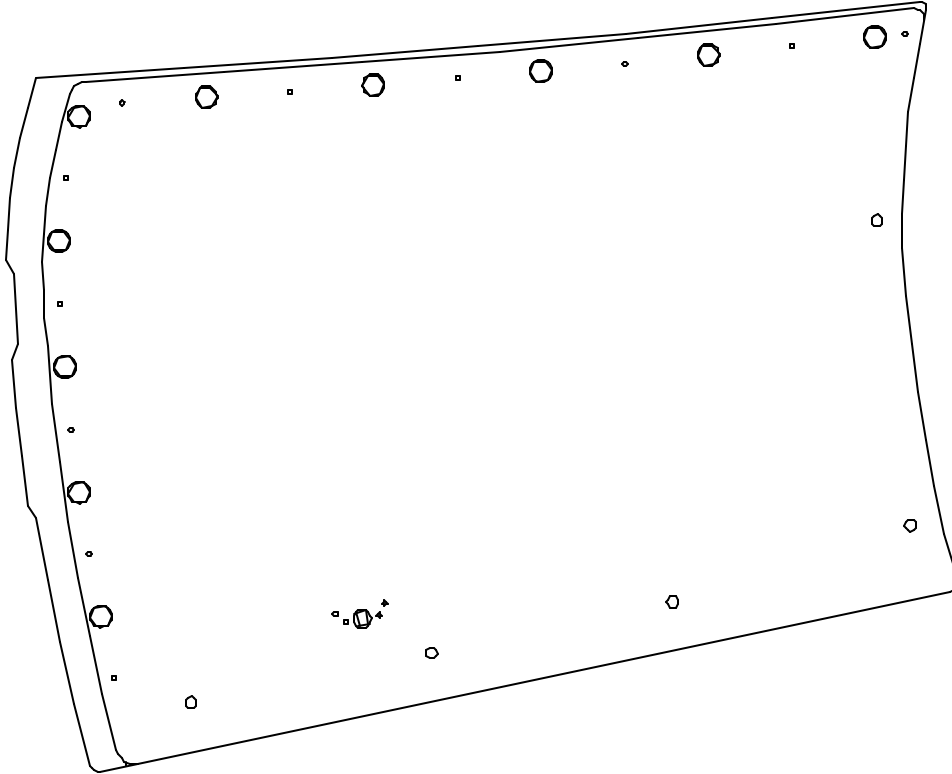




ALPINE AEROTECH LTD.



OIL COOLER SUPPORT, PANEL MODIFICATION INSTALLATION INSTRUCTIONS

MODELS: BELL 212/412

TRANSPORT CANADA CIVIL AVIATION
PACIFIC REGION
DAR APPROVED

BY:  DATE: 01/03/26
GEORGE EDWARDS P.ENG. DAR 191M

APPROVAL NO.: SH00-31

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

SCOPE

The intent of this modification is to change the existing riveted panel into a removable panel to aid in inspection and maintenance.

INSPECTION

Refer to the Daily Inspection - Part A or 25 hour/15 day - Part B of the Fuselage, paragraph 3, in the aircraft Maintenance Manual.

WEIGHT & BALANCE

<u>Part Number</u>	<u>Description</u>	<u>Weight</u> (Lbs.)	<u>Long. Arm</u> (Inches)	<u>Lat. Arm</u> (Inches)
AAL-061-811-001	Panel Mod. Kit, LHS	Negligible	N/R	N/R
AAL-061-811-002	Panel Mod. Kit, RHS	Negligible	N/R	N/R

