

**Technical Bulletin**  
206/407AC-13-1, Rev. 0  
01/25/2013

**TO:**

Owners/Operators of Bell Model 206 Series or 407 helicopters equipped with Paravion Technology, Inc. Air Conditioner Installation Kits P/N 206AC-110-(X), 206AC-111-(X), 407AC-110-(X)

**SUBJECT:**

Compressor Service Fitting Replacement

**COMPLIANCE:**

At Customer's Option

**REFERENCES:**

Applicable Bell Helicopter Textron Maintenance, Standard Practices and Parts Manuals.

The following Paravion Technology, Inc. documents  
Compressor Installation Drawings, 206AC-310 Rev. F, dated 03/06/2002 (206A/B)  
206AC-311 Rev. F, dated 09/25/2009 (206L Series)  
407AC-310 Rev. F, dated 05/08/2008 (407) or later FAA approved revisions.  
Installation Instructions 206AC-900M rev. L dated 08/16/2012, 407AC-900M Rev. L,  
dated 07/02/2012.

Instructions for Continued Airworthiness, PR-206AC-120M Rev. 1, or PR-407AC-120M Rev. 7 or later FAA approved revision.

**DESCRIPTION:**

This bulletin describes the minimum parts and instructions necessary to replace the current compressor service fittings with an alternate configuration to enhance servicing.

**APPROVAL:**

The engineering design aspects of this bulletin are Paravion Technology, Inc. approved.

**APPLICABLE PARTS LISTING:**

The following is a list of minimum applicable parts necessary to convert the existing service fitting configuration to an alternate configuration.

Item Number	Part Number	Description	Qty.	Notes
1	V332	Adaptor	1	Installed on suction port side
2	V330	Adaptor	1	Installed on discharge port side
3	GA1533	Service Port*	2	Replaces both service ports
4	6502-4-4	45 deg. Elbow**	1	Installed on discharge port side
5	SECO 7A4	Seal	1	Between service port & discharge
--	L29010B	Thread locker	1	Permatex Corp.

\*Remove Schrader valve before installing this fitting.

\*\*Modified elbow per dwg. 407AC-3110 Rev. G or later FAA approved revision.

**COMPLIANCE:**

The following steps should be taken to remove the existing service valve configuration;

- A. Referencing the appropriate aircraft model installation drawing and BHT Maintenance Manuals, gain access to the compressor installation in the engine compartment.
- B. Remove the refrigerant charge per the ICA and installation instructions.
- C. Remove and discard existing compressor service fittings one at a time.

**NOTE: Remove Schrader valve from new GA1533 service ports before re-assembly.**

- D. With figure 1 of this document as a guide, install new fittings. Maintain the 25 deg. angle shown to facilitate servicing. Torque all fittings per ICA torque table recommendations.

**NOTE: Apply a small amount of thread locking compound at each thread joint being careful not to introduce contamination into the compressor.**

Use a small amount of refrigerant oil on seal surfaces, assure Schrader valves are tight and in service adaptors only.

- 1. Service the air conditioning system in accordance with the applicable ICA. Weight & balance is not significantly affected by compliance with this bulletin.
- 2. Record bulletin compliance and system servicing in aircraft logbook.

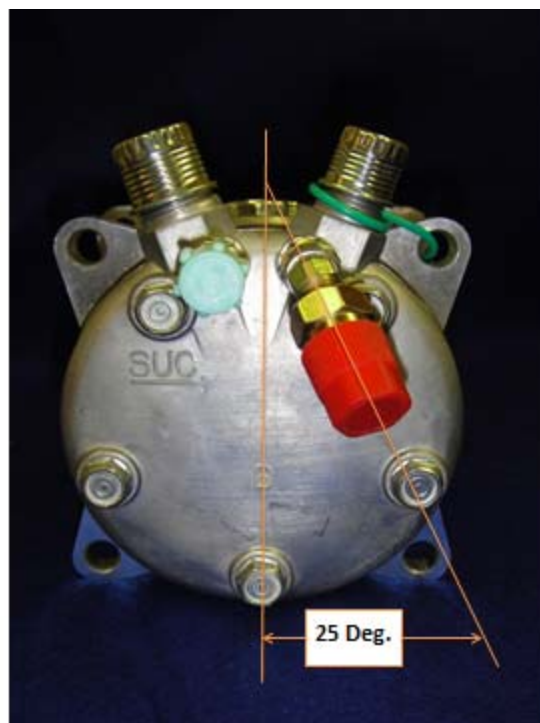
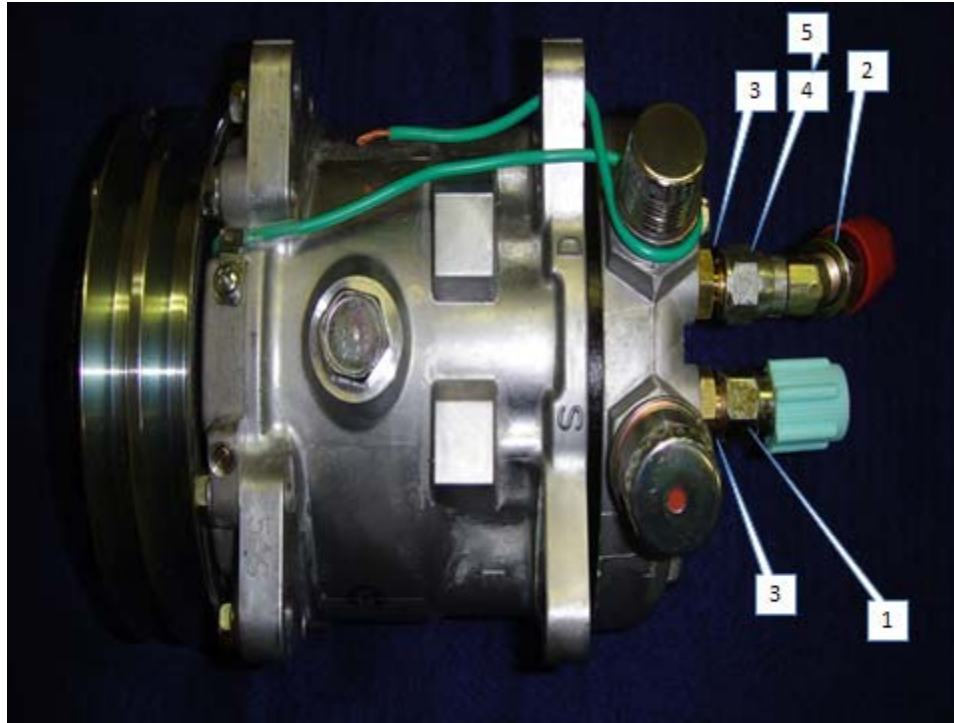


FIGURE 1