**MODEL AFFECTED:** 205A/205A-1

**SUBJECT:** TAILBOOM ASSEMBLIES P/N 205-032-802-003 THROUGH -051 & 212-030-100-081 THROUGH -107, MODIFICATION FOR USE ON ALL MODEL 205A/A-1 HELICOPTERS

**HELIICOPTERS AFFECTED:** All model 205A/A-1 helicopters

**COMPLIANCE:** At customer’s option

**DESCRIPTION:**

Operators of multiple 205A/205A-1 fleets desire to have interchangeable tailbooms and common spares. The tailboom aerodynamic shape and structural arrangement has not changed, however, product improvements have been incorporated over the years to facilitate produceability and reliability. A new tailboom assembly dash number was assigned with most product improvements. Service Letters, Alert Service Bulletins and Technical Bulletins have been issued for all changes practical for field incorporation.

This technical bulletin provides the instructions necessary to modify all existing tailbooms by incorporating applicable bulletins so that tailbooms so modified may be used on other model 205A and 205A-1 helicopters.

**APPROVAL:**

The engineering design aspects of this bulletin are FAA/DER approved.

**MANPOWER:**

The actual number of man-hours required to complete this bulletin will vary based on the level of upgrade required.
**WARRANTY:**

There is no warranty credit applicable for parts or labor associated with this bulletin.

**MATERIAL:**

**Required Material:**

See applicable bulletins.

The following material is required for the modifications described in paragraphs 2, 3 and 4 of this bulletin (See Table 1 for applicability). They may be obtained through your Bell Helicopter Textron Supply Center.

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\(^1\) May be locally fabricated from a 6.1 in. x 6.8 in. sheet of 2024T3, 0.040 in. thick aluminum per spec. QQ-A-250/5.

\(^2\) May be locally fabricated from a 20-inch piece of 299-947-110 TY3 CL1 Tape.
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**Consumable Material:**

This material is considered consumable (bench stock) material and may not require ordering depending on the operator’s consumable material stock levels. This material may be obtained through your Bell Helicopter Textron Supply Center.

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**SPECIAL TOOLS:**

See applicable bulletins.

**WEIGHT AND BALANCE:**

See applicable bulletins.

**ELECTRICAL LOAD DATA:**

See applicable bulletins.

**REFERENCES:**

BHT-205-IPB Illustrated Parts Breakdown.
BHT-MED-SRM-1 Structural Repair Manual.
Service Letter 205A-90 Application of pro-seal 890 to tailboom skin line at junction of baggage compartment and tail boom aft section. Inspection of

\(^3\) Support P/N 212-030-124-037 may be used as an alternate

\(^4\) MIL-S-8802 Class B2 (C308) Sealant or MIL-S-81733, Type II (C392) Sealant may be used as alternate material.

\(^5\) Magnobond 6398 may be used as an alternate
tailboom interior for corrosion and/or possible cracks and repair instructions.
TB 205-01-73-1 Modification of tailboom, P/N 205-032-802 (All dash numbers)
TB 205-50-73-3 Installation of improved tail rotor kit P/N 205-704-040-1 on model 205A-1 helicopters prior to S/N 30020
TB 205-76-8 Installation and rework of “J” stringers aft of tailboom baggage compartment
ASB 205-77-4 Limit service life of the upper left hand tailboom longeron assembly to 3000 flight hours. Inspection, repair and replacement of tailboom attachment fittings and longerons
ASB 205-77-11 Inspection of tail rotor driveshafts and removal of anti-chafing tape from the tail rotor driveshaft cover and the fin cover door assemblies
ASB 205-78-5 Mandatory installation of tail rotor push-pull control system
TB 205-78-15 Tail rotor driveshaft P/N 204-040-620-3 and -7, Replacement with new tail rotor drive shaft P/N 204-040-620-11
TB 205-79-19 Rework of the baggage compartment forward bulkhead P/N 205-032-804
TB 205-82-47 Replacement of upper honeycomb panel, tailboom baggage compartment, with sheetmetal skin
ASB 205-84-21 Elevators, P/N 205-030-856-091, and -093 and prior dash numbers to horn assembly, P/N 205-001-914-027, attachment, Modification of
ASB 205-90-39 Tailboom upper longeron splice inspection provisions
ASB 205-93-56 Tailboom doubler P/N 212-030-099-089/-129
ASB 205-95-62 Powertrain modification on model 205A/205A-1
ASB 205-98-73 Fin spar 205-030-899-101, 205-030-846-087/-089, 205-032-851-003/-007/-009 replacement
TB 205-00-111 Fin spar cap 212-030-447-001/-101, Replacement of.
TB 205-05-119 Tailboom bulkhead reinforcement
TB 205-06-120 Improved baggage compartment door seal
TB 205-06-121 Vertical fin cover hinge pin improved installation
Service Instruction 205-38 Improved tail rotor
Service Instruction 205-46 Push/Pull Anti-torque retrofit kit

