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Service Instruction

Service Instruction Number: HF-SI-2

Date: March 26, 2013

To: All Owners/ Operators of Helifab Bell 206L Series Litter Installation (STC SR09441RC)

Subject: Installation of edge guard to prevent cosmetic damage to litter board edge or prevent deterioration of existing cosmetic damage to litter board edge.

Approval: The engineering aspects of this service instruction are FAA approved.

Compliance Requirements: At owner /operator discretion

Description:

This service instruction is issued to inform the owners / operators of Helifab's Bell 206L Litter Installation (STC SR09441RC) of the procedure to be used in order to install a protective edge guard to the litter board in order to prevent cosmetic damage or deterioration of existing cosmetic damage. To accomplish this modification follow the instructions provided in this service instruction.

Log of Revisions

<i>REV</i>	<i>DATE</i>	<i>DESCRIPTION</i>	<i>PAGES REVISED</i>	<i>PREPARED BY</i>
IR	06/07/2012	Initial Release	1 thru 9	KDS
A	03/26/2013	Added log of revisions sheet. Revise figure 4,5 and 6 to install PN 2200.0039, 2200.0040, and 2200.0041 flush with existing litter board edge. Revise installation instructions 3(g) to install PN 2200.0041 with AMS-S-8802 sealant and 3(c) to trim litter board top skin and edge fill for proper fit of angle PN 2200.0041.	1 thru 10	KDS

Accomplishment Instructions:

- 1) Order Helifab Modification Kit Part Number SI-2-1. This kit consists of:
 - 1 ea PN 2200.0039 (Top Cap)
 - 1 ea PN 2200.0040 (Core Plug)
 - 1ea PN 2200.0041 (Angle)
 - 10 ea PN CR3242-4-3 (Rivet)
 - 3 ea PN MS20426AD4 (Rivet)

- 2) Install top cap (PN 2200.0039) and core plug (PN 2200.0040) as follows:
 - a. Remove two existing rivets as shown in figure 1 and 2 and extend rivet holes completely through the litter board.
 - b. Remove edge filler and core in the core plug (PN 2200.0040) installation area as shown in figure 3. Remove only minimum of core necessary for installation.
 - c. Locate core plug (PN 2200.0040) as shown in figure 4 and match drill existing fastener locations from litter board to core plug.
 - d. Locate top cap (PN 2200.0039) in location shown in figure 5 and match drill existing fastener locations from litter board to top cap. Match drill a third fastener hole through litter board and core plug (PN 2200.0040) using the pre-drilled hole location in the top cap(PN 2200.0039).
 - e. Countersink for rivet installation as shown in figure 5.
 - f. Deburr all parts.
 - g. Remove all dirt and debris from core plug (PN 2200.0040) and top cap (PN 2200.0039) installation area and clean using denatured alcohol.
 - h. Install top cap and core plug using AMS-S-8802 sealant and install 3 ea MS20426AD4 attachment rivets wet. Trim MS20426AD rivets to length required prior to installation.
 - i. Remove any excess sealant.

- 3) Install angle (PN 2200.0041) as follows (angle is optional and installed at discretion of owner / operator):
 - a. Locate angle (PN 2200.0041) and trim length of angle as shown in figure 6.
 - b. Match drill fastener holes from angle to litter board. Drill through only the top skin of litter board using caution not to damage litter board lower skin.
 - c. Trim top skin and edge fill of litter board in angle installation area to allow for angle to fit flush with existing litter board edge (see figure 6). Radius top outboard corner of litter board aluminum skin and formica to match interior radius of angle.
 - d. Abrade the inner side of angle using abrasive paper to produce a roughened finish.
 - e. Deburr all parts.
 - f. Clean angle (PN 2200.0041) and litter board in angle installation area using denatured alcohol.
 - g. Apply thin coating of AMS-S-8802 sealant to mating surface of angle (PN 2200.0041) and install angle to litter board using CR3242-4 rivets.
 - h. Blend transition area between core plug/ top cap and angle as necessary to remove any sharp edges.
 - i. Permanently mark litter board with indelible ink or placard that states "Modified in accordance with HF-SI-2" (see figure 7).
 - j. Seal edges of installed angle, cap and core plug with AMS-S-8802 sealant to produce a smooth surface and refinish as required.

