



AERONAUTICAL ACCESSORIES, INC.

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INSTALLATION INSTRUCTIONS

PASSENGER WEDGE WINDOW ASSEMBLY

P/N 206-554-083
P/N 206-554-084
P/N 206-554-283
P/N 206-554-284
P/N 206-554-383
P/N 206-554-384



for

Bell 206L, L-1, L-3, L-4 Model Helicopter

**Report AA-85009
Revision H**

December 12, 2005

LOG OF REVISIONS

Rev.	Date	Description	Effected Pages
A	10/28/87	Various Technical Updates	All
B	1/13/94	Revised header Added L-4 model eff. Replaced AN470A4 rivet with MS20470AD4	1
C	4/24/96	Created new cover page Added STC statement Changed rivet material	1
D	10/11/96	Added hardware kit Created window kits Created Log of Revisions page	2,3,4
E	4/8/97	Added Figure 1 Added note for rubber mounted windows Added Decal Kit	All 3 5
F	7/16/98	Changed Window and Kit part numbers.	6
G	1/2/03	Added Window and Kit part numbers Changed Washer P/N from AN960JD4 to NAS1149DN432J	1,6 3,7
H	12/12/05	Removed L-2 from Model Effectivity Renumbered body of report Added Disclosure Statement	1 4,5 3

This change has been determined to be minor
in accordance with the agreement between
the FAA and AAJ dated September 3, 2009

RC Clapier
Signature

12-1-09
Date

RESTRICTED DISCLOSURE NOTICE

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AERONAUTICAL ACCESSORIES, INC.

1.0 INTRODUCTION

These instructions contain the necessary information to install the **AERONAUTICAL ACCESSORIES, INC.** replacement **PASSENGER WEDGE WINDOW ASSEMBLIES** on Bell Helicopter Textron Model 206L, L-1, L-3, L-4 Helicopters. These instructions are FAA approved under STC No. SH1664SO.

2.0 INSTALLATION INSTRUCTIONS

- 2.1 The **PASSENGER WEDGE WINDOW ASSEMBLIES** are fabricated of acrylic plastic, and are installed using existing rivet locations in the doors. Water tight sealant is applied to the faying surfaces of the window assemblies and the doors.
- 2.2 Drill out heads of old rivets around old window, and use punch to knock out remaining rivet stems.

NOTE

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

- 2.3 Use a thin putty knife to loosen sealant around window, and gently pry out window.
- 2.4 Remove all old sealant from around window opening of door; clean surfaces with Naphtha.
- 2.5 Due to slight differences from airframe to airframe, it may be necessary to trim the wedge window assembly to ensure fit. Hold new window in place and trim to fit as required.
- 2.6 Once fit is determined, hold in place, back drill with No. 39 drill bit and cleco in place. Mark location of hinge by making a depression (lightly tap edging with a hammer).
- 2.7 Remove old window and drill out depression to clear hinge rivet. Deburr holes.
- 2.8 Apply sealant (AMS-S-8802 or equivalent) around edges of window opening and install wedge window assembly with Rivets (MS20470A4-8) using existing rivet locations. Install Washers (NAS1149DN432J) on rivets inside window.
- 2.9 Remove sealant squeeze-out with a sharpened piece of acrylic plastic blending wedge window assembly into door.

- 2.10 Clean the **PASSENGER WEDGE WINDOW ASSEMBLIES** 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

- 2.11 Weight change is negligible. Weight and balance is not affected.

