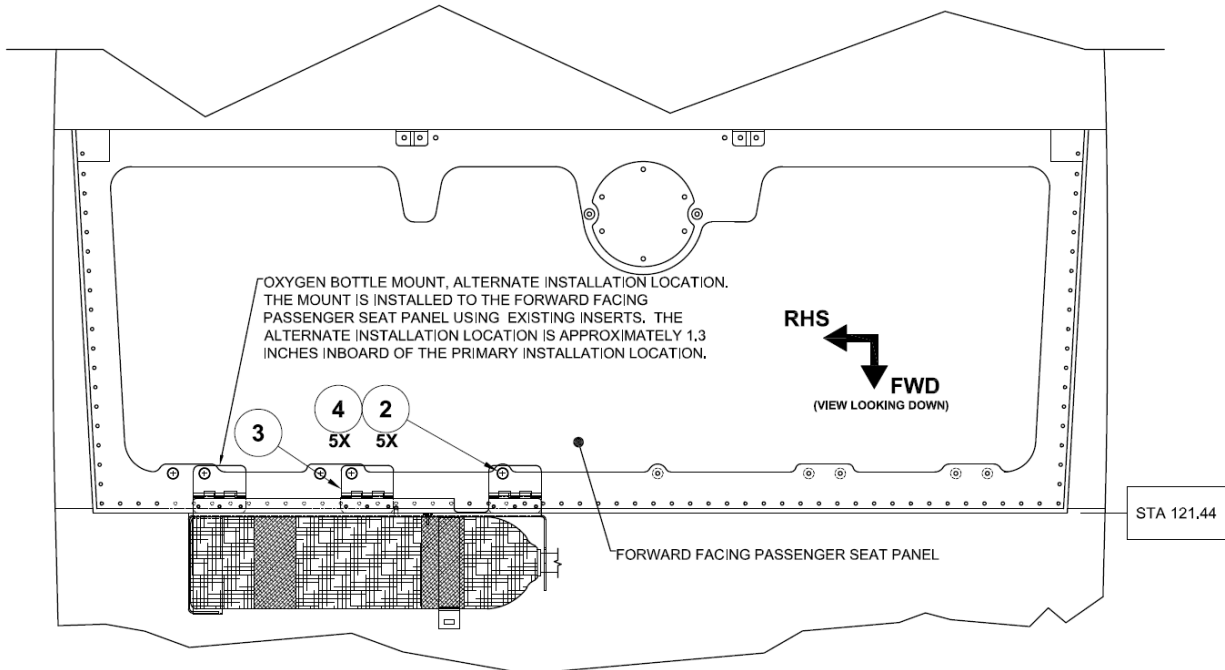
- (1) Determine length of fastener upon installation unless otherwise specified.
- (2) Length of fasteners may be increased if necessary for proper engagement.
- (3) Torque all fasteners per torque table in section 1.2 of this document.
- (4) Item 1 may be replaced with item 9, 10, and 11. Item 9, 10, and 11 are to be installed in eye of item 5 in order to secure item 3 to item 5.

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**FIGURE 1**  
**Oxygen Bottle Mount Primary Installation Location**