Figure 1
Litter Board, Existing Rivet Removal
(View looking Down)

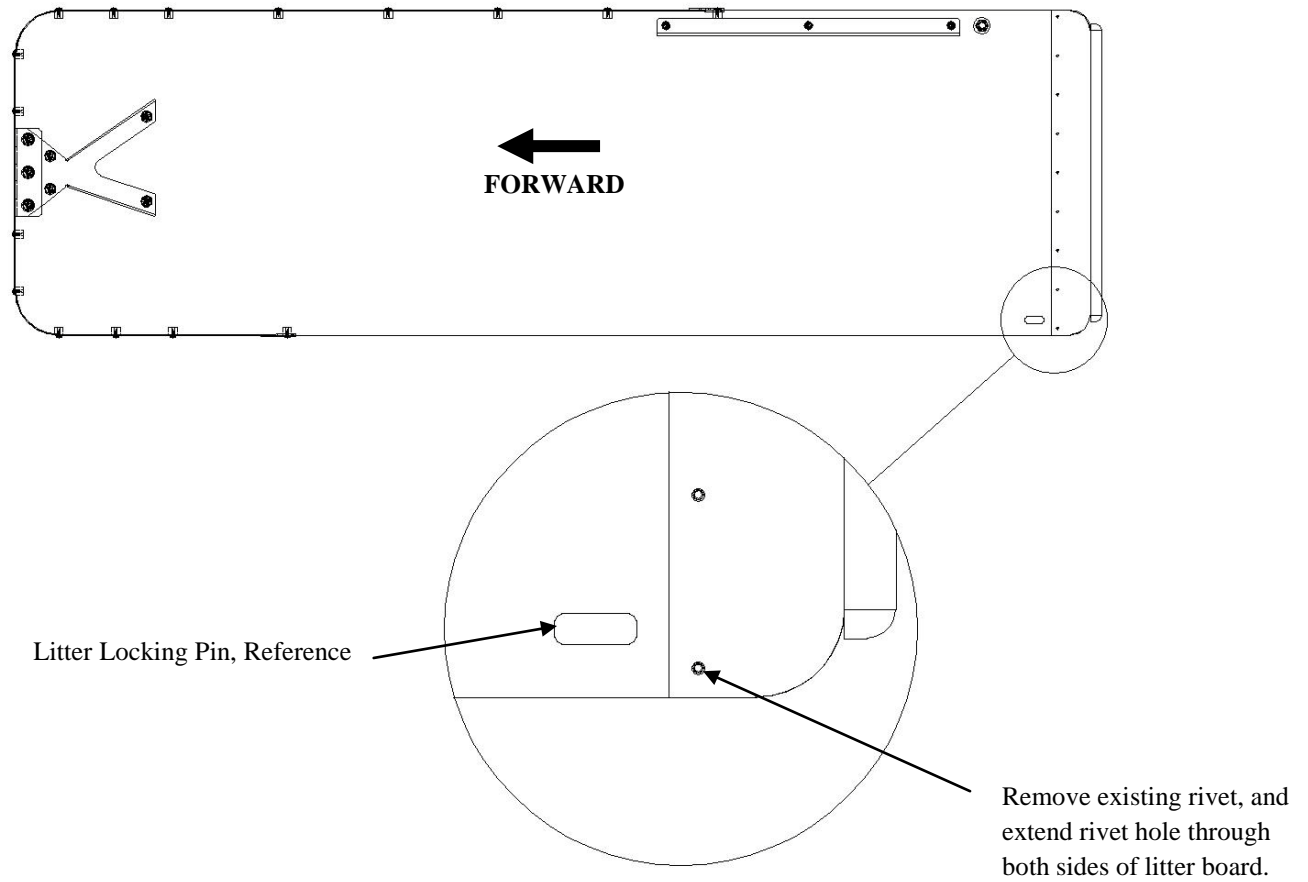


Figure 2
Litter Board, Existing Rivet Removal
(View looking Up)

