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INSTALLATION INSTRUCTIONS

PASSENGER VERTICAL SLIDE WINDOW ASSEMBLY KIT

206-559-059 WINDOW ASSY
206-559-060 WINDOW ASSY
206-559-257 WINDOW ASSY
206-559-258 WINDOW ASSY

FOR

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

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**INSTALLATION INSTRUCTIONS
PASSENGER VERTICAL SLIDE WINDOW
ASSEMBLY KIT**

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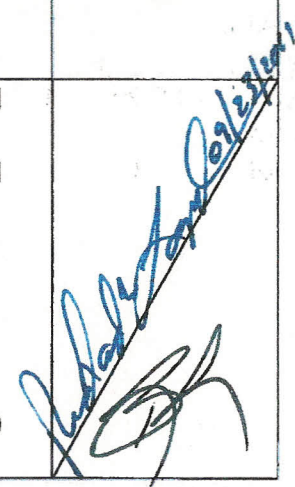
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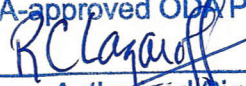
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LOG OF REVISIONS

Rev.	Date	Description	Pages	Prepared By
				Approved by
A thru I	12/29/97	Various Technical Updates	All	N/A
J	04/02/98	Added Log of Revisions Page Added note Deleted Steps 13.1 – 13.3 Revised Steps 10, 11, & 14 Added Kits 206-559-305/ -306/ -313/-314	2 3 4, 5 4, 5 All	N/A
K	06/30/98	Deleted Parts List for -301/ -302/ -303/ -304 Kits Deleted Sheet 8 and renumbered	7 All	N/A
L	05/22/00	Revised Washer Callout	4, 7	N/A
M	05/16/08	Reformatted Document Deleted Step 2.14 and Re-sequenced Revised 206-559-200 Parts List	All 6 9	N/A
N	09/23/11	Reformatted Document to current AA standards and revised all references from AAI to AA. Resequenced Document Added Section 2.0 General Notes Added Note to Section 3.2 Added Section 3.15 Deleted Caution Note in Section 4.1 and moved to Section 2.3 Revised Figure 1 to add rivet and washer callouts Added NAS1149DN832J Washer quantity of 2 to 206-559-200 Hardware Kit in Parts List	All All 5 6 7 8 9 10	

This data has been approved by
BHTI ODA-710621-SW, IAW the
FAA-approved ODA Procedures Manual
 10-7-11
Authorized Signature/Date

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**INSTALLATION INSTRUCTIONS
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1.0 INTRODUCTION

These instructions provide the information necessary to install the **AERONAUTICAL ACCESSORIES PASSENGER VERTICAL SLIDE ASSEMBLY KIT** on Bell Helicopter Textron models 206 A, B, L, L-1, L-3, and L-4 helicopters. All Engineering aspects of these instructions are FAA approved under STC No. SH2365SO.

NOTE

Refer to Bell Helicopter Model 206 Maintenance Manual and all applicable maintenance manuals and/or ICAs for disassembly/reassembly instructions not specifically addressed in this document. Read ALL instructions thoroughly and have a clear understanding BEFORE beginning.

NOTE

If installing both L/H and R/H sliding windows without crew wedge windows or center bulged windows installed, the Passenger Vertical Slide Optional Deflector Kit (206-559-353/-354 for 206L, L-1, L-3, L-4 or 206-559-355/-356 for 206A, 206B) is required. The Deflector Kit will be provided at no charge by customer request.

2.0 GENERAL NOTES

- 2.1 Tag all parts, including attaching hardware (unless otherwise noted), removed to gain access to work areas. Protect parts from damage until re-installed.
- 2.2 Following any drilling or cutting operation, remove burrs and particles. Apply a thin coat of primer per MIL-PRF-23377 to bare metal surfaces, except when used for grounding.
- 2.3 Before applying adhesive to bonded surfaces, remove protective finish to bare metal. Wipe clean with MEK (methyl ethyl ketone) or equivalent, and wipe dry before MEK evaporates.

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.

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- 2.4 For 099-050-222 and 099-050-232 Sealants, allow 24 hours curing time (room temperature) for a tack free cure and 72 hours curing time (room temperature) for a full cure.
- 2.5 The installation figures included in these instructions may show either the L/H or R/H Passenger Vertical Slide Window Assembly Kit installation.
- 2.6 Cover the windows and the airframe during kit installation to prevent damage.

3.0 INSTALLATION INSTRUCTIONS

- 3.1 The **PASSENGER VERTICAL SLIDE WINDOW ASSEMBLIES** 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.
- 3.2 Drill out the heads of the old rivets around the old window, and use a punch to knock out the remaining stems of the rivets. Remove and discard the existing window.

