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INSTALLATION INSTRUCTIONS

CREW VERTICAL SLIDE WINDOW ASSEMBLY KIT

P/N 206-557-301 KIT FOR 206-557-047 WINDOW ASSY
P/N 206-557-302 KIT FOR 206-557-048 WINDOW ASSY
P/N 206-557-303 KIT FOR 206-557-141 WINDOW ASSY
P/N 206-557-304 KIT FOR 206-557-142 WINDOW ASSY

FOR

BELL HELICOPTER TEXTRON MODEL 206 A,B,L,L-1,L-3,L-4 HELICOPTERS

Report Number AA-86029

Revision J

December 22, 2008



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LOG OF REVISIONS

Revision	Date	Description	Pages
-	11/11/86	Original Release	All
H	4/8/97	Various Technical Updates	All
I	8/3/00	Revised Washer Callouts	4,6
J	12/22/08	Reformatted Document	All
		Added Restricted Disclosure Notice	2
		Removed Alt: washer P/Ns	8

INTRODUCTION

These instructions provide the information necessary to install the **AERONAUTICAL ACCESSORIES, INC. CREW VERTICAL SLIDE WINDOW ASSEMBLY KIT** on Bell Helicopter Textron model 206 helicopters. All Engineering aspects of these instructions are FAA approved under STC No. SH2139SO.

NOTE

Refer to Bell Helicopter Model 206 A,B,L,L-1,L-3,L-4 Maintenance Manual(s) and all applicable maintenance manuals and/or ICA's for disassembly/reassembly instructions not specifically addressed in this document. Read ALL instructions thoroughly and have a clear understanding BEFORE beginning.

1.0 INSTALLATION INSTRUCTIONS

- 1.1 The **CREW VERTICAL SLIDE WINDOW ASSEMBLIES** are fabricated of blue tinted acrylic plastic and are installed using new and existing rivet locations in the doors. Watertight sealant is applied to the contacting surfaces of the window assemblies and the doors.
- 1.2 Drill out the heads of the old rivets around old window, and use a punch to knock out the remaining stems of the rivets.

NOTE

If aircraft had rubber mounted windows installed, establish rivet hole pattern in new window and door (Ref. Figure 1)

- 1.3 Use a thin putty knife to loosen the sealant around the window and gently pry out the window.
- 1.4 Remove all old sealant from around the window opening of the door and clean the surfaces with Naphtha.
- 1.5 Remove the Sliding Window Assembly (206-557-261 or -262) from the window assembly by removing the four screws holding the handle on the sliding window. Retain all mounting hardware and set the sliding window aside in a protected place for re-installation later.
- 1.6 Due to slight differences from airframe to airframe, it may be necessary to trim the window assembly to ensure fit. Hold the new window in place and trim to fit as required.

- 1.7 Once fit is determined, hole the window in place, back drill and Cleco it in place. Mark the location of the hinge rivet by making a depression in the edging (tap edging lightly with a hammer).
- 1.8 Remove the window and drill out the depression to clear the hinge rivet. Deburr all holes.
- 1.9 Replace the window assembly on the door assembly and secure it in place using Clecos. Temporarily install the sliding window assembly. Orient the sliding window with the lower seal strip facing inboard and carefully slide the window up. Secure the handle on the sliding window as desired and slide the window down as far as possible.
- 1.10 Holding the two tracks securely in position, locate the new rivet locations using approximately 3 inch rivet spacing and maintaining proper edge distance. Using a #30 (.128) bit, drill through the track flange and the **OUTER SKIN ONLY** of the door at the locations marked. Cleco the tracks to the door as drilling progresses. Ensure that the sliding window slides freely.
- 1.11 After the tracks have been match drilled to the door, the bottom brace may be removed if desired. Ensure that the track extends slightly below the sliding window in the full down position. Maintain proper edge distance when trimming and add one rivet to each side as required.
- 1.12 Remove the window assembly from the door. Deburr all holes in the window edging, track and door.
- 1.13 Apply a small bead of sealant (Proseal AMS-S-8802 or equivalent) on the contacting surfaces of the window edging and track. Cleco the window assembly in place on the door. Install rivets (MS20470A3-8) with washers (140-001-11) inside around the edging (i.e. existing rivet locations) and rivets (MS20470A4-3) with washers (NAS1149DN632J) in the lower tracks (i.e. new rivet locations).
- 1.14 Remove any sealant squeeze-out with a sharpened piece of acrylic plastic. Blend the window assembly and tracks into the door to minimize gaps. Paint the window assembly edging and tracks into the door to minimize gaps. Paint the window assembly edging and tracks as desired to match existing aircraft paint scheme.