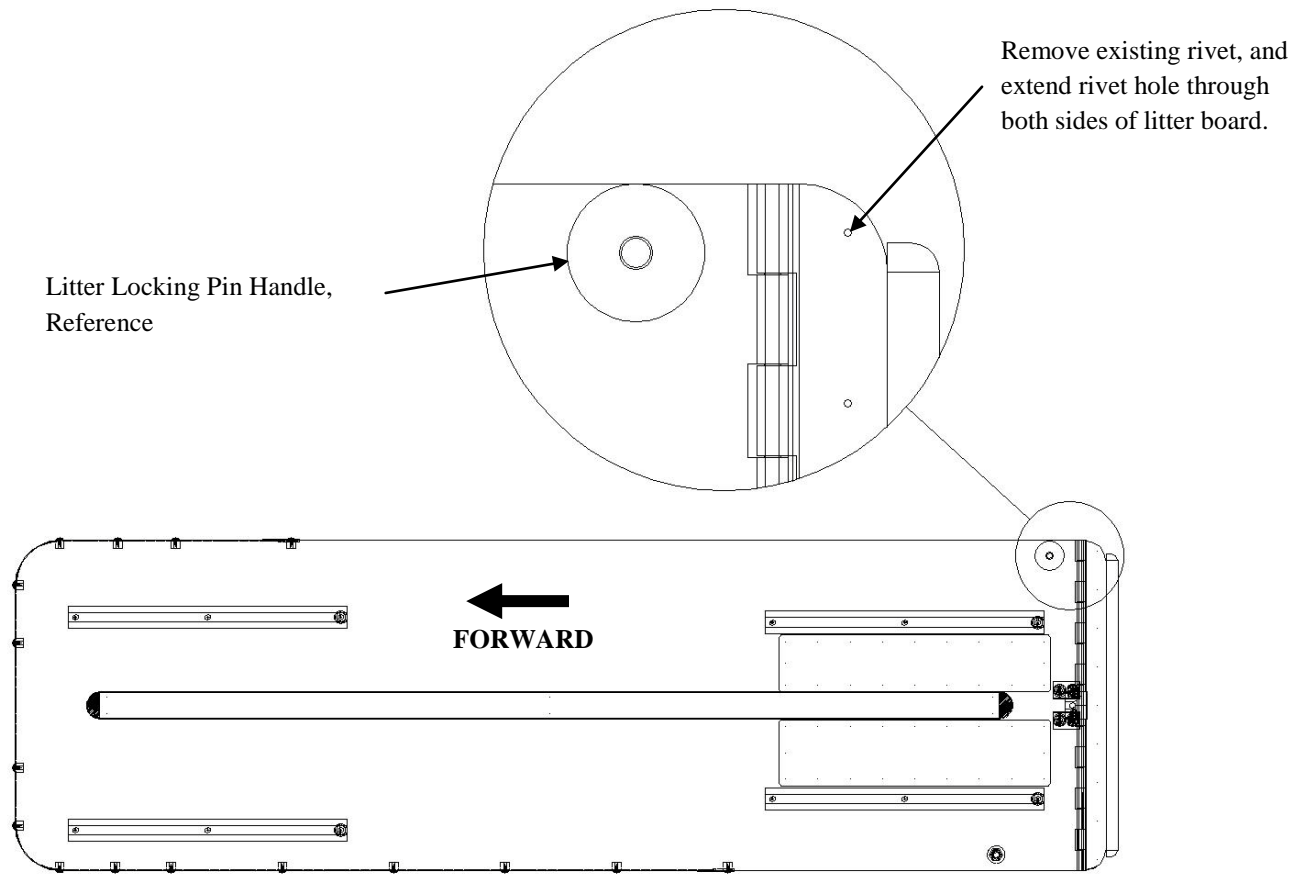
