



AERONAUTICAL ACCESSORIES, INC.

P.O. BOX 3689 BRISTOL, TENNESSEE 37625-3689 USA
TELEPHONE: 423-538-5151 TOLL FREE: 800-251-7094
TELEFAX: 423-538-8469 E-MAIL: sales@aero-access.com
techsupport@aero-access.com

INSTRUCTIONS for CONTINUED AIRWORTHINESS for SKID TUBES

STC: SH2941SO-D
STC: SH2804SO-D
STC: SR09532RC-D

FOR
BELL HELICOPTER TEXTRON MODEL 206L, 206L-1, 206L-3 AND 206L-4 HELICOPTERS

Report Number AA-01145

Revision E

October 5, 2010



RESTRICTED DISCLOSURE NOTICE

THE DRAWINGS, SPECIFICATIONS, DESCRIPTIONS, AND OTHER TECHNICAL DATA ATTACHED HERETO ARE PROPRIETARY AND CONFIDENTIAL TO AERONAUTICAL ACCESSORIES, INC., AND CONSTITUTE TRADE SECRETS FOR PURPOSES OF THE TRADE SECRET AND FREEDOM OF INFORMATION ACTS. NO DISCLOSURE TO OTHERS, EITHER IN THE UNITED STATES OR ABROAD, OR REPRODUCTION OF ANY PART OF THE INFORMATION SUPPLIED IS TO BE MADE, AND NO MANUFACTURE, SALE OR USE OF ANY INVENTION OR DISCOVERY DISCLOSED HEREIN SHALL BE MADE, EXCEPT BY WRITTEN AUTHORIZATION OF AERONAUTICAL ACCESSORIES, INC. THIS NOTICE WILL NOT OPERATE TO NULLIFY OR LIMIT RIGHTS GRANTED BY CONTRACT. THE DATA SUBJECT TO THIS RESTRICTION IS CONTAINED IN ALL SHEETS AND IS DISCLOSED TO PERSONNEL OF AERONAUTICAL ACCESSORIES, INC., FOR THE PURPOSE(S) OF INTERNAL USE AND DISTRIBUTION ONLY.

© (2010) Aeronautical Accessories, Inc.

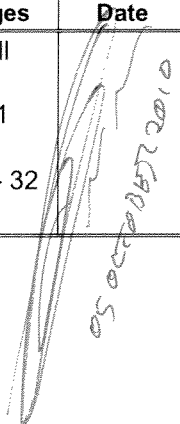
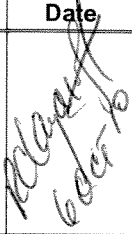
UNPUBLISHED - ALL RIGHTS RESERVED

AERONAUTICAL ACCESSORIES, INC.

LOG OF REVISIONS

Date	Revision	Description	Affected Pages	Approved / Date	Accepted / Date
08/24/01	-	Original Release	All	—	—
03/27/03	A	Revised 5.2 title, and 5.4 title Revised 12.0 Parts Breakdown Table 4, 5, and 6 Revised 12.0 Parts Breakdown Table 4, 5, and 6	14, 15 16 17-19	—	—
05/25/06	B	Reformatted Document Revised Section 1.0, Introduction Revised Section 1.1, Distribution Added Section 2.1, Skid Tubes Provisioned for Tri-Bag Float Systems Revised Section 3.1, 100 Hour / 6 Month Inspection Revised section 3.2, Repair Added Section 5.5, Removal – Saddles Added Section 5.6, Installation – Saddles Added Section 5.7, Removal – Plug Added Section 5.8, Installation – Plug Added Section 5.9, Removal – Cover (Cap) Added Section 5.10, Installation – Cover (Cap) Revised Section 10.0, Weight and Balance Revised, reorganized Section 12, Parts Breakdown Revised Figures 1 thru 4 Revised Appendix A, Inspection Record	All 7 7 7 7-8 9-10 13 13 13 14 14 14 15 16-31 32-35 36-37	—	—
09/21/07	C	Deleted Table 1, Damage and Repair Limits Revised AMS-S-8802 to AMS-S-8802, Type 2, Class B Revised MIL-PRF-23377 to MIL-PRF-23377, Type I, Class C2 Added Section 3.1.1, Damage and Repair Limits Revised, reorganized Section 3.2, Repair Revised Table 4, Troubleshooting Revised Section 5.5, Removal – Saddles Revised Table 5 skid tube applicability from Low Gear to Low Gear or High Gear Revised Figure 1, Skid Tube Damage and Repair Limits Revised Figure 2, Typical Repair Instruction Revised Figure 3, Skid Shoe Attachment for 206-325 Series Skid Tubes, Low Gear or High Gear Revised Figure 4, Skid Shoe Attachment for 206-324 Series Skid Tubes, Float Gear Revised Table 5 skid tube applicability from Low Gear to Low Gear or High Gear	- 8, 10, 12, 13, 14 9, 10, 13, 14 8 9 – 11 11 13 19 – 20 32 33 34 35 -	—	—
11/21/08	D	Revised Section 1.0, Introduction Revised Section 2.1, Skid Tubes Provisioned for Emergency Floatation Systems Added STC applicability to Section 12, Table 4 thru Table 11	7 7 17 – 31	—	—

LOG OF REVISIONS

Date	Revision	Description	Affected Pages	Approved / Date	Accepted / Date
10/05/10	E	Revised document format, revised Log of Revisions, Table of Contents, List of Tables, List of Figures format Corrected metric equivalent measurements, Section 3.1.1 step 1.c and step 5.c Revised titles of Table 4 thru Table 11 to improve usability	All 11 20 – 32	 05 OCT 2010	 6 OCT 10

LIST OF EFFECTIVE PAGES

All pages contained herein are at latest revision shown in Log of Revisions.

LIST OF EFFECTIVE PAGES

1 – 39

TABLE OF CONTENTS

<u>Identification</u>	<u>Title</u>	<u>Page</u>
1.0	INTRODUCTION.....	9
1.1	DISTRIBUTION.....	9
1.2	REVISION.....	9
2.0	DESCRIPTION.....	9
2.1	SKID TUBES PROVISIONED FOR EMERGENCY FLOATATION SYSTEMS..	9
3.0	MAINTENANCE INSTRUCTIONS.....	10
3.1	100 HOUR / 6 MONTH INSPECTION.....	10
3.1.1	DAMAGE AND REPAIR LIMITS.....	11
3.2	REPAIR.....	12
3.2.1	CORROSION REPAIR.....	12
3.2.2	SKID TUBE REPAIR.....	12
3.2.3	SKID SHOE REPAIR.....	13
3.2.4	WINGWALK REPAIR.....	13
3.3	CLEANING REQUIREMENTS.....	13
3.4	ADJUSTMENTS.....	14
4.0	TROUBLESHOOTING INFORMATION.....	14
5.0	REMOVAL AND REPLACEMENT INFORMATION.....	15
5.1	REMOVAL – SKID TUBES.....	15
5.2	INSTALLATION – SKID TUBES.....	15
5.3	REMOVAL – SKID SHOES.....	15
5.4	INSTALLATION – SKID SHOES.....	15
5.5	REMOVAL – SADDLES.....	15
5.6	INSTALLATION – SADDLES.....	16
5.7	REMOVAL – PLUG.....	16
5.8	INSTALLATION – PLUG.....	17
5.9	REMOVAL – COVER (CAP).....	17
5.10	INSTALLATION – COVER (CAP).....	17
6.0	STRUCTURAL FASTENER DATA.....	18
7.0	SPECIAL TOOLS NEEDED.....	18
8.0	RECOMMENDED OVERHAUL PERIODS.....	18
9.0	AIRWORTHINESS LIMITATIONS.....	18
10.0	WEIGHT AND BALANCE.....	18
11.0	PARTS BREAKDOWN.....	19
APPENDIX A		38

