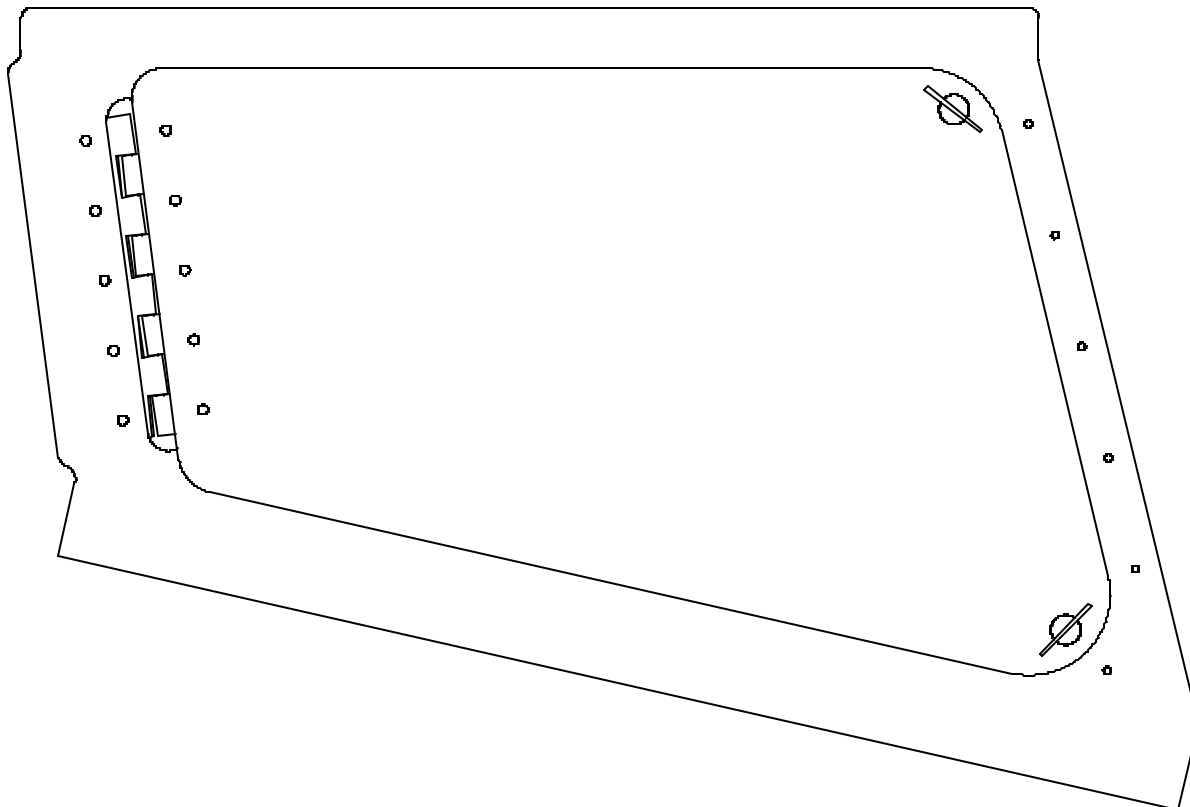




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**OIL COOLER SUPPORT,
ACCESS DOOR
INSTALLATION INSTRUCTIONS**

MODELS: BELL 212/412

Read all of the instructions thoroughly prior to the installation of this product.



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INSPECTION

- 1) Refer to the Oil Cooler Support, Access Door Maintenance Manual Supplement, Models: BELL 212/412.

Document No.: 191M-99-006-MMS

WEIGHT & BALANCE

	<u>Weight</u> (Lbs.)	<u>Long. Arm</u> (Inches)	<u>Lat. Arm</u> (Inches)
Oil Cooler Support, Access Door Assy, LHS P/N: AAL-061-812-001	Negligible	N/R	N/R
Oil Cooler Support, Access Door Assy, RHS P/N: AAL-061-812-002	Negligible	N/R	N/R

INSTALLATION NOTES

- 1) All instructions, where applicable, are to be completed using standard aircraft sheet metal and maintenance practices.
- 2) All hardware must be torqued to standard specs.
- 3) Reference numbers in installation correspond to dash numbers in Parts List.

INSTALLATION

- 1) Remove existing rivets in oil cooler support bulkhead as shown. 1/8", 9 places, and 3/32", 9 places. Reference Figure 1.
- 2) Cleco Layout Template, -109, to exterior of oil cooler support bulkhead as shown. Reference Figure 2.
- 3) Transfer all holes from Layout Template, -109, into oil cooler support bulkhead as shown. .125" dia., 5 places, and .094" dia., 6 places. Reference Figure 2.

