

Instructions for Continued Airworthiness ICA-0319-001 Yoke Assembly Repair

REVISION: C DOCUMENT NO.: ICA-0319-001 DATE EFFECTIVE: 12/12/2023

1. Distribution of ICA

1.1. Upon completion of EO-0319-015, the following data tag shall be shipped to the customer with the repaired voke:



Installation Instructions - Please Read

Yoke bearing journals restored for use with supplied bearings IAW FAA approved repair. The NHA (206-011-100) must include these bearings in lieu of OEM P/N 206-011-118-001. OEM instructions for continued airworthiness still apply, with exception to the limits provided in the table below. Contact Able Aerospace Services for replacement bearings and maintenance questions.

Note: Vibro-etch M/R hub assembly dash number and serial number on label plate attached to yoke.

| Journal Dimensions | Bearing Part Number |
|--------------------|---------------------|
| 3.4895"-3.4900" | HLD-3174-000-OS1 |
| 3.4845"-3.4850" | HLD-3174-000-OS2 |
| 3.4795"-3.4800" | HLD-3174-000-OS3 |

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2. Parts Affected

- 2.1. Main Rotor Hub Assembly P/N: 206-011-100-103/-105/-107/-127/-129/-137/-139/-145/-147/-149/-151/-157/-159
- 2.2. Yoke Assembly P/N: 206-011-149-105, repaired by Able Aerospace Services EO-0319-015 (Revision D, Dated July 24, 2017)
- 2.3. Bearing, Roller P/N: HLD-3174-000-OS1/-OS2/-OS3

3. Overhaul/Maintenance Affected

3.1. The repair of the yoke assembly journals allows for three different sizes. To accommodate for these three different sizes, matching bearings are provided by Able Aerospace Services. These bearings are labeled. The repaired yoke assembly is also labeled.

CAUTION: The repaired yoke assembly and bearings are a matched set. The bearings are not interchangeable.

3.2. The main rotor hub assembly, including the yoke assembly and bearings shall be maintained in accordance with the original equipment manufacturer (OEM) instructions with exception to the yoke assembly journal limits. The limits for each of the three different undersized journal diameter conditions have been provided below.



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| | MINIMUM | | MAXIMUM | |
|-------------------------------|---------|----------|---------|----------|
| | inch | (mm) | inch | (mm) |
| Yoke – Bearing Journals (OS1) | 3.4895 | (88.633) | 3.4900 | (88.646) |
| Yoke – Bearing Journals (OS2) | 3.4845 | (88.506) | 3.4850 | (88.519) |
| Yoke – Bearing Journals (OS3) | 3.4795 | (88.379) | 3.4800 | (88.392) |

4. Airworthiness Limitations

4.1. Yoke assembly P/N: 206-011-149-105 is an "on condition" component. This life limitation will remain in effect as stated within the Maintenance Manuals of model 206B, L, L1, L3, and L4 rotorcraft. No additional airworthiness limitations apply.

5. REVISION HISTORY

| Revision | Date of Revision | Sections | Description of Changes | Prepared By |
|-------------------------|---------------------|-------------------------------|---|-------------------|
| N/C | 6/16/2015 | | Initial Release | |
| N/C Admin. Change | | Multiple | Updates Able Engineering and Component Services Inc. to Able Aerospace Services | |
| Α | 11/3/2017 | 2.1 2.3 3.2 Multiple | Updates main rotor hub assembly applicability Updates bearing part number Adds third oversize condition to the roller bearing. Updates company name | |
| В | 7/30/2020 | 3.2 4.0 | Adds section regarding overhaul/maintenance Adds section regarding airworthiness limitations | Olivia Madsen |
| С | 12/12/2023 | 1.1 All | Replaced requirement to mail this document to customers with a copy of the tag that is included with repaired yokes. Reformatted document. | Tyler Anderson |