PUBLICATIONS AFFECTED:
See applicable bulletins.

ACCOMPLISHMENT INSTRUCTIONS:

-Note-

Table 1 shows the Service Letters (SLs), Alert Service Bulletins (ASBs), Technical Bulletins (TBs) or tasks for which the accomplishment is required to achieve a later tailboom
configuration. ASBs are listed in Table 1 as a reminder since all ASBs are required to maintain configuration and should have previously been accomplished.

1. On a separate piece of paper, make a list of all the bulletins/tasks marked with a (✓) beside the original configuration (dash number) in Table 1. If the original configuration has split effectivity, pick the earliest. From that list, remove the bulletins/tasks marked with a (✓) beside the desired configuration. If the desired configuration has split effectivity, pick the latest. The remaining bulletins/tasks on the list are the ones required to perform the upgrade. Verify and/or comply with all applicable ASBs, TBs and tasks on the list. See example below.

Example:

For example, if a 205-032-802-011 tailboom is to be upgraded to a -051 configuration to be installed on A/C 30209, Service Letter 205A-90, TB 205-01-73-1 and TB 205-76-8 have to be accomplished or confirmed accomplished.

2. This paragraph describes a modification to upgrade Bulkhead (BS. 59.50) by increasing the size of one hole for the elevator control tube and replacing (qty 3) fairleads, as follows (refer to Figure 1 & 2):

-Note-

It is recommended to accomplish paragraph 4 of this bulletin concurrently with this paragraph (even if not required per Table 1) due to access opportunities.

a. Remove elevator control tube P/N 205-001-038-001 or -101.

b. Remove lower panel P/N 205-032-814-003 recording type, size and location of fasteners.

c. Remove three fairleads at BS 37.65, 59.50 & 80.56.

d. On frame P/N 205-032-817-017 at BS 59.50, mark and enlarge hole to 1.43-inch diameter, as shown on Figure 2.

e. Deburr and apply primer to any bare metal area.

f. Install three new grommets P/N 60-008-3 using six MS27039-1-10 screws and existing washers and nuts.

g. Apply sealant (C-308) to faying surfaces and re-install lower panel. Apply a bead of sealant around periphery of panel.
h. Re-install elevator control tube.

3. This paragraph describes a modification to upgrade the Center Tailboom Section as well as some modifications to the vertical fin. Refer to Figure 1, 3, 4 & 5. Deburr all holes prior to final installation.

a. Install tailboom in an approved fixture.

b. Remove side skins and lower skin between BS 101.38 and 194.30 recording type, size and location of fasteners.

c. Remove all four longerons between BS 101.38 and 175.00 and splices at BS 175.00 recording type, size and location of fasteners.

d. Remove bulkheads at BS 122.23, 143.28 and 164.23 recording type, size and location of fasteners.

e. Using top skin rivet holes as locators, position and install new bulkheads as follows using original type and size fasteners:

   205-032-821-023   BS 122.33
   205-032-820-031   BS 143.28
   205-032-827-013   BS 164.23

f. Prepare longerons and splices for installation between BS 101.38 and 175.00 as per Structural Repair Manual, chapter 3. Install longerons and splices as follows using original type and size fasteners:

   212-030-132-149   Longeron (Upper LH)
   212-030-132-150   Longeron (Upper RH)
   212-030-132-151   Longeron (Lower LH)
   212-030-132-153   Longeron (Lower RH)
   212-030-132-155   Splice (Upper LH)
   212-030-132-156   Splice (Upper RH)
   212-030-132-157   Splice (Lower LH)
   212-030-132-159   Splice (Lower RH)

g. Re-install side and lower skins using original type and size fasteners and apply a bead of sealant (C-308) on periphery of skins.

h. Remove tailboom from fixture.
i. Remove lower access doors at BS 130 and 175 and replace with new doors as
follows:

- 205-030-814-019 Door BS 130
- 205-030-814-021 Cover BS 130
- MS27039-08-07 Screw (qty 12) BS 130
- MS21042L08 Nut (qty 12) BS 130
- 212-030-283-009 Door assy BS 175

j. Build-up and install flux valve support bracket at BS 164.23 as shown on Figure
3.

k. Add drain holes aft of baggage compartment as per Figure 4.

l. Remove aft LH skin on vertical fin and aft ribs at Fin Sta (FS) 46.95, FS 34.56
and FS 22.37 recording type, size and location of fasteners. Install new aft ribs
as follows using original type and size fasteners:

- 212-030-127-027 Rib (Fin Sta 46.95)
- 212-030-127-015 Rib (Fin Sta 34.56)
- 212-030-127-017 Rib (Fin Sta 22.37)

m. Remove original strip 205-032-850-076 from RH side of fin. Remove rivets at
base of vertical fin (RH-side, forward skin) enough for the installation of doubler
and filler, as shown on Figure 5, recording type, size and location of fasteners.

n. Mark and drill doubler and filler 212-030-443-005 and -007 and deburr.

o. Clean all cavities of fin from rivet stems and other foreign objects and install
doubler and filler using original type and size fasteners as shown on Figure 5.

p. Re-install LH aft skin using original type and size fasteners. Apply a bead of
sealant (C-308) around periphery of skins.

q. Install new strip 205-032-850-076.

4. This paragraph describes a modification to upgrade Bulkhead (FS 101.38) by
replacing an angle (P/N 205-032-805-027) made of aluminum with a stronger
one (P/N 205-032-805-041) made of steel. Paragraph 2 should be
accomplished concurrently with this paragraph (if required). Refer to Figure 1
& 6.

a. Remove Bellcrank Support from aft face of Baggage Compartment Aft
Bulkhead.
b. Remove Drain Tube from lower surface of Baggage Compartment Floor recording type, size and location of fasteners.

c. Remove rivets holding Nutplates, Radius Blocks and Support.


e. Install Support, Radius Blocks and Nutplates using original type and size fasteners.

f. Reinstall Drain Tube using sealant (C-308) on upper flange and using existing type and size of fasteners. Apply Sealant (C-308) around tube at Panel assy, as shown on Figure 6.

g. Reinstall Bellcrank Support on aft face of Baggage Compartment Aft Bulkhead.

5. Using a vibrating stylus, mark tailboom mod plate with the new configuration part number with the suffix FM (e.g. 205-032-802-051FM), this technical bulletin number and the date of compliance.

-Note-

This Technical Bulletin only upgrades the tailboom assembly (structure only). All other components (i.e. Elevator Installation, Flight Control Installation, Drive System Installation, etc.) applicable to the serial number on which the upgraded tailboom assembly is to be installed are required.

-Note-

The upgraded tailboom assemblies may be installed on serial numbers corresponding to the upgraded configuration or on serial numbers corresponding to earlier configurations.