LIST OF TABLES

<u>List of Tables</u>	<u>Title</u>	<u>Page</u>
TABLE 1.	DELETED	11
TABLE 2.	TORQUE VALUES	14
TABLE 3.	TROUBLESHOOTING	14
TABLE 4.	PARTS BREAKDOWN, 206-325-00X SERIES, LOW GEAR SKID TUBES ⁽¹⁾ 206-325-003 (L/H) / 206-325-004 (R/H) SKID TUBE ASSEMBLY	20
TABLE 5.	PARTS BREAKDOWN, 206-325-2XX SERIES, LOW OR HIGH GEAR // 206-325-3XX SERIES, HIGH GEAR SKID TUBES ⁽¹⁾ 206-325-201 / 206-325-301 (L/H) // 206-325-202 / 206-325-302 (R/H) SKID TUBE ASSEMBLY	22
TABLE 6.	PARTS BREAKDOWN, 206-323-00X SERIES, HIGH GEAR SKID TUBES ⁽¹⁾ 206-323-003 (L/H) / 206-323-004 (R/H) SKID TUBE ASSEMBLY	24
TABLE 7.	PARTS BREAKDOWN, 206-323-2XX / 206-323-3XX SERIES, HIGH GEAR SKID TUBES ⁽¹⁾ 206-323-211 / 206-323-301 (L/H) // 206-323-212 / 206-323-302 (R/H) SKID TUBE ASSEMBLY	25
TABLE 8.	PARTS BREAKDOWN, 206-324-00X SERIES, FLOAT GEAR SKID TUBES 206-324-003 / 206-324-005 / 206-324-007 / (L/H) // 206-324-004 / 206-324-006 / 206-324-008 (R/H) SKID TUBE ASSEMBLY	26
TABLE 9.	PARTS BREAKDOWN, 206-324-2XX SERIES, FLOAT GEAR SKID TUBES 206-324-257 / 206-324-259 (L/H) / 206-324-258 / 206-324-260 (R/H) SKID TUBE ASSEMBLY	28
TABLE 10.	PARTS BREAKDOWN, 206-324-3XX SERIES, FLOAT GEAR SKID TUBES 206-324-307 / 206-324-309 (L/H) // 206-324-308 / 206-324-310 (R/H) SKID TUBE ASSEMBLY ⁽¹⁾ 206-324-357 / 206-324-359 (L/H) // 206-324-358 / 206-324-360 (R/H) SKID TUBE ASSEMBLY ⁽²⁾	30
TABLE 11.	PARTS BREAKDOWN, 206-324-4XX SERIES, FLOAT GEAR SKID TUBES ⁽¹⁾ 206-324-457 / 206-324-459 (L/H) // 206-324-458 / 206-324-460 (R/H) SKID TUBE ASSEMBLY	32

LIST OF FIGURES

<u>List of Figures</u>	<u>Title</u>	<u>Page</u>
FIGURE 1.	SKID TUBE DAMAGE AND REPAIR ZONES	34
FIGURE 2.	TYPICAL REPAIR INSTRUCTION	35
FIGURE 3.	SKID SHOE ATTACHMENT FOR 206-325 SERIES SKID TUBES, LOW GEAR OR HIGH GEAR.....	36
FIGURE 4.	SKID SHOE ATTACHMENT FOR 206-324 SERIES SKID TUBES, FLOAT GEAR	37

1.0 INTRODUCTION

These instructions contain the information necessary for inspection and maintenance of **AERONAUTICAL ACCESSORIES, INC. SKID TUBES** installed on Bell Helicopter Textron model 206L, 206L-1, 206L-3 and 206L-4 helicopters with high, low, or emergency lightweight floatation landing gear assemblies. See part number-applicable Parts Breakdown Table for applicable STC number(s).

1.1 DISTRIBUTION

These instructions are provided with each Skid Tube. Any airworthiness or flight safety revisions will be immediately made available to all affected Skid Tube owners.

1.2 REVISION

A Log of Revision section is included in these instructions and will be utilized to document all changes. Change recommendations should be submitted to:

Aeronautical Accessories Inc.
P.O. Box 3689
Bristol, TN 37625-3689

2.0 DESCRIPTION

The Aeronautical Accessories, Inc. 206L-series Skid Tubes are complete assemblies, which include Saddles. The Skid Tubes are designed to provide an interface between the Landing Gear Crosstubes and the ground, evenly distributing the weight of the helicopter while at rest.

2.1 SKID TUBES PROVISIONED FOR EMERGENCY FLOATATION SYSTEMS

NOTE

Skid tubes P/N 206-325-xxx and 206-323-xxx may not be installed in conjunction with emergency floatation systems.

Skid Tubes P/N 206-324-xxx are provisioned for emergency floatation systems, and are approved ONLY for installation in conjunction with emergency floatation systems.

Installation of Skid Tubes 206-324-357 (L/H), 206-324-358 (R/H), 206-324-359 (L/H), 206-324-360 (R/H), provisioned for Tri-Bag Float Systems, require installation of STC SR01535LA (Apical Industries).

3.0 MAINTENANCE INSTRUCTIONS

3.1 100 HOUR / 6 MONTH INSPECTION

The Skid Tubes shall receive a 100-hour or a 6-month inspection whichever comes first. Inspection may be incorporated into progressive maintenance programs, as appropriate. The inspection shall consist of the following items.

NOTE

Removal of Skid Tubes from the helicopter is not required for inspection. If any damage is noted during the inspection, refer to Section 3.2, Repair.

NOTE

Particular care should be taken to inspect in the areas of the fasteners in the Skid Tubes and all attaching components.

NOTE

The indications of corrosion are 1) corrosion deposits (a white or gray powder on aluminum), 2) pits in the aluminum surface, 3) blisters, bulging, or flaking of protective coatings.

1. Inspect the skid tubes for scratches, nicks, dents, and corrosion. Refer to Section 3.1.1 for damage and repair limits and to Figure 1 for damage and repair zones. Only one damage rework is permissible per zone. If the damage limits are exceeded, the skid tube must be replaced.
2. Visually inspect the Skid Shoes for damage. Refer to Section 3.2.3 for repair instructions.
3. Inspect the wingwalk coating on the top 1/3 of each skid tube. Refer to Section 3.2.4 for repair instructions.

3.1.1 DAMAGE AND REPAIR LIMITS

Refer to Figure 1 for repair zones.

NOTE

Skid tubes with dents and holes measuring greater than 2" (50.8mm) in diameter shall be scrapped.

1. Skid tube damage within the following limits do not require repair, but should be cleaned per Section 3.2.1.
 - a. Circumferential scratches, scuffs, and nicks not exceeding $\frac{1}{4}$ tube circumference and less than 0.015" (0.38mm) depth in Zone A or 0.030" (0.76mm) depth in Zone B.
 - b. Longitudinal scratches, scuffs, and nicks of any length and depth not exceeding 0.015" (0.38mm) in Zone A or 0.030" (0.76mm) in Zone B.
 - c. Dents not exceeding 1.0" (25.4mm) diameter and less than 0.025" (0.64mm) depth in Zone A or 0.050" (1.27mm) depth in Zone B.
 - d. Corrosion damage not exceeding 0.015" (0.38mm) depth in Zone A or 0.030" (0.76mm) depth in Zone B with a total area less than $\frac{1}{4}$ tube circumference by 3.0" (76.2mm) length after cleanup. When removing corrosion, check hidden areas for pockets of corrosion.
2. Skid tubes with damage (scratches, scuffs, nicks, and dents) exceeding the limits of 1.a thru 1.d above and within 4.5" (114mm) of crosstube saddles shall be scrapped.
3. Skid tube damage (scratches, scuffs, nicks, and dents of any depth/length) in Zone C do not require repair, but should be cleaned per Section 3.2.1.
4. Skid tube damage (holes) in Zone C shall be sealed to prevent moisture from entering tube with sealant (AMS-S-8802, Type 2, Class B) and cleaned per Section 3.2.1.
5. Skid tube damage within the following repairable limits shall be repaired per Section 3.2.2.
 - a. Circumferential scratches, scuffs, and nicks not exceeding $\frac{1}{4}$ tube circumference and greater than 0.015" (0.38mm) depth in Zone A or 0.030" (0.76mm) depth in Zone B.
 - b. Longitudinal scratches, scuffs, and nicks of any length and greater than 0.015" (0.38mm) depth in Zone A or 0.030" (0.76mm) depth in Zone B.
 - c. Dents not exceeding 2.0" (50.8mm) diameter, but exceeding 1.0" (25.4mm) diameter and/or 0.025" (0.64mm) depth in Zone A or 0.050" (1.27mm) depth in Zone B.
 - d. Holes not exceeding 2.0" (50.8mm) diameter through only one tube surface in Zone A or B.

**TABLE 1. DELETED
AERONAUTICAL ACCESSORIES, INC.**

3.2 REPAIR

3.2.1 CORROSION REPAIR

Repair slight damage or light corrosion as follows:

1. Remove scratches, scuffs, nicks or corrosion by sanding or polishing.
2. Apply one coat of Epoxy Polyamide Primer per MIL-PRF-23377, Type I, Class C2 or equivalent to the affected skid tube area.
3. Paint the reworked area to match the rest of the tube and apply two coats of wingwalk to appropriate areas.

3.2.2 SKID TUBE REPAIR

Repair damage to the skid tube as follows:

NOTE

Repairs are only allowed on top of the skid tube. (See Figure 2.)

