

EAGLE TECHNICAL BULLETIN

REF. TCCS STC: SH07-28
REF. FAA STC: SR02831NY

Eagle Technical Bulletin Number: **TB-E212-725-7**

Purpose: To provide instructions for the extension of the Bell 212 pylon channels.

Eligible Serial Numbers: ALL

Compliance: Optional

Description: This technical bulletin (TB) provides instructions to extend the existing Bell 212 Pylon Channels by splicing a section onto the end of the Bell 212 Pylon Channel to match the dimensions of the Bell 205 Pylon Channels.

Parts List:

ITEM	-101 QTY	-102 QTY	PART NUMBER	DESCRIPTION
	X		TB-E212-725-7-101	PYLON EXTENSION, LH
		X	TB-E212-725-7-102	PYLON EXTENSION, RH
1	1		TB-E212-725-7-1	DOUBLER, 0.063 THK 2024-T3, QQ-A-250/4
2		1	TB-E212-725-7-2	DOUBLER, 0.063 THK 2024-T3, QQ-A-250/4
3	1		TB-E212-725-7-3	DOUBLER, 0.063 THK 2024-T3, QQ-A-250/4
4		1	TB-E212-725-7-4	DOUBLER, 0.063 THK 2024-T3, QQ-A-250/4
5	1	1	TB-E212-725-7-5	FILLER, 0.063 THK 2024-T3, QQ-A-250/4
6	1	1	TB-E212-725-7-7	RADIUS BLOCK, 0.125 THK 2024-T3, QQ-A-250/5
7	1	1	TB-E212-725-7-9	RADIUS BLOCK, 0.125 THK 2024-T3, QQ-A-250/5
8	1		TB-E212-725-7-11	BRACKET, 0.050 THK 2024-T3, QQ-A-250/4*
9		1	TB-E212-725-7-12	BRACKET, 0.050 THK 2024-T3, QQ-A-250/4*
10	1	1	TB-E212-725-7-13	SHIM, 0.75 X 3.5 X 0.063 THK 2024-T3, QQ-A-250/4*
11	AR	AR	MS20470AD5	RIVET (LENGTH AS REQUIRED)
12	AR	AR	MS20615-5M (REF)	RIVET (LENGTH AS REQUIRED)
13	AR	AR	S317	ADHESIVE
14	AR	AR	S204	EPOXY POLYAMIDE PRIMER
15	AR	AR	S392	SEALANT

* Alternate 6013-T4, AMS4347

Weight and Balance: The incorporation of this Technical Bulletin has a negligible effect on the Aircraft Weight and Balance.

B	DIMENSION & BEND RADIUS CHANGE ON TB-E212-725-7-1/-2, TB-E212-725-7-3/-4 & TB-E212-725-7-11/-12	JK	2024-08-14
A	NEW ISSUE	MC	2022-01-04
REV	DESCRIPTION	BY	DATE
DESIGN	<i>JK</i>	EAGLE COPTERS LTD CALGARY, AB, CANADA	
DRAWN	N/A	DRAWING NO.	REV. B
CHECKED	<i>AS</i>	TB-E212-725-7	SHEET 1 OF 10
MFG. APPR.	N/A	TITLE	
APPROVED	<i>AP</i>	PYLON CHANNEL MODIFICATION	
DE APPR.	N/A	DATE	
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Procedure:

NOTE: If this modification is completed, there is no need to replace the Bell 212 Pylon Channels (PN: 212-030-919-051/-052) as described in the Eagle Single Installation Instructions, IIN-D212-725, Section 12.3, Modification to Beam Assembly. Steps 12.3.8 and 12.3.14 through 12.3.16 of Section 12.3 are not to be completed if TB-E212-725-7 is incorporated.

1. Gain access to the LH Pylon Channel in accordance with ICA-D212-725 and BHT-212-MM and perform steps 2 through 20 using parts from the TB-E212-725-7-101 kit.
2. Fluorescent penetrant inspect the channel and adjacent structures for cracks. Inspect exposed areas for corrosion, damage, or contamination, in accordance with BHT-ALL-SRM.