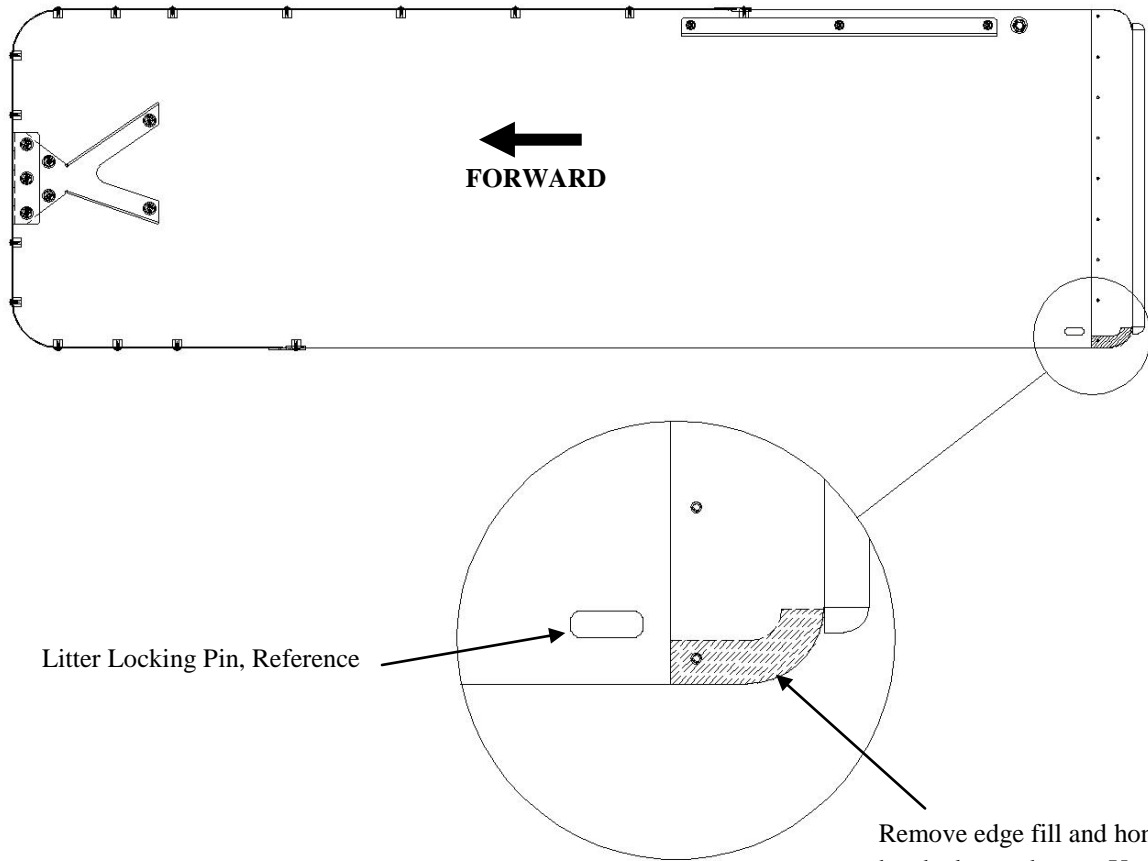