1. Prepare the damaged region for repair. Do not reshape or cut out smooth dents. Deburr all holes and remove scratches, scuffs, nicks or corrosion by sanding and polishing. Do not exceed the damage limits listed in Section 3.1.1 after completion of repair procedure. If the repaired region exceeds the damage limits the tube must be replaced.
2. Construct a repair large enough to cover the affected area and the rivet rows indicated in Figure 2. Form the repair to the shape of the skid tube. Repairs may extend to the edge of the skid shoes but no further around the tube, as patches are not permitted on the bottom of the tube.
Repair Material: .090" thick, 7075-T6 per AMS-QQ-A-250/12 Aluminum sheet or equivalent.
3. Clamp the repair in place and lay out the rivet patterns per Figure 2. Match drill (#10 drill) the rivet holes. Cleco's may aid as drilling progresses.
4. Remove the repair and deburr all holes. Clean the repair material and the area of the tube to be repaired of paint and dirt.
5. Apply one coat of Epoxy Polyamide Primer per MIL-PRF-23377, Type I, Class C2 or equivalent to the affected skid tube area and all surfaces of the repair.
6. Coat the surfaces with sealant (AMS-S-8802, Type 2, Class B). Position the repair in place and secure with rivets (CR3212-4-XX).
7. Paint the reworked area to match the rest of the tube and apply two coats of wingwalk to appropriate areas. Refer to Section 3.2.4 for wingwalk application procedures.

3.2.3 SKID SHOE REPAIR

Repair skid shoe damage as follows:

1. Replace damaged or loose NMTR10 inserts in 206-325 series skid gear per Figure 3. Wet install inserts with sealant (AMS-S-8802, Type 2, Class B).
2. Replace damaged or loose inserts in 206-323 series skid gear (NMTR10-230L or equivalent, use MS27039-1-12 screw and NAS1149F0332J washer). Wet install inserts with sealant (AMS-S-8802, Type 2, Class B).
3. Replace damaged or loose NMTR10 inserts or NAS1330 rivnuts in 206-324 series float gear per Figure 4. Wet install inserts/rivnuts with sealant (AMS-S-8802, Type 2, Class B).
4. Dents may be repaired by cold forming or hot reforming with an acetylene torch only if the borium weld beads on the bottom of the shoes are free from damage. Do not use skid shoes with weld bead damage.

CAUTION

Prior to welding repairs, remove the Skid Shoe from the Skid Tube to avoid damage to the aluminum Skid Tube from excessive heat.

3.2.4 WINGWALK REPAIR

Repair wingwalk coating as follows:

1. Clean the area to be repaired by lightly sanding with abrasive cloth or paper and dry with a clean cloth.
2. Mask the area not to receive wingwalk coating.
3. Apply wingwalk to the needed area. Allow a minimum of 30 minutes drying time between coats. The first coat shall be a light coat, and the second coat shall be a heavy cross coat.
4. Remove masking paper when process is finished.

3.3 CLEANING REQUIREMENTS

Any dirt, sand, or debris should be cleaned from the Skid Tubes using a mild, nonabrasive soap. Wipe surfaces dry with a nonabrasive cloth or paper before cleaning agent evaporates.

3.4 ADJUSTMENTS

Adjustments to the Skid Tubes are not required. Apply the following torque to all noted fasteners during component or fastener replacement (torque all fasteners in accordance with Table 2):

1. Torque the fasteners attaching the Skid Shoe to the Skid Tube (10 Fastener Size).
2. Torque the fasteners attaching the Saddles to the Crosstubes (5/16 Fastener Size).

TABLE 2. TORQUE VALUES

Fastener Size	Torque (In-Lbs)
10	20 – 25
5/16	100 – 140

4.0 TROUBLESHOOTING INFORMATION

TABLE 3. TROUBLESHOOTING

Problem	Probable Cause	Remedy
Landing Gear / Skid Tube is loose or has excessive vibration.	Attachment components or fasteners loose, damaged, or missing.	Check security of skid tube attachment components. Check torque on all fasteners according to Section 3.4.
	Skid Tube is damaged allowing movement.	Check Skid Tube for cracks or other damage in accordance with Section 3.1. Repair and replace as needed.

5.0 REMOVAL AND REPLACEMENT INFORMATION

5.1 REMOVAL – SKID TUBES

1. Hoist or jack the helicopter until no weight is on the skid tubes.
2. Remove all attaching hardware from the forward and aft saddles.
3. Remove skid tubes from the forward and aft crosstubes.

NOTE

The use of heat may be needed to remove the skid tube from the crosstube as desired.

5.2 INSTALLATION – SKID TUBES

1. Hoist or jack the helicopter until there is sufficient space under the fuselage to place the skid tubes.
2. Place the skid tubes to fit the forward and aft crosstubes.
3. Apply sealant (AMS-S-8802, Type 2, Class B) under each screw head.
4. Before tightening, ensure screws are in place and threads have engaged. Torque all screws attaching crosstubes to saddles to 100 – 140 in-lbs.
5. Lower helicopter to ground.
6. Apply a fillet of sealant (AMS-S-8802, Type 2, Class B) around the top edge of the saddles.

5.3 REMOVAL – SKID SHOES

1. Hoist or jack the helicopter until no weight is on the skid tubes.
2. Remove all attaching hardware from the skid shoes.
3. Remove the skid shoes.

5.4 INSTALLATION – SKID SHOES

(Refer to Figures 3 and 4)

1. Clean the surface of the skid tube as to remove dirt and old sealant. Apply a ¼ inch bead of sealant (AMS-S-8802, Type 2, Class B) around the perimeter of the skid shoe and fasten in place with the existing screws and washers. Torque fasteners 20 – 25 in-lbs (Refer to Table 2).
2. Apply sealant (AMS-S-8802, Type 2, Class B) to the edge of the skid shoe to form a fillet between the shoe and the tube. Remove excess sealant.

5.5 REMOVAL – SADDLES

NOTE

If removing both forward and aft saddles, remove and install one at a time.

1. Remove skid tubes from helicopter per Section 5.1.
2. Drill out the rivets attaching the saddle to the skid tube.

3. Remove the saddle.

NOTE

The use of heat may be needed to remove the saddle from the skid tube as desired.

5.6 INSTALLATION – SADDLES

1. Clean the surface of the skid tube as to remove dirt and old sealant.
2. Position the saddle on the skid tube. Using the non-removed saddle to obtain proper angular alignment, match drill existing rivet holes from the skid tube to the saddle. Ensure proper rivet hole edge distance.
3. Deburr and apply coat of primer per MIL-PRF-23377, Type I, Class C2 to rivet holes in saddle.
4. Apply ¼ inch bead of sealant (AMS-S-8802, Type 2, Class B) around the perimeter of the saddle.
5. Wet install rivets with sealant (AMS-S-8802, Type 2, Class B).
6. Apply sealant (AMS-S-8802, Type 2, Class B) to the edge of the saddle to form a fillet between the saddle and the tube. Remove excess sealant.

5.7 REMOVAL – PLUG

1. Hoist or jack the helicopter until no weight is on the skid tubes and there is sufficient space under the skid tube to remove the plug.
2. Remove all attaching hardware from the plug.
3. Remove the plug from the skid tube.

NOTE

The use of heat may be needed to remove the plug from the skid tube as desired.

5.8 INSTALLATION – PLUG

1. If required, hoist or jack the helicopter until no weight is on the skid tubes and there is sufficient space under the skid tube to install the plug.
2. Slide the plug into the skid tube one inch. Match drill the plug to the skid tube.
3. Deburr and apply coat of primer per MIL-PRF-23377, Type I, Class C2 to rivet holes in plug.
4. Apply ¼ inch bead of sealant (AMS-S-8802, Type 2, Class B) around the outside edge of the plug.
5. Wet install rivets with sealant (AMS-S-8802, Type 2, Class B).
6. Apply sealant (AMS-S-8802, Type 2, Class B) to the edge of the plug to form a fillet between the plug and the tube. Remove excess sealant.

5.9 REMOVAL – COVER (CAP)

1. Remove all attaching hardware from the cover (cap).
2. Remove the cover from the skid tube.

NOTE

The use of heat may be needed to remove the cover (cap) from the skid tube as desired.

5.10 INSTALLATION – COVER (CAP)

1. Place the cover (cap) over the end of the skid tube.
2. If installing new cover (cap), match drill the cover (cap) to the skid tube, if installing previously removed cover (cap) skip to step 3. Trim cover (cap) to be the same size as the end of the skid tube.
3. Deburr and apply coat of primer per MIL-PRF-23377, Type I, Class C2 to rivet holes and edge of cover (cap).
4. Apply bead of sealant (AMS-S-8802, Type 2, Class B) around the top of the skid tube.
5. Wet install rivets with sealant (AMS-S-8802, Type 2, Class B). Remove excess sealant.

6.0 STRUCTURAL FASTENER DATA

For hardware identification and torque refer to Tables 2 and 4 thru 11.

7.0 SPECIAL TOOLS NEEDED

Torque Wrench

8.0 RECOMMENDED OVERHAUL PERIODS

No component overhaul required for this type design change.

9.0 AIRWORTHINESS LIMITATIONS

No airworthiness limitations associated with this type design change.

10.0 WEIGHT AND BALANCE

No Change.