NOTE: If damage to the existing Bell 212 pylon channel is discovered and is within the damage limits as defined in BHT-MED-SRM-1 4-6-4 PYLON SUPPORT INSTL – LEFT SIDE OR RIGHT SIDE REPAIR, this modification may be used in place of the repair. If damage exceeds the allowable damage limits as defined in the repair instructions, contact Eagle Customer Support.

3. If applicable, cut out and remove damaged portion of channel flange in accordance with BHT-MED-SRM-1 Section 4-6-4.
4. Deburr all edges, remove all debris and loose material.
5. Prepare TB-E212-725-7-1 (-2 Opposite) Doubler as shown in Figure 1. Break all sharp edges.
6. Prepare TB-E212-725-7-3 (-4 Opposite) Doubler as shown in Figure 2. Break all sharp edges.
7. Prepare TB-E212-725-7-5 Filler as shown in Figure 3. Trim filler to fit, break all sharp edges.
8. Prepare TB-E212-725-7-7/-9 Radius Blocks as shown in Figure 4. Break all sharp edges.
9. Prepare TB-E212-725-11 (-12 Opposite) Bracket as shown in Figure 5. Break all sharp edges.
10. Locate all parts in position and drill new fasteners using fastener pattern shown in Figure 6. Maintain proper edge distance and spacing. Transfer existing fastener holes, same size as originals. Trim parts to fit as required, maintaining proper edge distance, and spacing.
11. Remove all parts, deburr all holes, remove debris and loose material.
12. Remove paint, dirt, and primer from area and clean for bonding, in accordance with BHT-MED-SRM-1 3-2-3 Removal of Paints and Primers and 3-2-5 Preparation of Panel Bonding Surfaces.
13. Locate and bond all parts in position using item 13 (bonding adhesive), in accordance with BHT-MED-SRM-1 3-2-7 Bonding of Flat Stock.
14. Secure all parts using new fasteners, (item 11 and item 12) of the original type and size in the original locations, as shown in Figure 6 and 7. Install all rivets wet with item 13 (bonding adhesive) while adhesive is still wet.
15. Remove excess adhesive squeeze out.

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MFG. APPR.	N/A	TB-E212-725-7	SHEET 2 OF 10
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16. Allow to cure at room temperature for 24 hours applying a pressure of 0.50 to 1.00 psi to the repair area.
17. Inspect for voids and unbonded area(s). Voids shall not exceed 10% of the total bonded area. No one void shall exceed 0.25 square inches in area.
18. Prime all bare metal surfaces using item 14 (epoxy polyamide primer). Allow to dry.
19. Seal all edges of repair area using item 15 (sealant). Allow to dry and prime sealant.
20. Finish as required in accordance with ICA-D212-725.
21. Gain access to the RH Pylon Channel in accordance with ICA-D212-725 and BHT-212-MM and repeat steps 2 through 20 using parts from the TB-E212-725-7-102 kit.
22. Make an entry into the aircraft technical reports to indicate TB-E212-725-7 has been completed.
23. Notify Eagle Copters that this Technical Bulletin has been accomplished by filling out the attached form (Sheet 10) and emailing it to Eagle Copters.