Figure 3
Litter Board, Core Removal
(View Looking Down)



Remove edge fill and honeycomb core in hatched area shown. Use core plug as a reference for depth of core to remove. Remove only minimum core necessary.

Figure 4
Litter Board, Core Plug Installation
(View Looking Down)

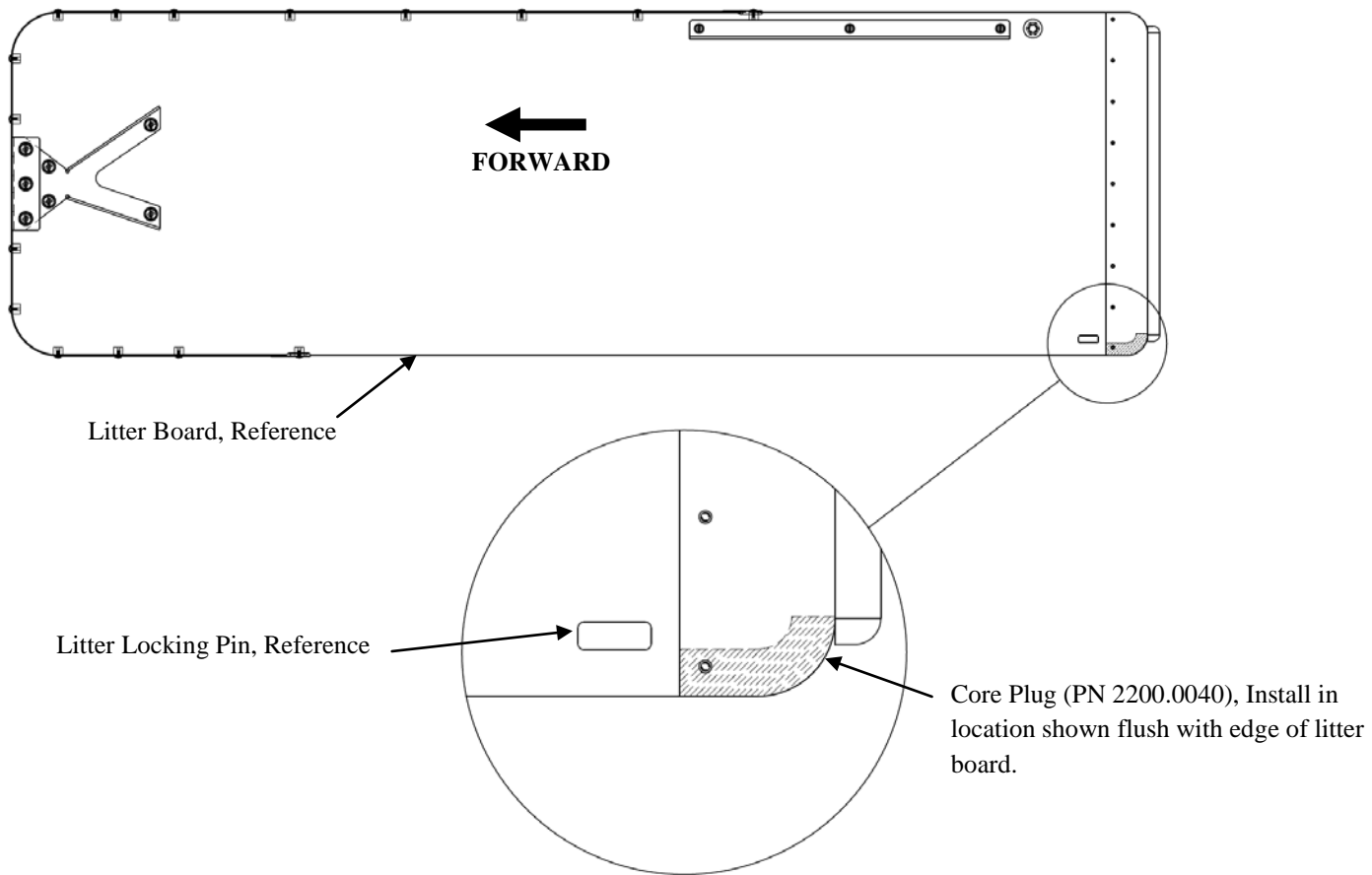
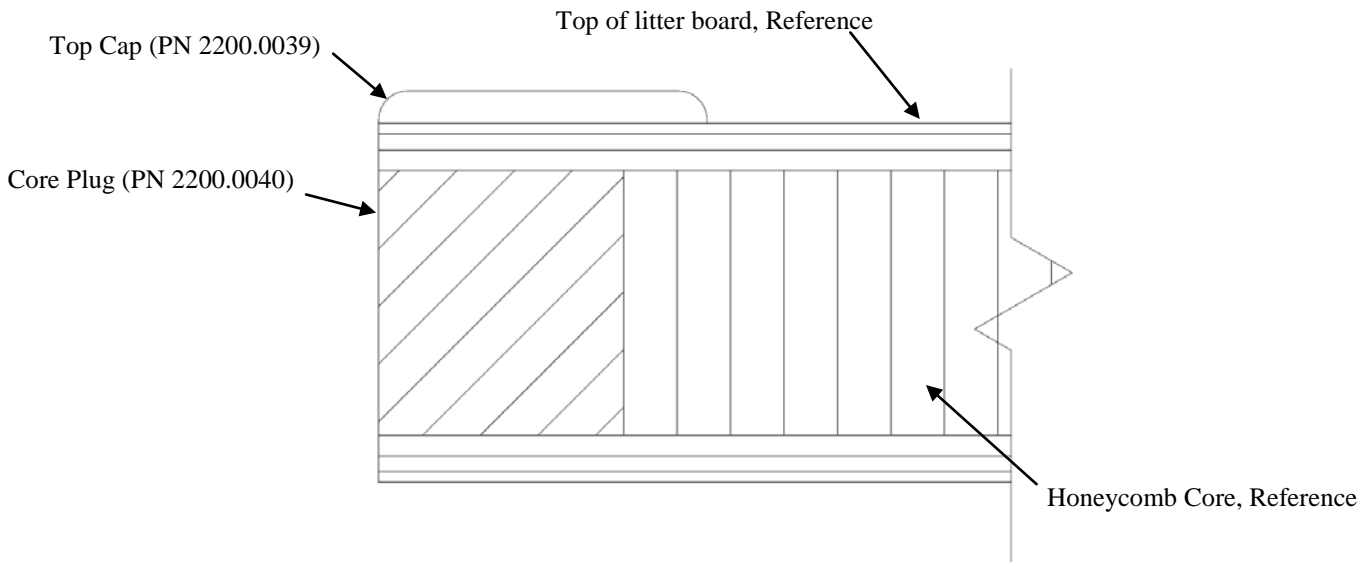
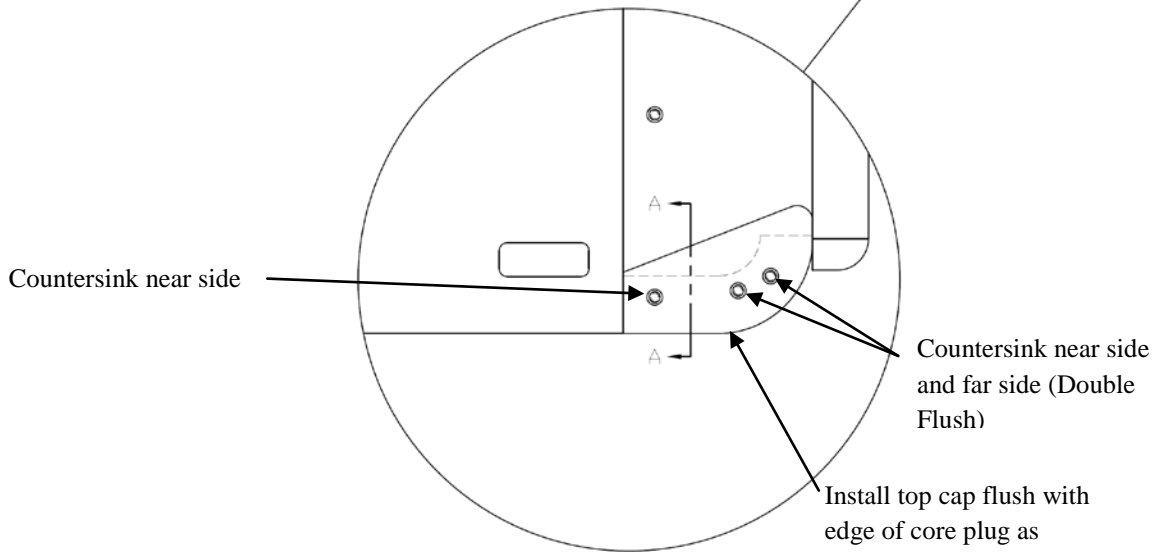
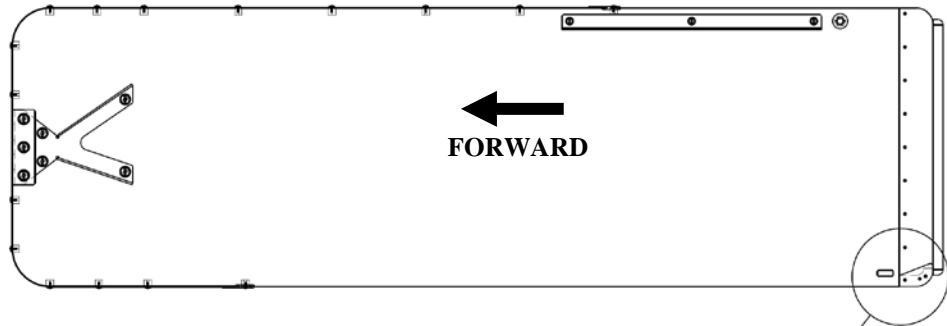