INSTRUCTIONS for CONTINUED AIRWORTHINESS SKID TUBES

11.0 PARTS BREAKDOWN

Tables 4 thru 11 contain Parts Breakdown data for Aeronautical Accessories, Inc., Bell Helicopter Textron model 206L series Skid Tubes. Table 4 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-325-00x series Skid Tubes for Low Skid Gear. Table 5 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-325-2xx / -3xx series Skid Tubes for Low or High Skid Gear. Table 6 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-323-00x series Skid Tubes for High Skid Gear. Table 7 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-323-2xx / -3xx series Skid Tubes for High Skid Gear. Table 8 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-324-00x series Skid Tubes for Emergency Lightweight Floatation Landing Gear. Table 9 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-324-2xx series Skid Tubes for Emergency Lightweight Floatation Landing Gear. Table 10 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-324-3xx series Skid Tubes for Emergency Lightweight Floatation Landing Gear. Table 11 contains Parts Breakdown data for Aeronautical Accessories, Inc. 206-324-4xx series Skid Tubes for Emergency Lightweight Floatation Landing Gear.

The column Availability Code (AV Code) specifies the procurement status for each part. The codes to identify if a part is procurable, procedure details to get an assembly or local manufacture code are as follows:

AV Code	Details
0	Nonprocurable part
1	Procurable part
2	Procure as detail parts only
3	Procurable as Next Higher Assembly
4	Local manufacture. Contact AAI Product Support Engineering (PSE)
5	Part replacement requires a fixture or special equipment. Contact AAI PSE
6	Non-stock procurable part

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES**TABLE 4. PARTS BREAKDOWN, 206-325-00X SERIES, LOW GEAR SKID TUBES ⁽¹⁾**
206-325-003 (L/H) / 206-325-004 (R/H) SKID TUBE ASSEMBLY

Qty -003	Qty -004	Part Number	Description	AV Code
1		601-001-107	Skid Tube (L/H)	3
	1	601-001-108	Skid Tube (R/H)	3
1	1	601-007-203	Saddle (Forward) (Alt: 601-007-103)	1
1	1	601-007-205	Saddle (Aft) (Alt: 601-007-105)	1
2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	601-011-015	Washer	1
2	2	601-011-117	Insert Assembly	0
1	1	601-013-003	Fitting (Ground Handling)	1
5	5	601-015-301	Shoe Assembly (Alt: 601-015-201 / 601-015-101)	1
1	1	601-015-303	Shoe Assembly (Alt: 601-015-203 / 601-015-103)	1
1	1	601-015-307	Shoe Assembly (Alt: 601-015-207 / 601-015-107)	1
1	1	601-019-105	Plug	1
1	1	601-021-001	Cover	1
1	1	601-021-011	Clip (L/H)	1
1	1	601-021-012	Clip (R/H)	1
4	4	CR3212-4-3	Rivet	1
3	3	CR3213-4-3	Rivet	1
8	8	CR3213-4-4	Rivet	1
8	8	CR3213-4-5	Rivet	1
4	4	CR3213-4-7	Rivet	1
4	4	MS20426AD4-5	Rivet	1
12	12	MS27039-1-10	Screw (Alt: MS27039-1-09)	1
8	8	MS27039-1-11	Screw (Alt: MS27039-1-10)	1
8	8	MS27039-1-12	Screw (Alt: MS27039-1-11)	1

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES**TABLE 4. PARTS BREAKDOWN, 206-325-00X SERIES, LOW GEAR SKID TUBES ⁽¹⁾**
206-325-003 (L/H) / 206-325-004 (R/H) SKID TUBE ASSEMBLY

Qty -003	Qty -004	Part Number	Description	AV Code
1	1	MS27039-4-06	Screw	1
40	40	MS90354-08-05	Lock Bolt	1
1	1	NAS1149C0463R	Washer	1
1	1	NAS1149D0663J	Washer	1
28	28	NAS1149F0332P	Washer	1
1	1	NAS1149F1063P	Washer	1
12	12	NMTR10-130L	Insert (Alt: H111F365-130)	1
8	8	NMTR10-180L	Insert (Alt: H111F365-180)	1
8	8	NMTR10-230L	Insert (Alt: H111F365-230)	1
1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1

Notes:

1. Low Gear installation in accordance with STC SH2941SO-D

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

**TABLE 5. PARTS BREAKDOWN, 206-325-2XX SERIES, LOW OR HIGH GEAR /
206-325-3XX SERIES, HIGH GEAR SKID TUBES ⁽¹⁾
206-325-201 / 206-325-301 (L/H) // 206-325-202 / 206-325-302 (R/H) SKID TUBE ASSEMBLY**

Qty -201	Qty -202	Qty -301	Qty -302	Part Number	Description	AV Code
1		1		601-001-407	Skid Tube (L/H)	3
	1		1	601-001-408	Skid Tube (R/H)	3
1	1	1	1	601-007-203	Saddle (Forward) (Alt: 601-007-103)	1
1	1	1	1	601-007-205	Saddle (Aft) (Alt: 601-007-105)	1
2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	601-011-015	Washer	1
2	2	2	2	601-011-117	Insert Assembly	0
1	1	1	1	601-013-003	Fitting (Ground Handling)	1
5	5			601-015-301	Shoe Assembly	1
		5	5	601-015-401	Shoe Assembly	1
1	1			601-015-303	Shoe Assembly	1
		1	1	601-015-403	Shoe Assembly	1
1	1			601-015-307	Shoe Assembly	1
		1	1	601-015-407	Shoe Assembly	1
1	1	1	1	601-019-105	Plug	1
1	1	1	1	601-021-001	Cover	1
1	1	1	1	601-021-011	Clip (L/H)	1
1	1	1	1	601-021-012	Clip (R/H)	1
4	4	4	4	CR3212-4-3	Rivet	1
3	3	3	3	CR3213-4-3	Rivet	1
8	8	8	8	CR3213-4-4	Rivet	1
8	8	8	8	CR3213-4-5	Rivet	1
4	4	4	4	CR3213-4-7	Rivet	1
4	4	4	4	MS20426AD4-5	Rivet	1
12	12	12	12	MS27039-1-10	Screw (Alt: MS27039-1-09)	1
8	8	8	8	MS27039-1-11	Screw (Alt: MS27039-1-10)	1
8	8	8	8	MS27039-1-12	Screw (Alt: MS27039-1-11)	1

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

**TABLE 5. PARTS BREAKDOWN, 206-325-2XX SERIES, LOW OR HIGH GEAR /
206-325-3XX SERIES, HIGH GEAR SKID TUBES ⁽¹⁾
206-325-201 / 206-325-301 (L/H) // 206-325-202 / 206-325-302 (R/H) SKID TUBE ASSEMBLY**

Qty -201	Qty -202	Qty -301	Qty -302	Part Number	Description	AV Code
1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	MS90354-08-05	Lock Bolt	1
1	1	1	1	NAS1149C0463R	Washer	1
1	1	1	1	NAS1149D0663J	Washer	1
28	28	28	28	NAS1149F0332P	Washer	1
1	1	1	1	NAS1149F1063P	Washer	1
12	12	12	12	NMTR10-130L	Insert (Alt: H111F365-130)	1
8	8	8	8	NMTR10-180L	Insert (Alt: H111F365-180)	1
8	8	8	8	NMTR10-230L	Insert (Alt: H111F365-230)	1
1	1	1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1

Notes:

- Low Gear installation in accordance with STC SH2941SO-D
High Gear installation in accordance with STC SR09532RC-D

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 6. PARTS BREAKDOWN, 206-323-00X SERIES, HIGH GEAR SKID TUBES ⁽¹⁾
206-323-003 (L/H) / 206-323-004 (R/H) SKID TUBE ASSEMBLY

Qty -003	Qty -004	Part Number	Description	AV Code
1		601-001-105	Skid Tube (L/H)	3
	1	601-001-106	Skid Tube (R/H)	3
1	1	601-007-203	Saddle (Forward) (Alt: 601-007-103)	1
1	1	601-007-205	Saddle (Aft) (Alt: 601-007-105)	1
2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	601-011-015	Washer	1
2	2	601-011-117	Insert Assembly	0
1	1	601-013-003	Fitting (Ground Handling)	1
6	6	601-005-301	Shoe Assembly	1
1	1	601-015-305	Shoe Assembly	1
1	1	601-019-005	Plug	1
1	1	601-021-007	Cap	1
1	1	601-021-009	Clip (L/H)	1
1	1	601-021-010	Clip (R/H)	1
4	4	CR3212-4-4	Rivet	1
3	3	CR3213-4-4	Rivet	1
16	16	CR3213-4-5	Rivet	1
4	4	CR3213-4-7	Rivet	1
4	4	MS20426AD4-5	Rivet	1
38	38	MS27039-1-12	Screw (Alt: MS27039-1-11)	1
1	1	MS27039-4-06	Screw	1
40	40	MS90354-08-05	Lock Bolt	1
1	1	NAS1149C0463R	Washer	1
1	1	NAS1149D0663J	Washer	1
38	38	NAS1149F0332P	Washer	1
1	1	NAS1149F1063P	Washer	1
38	38	NMTR10-230L	Insert (Alt: H111F365-230)	1
1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1
Notes:				
1. High Gear installation in accordance with STC SH2804SO-D				

AERONAUTICAL ACCESSORIES, INC.