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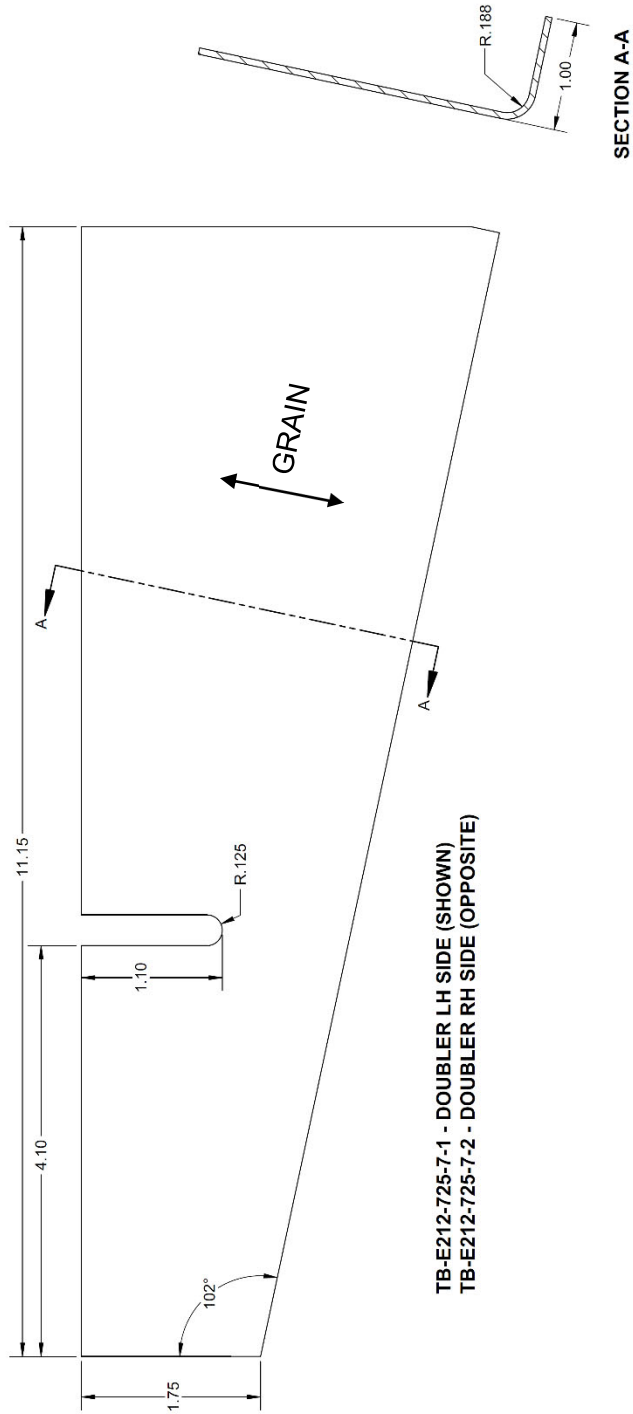