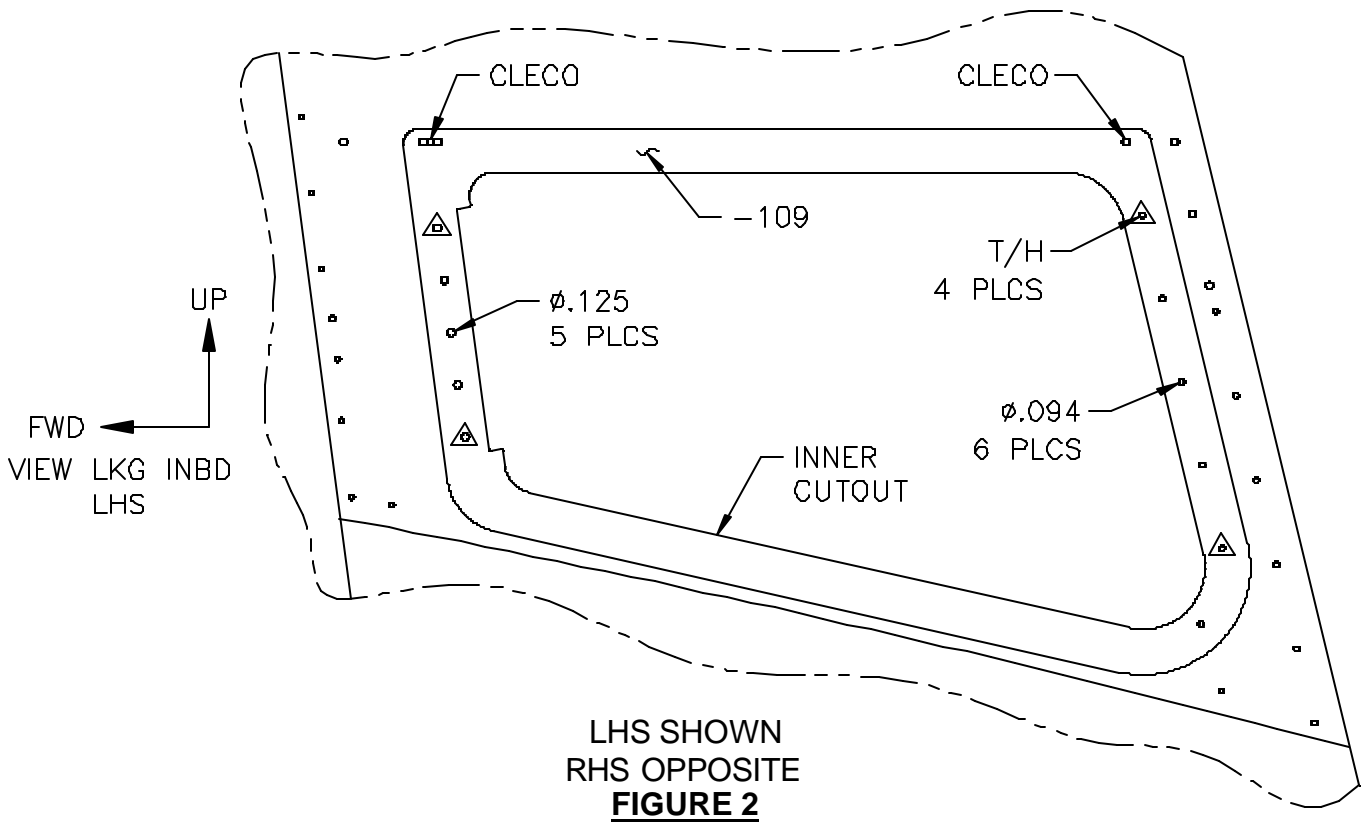
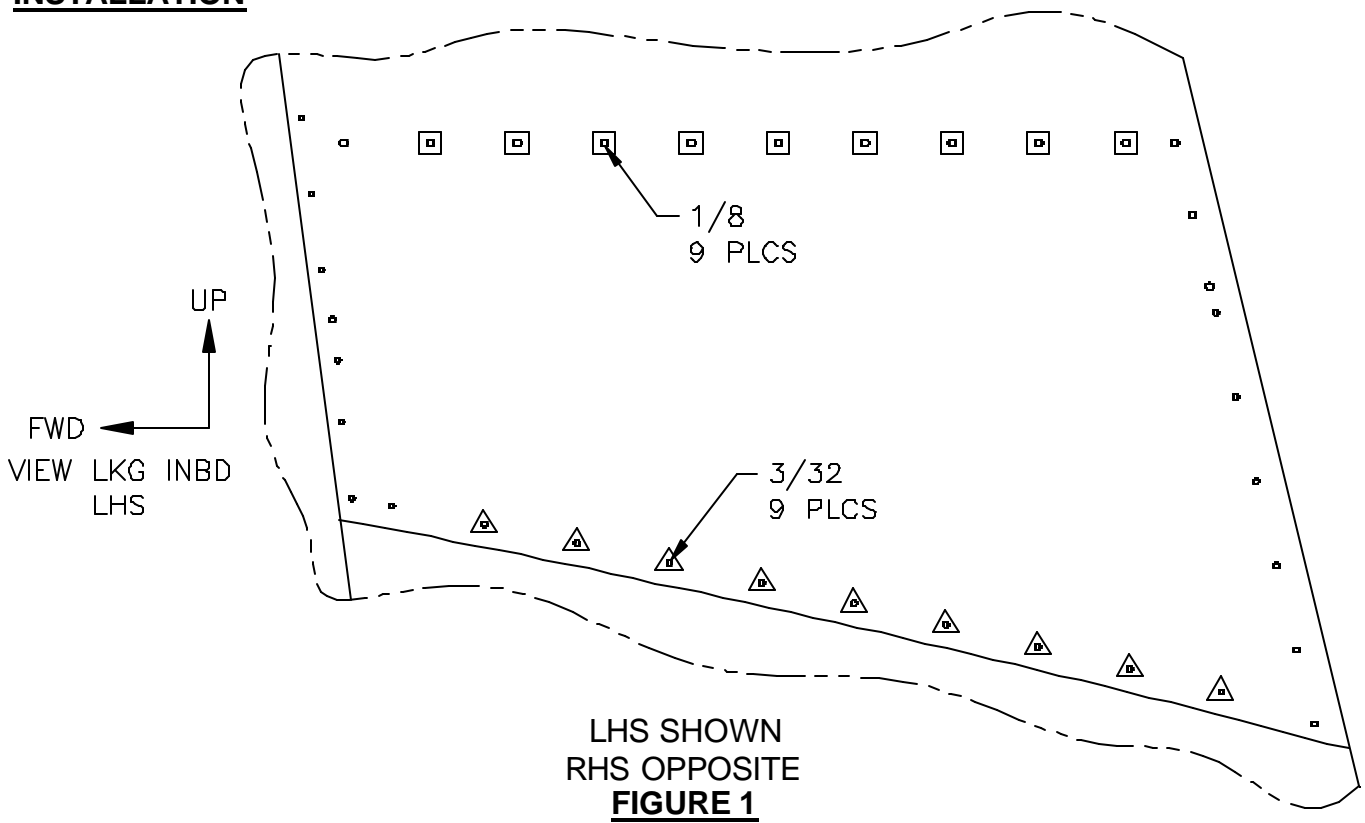
NOTE: Take care when drilling tooling holes indicated with T/H.