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 7. PARTS BREAKDOWN, 206-323-2XX / 206-323-3XX SERIES, HIGH GEAR SKID TUBES ⁽¹⁾
206-323-211 / 206-323-301 (L/H) // 206-323-212 / 206-323-302 (R/H) SKID TUBE ASSEMBLY

Qty -211	Qty -212	Qty -301	Qty -302	Part Number	Description	AV Code
1	1	1		601-001-405	Skid Tube (L/H)	3
	1		1	601-001-406	Skid Tube (R/H)	3
1	1	1	1	601-007-203	Saddle (Forward) (Alt: 601-007-103)	1
1	1	1	1	601-007-205	Saddle (Aft) (Alt: 601-007-105)	1
2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	601-011-015	Washer	1
2	2	2	2	601-011-117	Insert Assembly	0
1	1	1	1	601-013-003	Fitting (Ground Handling)	1
6	6			601-015-301	Shoe Assembly	1
1	1			601-015-305	Shoe Assembly	1
		6	6	601-015-401	Shoe Assembly	1
		1	1	601-015-405	Shoe Assembly	1
1	1	1	1	601-019-005	Plug	1
1	1	1	1	601-021-007	Cap	1
1	1	1	1	601-021-009	Clip (L/H)	1
1	1	1	1	601-021-010	Clip (R/H)	1
4	4	4	4	CR3212-4-4	Rivet	1
3	3	3	3	CR3213-4-4	Rivet	1
16	16	16	16	CR3213-4-5	Rivet	1
4	4	4	4	CR3213-4-7	Rivet	1
4	4	4	4	MS20426AD4-5	Rivet	1
38	38	38	38	MS27039-1-12	Screw (Alt: MS27039-1-11)	1
1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	MS90354-08-05	Lock Bolt	1
1	1	1	1	NAS1149C0463R	Washer	1
1	1	1	1	NAS1149D0663J	Washer	1
38	38	38	38	NAS1149F0332P	Washer	1
1	1	1	1	NAS1149F1063P	Washer	1
38	38	38	38	NMTR10-230L	Insert (Alt: H111F365-230)	1
1	1	1	1	099-050-222	Sealant (CS3204B2, Chemseal) (Alt: 099-050-223)	1

Notes:

1. High Gear installation in accordance with STC SH2804SO-D

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 8. PARTS BREAKDOWN, 206-324-00X SERIES, FLOAT GEAR SKID TUBES
206-324-003 / 206-324-005 / 206-324-007 / (L/H) // 206-324-004 / 206-324-006 / 206-324-008 (R/H)
SKID TUBE ASSEMBLY

Qty -003	Qty -004	Qty -005	Qty -006	Qty -007	Qty -008	Part Number	Description	AV Code
1				1		601-001-111	Skid Tube (L/H)	3
	1				1	601-001-112	Skid Tube (R/H)	3
		1				601-001-113	Skid Tube (L/H)	3
			1			601-001-114	Skid Tube (R/H)	3
1	1					601-007-103	Saddle (Forward)	1
1	1					601-007-105	Saddle (Aft)	1
		1	1	1	1	601-007-203	Saddle (Forward) (Alt: 601-007-103)	1
		1	1	1	1	601-007-205	Saddle (Aft) (Alt: 601-007-105)	1
2	2	2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	2	2	601-011-015	Washer	1
2	2	2	2	2	2	601-011-017	Insert Assembly	0
1	1	1	1	1	1	601-013-003	Fitting (Ground Handling)	1
6	6					601-015-201	Shoe Assembly	1
1	1					601-015-205	Shoe Assembly	1
		6	6	6	6	601-015-301	Shoe Assembly (Alt: 601-015-201)	1
		1	1	1	1	601-015-305	Shoe Assembly (Alt: 601-015-205)	1
		1	1	1	1	601-015-307	Shoe Assembly (Alt: 601-015-207)	1
3	3	3	3	3	3	601-017-007	Doubler	1
1	1	1	1	1	1	601-017-009	Doubler	1
		7	7	7	7	601-017-017	Doubler	1
		1	1	1	1	601-017-019	Doubler	1
1	1					601-019-005	Plug	1
		1	1	1	1	601-019-105	Plug	1
1	1	1	1	1	1	601-021-007	Cap	1
1	1	1	1	1	1	601-021-009	Clip (L/H)	1
1	1	1	1	1	1	601-021-010	Clip (R/H)	1
1	1					AN960-1016	Washer	1
38	38					AN960-10L	Washer	1
1	1					AN960C416	Washer	1

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 8. PARTS BREAKDOWN, 206-324-00X SERIES, FLOAT GEAR SKID TUBES
206-324-003 / 206-324-005 / 206-324-007 / (L/H) // 206-324-004 / 206-324-006 / 206-324-008 (R/H)
SKID TUBE ASSEMBLY

Qty -003	Qty -004	Qty -005	Qty -006	Qty -007	Qty -008	Part Number	Description	AV Code
1	1					AN960JD616	Washer	1
4	4	4	4	4	4	CR3212-4-3	Rivet	1
4	4	3	3	3	3	CR3213-4-3	Rivet	1
16	16	16	16	16	16	CR3213-4-5	Rivet	1
4	4	4	4	4	4	CR3213-4-8	Rivet	1
4	4	4	4	4	4	MS20426AD4-5	Rivet	1
8	8					MS27039-1-09	Screw (Alt: MS27039-1-10)	1
10	10	12	12	12	12	MS27039-1-10	Screw (Alt: MS27039-1-11)	1
20	20	10	10	10	10	MS27039-1-11	Screw (Alt: MS27039-1-12)	1
		20	20	20	20	MS27039-1-12	Screw	1
1	1	1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	40	40	MS90354-08-05	Lock Bolt	1
		1	1	1	1	NAS1149C0463R	Washer (Alt: AN960C416)	1
		1	1	1	1	NAS1149D0663J	Washer (Alt: AN960JD616)	1
		42	42	42	42	NAS1149F0332P	Washer (Alt: AN960-10L)	1
		1	1	1	1	NAS1149F1063P	Washer (Alt: AN960-1016)	1
		4	4			NAS1330H5K256L	Insert	1
16	16	20	20	20	20	NMTR10-130L	Insert (Alt: H111F365-130)	1
34	34	34	34	34	34	NMTR10-180L	Insert (Alt: H111F365-180)	1
44	44	44	44	44	44	NMTR10-230L	Insert (Alt: H111F365-230)	1
1	1	1	1	1	1	890B2-PRC	Proseal	1
1	1	1	1	1	1	EA9309NA	Adhesive	1

Notes:
1. Float Gear installation in accordance with STC SH2804SO-D

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 9. PARTS BREAKDOWN, 206-324-2XX SERIES, FLOAT GEAR SKID TUBES
206-324-257 / 206-324-259 (L/H) / 206-324-258 / 206-324-260 (R/H) SKID TUBE ASSEMBLY

Qty -257	Qty -258	Qty -259	Qty -260	Part Number	Description	AV Code
1				601-001-213	Skid Tube (L/H)	3
	1			601-001-214	Skid Tube (R/H)	3
		1		601-001-211	Skid Tube (L/H)	3
			1	601-001-212	Skid Tube (R/H)	3
1	1	1	1	601-007-203	Saddle (Forward)	1
1	1	1	1	601-007-205	Saddle (Aft)	1
2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	601-011-015	Washer	1
2	2	2	2	601-011-117	Insert Assembly	0
1	1	1	1	601-013-003	Fitting (Ground Handling)	1
6	6	6	6	601-015-301	Shoe Assembly	1
1	1	1	1	601-015-305	Shoe Assembly	1
1	1	1	1	601-015-307	Shoe Assembly	1
3	3	3	3	601-017-007	Doubler	1
7	7	7	7	601-017-017	Doubler	1
1	1	1	1	601-017-019	Doubler	1
1	1	1	1	601-019-105	Plug	1
1	1	1	1	601-021-007	Cap	1
1	1	1	1	601-021-009	Clip (L/H)	1
1	1	1	1	601-021-010	Clip (R/H)	1
4	4	4	4	CR3212-4-3	Rivet	1
3	3	3	3	CR3213-4-3	Rivet	1
16	16	16	16	CR3213-4-5	Rivet	1
4	4	4	4	CR3213-4-8	Rivet	1
4	4	4	4	MS20426AD4-5	Rivet	1
8	8	8	8	MS27039-1-10	Screw	1
10	10	10	10	MS27039-1-11	Screw	1
24	24	24	24	MS27039-1-12	Screw	1
1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	MS90354-08-05	Lock Bolt	1
1	1	1	1	NAS1149C0463R	Washer	1