NOTE

The rivets holding the door hinge to the aircraft do not need to be drilled out unless they are through the existing window frame. Drill out the rivets and replace with MS20470AD5-8 rivets and NAS1149DN832J washers. Do not put the rivet through the new window frame.

NOTE

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

- 3.3 Use a thin putty knife to loosen the sealant around window, and gently pry out the window.
- 3.4 Remove all of the old sealant from around the window opening and clean all surfaces with solvent.
- 3.5 Remove the eight (8) screws holding the handle to the slide window. Remove the 206-559-271 Slide Window Assembly L/H (206-559-272 Slide Window Assembly R/H) from the window assembly. Retain all of the mounting hardware. Set the slide window assembly in a protected area for reinstallation at a later time.
- 3.6 Due to slight differences from airframe to airframe, it may be necessary to trim the window assembly for a proper fit. Hold the new window in place and trim to fit as required.

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- 3.7 Once fit is determined, hold the window in place; back drill, and Cleco into place.
- 3.8 Remove the window and deburr all holes.
- 3.9 Replace the window assembly on the door assembly and secure in place using Clecos. Temporarily install the slide window assembly. Orient the slide window with the lower seal strip facing inboard. Carefully slide the window into the up position. Secure the handle with the previously removed hardware. Slide the window to the down position.
- 3.10 Holding the two tracks securely in position, locate the new rivet locations using approximately 2.9 inch rivet spacing and maintaining proper edge distance. Remove door carpet to prevent damage. 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 slide window slides freely.
- 3.11 After the tracks have been match drilled to the door, the bottom brace should be removed. Ensure that the track extends slightly below the slide window in the full down position. Maintain proper rivet edge distance when trimming; add one additional rivet on each side as required. At this time, countersink the rivet holes that fall between the vertical slide tracks. Flush head rivets (MS20426A3-8) are utilized in this location to eliminate interference with the slide window.
- 3.12 Remove window assembly from the door. Deburr all the holes in the window edging, track and door.
- 3.13 Apply a small bead of Sealant (099-050-222) on the contacting surfaces of the window edging and track. Cleco the window assembly in place on the door. Measure and trim all MS rivets to proper length. Insert rivets (MS20470A3-8) into the holes around window edge and slide washers (140-001-11) over each rivet before upsetting. Insert rivets (MS20426A3-8) in the countersunk holes between the window tracks. Slide washers (140-001-11) over each rivet before upsetting. Assemble the washers (NAS1149DN632J) onto the rivets (MS20470A4-3) before inserting the rivets into door/track assembly.
- 3.14 Remove any sealant squeeze out with a sharpened piece of acrylic plastic. Blend the window assembly and tracks into door to minimize gaps. Paint the window assembly edging and tracks as desired to match existing aircraft paint scheme.
- 3.15 Installation Complete.

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4.0 MAINTENANCE INSTRUCTIONS

- 4.1 Clean the **PASSENGER 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.