Figure 1 TB-E212-725-7-1/-2 Doubler

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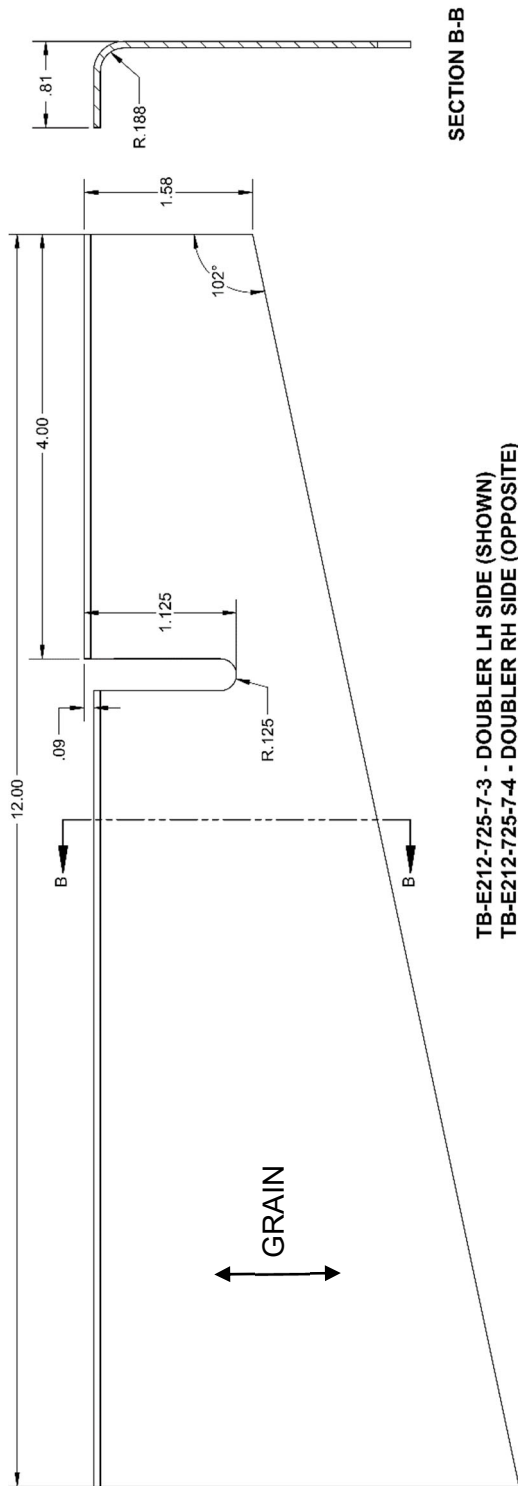
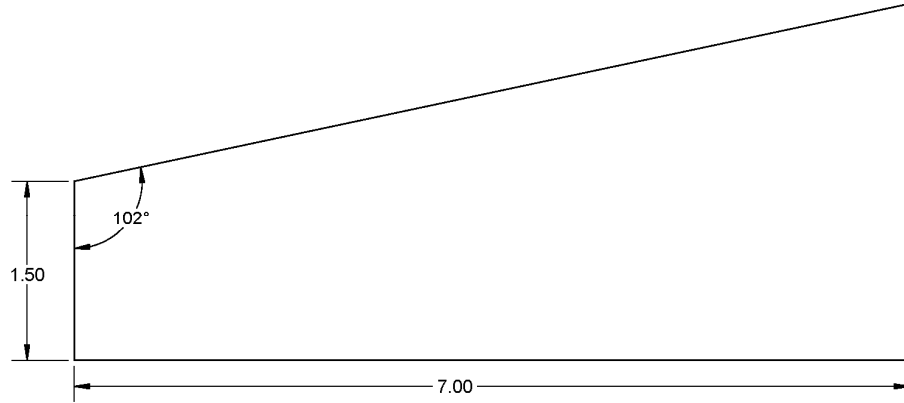


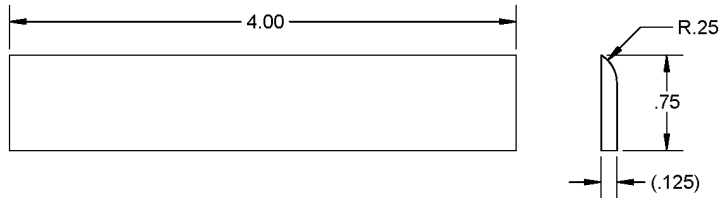
Figure 2 TB-E212-725-7-3/-4 Doubler

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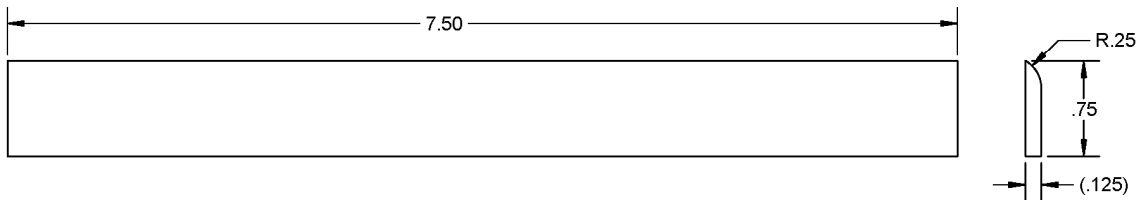