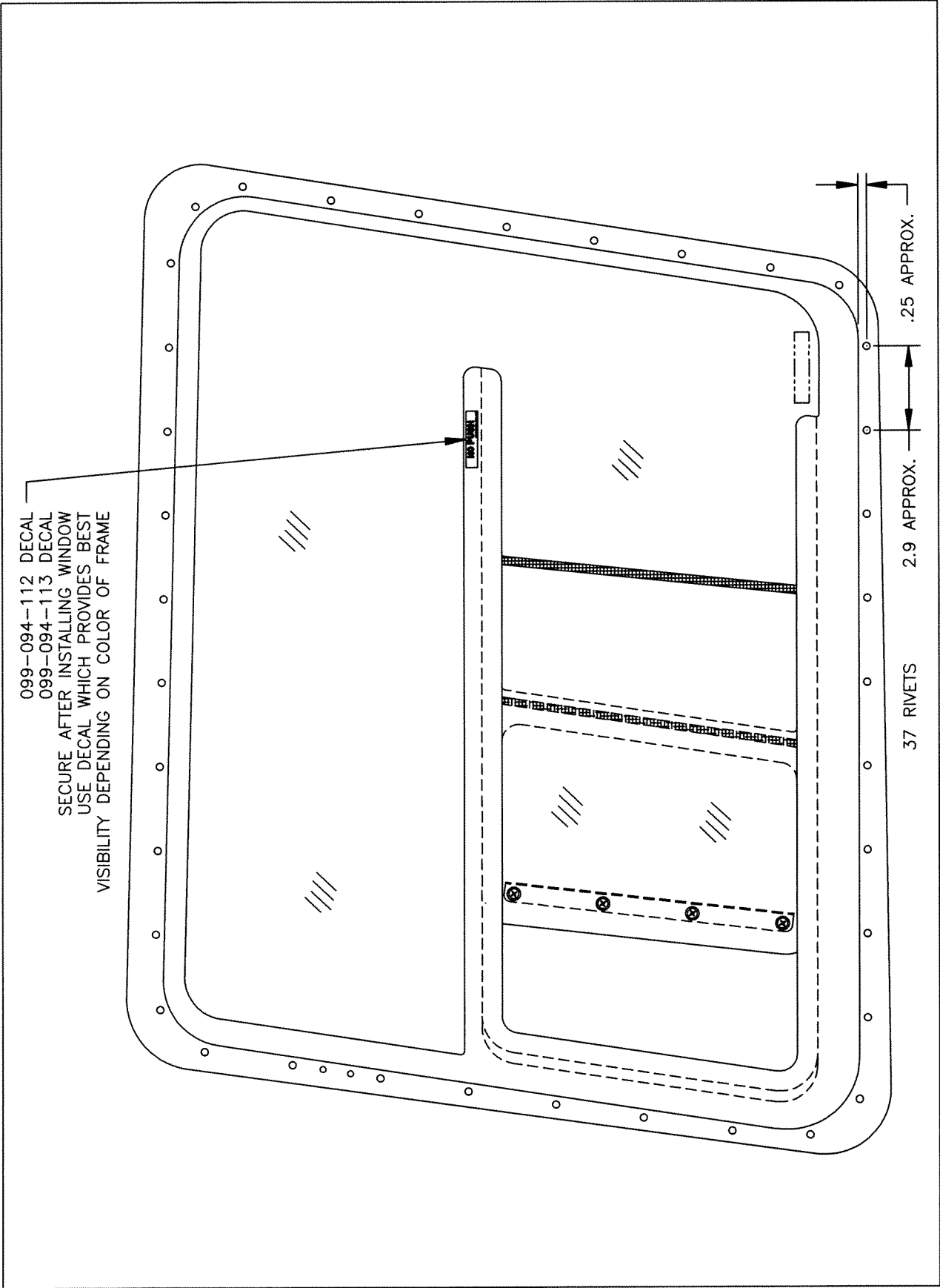


Figure 1

AERONAUTICAL ACCESSORIES, INC.

PARTS LIST**PASSENGER WEDGE WINDOW ASSEMBLY
INSTALLATION KIT**

P/N 206-554-001

P/N 206-554-002

P/N 206-554-011

P/N 206-554-012

P/N 206-554-021

P/N 206-554-022

	-001 Qty.	-002 Qty.	-011 Qty.	-012 Qty.	-021 Qty.	-022 Qty.	Part Number	Description
_____	1						206-554-083	Passenger Wedge Window Assembly L/H
_____		1					206-554-084	Passenger Wedge Window Assembly R/H
_____			1				206-554-283	Passenger Wedge Window Assembly L/H
_____				1			206-554-284	Passenger Wedge Window Assembly R/H
_____					1		206-554-383	Passenger Wedge Window Assembly L/H
_____						1	206-554-384	Passenger Wedge Window Assembly R/H
_____	1	1	1	1	1	1	099-051-001	Hardware Kit
_____	1	1	1	1	1	1	099-094-001	Decal Kit

PARTS LIST

HARDWARE KIT
P/N 099-051-001

-001 Qty.	Part Number	Description
45	MS20470A4-8	Rivet
45	NAS1149DN432J Alt: AN960JD4	Washer

PARTS LIST

DECAL KIT
P/N 099-094-001

-001 Qty.	Part Number	Description
1	099-094-112	Decal – No Push
1	099-094-113	Decal – No Push

Confirm inventory prior to installation.

Packed by: _____ Date: _____ / ____ / ____

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

Number SH1664SO

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

Description of Type Design Change: Installation of replacement windows and windshields in accordance with Aeronautical Accessories, Inc. Report No. KR-362, Drawing List Replacement Windshield and Window Installation dated August 23, 1984, or later FAA approved revision.