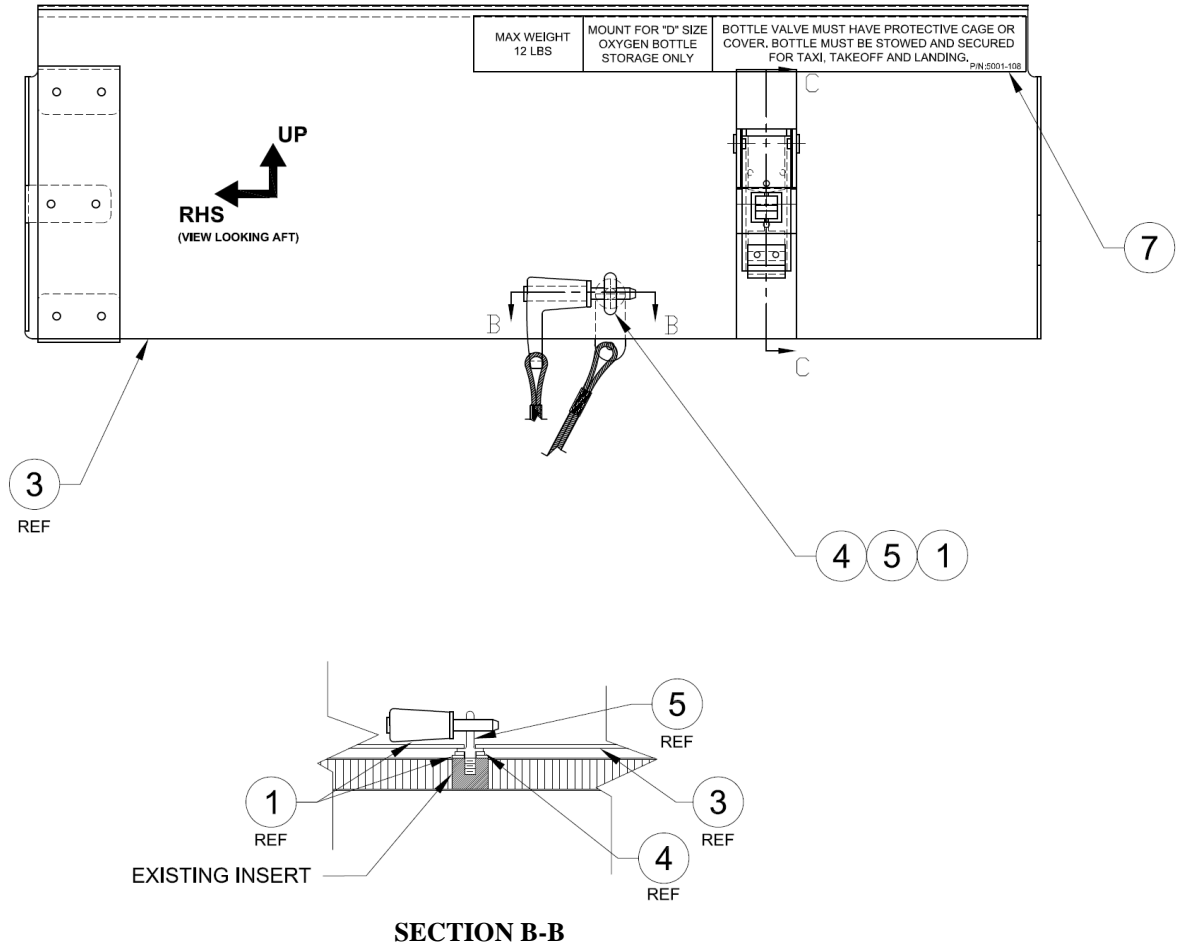


**FIGURE 2**  
**Oxygen Bottle Mount Alternate Installation Location**



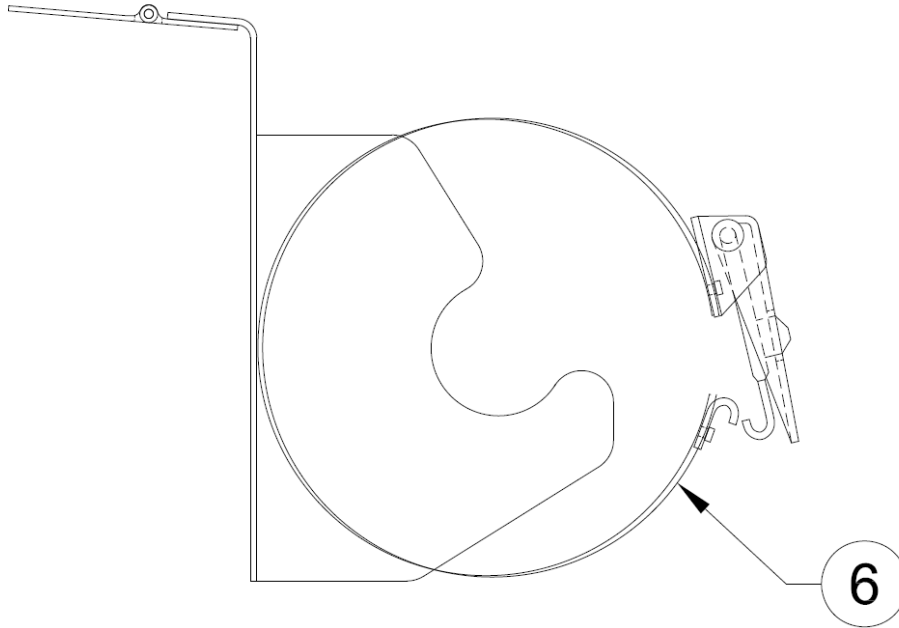
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**FIGURE 3**  
**Oxygen Bottle Mount Installation**