TB-E212-725-7-5 - FILLER

Figure 3 TB-E212-725-7-5 Filler



TB-E212-725-7-7 - Radius Block



TB-E212-725-7-9 - Radius Block

Figure 4 TB-E212-725-7-7 Radius Block and TB-E212-725-7-9 Radius Block

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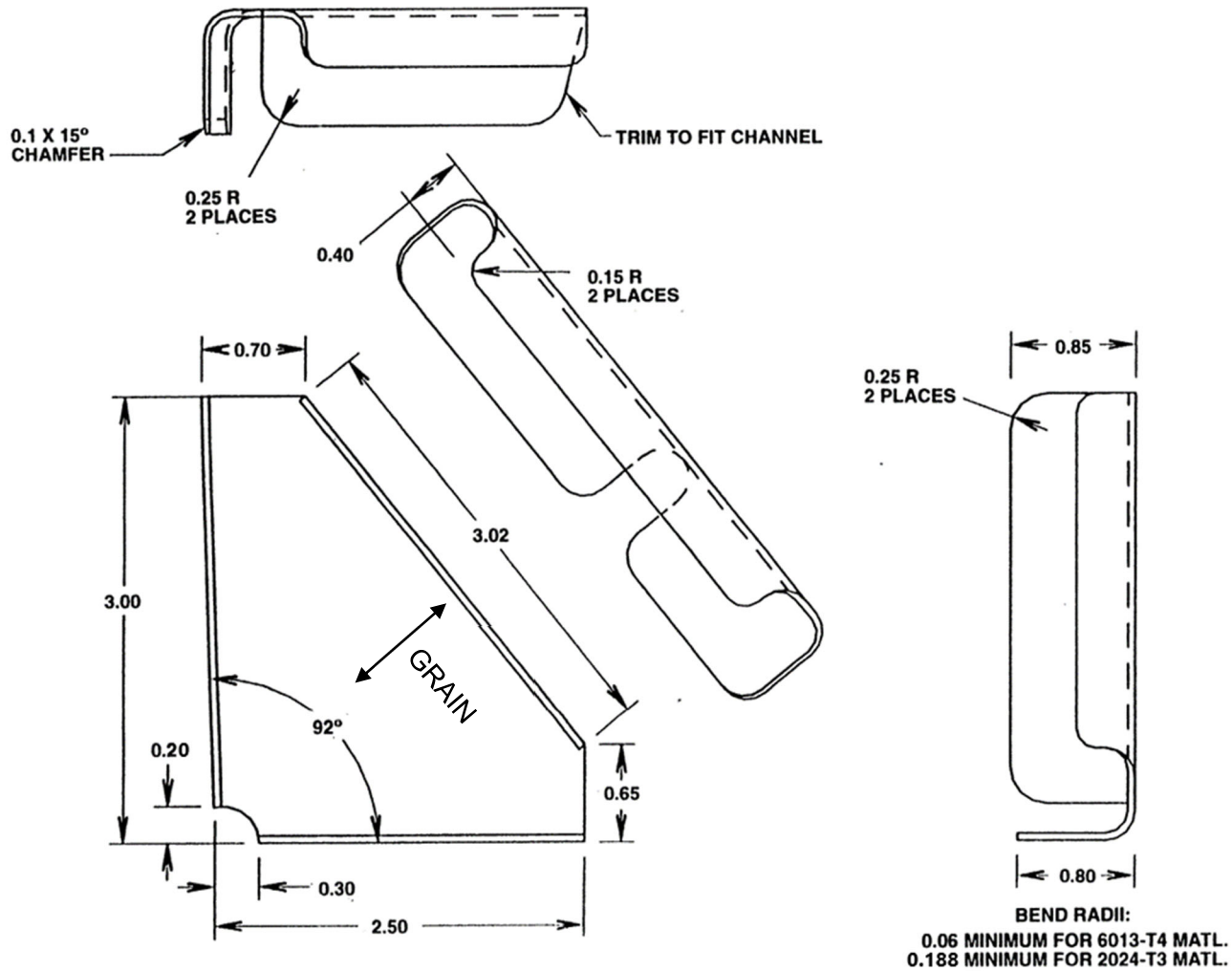