2.0 WEIGHT AND BALANCE:

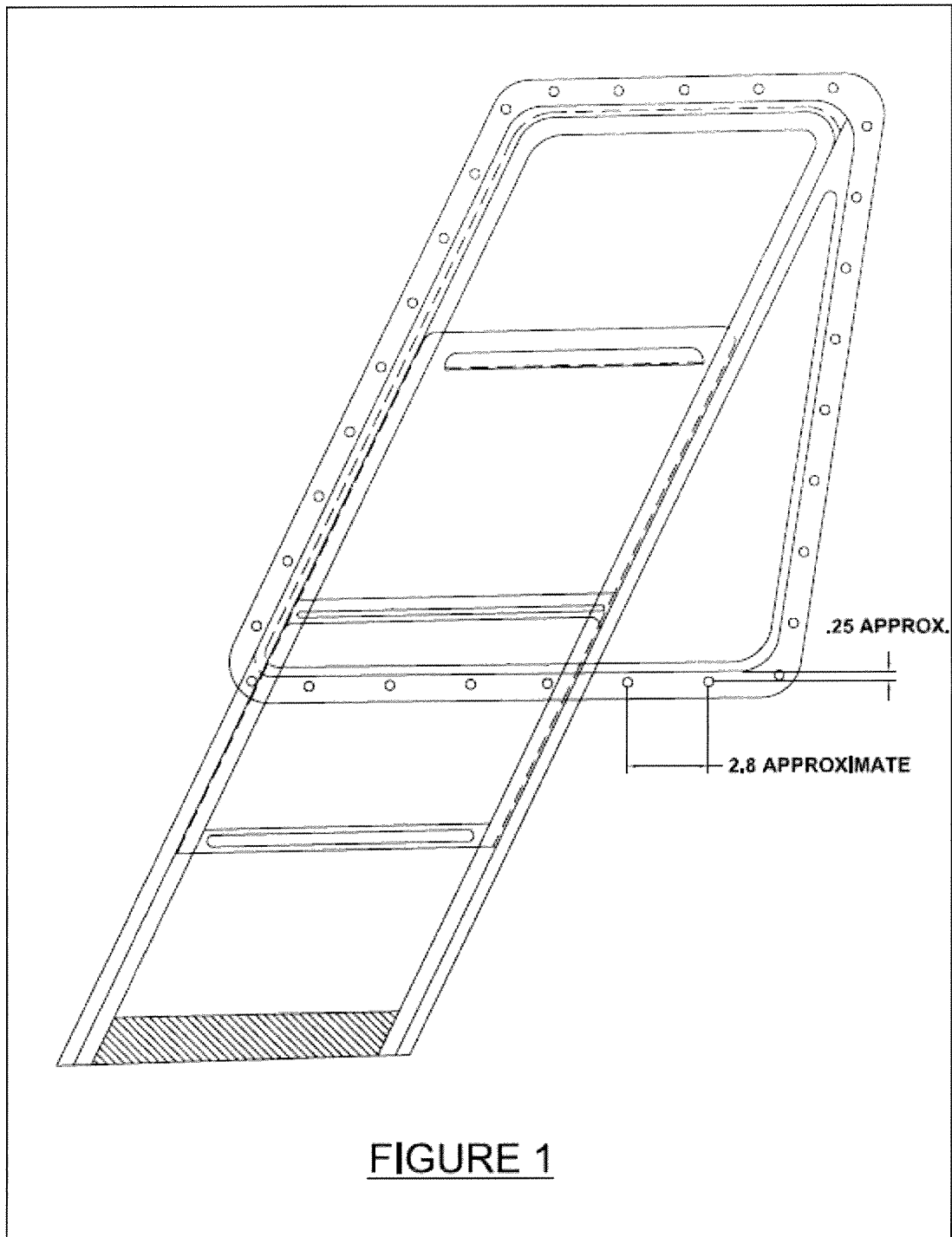
Net weight change: Negligible

3.0 MAINTENANCE INSTRUCTIONS

Clean the **VERTICAL SLIDE WINDOWS** with mild, nonabrasive soap and clean, particulate free, water. Use your bare hand to carefully feel and dislodge dirt, salt or other contamination. Dry with a clean, damp chamois. A soft tissue may be used providing care is taken not to continue rubbing after plastic is dry.