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 of 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: May 9, 1984

Date reissued:

Date of issuance: August 29, 1984

Date amended: October 5, 1992



By direction of the Administrator
Paul C. Scorsone
Paul C. Scorsone
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.

This certificate may be transferred in accordance with FAR 21.47.



REPÚBLICA FEDERATIVA DO BRASIL
Ministério da Aeronáutica
CENTRO TÉCNICO AEROSPACIAL

CERTIFICADO DE HOMOLOGAÇÃO SUPLEMENTAR DE TIPO

NÚMERO 9603-19

CATEGORIA NORMAL

Este documento, emitido com base na Portaria nº 453/GM5, de 02 de agosto de 1991, em nome de: **AERONAUTICAL ACCESSORIES, INC.**

P.O. Box 3689

Bristol, TN - 37625

U.S.A.

atesta que a modificação ao projeto de tipo do produto citado abaixo, observadas as limitações e condições especificadas, satisfaz aos requisitos de aeronavegabilidade aplicáveis ao:

PRODUTO ORIGINAL:

Marcas de nacionalidade e de matrícula: -X-X-

Fabricante: BELL HELICOPTER TEXTRON

Modelo(s): 206A, B, L, L-1, L-3 & L-4

Nº de série: -X-X-

Nº do Certificado de Tipo: H2SW (FAA - U.S.A.)

DESCRIÇÃO DA MODIFICAÇÃO AO PROJETO DE TIPO:

Instalação de "WINDOWS AND WINDSHIELDS", da Aeronautical Accessories, Inc., de acordo com o "Report Nº KR-362 Drawing List", Rev.G, de 14 Jan. 94, ou em revisões posteriores aprovadas pelo CTA.

LIMITAÇÕES E CONDIÇÕES:

Conforme listadas na pág. 01 de 01 do Adendo a este CHST.

DATAS:

Do requerimento: 16 MAR 1993

Da emissão: 28 MAR 1996

Da reemissão:

APROVAÇÃO:

CLODOALDO MATIAS DE OLIVEIRA - Ten.-Cel.-Av.
Chefe da Divisão de Homologação Aeronáutica

Maj. Br. A. A. REGINALDO DOS SANTOS
Dirutor do Centro Técnico Aeroespacial



REPÚBLICA FEDERATIVA DO BRASIL
Ministério da Aeronáutica
CENTRO TÉCNICO AEROSPAÇIAL

ADENDO AO CERTIFICADO DE HOMOLOGAÇÃO SUPLEMENTAR DE TIPO

NÚMERO 9603-19

FOLHA 01 DE 01

LIMITAÇÕES E CONDIÇÕES:

- I. Os dados referentes a esta modificação são considerados adequados para reprodução em outras aeronaves de mesmo tipo e modelo.
- II. A aprovação desta modificação não é estendida para outras aeronaves de mesmo tipo e modelo que tenham recebido anteriormente outra modificação aprovada; e não ser que o responsável pela modificação verifique se não há incompatibilidade desta modificação com as anteriormente instaladas e que não haverá nenhum efeito adverso na aeronavegabilidade da aeronave.
- III. Permanecem válidas as limitações e condições estabelecidas na especificação da aeronave nº H2SW, emitida pela FAA (U.S.A.).
- IV. Uma cópia do Certificado, do Adendo, e dos Relatórios abaixo especificados devem ser mantidos como parte integrante dos documentos da aeronave modificada.

RELATÓRIO Nº	REV. / DATA	DESCRIÇÃO
AA-89001	F / 30.11.94	Windshield Installation Instructions - Bell 206A, B, L, L-1, L-3, L-4
AA-88103	E / 21.12.94	Lower Window Installation Instructions - Bell 206A, B, L, L-1, L-3, L-4
AA-88106	E / 20.12.94	Lower Window Installation Instructions - Bell 206A, B, L, L-1, L-3, L-4
AA-88098	B / 01.07.93	Crew Window Installation Instructions - Bell 206A, B
AA-85017	B / 01.07.93	Crew Window Installation Instructions - Bell 206L, L-1, L-3, L-4
AA-90020	C / 01.07.93	Passenger Window Installation Instructions - Bell 206A, B
AA-85018	B / 01.07.93	Passenger Window Installation Instructions - Bell 206L, L-1, L-3, L-4
AA-90021	B / 01.09.93	Skylight Installation Instructions - Bell 206A, B, L, L-1, L-3, L-4
AA-88097	A / 28.10.87	Passenger Wedge Window Installation Instructions - Bell 206A, B
AA-85009	B / 13.01.94	Passenger Wedge Window Installation Instructions - Bell 206L, L-1, L-3, L-4
AA-86013	C / 11.03.94	Litter Door/Fuselage Window Assembly Installation Instructions - Bell 206L, L-1, L-3, L-4