INSTALLATION NOTES

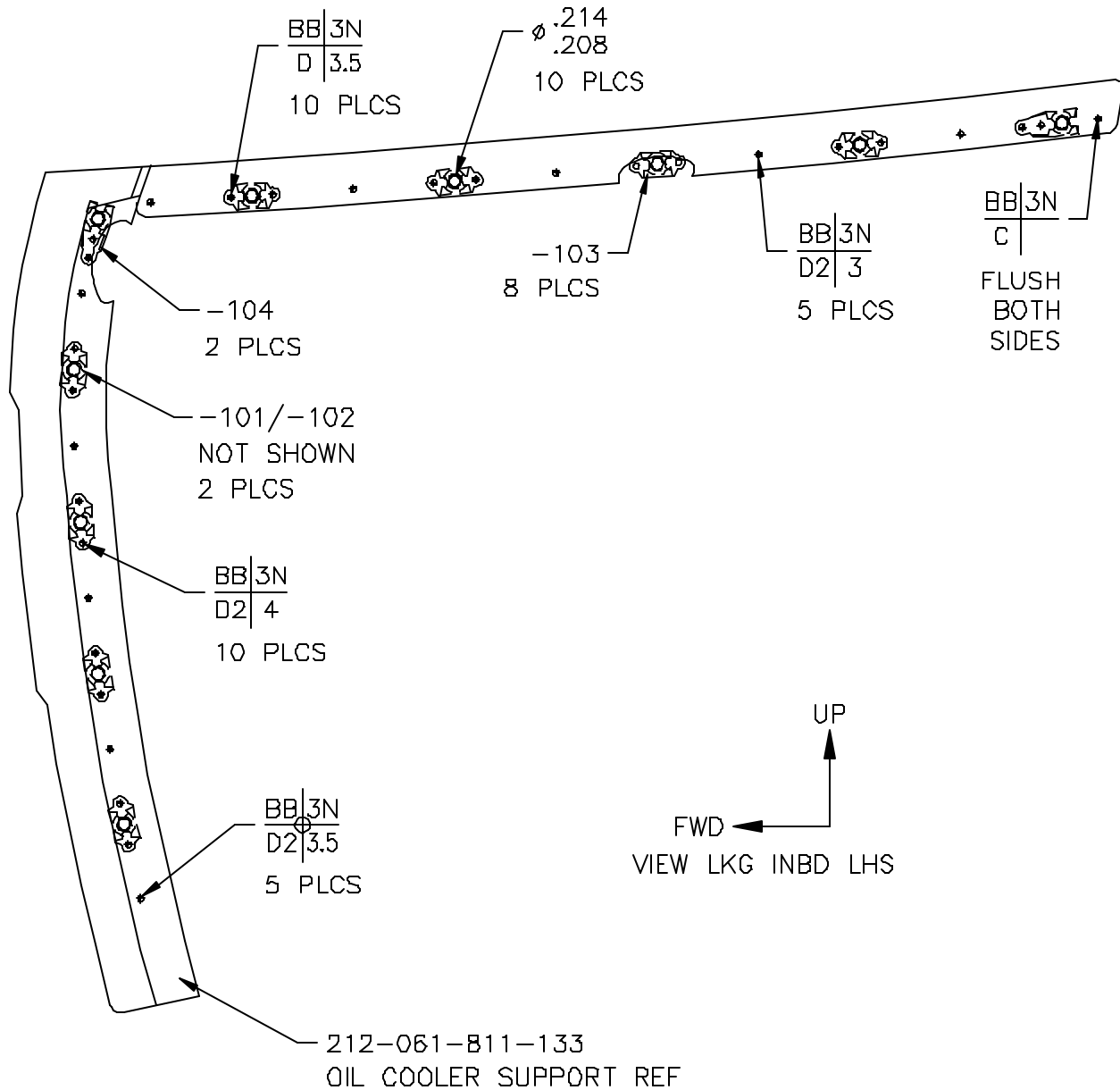
- 1) All instructions, where applicable, are to be completed using standard aircraft sheet metal and maintenance practices.
- 2) All hardware must be torqued to standard specs.
- 3) Reference numbers in installation correspond to dash numbers on Parts List.

INSTALLATION

- 1) Reference Figures 1 & 2.
- 2) Drill out all the existing rivets that attached the panel (P/N 212-061-811-043 L/H & -044 R/H) to the oil cooler support assembly (P/N 212-061-811-133) using a 3/32" dia. drill and remove the panel.
- 3) Drill out every other existing rivet hole in the oil cooler support using a .208 - .214 dia. drill (No. 4 drill suitable).
- 4) Locate and install the supplied nutplates on the inboard side of the oil cooler support.
- 5) Dimple and rivet the unused rivet holes in the oil cooler support. **Install the flush head on the outboard side.**
- 6) Drill out every other existing rivet hole in the panel using a .190 - .196 dia. drill (No. 11 drill suitable). Make sure these holes match the ones in the oil cooler support.