5.0 WEIGHT AND BALANCE

- 5.1 Net Weight Change: Negligible

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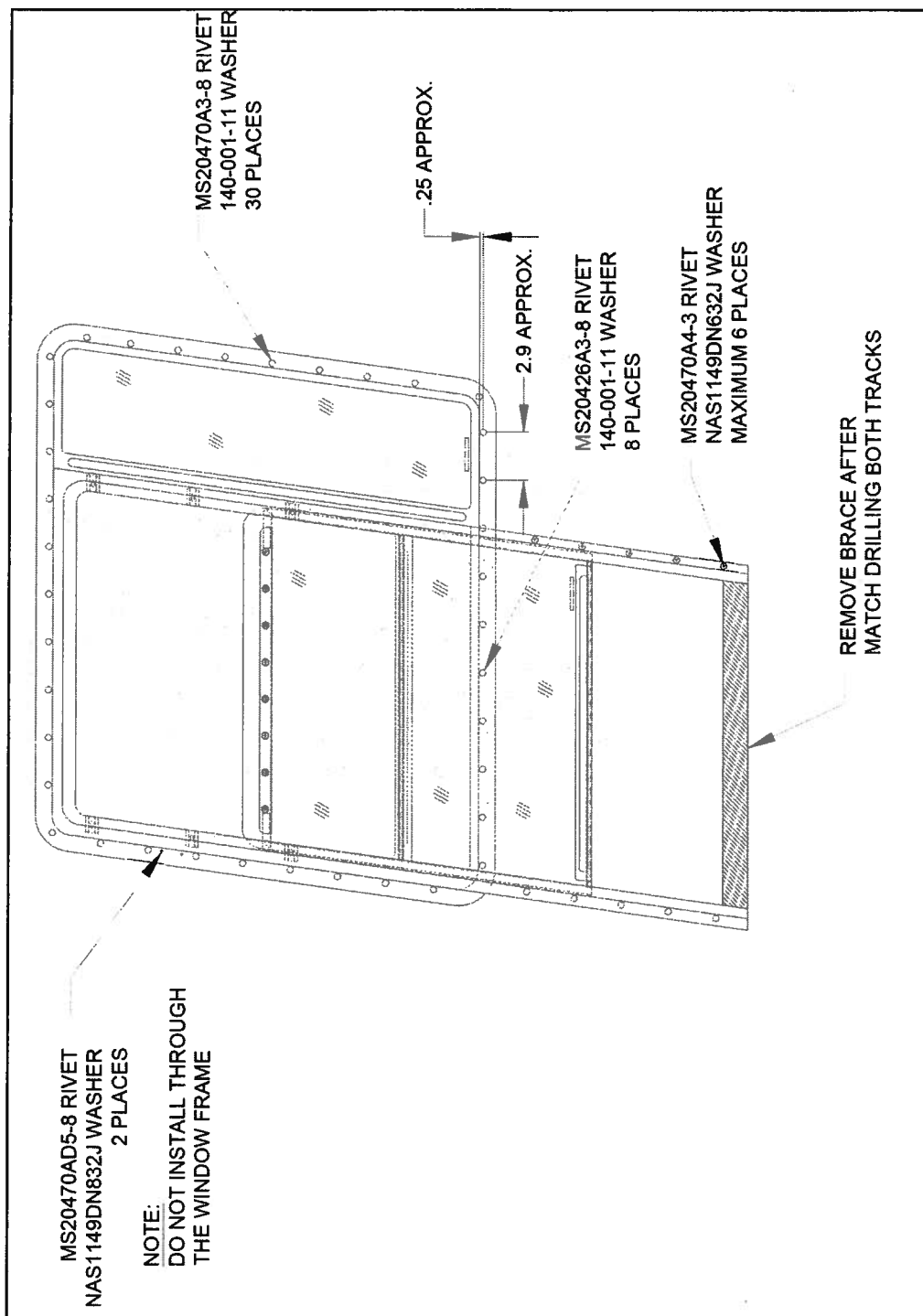


FIGURE 1
Rivet Hole Pattern

**INSTALLATION INSTRUCTIONS
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PARTS LIST

**206-559-305 L/H A, B
206-559-306 R/H A, B
206-559-313 L/H L, L-1, L-3, L-4
206-559-314 R/H L, L-1, L-3, L-4**

	<u>Qty</u> <u>-305</u>	<u>Qty</u> <u>-306</u>	<u>Qty</u> <u>-313</u>	<u>Qty</u> <u>-314</u>	<u>Part Number</u>	<u>Description</u>
_____	1				206-559-059	Vert. Slide Window Assy L/H
_____		1			206-559-060	Vert. Slide Window Assy R/H
_____			1		206-559-257	Vert. Slide Window Assy L/H
_____				1	206-559-258	Vert. Slide Window Assy R/H
_____	1	1	1	1	206-559-200	Hardware Kit

206-559-200 Hardware Kit

	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>
_____	30	MS20470A3-8	Rivet
_____	11	MS20470A4-3	Rivet
_____	8	MS20426A3-8	Rivet
_____	2	MS20470AD5-8	Rivet
_____	40	140-001-11	Washer
_____	11	NAS1149DN632J	Washer
_____	2	NAS1149DN832J	Washer
_____	1	099-050-222	Sealant
		Alt.: 099-050-232	Sealant

Confirm inventory prior to installation.

Packed by: _____ / /

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

Number SH2365SO

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 vertical sliding window on passenger door in accordance with Aeronautical Accessories, Inc. Report No. AA-88035, "Drawing List - Passenger Vertical Slide Window Assembly BHT 206A/B/L/L-1/L-3 Model Helicopters" dated May 18, 1988 or later FAA approved revision.

Limitations and Conditions: Installation allowed on left, right, or both passenger doors. 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 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.

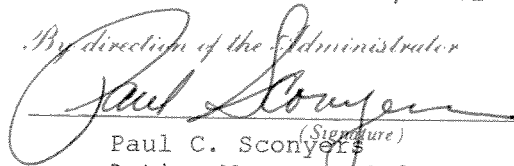
Date of application: May 20, 1988

Date issued:

Date of issuance: June 27, 1988

Date amended: October 5, 1992



By direction of the Administrator

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.