CAUTION

Do not use solvents such as acetone, benzene, carbon tetrachloride, fire extinguisher fluid, dry cleaning compounds, lacquer thinners, window sprays or kitchen scouring compounds on acrylic plastic.



PARTS LIST

206-557-301 CREW VERTICAL SLIDE WINDOW ASSEMBLY L/H (206 A,B)
206-557-302 CREW VERTICAL SLIDE WINDOW ASSEMBLY R/H (206 A,B)
206-557-303 CREW VERTICAL SLIDE WINDOW ASSEMBLY L/H (206 L,L-1,L-3,L-4)
206-557-304 CREW VERTICAL SLIDE WINDOW ASSEMBLY R/H (206 L,L-1,L-3,L-4)

	<u>Qty</u> <u>-301</u>	<u>Qty</u> <u>-302</u>	<u>Qty</u> <u>-303</u>	<u>Qty</u> <u>-304</u>	<u>Part Number</u>	<u>Description</u>
_____	1				206-557-047	Vert. Slide Window Assy L/H
_____		1			206-557-048	Vert Slide Window Assy R/H
_____			1		206-557-141	Vert Slide Window Assy L/H
_____				1	206-557-142	Vert Slide Window Assy R/H
_____	1	1	1	1	206-557-200	Hardware Kit

206-557-200 HARDWARE KIT

	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>
_____	26	MS20470A3-8	Rivet
_____	11	MS20470A4-3	Rivet
_____	6	MS20426A3-8	Rivet
_____	2	MS20470AD5-8	Rivet
_____	34	140-001-11	Washer
_____	11	NAS1149DN632J	Washer
_____	2	NAS1149DN832J	Washer

Confirm inventory prior to installation.

Packed by: _____ / /

AERONAUTICAL ACCESSORIES, INC.

United States of America
Department of Transportation — Federal Aviation Administration
Supplemental Type Certificate

Number

SH2139SO

This certificate, issued to

Aeronautical Accessories, Inc.
P.O. Box 3689
Bristol, Tennessee 37625

certifies that the change in the type design for the following product with the limitations and conditions therefor as specified hereon meets the airworthiness requirements of Part 6 of the Civil Air Regulations.

Original Product — Type Certificate Number:

H2SW

Make:

Bell Helicopter Textron, Inc.

Model:

206A, 206B, 206L, 206L-1, 206L-3, 206L-4

Description of Type Design Change:

Installation of crew vertical slide window assemblies in accordance with Aeronautical Accessories, Inc. Report No. AA-86031, Drawing List Crew Vertical Slide Window Assemblies, dated November 13, 1986, Report AA-86029, Installation Instructions, dated November 11, 1986 or later FAA approved revisions.

Limitations and Conditions:

This approval should not be extended to other rotorcraft of this model on which other previously approved modifications are incorporated unless it is determined by the installer that the interrelationship between this change and any of those other previously approved modifications will produce no adverse effect upon the airworthiness of that rotorcraft. This determination should include consideration of significant changes in weight distribution such as an increase in the fixed disposable weight in the fuselage.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application:

November 17, 1986

Date issued:

Date of issuance:

July 7, 1987

Date amended:

October 5, 1992

By direction of the Administrator



Paul C. Sconyers
(Signature)

Paul C. Sconyers
Acting Manager, Atlanta Aircraft
Certification Office

(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.



REPÚBLICA FEDERATIVA DO BRASIL
COMANDO DA AERONÁUTICA
DEPARTAMENTO DE PESQUISAS E DESENVOLVIMENTO
CENTRO TÉCNICO AEROESPACIAL
INSTITUTO DE FOMENTO E COORDENAÇÃO INDUSTRIAL

CERTIFICADO DE HOMOLOGAÇÃO SUPLEMENTAR DE TIPO

(Supplemental Type Certificate)

NÚMERO 2001S04-04
(Number)

Este certificado, emitido com base na Lei nº 7565 "Código Brasileiro de Aeronáutica", de 19 de dezembro de 1986,
(This certificate, issued in the basis of the Law No. 7565 "Código Brasileiro de Aeronáutica", dated 19 December 1986,

é conferido ao (à): Aeronautical Accessories, Inc.
is granted to:)

P.O. Box 3689

Bristol, Tennessee 37625-3689

USA

por ter a modificação ao projeto de tipo do produto abaixo citado, observadas as limitações e condições
(for having the change to the type design of the product mentioned below, with the limitations and conditions therefor as)

especificadas, satisfeito aos requisitos de aeronavegabilidade aplicáveis.
(specified hereon, met the applicable airworthiness requirements.)