INSTALLATION

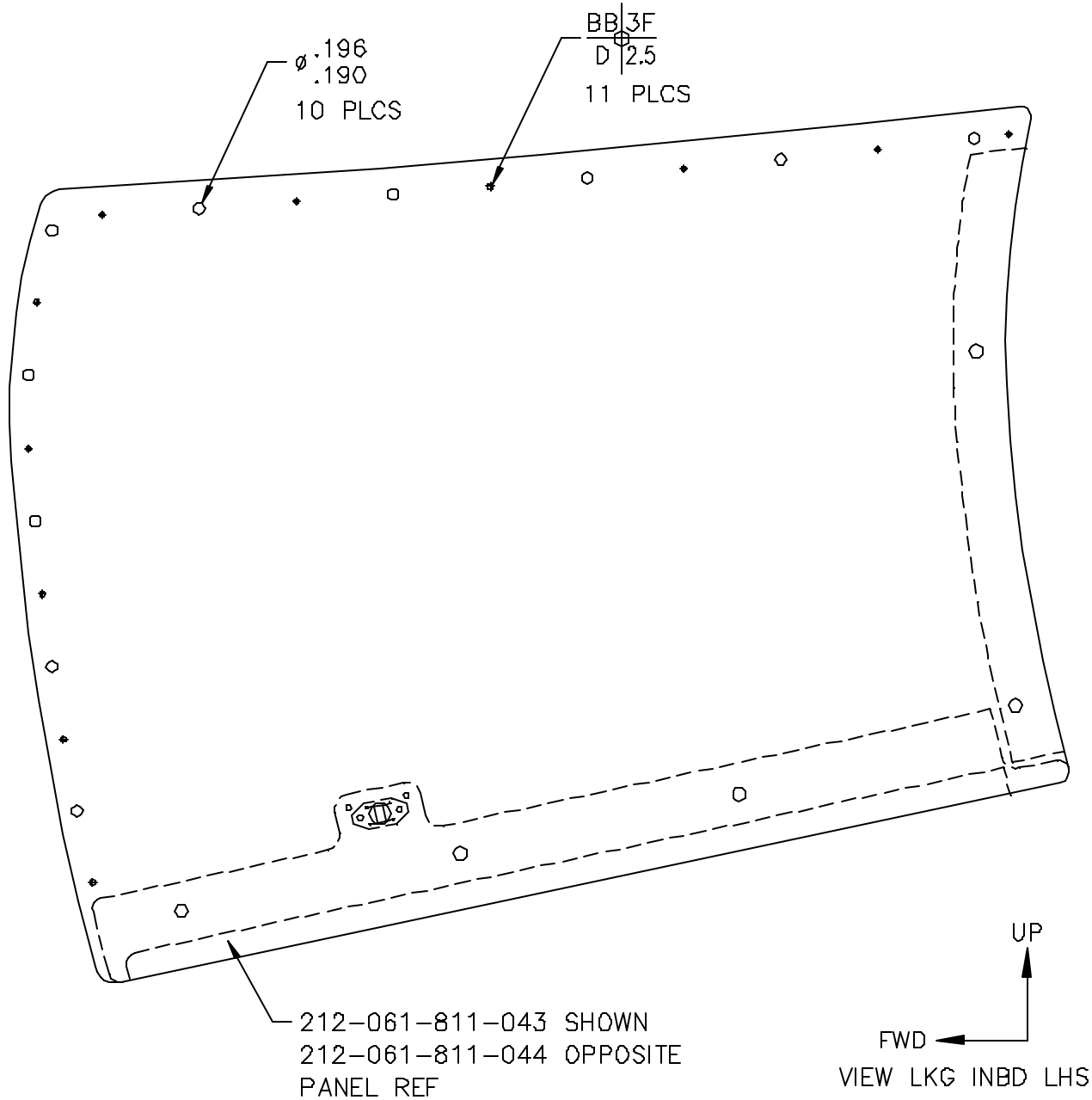
- 7) Dimple and rivet the unused rivet holes in the panel. **Install the flush head on the inboard side.** Dome the shop-formed rivet heads.
- 8) Reinstall the panel and install the supplied bolts and washers and torque to standard specs.



LHS SHOWN, RHS OPPOSITE
FIGURE 1



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LHS SHOWN, RHS OPPOSITE
FIGURE 2