Figure 5 TB-E212-725-7-11/-12 Bracket

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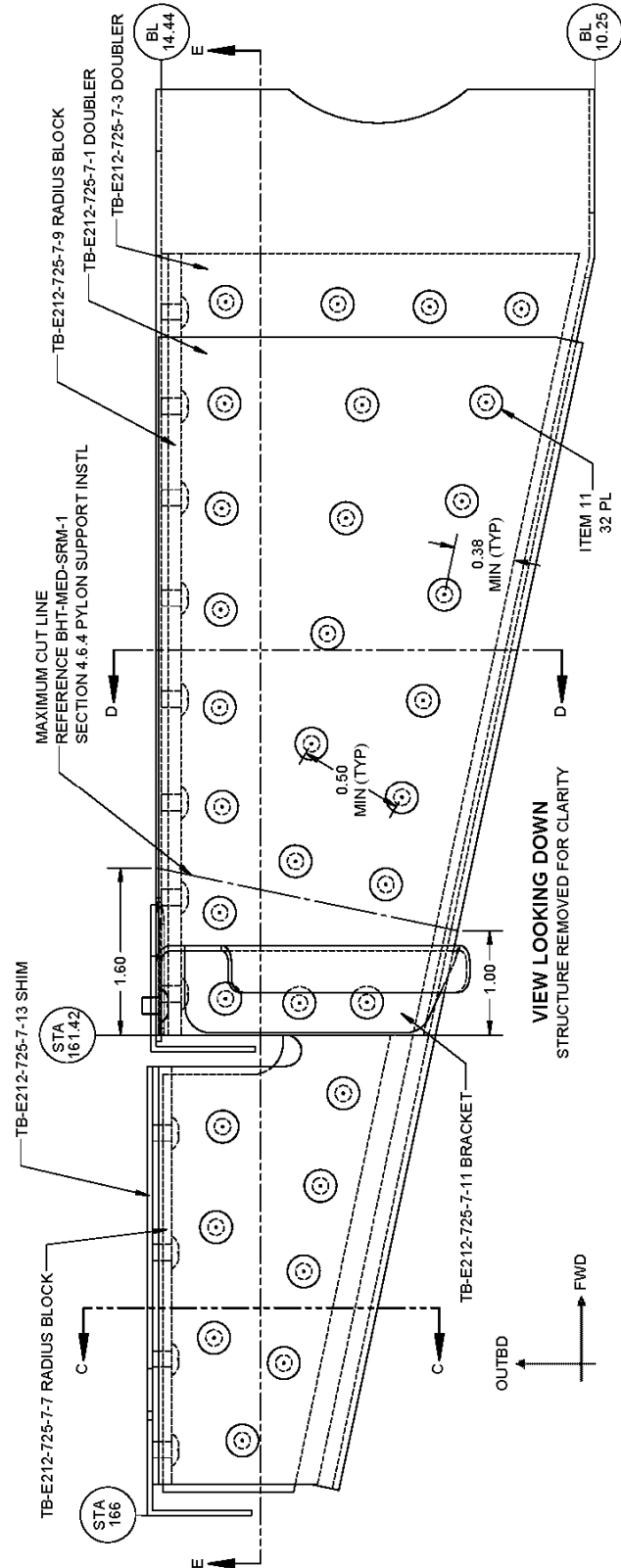


Figure 6 TB-E212-725-7-101 Installation (-102 Opposite)