Produto Original - Número do Certificado de Tipo: H2SW (FAA)

(Original Product - Type Certificate No:)

Fabricante: Bell Helicopter Textron, Inc.
(Manufacturer:)

Modelo(s): 206A, 206B, 206L, 206L-1, 206L-3 and 206L-4.
(Model(s):)

DESCRIÇÃO DA MODIFICAÇÃO AO PROJETO DE TIPO:
(Description of Type Design Change:)

Installation of Crew Vertical Slide Window Assemblies in accordance with Aeronautical Accessories, Inc. Drawing List Report No. AA-86031, Rev. E, dated 03 NOV 2000, or later approved revisions.

This CHST validates in Brazil the STC # SH2139SO, issued by FAA (USA).

LIMITAÇÕES E CONDIÇÕES:
(Limitations and Conditions:)

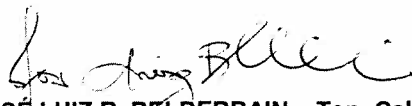
See continuation sheet for applicable data.

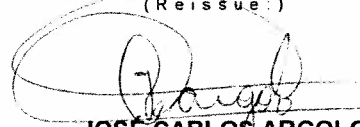
DATAS:
(Dates of:)

Do Requerimento: 03 JAN 2001
(Application:)

Da emissão: 09 APR 2001
(Issue:)

Da reemissão:
(Reissue:)


JOSÉ LUIZ R. BELDERRAIN - Ten.-Cel.-Eng.
Chefe da Divisão de Homologação Aeronáutica
(Chief, Divisão de Homologação Aeronáutica)


JOSÉ CARLOS ARGOLO - Cel.-Av.
Diretor do Instituto de Fomento e Coordenação Industrial
(Director, Instituto de Fomento e Coordenação Industrial)



REPÚBLICA FEDERATIVA DO BRASIL
COMANDO DA AERONÁUTICA
DEPARTAMENTO DE PESQUISAS E DESENVOLVIMENTO
CENTRO TÉCNICO AEROESPACIAL
INSTITUTO DE FOMENTO E COORDENAÇÃO INDUSTRIAL

Folha de Continuação ao
(Continuation Sheet to)

CERTIFICADO DE HOMOLOGAÇÃO SUPLEMENTAR DE TIPO
(Supplemental Type Certificate)

NÚMERO 2001S04-04
(Number)

LIMITAÇÕES E CONDIÇÕES:
(Limitations and Conditions:)

- I. The approval of this type design change should not be extended to other aircraft of this model on which other previously approved modifications are incorporated unless it is determined by the installer that the relationship between this change and any of those other previously approved modifications, including changes in Type Design, will introduce no adverse effect upon the airworthiness of that aircraft.
- II. If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.
- III. A copy of this Certificate shall be maintained as part of the permanent records for the modified aircraft.

----- END -----

AIRWORTHINESS APPROVAL NOTE NO: 23814 Issue 12

APPLICANT: CAA Internal Purposes

AIRCRAFT TYPE: Bell 206 Series

REGISTRATION NO: Not Applicable

CONSTRUCTOR'S NO: Not Applicable



Validation of Aeronautical Accessories FAA Bell 206 Series STC Approvals

In accordance with BCAR B2-2 para 7.2.3 procedures, the following Aeronautical Accessories, Inc modifications are approved for use in the Transport Category (Passengers) when installed in accordance with the FAA STC on UK registered Bell/Agusta Bell 206 Series aircraft, as appropriate:

<u>Description</u>	<u>STC</u>	<u>Model</u>
Range Extender	SH2889SW	Bell 206A,B
Longranger Extender	SH1522SO	Bell 206L,L-1
Raingutter	SH1148SO	Bell 206A,B,L,L-1,L-3
Spacemaker	SH227WE	Bell 206A,B,L,L-1,L-3,L-4,407
Maintenance Step	SH1281SO	Bell 206A,B
Folding Maintenance Step	SH2243SO	Bell 206A,B,L,L-1,L-3,L-4,407
Step/Handle	SH1282SO	Bell 206A,B
Step/Handle	SH1366SO	Bell 206L,L-1,L-3,I-4,407
High Skid Gear	SH1392SO	Bell 206A,B
High Skid Gear	SH2804SO	Bell 206L, L-1,L-3, L-4
Low Skid Gear	SH2764SO	Bell 206A,B
Low Skid Gear	SH2941SO	Bell 206L,L-1,L-3, I-4
Flitestep	SH1322SO	Bell 206A,B,L,L-1,L-3,L-4
Baggage Floor Protector	SH1147SO	Bell 206A,B,L,L-1,L-3,L-4,407
Cyclic Cover	SH244WE	Bell 206A,B,L,L-1,L-3,L-4
Collective Safety Cover	SH2373SO	Bell 206A,B,L,L-1,L-3,L-4
Crew Wedge Window	SH1815SO	Bell 206A,B,L,L-1,L-3,L-4
Replacement Windows	SH1664SO	Bell 206A,B,L,L-1,L-3,L-4
Crew Shoulder Harness	SH2073SO	Bell 206A,B,L,L-1,L-3,L-4
Door Openers	SH1990SO	Bell 206A,B,L,L-1,L-3,L-4,407
VRS	SH7882SW	Bell 206A,B
Cabin Floor Protector	SH289SO	Bell 206A,B,L,L-1,L-3,L-4,407
Crew Vertical Slide Windows	SH2139SO	Bell 206A, B,L,L-1,L-3,L-4,L-4 (Modified)
Replacement Drive Train Seals	SR00539AT	Bell 206A, B, L, L-1, L-3, L-4
Tail Rotor Pedal Lockout	SR00513AT	Bell 206A, B, L, L-1, L-3, L-4
Replacement Interior Trim	SIB298SO	Bell 206A, B, L, L-1, L-3
Replacement Door Locks and Locking	SR00095AT	Bell 206A, B, L, L-1, L-3, L-4
Fuel Cap		

APPLICANT
AIRCRAFT PROJECTS DEPARTMENT
FLIGHT MANUALS SECTION
POWERPLANT DEPARTMENT
REGIONAL MANAGER:-

<u>Description</u>	<u>STC</u>	<u>Model (Cont'd)</u>
Lightweight Replacement Nitrogen Reservoir Assembly	SR00175AT	Bell 206A, B, L, L-1, L-3, L-4
Electrical Inflation Valve Retrofit Kit	SR00822AT	Bell 206A, B, L, L-1, L-3
Air Deflector	SR01556AT	Bell 407
Air Deflector	SR01582AT	Bell 206A, B, L, L-1, L-3, L-4
Dual Video Camera System and Monitor	SH2292SO	Bell 206A, B, L, L-1, L-3
Hinged Circuit Breaker Panel	SR00347AT	Bell 206A, B, L, L-1, L-3, L-4

Issue 2 has been raised to correct minor editorial errors.

Issue 3 has been raised to include the Bell 206L4, where applicable.

Issue 4 has been raised to include the Crow Vertical Slide Windows.

Issue 5 has been raised to include the Replacement Drive Train Seals.

Issue 6 has been raised to include the Tail Rotor Pedal Lockout and Bell 206 L-4 applicability to High and Low Skid Gear.

Issue 7 has been raised to include the Replacement Interior Trim

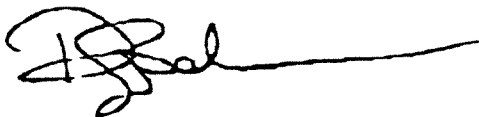
Issue 8 has been raised to include Replacement Door Locks and Locking Fuel Cap

Issue 9 has been raised to include replacement Nitrogen Reservoir and Electrical Inflation Valves for the Bell Emergency Flotation Equipment.

Issue 10 has been raised to include installation of Air Deflection on crew and passenger door windows.

Issue 11 has been raised to include STCs SR01582AT, SH2292SO and SR00347AT.

Issue 12 has been raised to include the Bell 407, where applicable.



P Sparkes

For the Civil Aviation Authority

Date 8 October 1999