-Note-

Compliance with all future ASBs applicable to both the original and the upgraded configurations is required.

5. Make an entry in helicopter historical records indicating compliance with this technical bulletin.
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Table 1
Tailboom Configurations

See legend in text

Notes:

(1) Sometimes identified as 205-961-130-003. This tailboom is eligible for upgrade only if the vertical fin is of a later configuration. Configuration may be assessed by determining the offset of the fin on the tailboom at the tail skid and behind the intermediate gearbox. Fins that are not acceptable for upgrade (originally installed on tailboom P/N 205-032-802-003 or 205-961-130-003) are offset to the right of the tailboom by 0.4 inch. Fins that are acceptable for upgrade are offset to the left by 0.4 inch. If the fin is found to be acceptable for upgrade but its P/N cannot be determined accurately, it must be considered to be P/N 205-032-850-001 (applicable to 205-032-802-005 tailboom). Contact Product Support Engineering, if needed.

(2) Upgrade Bulkhead (BS 59.50) as described in paragraph 2 of this bulletin.

(3) Upgrade Center Tailboom Section as described in paragraph 3 of this bulletin.

(4) Upgrade Bulkhead (FS 101.38) as described in paragraph 4 of this bulletin.

(5) This bulletin does not apply to the tailboom assembly. It is mentioned only as a reminder.

(6) Not necessary (although recommended) when upgrading to 212-030-100-163 configuration.
Figure 1
General View

1. 205-032-814 panel ref.
2. 205-032-817 frame ref.
3. 205-032-821 bulkhead ref.
4. 205-032-820 bulkhead ref.
5. 205-032-827 bulkhead ref.
6. 212-030-132 longeron ref.
7. 212-030-132 splice ref.
8. 205-030-814 door ref.
9. 212-030-283 door assy. ref.
10. Flux valve bracket ref. (see Figure 3)
11. Drain holes (see Figure 4)
12. 212-030-127 rib ref.
Figure 2
Bulkhead (BS 59.50) Upgrade
(View Looking forward)

1. Baggage compartment floor ref.
2. 205-032-814 panel ref.
3. 205-032-817 bulkhead ref.

Remove existing grommet (3 loc). Install 60-008-3 grommet (qty 3), MS27039-1-10 screw (qty 6), and existing washers and nuts.

Enlarge hole to 1.43 inch (36.32 mm) diameter at BS 59.50 only
Figure 3
Flux Valve Bracket Installation

1. 205-030-804-015 bracket
2. 205-030-804-016 bracket
3. Lower skin ref.
4. 205-030-804-017 bracket

NOTE
⚠️ It is permissible to trim 0.06 inch (1.52 mm) maximum to cover bracket radius.

Rivets
-added MS20470AD4

IMO3546003
1. 205-032-817 bulkhead ref.
2. 205-032-814 panel ref.
3. 205-032-805 bulkhead ref.

NOTE

⚠️ Drill 0.186 to 0.190 inch (4.72 to 4.83 mm) diameter drain hole through panel and bulkhead, in line with rivet row.

Figure 4
Drain Holes
Figure 5
Doubler Installation

NOTES

1. Install filler and doubler over this rivet.
2. Trim filler and doubler as required to clear this rivet.
3. Drill 0.186 to 0.190 inch (4.72 to 4.83 mm) in hole through doubler and filler. Pick up location from existing hole. Nut plate may be left attached to skin.

Rivets

+ Existing MS20470AD4
↓ Added MS20470AD4 or M7885/6-4
★ Existing MS20426AD4
.getElementsByName("addedRivets")
★ Added MS20426AD4 or M7885/7-4
**Figure 6**
Bulkhead (BS 101.38) Upgrade
(View Looking Aft)
Portion of drain tube removed for clarity

1. Drain tube (Ref)
2. Panel assembly (Ref)
3. Nutplate (Ref)
4. Radius block (Ref)
5. Angle

**SEALANT (C-308)**

Portion of drain tube removed for clarity.