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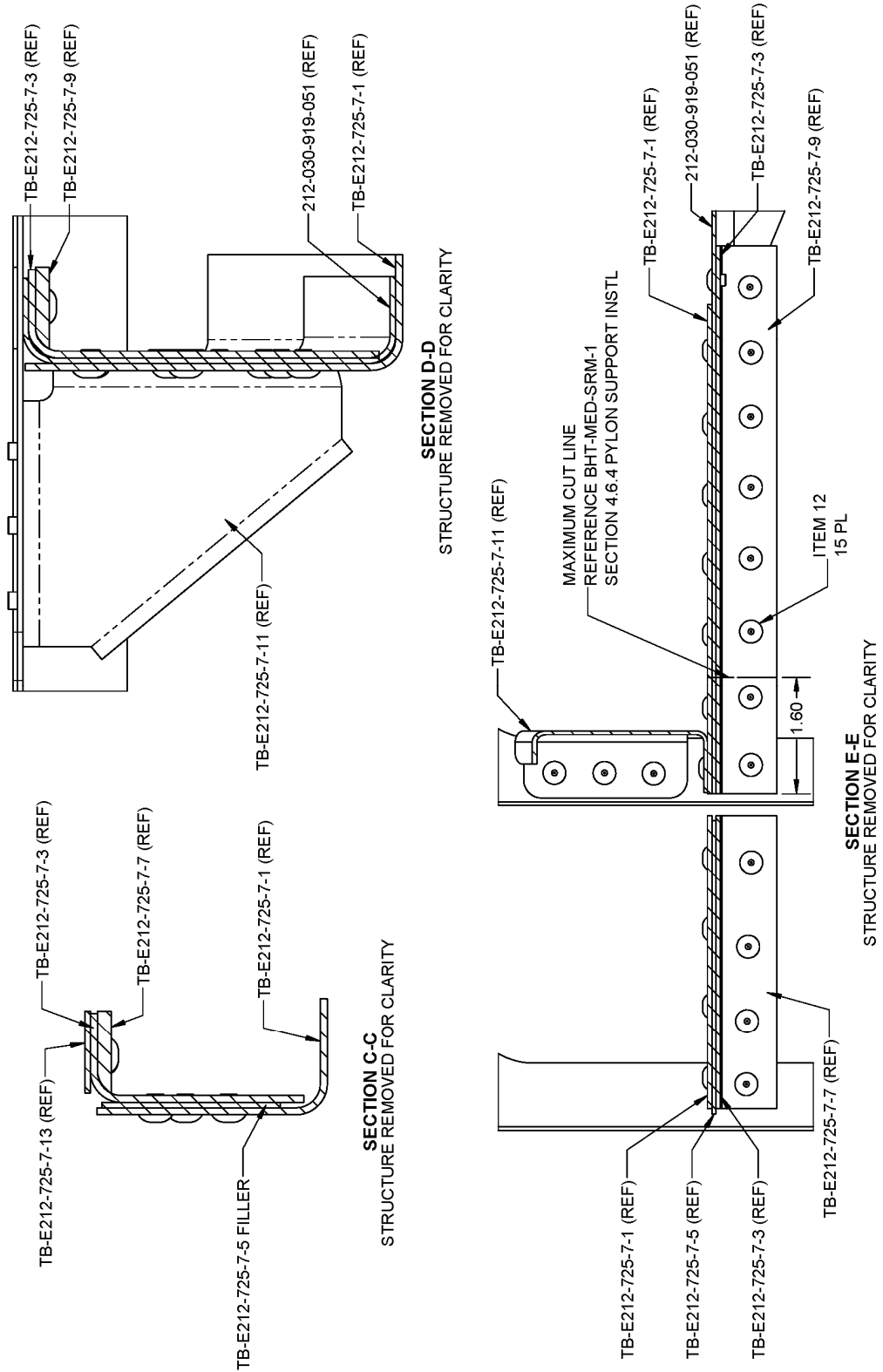


Figure 7 TB-E212-725-7-101 Installation (-102 Opposite) (continued)

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NOTIFY EAGLE COPTERS THAT THE TB-E212-725-7 HAS BEEN INCORPORATED INTO THE AIRCRAFT LISTED BELOW.

AIRCRAFT SERIAL NUMBER: _____

AIRCRAFT OWNER: _____

DATE TB-E212-725-7 WAS INCORPORATED ON THE ABOVE AIRCRAFT:

SIGNATURE OF PERSON RESPONSIBLE FOR ENTRY INTO AIRCRAFT TECHNICAL RECORD:

PRINT NAME OF PERSON RESPONSIBLE FOR ENTRY INTO AIRCRAFT TECHNICAL RECORD:

EMAIL THIS PAGE TO: customersupport@eaglecopters.com

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