INSTRUCTIONS for CONTINUED AIRWORTHINESS SKID TUBES

**TABLE 9. PARTS BREAKDOWN, 206-324-2XX SERIES, FLOAT GEAR SKID TUBES
206-324-257 / 206-324-259 (L/H) / 206-324-258 / 206-324-260 (R/H) SKID TUBE ASSEMBLY**

Qty -257	Qty -258	Qty -259	Qty -260	Part Number	Description	AV Code
1	1	1	1	NAS1149D0663J	Washer	1
42	42	42	42	NAS1149F0332P	Washer	1
1	1	1	1	NAS1149F1063P	Washer	1
14	14	14	14	NAS1330H3K116L	Rivnut (Alt: CH10K116L)	1
28	28	28	28	NAS1330H3K166L	Rivnut (Alt: CH10K166L)	1
52	52	52	52	NAS1330H3K216L	Rivnut (Alt: CH10K216L)	1
4	4			NAS1330H5K256L	Rivnut	1
1	1	1	1	099-050-137	Adhesive (EA9309NA)	1
1	1	1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1
Notes:						
1. Float Gear installation in accordance with STC SH2804SO-D						

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

TABLE 10. PARTS BREAKDOWN, 206-324-3XX SERIES, FLOAT GEAR SKID TUBES
206-324-307 / 206-324-309 (L/H) // 206-324-308 / 206-324-310 (R/H) SKID TUBE ASSEMBLY ⁽¹⁾
206-324-357 / 206-324-359 (L/H) // 206-324-358 / 206-324-360 (R/H) SKID TUBE ASSEMBLY ⁽²⁾

Qty -307	Qty -308	Qty -309	Qty -310	Qty -357	Qty -358	Qty -359	Qty -360	Part Number	Description	AV Code
		1						601-001-411	Skid Tube (L/H)	3
			1					601-001-412	Skid Tube (R/H)	3
1								601-001-413	Skid Tube (L/H)	3
	1							601-001-414	Skid Tube (R/H)	3
				1		1		601-001-463	Skid Tube (L/H)	3
					1		1	601-001-464	Skid Tube (R/H)	3
1	1	1	1	1	1	1	1	601-007-203	Saddle (Forward)	1
1	1	1	1	1	1	1	1	601-007-205	Saddle (Aft)	1
2	2	2	2	2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	2	2	2	2	601-011-015	Washer	1
2	2	2	2	2	2	2	2	601-011-117	Insert Assembly	0
1	1	1	1	1	1	1	1	601-013-003	Fitting (Ground Handling)	1
				6	6			601-015-301	Shoe Assembly	1
				1	1			601-015-305	Shoe Assembly	1
				1	1			601-015-307	Shoe Assembly	1
6	6	6	6			6	6	601-015-401	Shoe Assembly	1
1	1	1	1			1	1	601-015-405	Shoe Assembly	1
1	1	1	1			1	1	601-015-407	Shoe Assembly	1
3	3	3	3	3	3	3	3	601-017-007	Doubler	1
7	7	7	7	7	7	7	7	601-017-017	Doubler	1
1	1	1	1	1	1	1	1	601-017-019	Doubler	1
1	1	1	1	1	1	1	1	601-019-105	Plug	1
1	1	1	1					601-021-007	Cap	1
1	1	1	1					601-021-009	Clip (L/H)	1
1	1	1	1					601-021-010	Clip (R/H)	1
				9	9	9	9	601-035-121	Sleeve	1
				9	9	9	9	AN3-34A	Bolt	1
				1	1	1	1	AN3C33A	Bolt	1
4	4	4	4					CR3212-4-03	Rivet	1

AERONAUTICAL ACCESSORIES, INC.

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

TABLE 10. PARTS BREAKDOWN, 206-324-3XX SERIES, FLOAT GEAR SKID TUBES
206-324-307 / 206-324-309 (L/H) // 206-324-308 / 206-324-310 (R/H) SKID TUBE ASSEMBLY ⁽¹⁾
206-324-357 / 206-324-359 (L/H) // 206-324-358 / 206-324-360 (R/H) SKID TUBE ASSEMBLY ⁽²⁾

Qty -307	Qty -308	Qty -309	Qty -310	Qty -357	Qty -358	Qty -359	Qty -360	Part Number	Description	AV Code
3	3	3	3	3	3	3	3	CR3213-4-03	Rivet	1
16	16	16	16	16	16	16	16	CR3213-4-05	Rivet	1
4	4	4	4	4	4	4	4	CR3213-4-08	Rivet	1
4	4	4	4					MS20426AD4-5	Rivet	1
				10	10	10	10	MS21043-3	Nut	1
8	8	8	8	8	8	8	8	MS27039-1-10	Screw	1
10	10	10	10	10	10	10	10	MS27039-1-11	Screw	1
24	24	24	24	24	24	24	24	MS27039-1-12	Screw	1
1	1	1	1	1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	40	40	40	40	MS90354-08-05	Lock Bolt	1
				20	20	20	20	NAS1149C0363R	Washer	1
1	1	1	1	1	1	1	1	NAS1149C0463R	Washer	1
1	1	1	1	1	1	1	1	NAS1149D0663J	Washer	1
42	42	42	42	42	42	42	42	NAS1149F0332P	Washer	1
1	1	1	1	1	1	1	1	NAS1149F1063P	Washer	1
14	14	14	14	8	8	8	8	NAS1330H3K116L	Rivnut	1
28	28	28	28	10	10	10	10	NAS1330H3K166L	Rivnut	1
52	52	56	56	27	27	27	27	NAS1330H3K216L	Rivnut	1
4	4							NAS1330H5K256L	Rivnut	1
1	1	1	1	1	1	1	1	099-050-137	Adhesive (EA9309NA)	1
1	1	1	1	1	1	1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1
Notes:										
1. Float Gear installation in accordance with STC SH2804SO-D										
2. Provisioned for Apical Tri-Bag Float System – requires installation of STC SR01535LA (Apical Industries)										

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 11. PARTS BREAKDOWN, 206-324-4XX SERIES, FLOAT GEAR SKID TUBES ⁽¹⁾
206-324-457 / 206-324-459 (L/H) // 206-324-458 / 206-324-460 (R/H) SKID TUBE ASSEMBLY

Qty -457	Qty -458	Qty -459	Qty -460	Part Number	Description	AV Code
		1		601-001-411	Skid Tube (L/H)	3
			1	601-001-412	Skid Tube (R/H)	3
1				601-001-413	Skid Tube (L/H)	3
	1			601-001-414	Skid Tube (R/H)	3
1	1	1	1	601-007-203	Saddle (Forward)	1
1	1	1	1	601-007-205	Saddle (Aft)	1
2	2	2	2	601-011-013	Eyebolt (Ground Handling)	1
2	2	2	2	601-011-015	Washer	1
2	2	2	2	601-011-117	Insert Assembly	0
1	1	1	1	601-013-003	Fitting (Ground Handling)	1
6	6	6	6	601-015-301	Shoe Assembly	1
1	1	1	1	601-015-305	Shoe Assembly	1
1	1	1	1	601-015-307	Shoe Assembly	1
3	3	3	3	601-017-007	Doubler	1
7	7	7	7	601-017-017	Doubler	1
1	1	1	1	601-017-019	Doubler	1
1	1	1	1	601-019-105	Plug	1
1	1	1	1	601-021-007	Cap	1
1	1	1	1	601-021-009	Clip (L/H)	1
1	1	1	1	601-021-010	Clip (R/H)	1
4	4	4	4	CR3212-4-03	Rivet	1
3	3	3	3	CR3213-4-03	Rivet	1
16	16	16	16	CR3213-4-05	Rivet	1
4	4	4	4	CR3213-4-08	Rivet	1
4	4	4	4	MS20426AD4-5	Rivet	1
8	8	8	8	MS27039-1-10	Screw	1
10	10	10	10	MS27039-1-11	Screw	1
24	24	24	24	MS27039-1-12	Screw	1
1	1	1	1	MS27039-4-06	Screw	1
40	40	40	40	MS90354-08-05	Lock Bolt	1
1	1	1	1	NAS1149C0463R	Washer	1

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBESTABLE 11. PARTS BREAKDOWN, 206-324-4XX SERIES, FLOAT GEAR SKID TUBES ⁽¹⁾
206-324-457 / 206-324-459 (L/H) // 206-324-458 / 206-324-460 (R/H) SKID TUBE ASSEMBLY