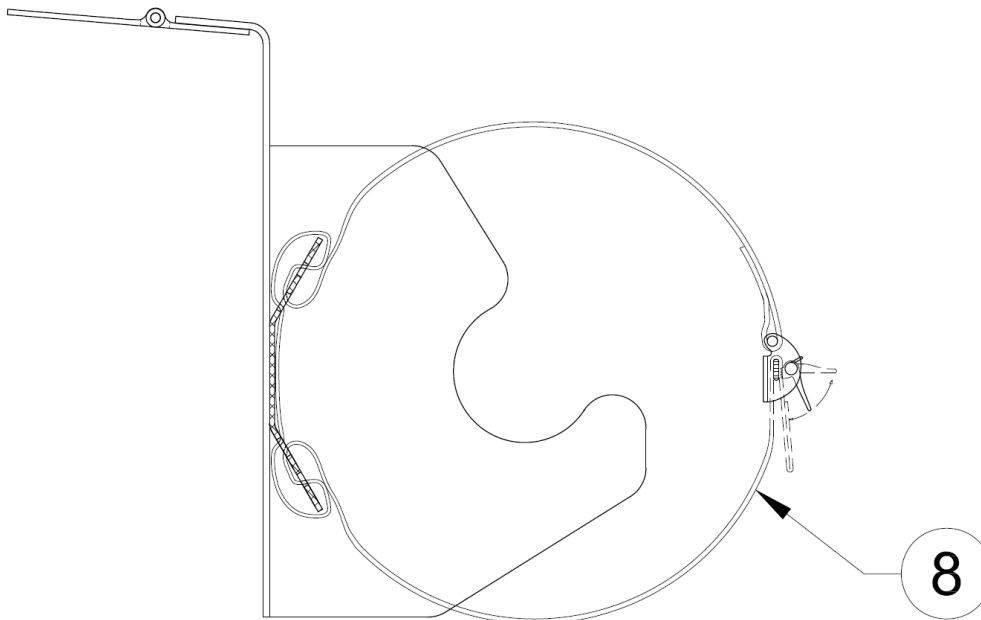


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**FIGURE 4**  
**SECTION C-C**  
(with PN 5001-02 Retaining Strap)



**FIGURE 4a**  
**SECTION C-C**  
(with PN 5001-05 Retaining Strap)



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**35.3 Removal/Installation and Troubleshooting –oxygen bottle mount**

- |    |                        |                   |
|----|------------------------|-------------------|
| A. | References:            | Figures 1 thru 4a |
| B. | Special Tools          | None              |
| C. | Consumables Materials: | None              |
| D. | Procedure:             |                   |

**Removal**

- (1) Remove items 1, 2, and 4 attaching the oxygen bottle mount to existing aircraft inserts.

**Installation**

- (1) Install items 1, 2, and 4 attaching oxygen bottle mount to existing aircraft inserts. For torque values see Section 1.2.

**Troubleshooting**

- (1) Loose or improper engagement of installation hardware can be corrected by replacement of defective or worn parts.

**35.4 Removal/Installation - Decal**

- |    |                        |           |
|----|------------------------|-----------|
| A. | References:            | Figures 3 |
| B. | Special Tools          | None      |
| C. | Consumables Materials: | None      |
| D. | Procedure:             |           |

**Removal**

- (1) Remove item 7 decal P/N 5001-108.

**Installation**

- (1) Install item 7 decal P/N 5001-108 in location shown on figure 3.

**35.5 Cleaning**

- |    |                       |  |
|----|-----------------------|--|
| A. | References:           | None   |
| B. | Special Tools:        | None   |
| C. | Consumable Materials: | Mild detergent or Bleach in 10 parts water to 1 part bleach mixture. |
| D. | Procedure:            |  |
1. Spray or brush cleaning solution on oxygen bottle mount
  2. Let stand 2 minutes then rinse thoroughly with fresh water.
  3. Allow to air dry thoroughly.

**35.6 Repair**

- A. No repairs other than those that can be accomplished with normal methods or that are called out in this EMM should be attempted unless the STC holder is contacted and specific written instructions are provided. These instructions must be FAA approved or done in accordance with FAA accepted data specific to the repairs required.

Normal repairs would include paint touch up and sheet metal repairs to nonstructural components done in accordance with generally accepted maintenance practices.