- 4) Scribe location of door cutout on oil cooler support bulkhead with inner cutout in Layout Template, -109, as shown. Reference Figure 2.



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- 5) Remove Layout Template, -109, and cut hole for door in oil cooler support bulkhead according to scribed lines. Reference Figure 2.
- 6) Place Frame assembly, -003 LHS/-004 RHS, through cutout in oil cooler support bulkhead and cleco to inside of bulkhead at Tooling Hole locations (T/H) as shown. Reference Figure 3.
- 7) Transfer all existing and new rivet holes from oil cooler support bulkhead into Frame assembly, -003 LHS/-004 RHS, as shown. .125" dia., 12 places, and .094" dia., 13 places. Reference Figure 3.
- 8) Place Door assembly, -005 LHS/-006 RHS, on Frame assembly, -003 LHS/-004 RHS keeping the hinge on the inboard side of oil cooler support bulkhead as shown. Cleco Door to bulkhead and Frame at Tooling Hole locations (T/H). Reference Figure 4.
- 9) Check operation of Door assembly, -005 LHS/-006 RHS, and location relative to cutout in oil cooler support bulkhead.
- 10) Transfer remaining rivet holes from oil cooler support bulkhead into Door assembly, -005 LHS/-006 RHS, as shown. .125" dia., 3 places. Reference Figure 4.
- 11) Open all .125" dia. and .094" dia. rivet holes to #30 dia. and #40 dia., respectively, in bulkhead, Frame assembly, -003 LHS/-004 RHS, and Door assembly, -005 LHS/-006 RHS.
- 12) Rivet Frame assembly, -003 LHS/-004 RHS, and Door assembly, -005 LHS/-006 RHS, to oil cooler support bulkhead as shown. Reference Figure 4.
- 13) Apply suitable anti-corrosion primer to all rivets as required.
- 14) Apply suitable paint to exposed surfaces of Door assembly, -005 LHS/-006 RHS, and Frame assembly, -003 LHS/-004 RHS, on exterior of oil cooler support bulkhead as required.



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INSTALLATION