Qty -457	Qty -458	Qty -459	Qty -460	Part Number	Description	AV Code
1	1	1	1	NAS1149D0663J	Washer	1
42	42	42	42	NAS1149F0332P	Washer	1
1	1	1	1	NAS1149F1063P	Washer	1
14	14	14	14	NAS1330H3K116L	Rivnut	1
28	28	28	28	NAS1330H3K166L	Rivnut	1
52	52	52	52	NAS1330H3K216L	Rivnut	1
4	4			NAS1330H5K256L	Rivnut	1
1	1	1	1	099-050-137	Adhesive (EA9309NA)	1
1	1	1	1	099-050-222 (Alt: 099-050-223)	Sealant (CS3204B2, Chemseal) (CS3204B4, Chemseal)	1

Notes:

1. Float Gear installation in accordance with STC SH2804SO-D

**INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES**

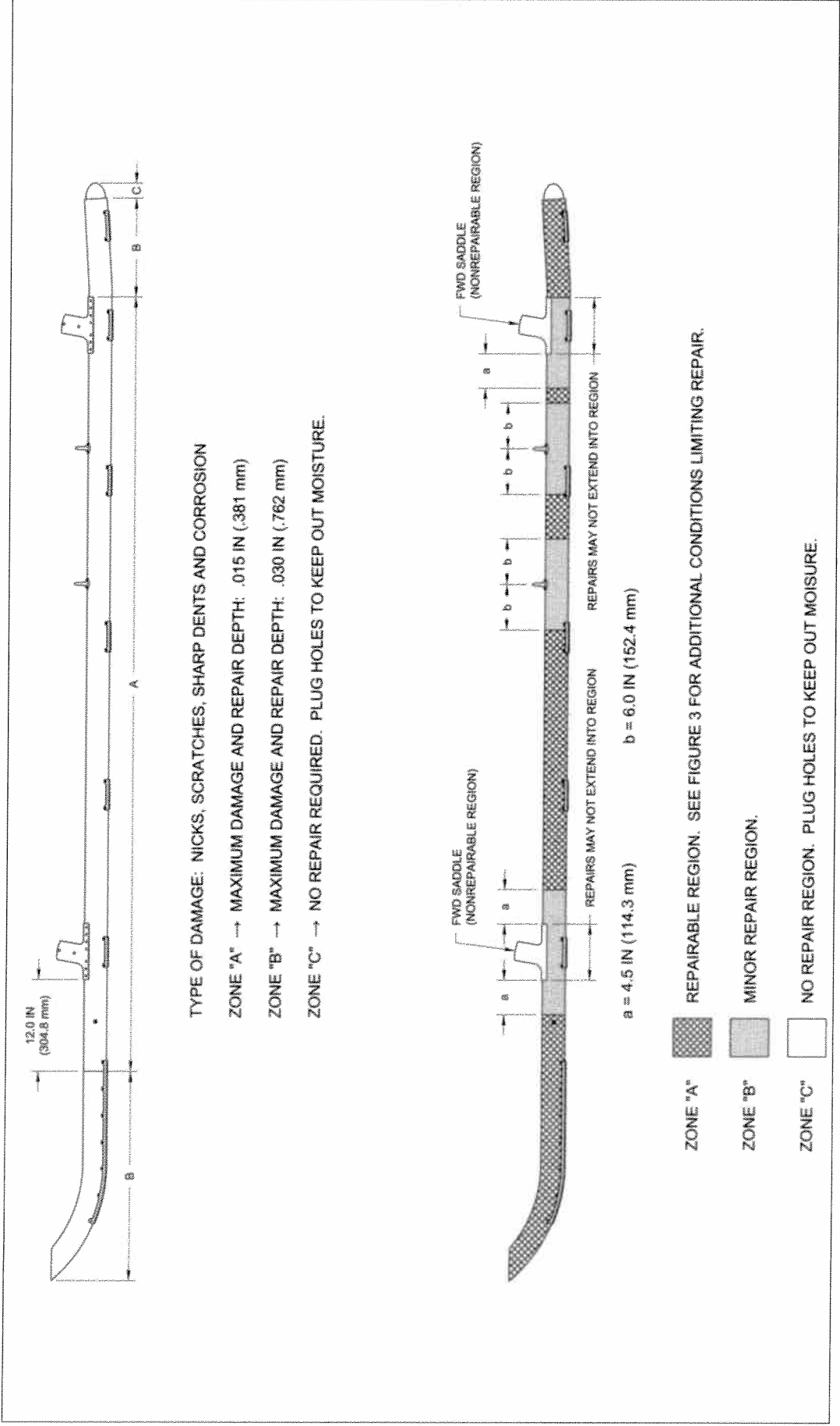
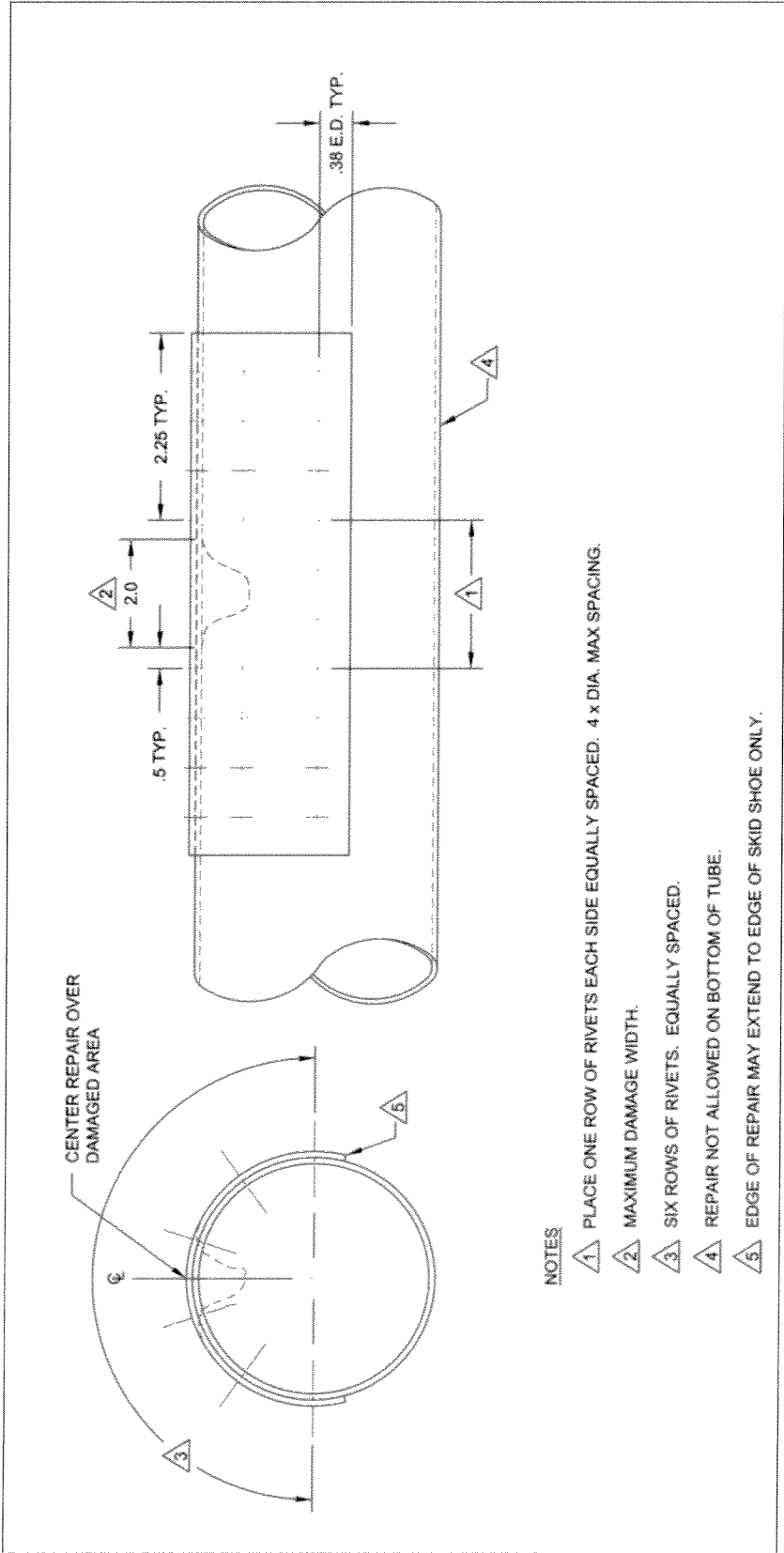