DATAS:

Da emissão: 18 MAR 1996

Da reemissão:

APROVAÇÃO:


CLODOALDO MATIAS DE OLIVEIRA - Ten.-Cel.-Av.
Chefe da Divisão de Homologação Aeronáutica


Maj.-Brig.-do-Ar REGINALDO DOS SANTOS
Diretor do Centro Técnico Aeroespacial

中国民用航空总局

GENERAL ADMINISTRATION OF CIVIL AVIATION OF CHINA

补 证

VALIDATION OF SUPPLEMENTAL TYPE CERTIFICATE

编号/NO. VSTC151

本证颁发给/This Certificate is issued to

Aeronautical Accessories, Inc.

适用机型/Applicable Aircraft Model:

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

叙述/Description:

Manufacture of Replacement Windows and Windshields in accordance with Aeronautical Accessories, Inc. Drawing List Report No. KR-382, no revision, dated August 23, 1984, or later FAA approved revisions, and installation per "Installation Instructions" listed in that report.

使用限制/Limitation:

See the "Limitation and Conditions" of SH1664SO (Issued on March 26, 1998)

经中国民用航空总局审查确认, 上述民用航空产品的设计更改符合中国民用航空规章的有关规定。中国民用航空总局对由 FAA 颁发的第 SH1664SO 号补充型号合格证给予认可。

This is to certify that design change of above civil aeronautical product meets applicable China Civil Aviation Regulations. General Administration of Civil Aviation of China validates the Supplemental Type Certificate No.

SH1664SO issued by FAA

局长授权:

For the Minister of CAAC:

签字/Signature Zhou Kaixuan

职务/Title Deputy Director General

部门/Department CAAC-AAD

日期/Date 8/11/2005

AAIC-186(01/2000)

RECEIVED TIME 18.AUG. 14:29

PRINT TIME 18.AUG. 14:36

Mitteilung über die Ergänzung der Musterzulassung Nr. 0555/3034

Gegenstand der Änderung: Diverse Fenster und Windschutzscheiben

Drehflügler-Baureihe(n): Bell 206A, 206B, 206L, 206L-1, 206L-3, 206L-4

Drehflügler-Kennblatt Nr: 3034

Antragsteller: Fa. Aeronautical Accessories, Inc. (U.S.A.)

Der Zulassungsumfang der o.g. Drehflügler-Baureihe(n) wird wie folgt geändert:

Der Einbau von Fenster und Windschutzscheiben in o. g. Hubschraubermuster gemäß STC SH1664S0 vom 29.08.1984, Rev. vom 5.10.1992 oder späterer FAA-anerkannter Revision, ist zugelassen.

Definition der Änderung:

Aeronautical Accessories Report No. KR-362 " Drawing List Replacement Windshield and Window Installation vom 23. August 1984 oder späterer FAA-anerkannter Revision.

Kit P/N: 206-540-003 (L/H), 206-540-004 (R/H), 206-542-001 (L/H), 206-542-002 (R/H), 206-542-003 (L/H), 206-542-004 (R/H), 206-544-107 (L/H), 206-544-108 (R/H), 206-545-113 (L/H), 206-545-114 (R/H), 206-546-109 (L/H), 206-546-110 (R/H), 206-548-031 (L/H), 206-548-032 (R/H), 206-558-145 (L/H) und 206-558-146 (R/H).

Ergänzende Betriebsanweisungen:

Installation Instructions:

Aeronautical Accessories, Inc. Reports No.:
AA-89001, AA-88103, AA-88106, AA-88098, AA-85017, AA-90020, AA-85018,
AA-90021, AA-88097, AA-85009 und AA-86013,

in der jeweils gültigen Revision.

Lärmzulassung: Änderung nicht lärmrelevant

Bezugsquelle für die Betriebsunterlagen:

Aeronautical Accessories, Inc.
P.O. Box 3689
Bristol, Tennessee 37625-3689
U.S.A.

Diese Mitteilung gilt in Verbindung mit dem Drehflügler-Kennblatt Nr. 3034 in der jeweils gültigen Ausgabe.

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,L-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,L-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	SH2289SO	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

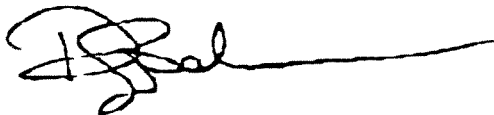
Issue 8 has been raised to include Replacement Door Locks and Locking Fuel Cap

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

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For the Civil Aviation Authority

Date 8 October 1999