Figure 5
Litter Board, Core Plug and Top Cap Installation
 (View Looking Down)



Section A-A

Trim top skin and edge fill of litter board in angle (PN 2200.0041) installation area to allow angle to fit flush with existing litter board edge (trim to be maximum of 0.060" depth). Radius top edge of litter board aluminum skin and formica to match interior radius of angle.

Figure 6
Litter Board, Angle Installation
 (View Looking Down)

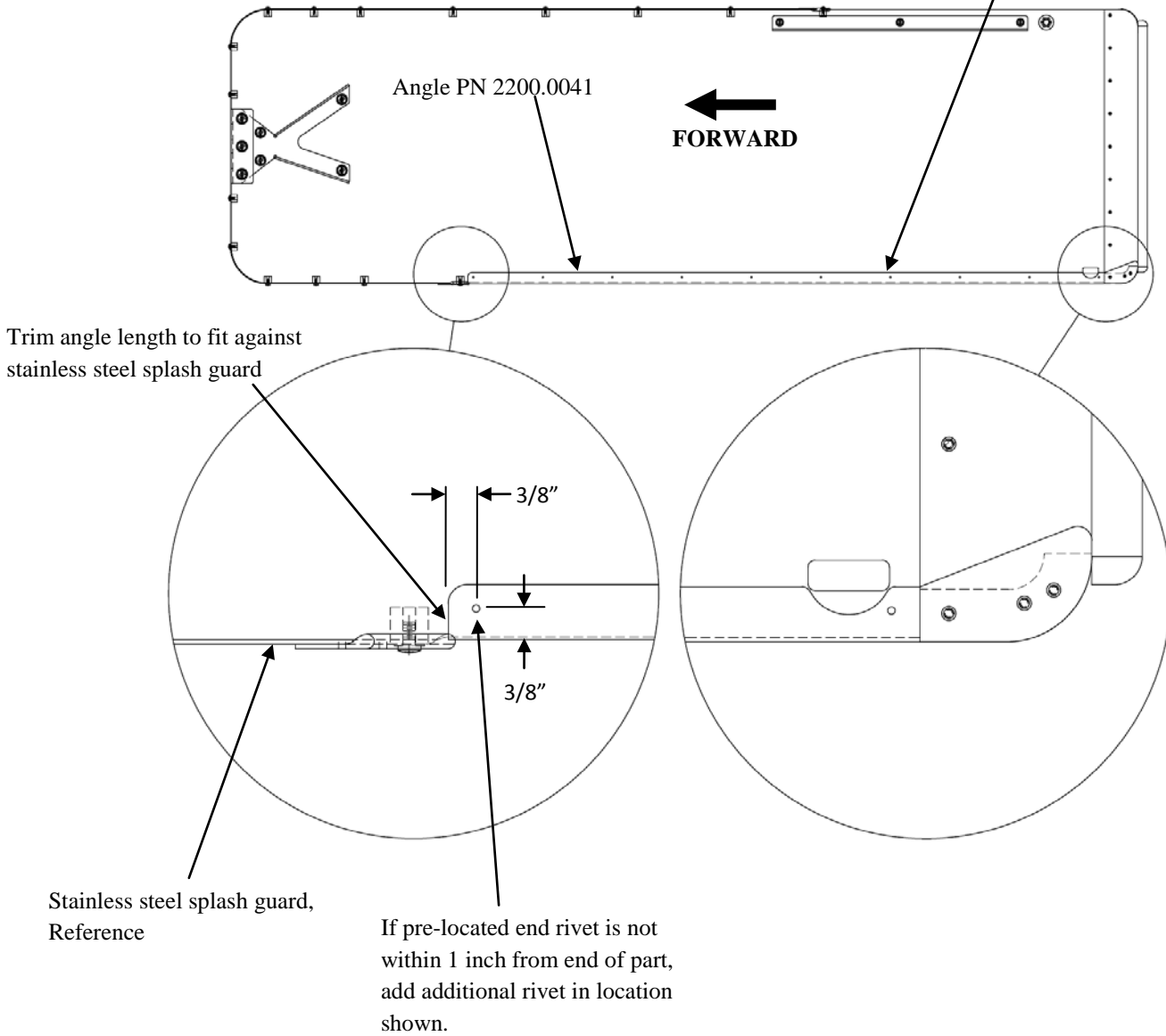
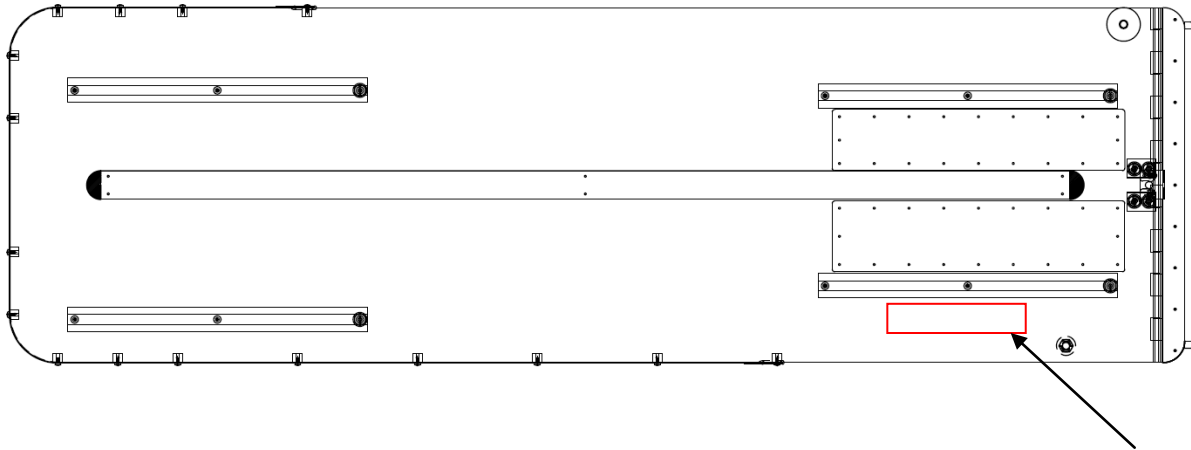


Figure 7
Litter Board, Marking
(View Looking Down)



Add "Modified in
accordance with HF-FI-2".
Mark in location shown.