FIGURE 1. SKID TUBE DAMAGE AND REPAIR ZONES

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES



INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

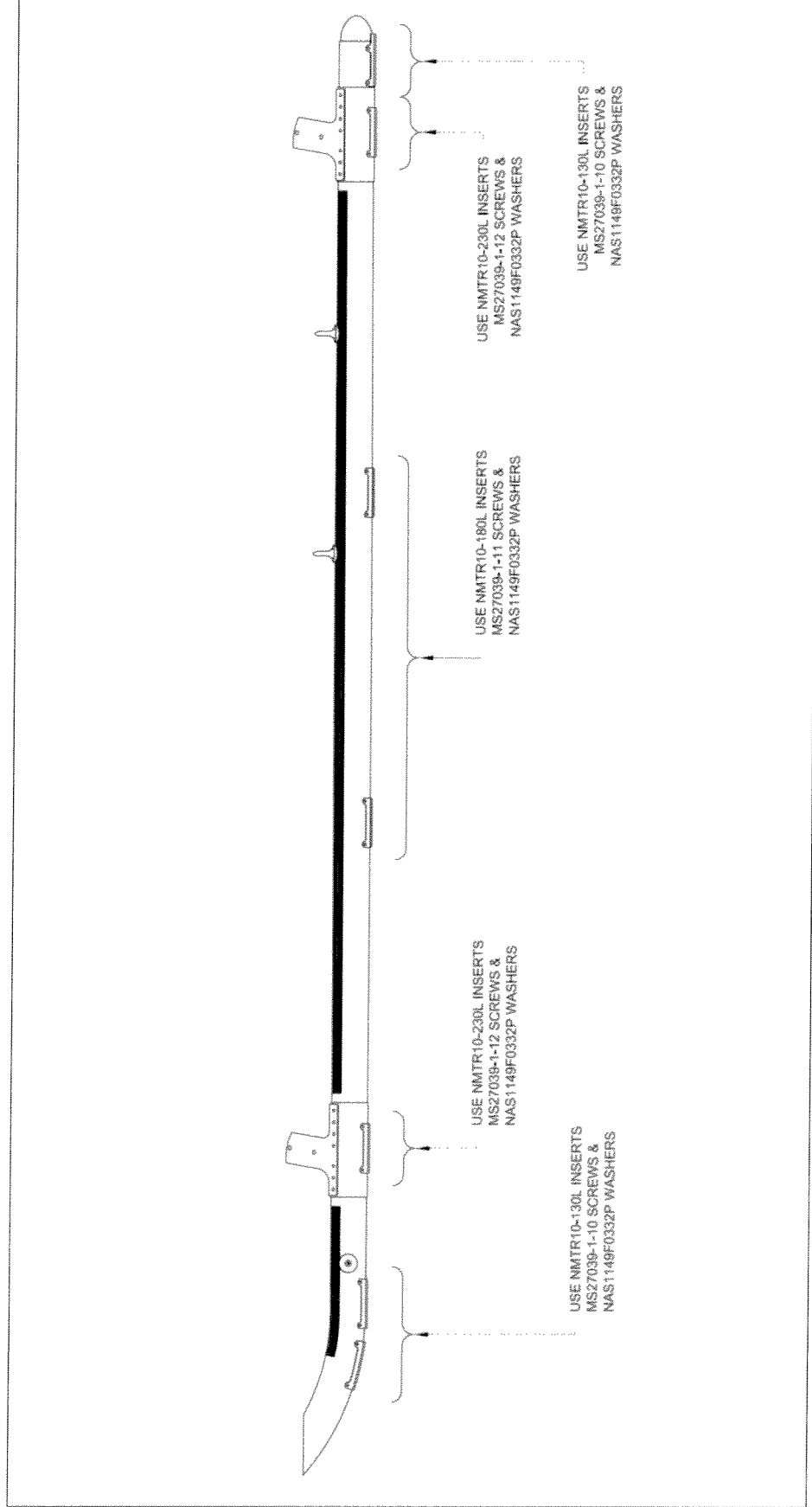


FIGURE 3. SKID SHOE ATTACHMENT FOR 206-325 SERIES SKID TUBES, LOW GEAR OR HIGH GEAR

INSTRUCTIONS for CONTINUED AIRWORTHINESS
SKID TUBES

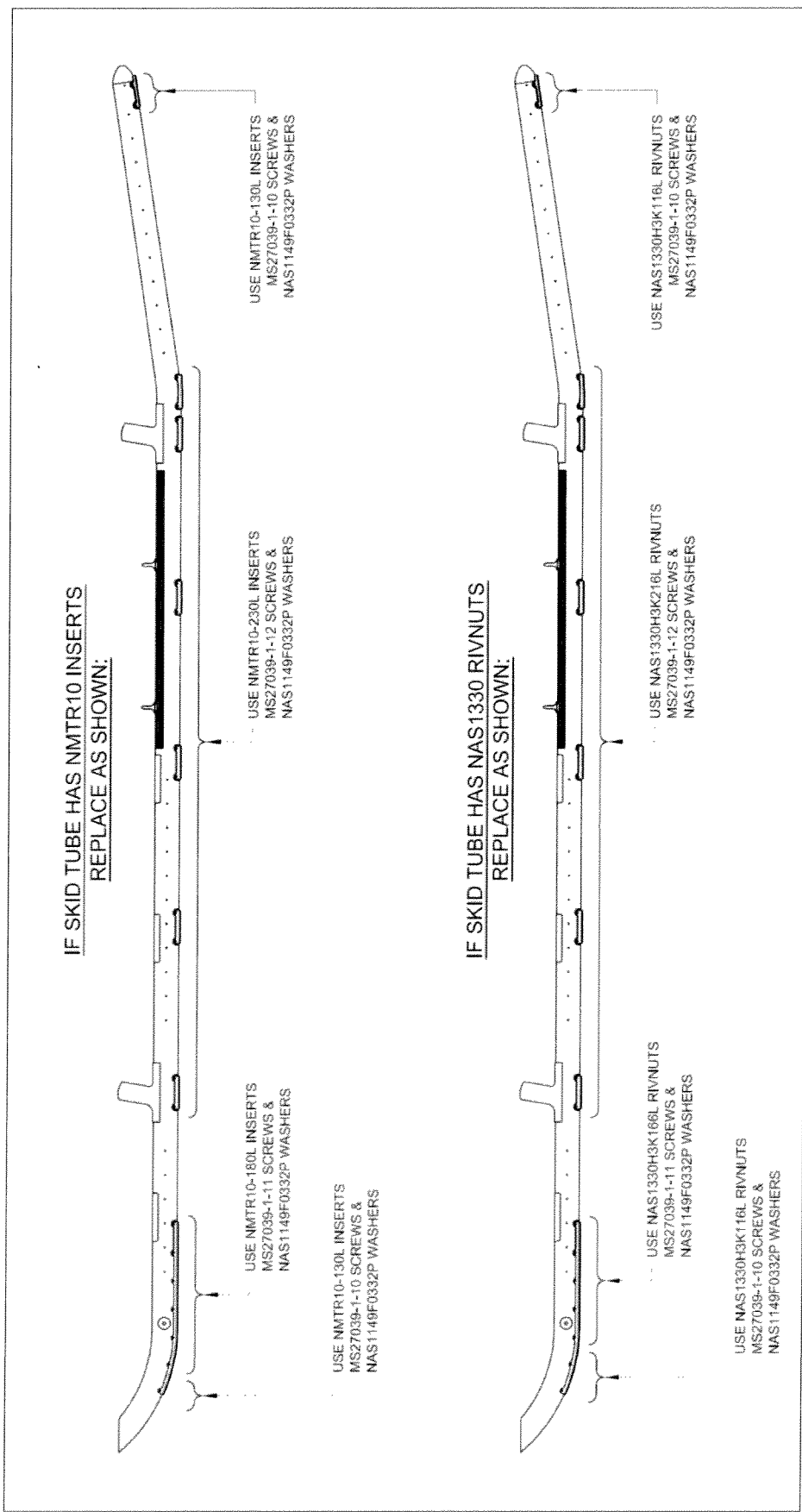


FIGURE 4. SKID SHOE ATTACHMENT FOR 206-324 SERIES SKID TUBES, FLOAT GEAR

APPENDIX A

100 Hour/6 Month Inspection Record

Work Order Number: _____
Registration Number: _____
Serial Number: _____
Total Time: _____
Date: _____

The Skid Tubes shall receive a 100-hour or a 6-month inspection whichever comes first. Inspection may be incorporated into progressive maintenance programs, as appropriate. The inspection shall consist of the following items:

NOTE

Removal of Skid Tubes from the helicopter is not required for inspection. If any damage is noted during the inspection, refer to Section 3.2 Repair.

NOTE

Particular care should be taken to inspect in the areas of the fasteners in the skid Tubes and all attaching components.

NOTE

The indications of corrosion are 1) corrosion deposits (a white or gray powder on aluminum), 2) pits in the aluminum surface, 3) blisters, bulging, or flaking of protective coatings.

1. Inspect the skid tubes for scratches, nicks, dents, and corrosion. Refer to Section 3.1.1 for damage and repair limits and to Figure 1 damage and repair zones. Only one damage rework is permissible per zone. If the damage limits are exceeded, the skid tube must be replaced.
3. Visually inspect the Skid Shoes for damage. Refer to Section 3.2.3 for repair instructions.
4. Inspect the wingwalk coating on the top 1/3 of each Skid Tube. Refer to Section 3.2.4 for repair instructions.

Signature _____ **A & P No.** _____

Signature _____ **Inspector** _____