ENGINE - LP COMPRESSOR - ENLARGE THE HOLE DIAMETER OF THE FAN CASE REAR EXTENSION - CATEGORY CODE 4 - MOD.ENG-72-0226

1. Planning Information

A. Effectivity

(1) Aircraft: (a) McDonnell Douglas MD-90

(2) Engine: (a) V2500-D5 Engine Serial No. V20022 only.

B. Reason

Inspection revealed that diameter of the holes on the existing fan case rear extension is out of limit which may impede installation of the bolts.

C. Compliance

Category Code 4

Accomplish at the first visit of an engine or module to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action or the reason for engine removal.

D. Approval

The 'Compliance' statement and the procedures described in paragraph G. of this service bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

E. References

(1) Internal Reference No.

95VJ610

(2) Other References

V2500 Standard Practises/Processes Manual

V2500 Inspection Review Order VIRO-JI-016 (IAE Reference)

F. Manpower

VENUE	EST' MANHOURS
(1) In Service	
(a) Rework the hole diameter ..	2 hours 35 minutes

(2) In shop ..... Not affected

Remarks: The V20022 engine has been delivered as a spare engine therefore, the action of gain access is not required.

G. Action

(1) Enlarge the diameter of holes on the fan extension case in accordance with following instruction.

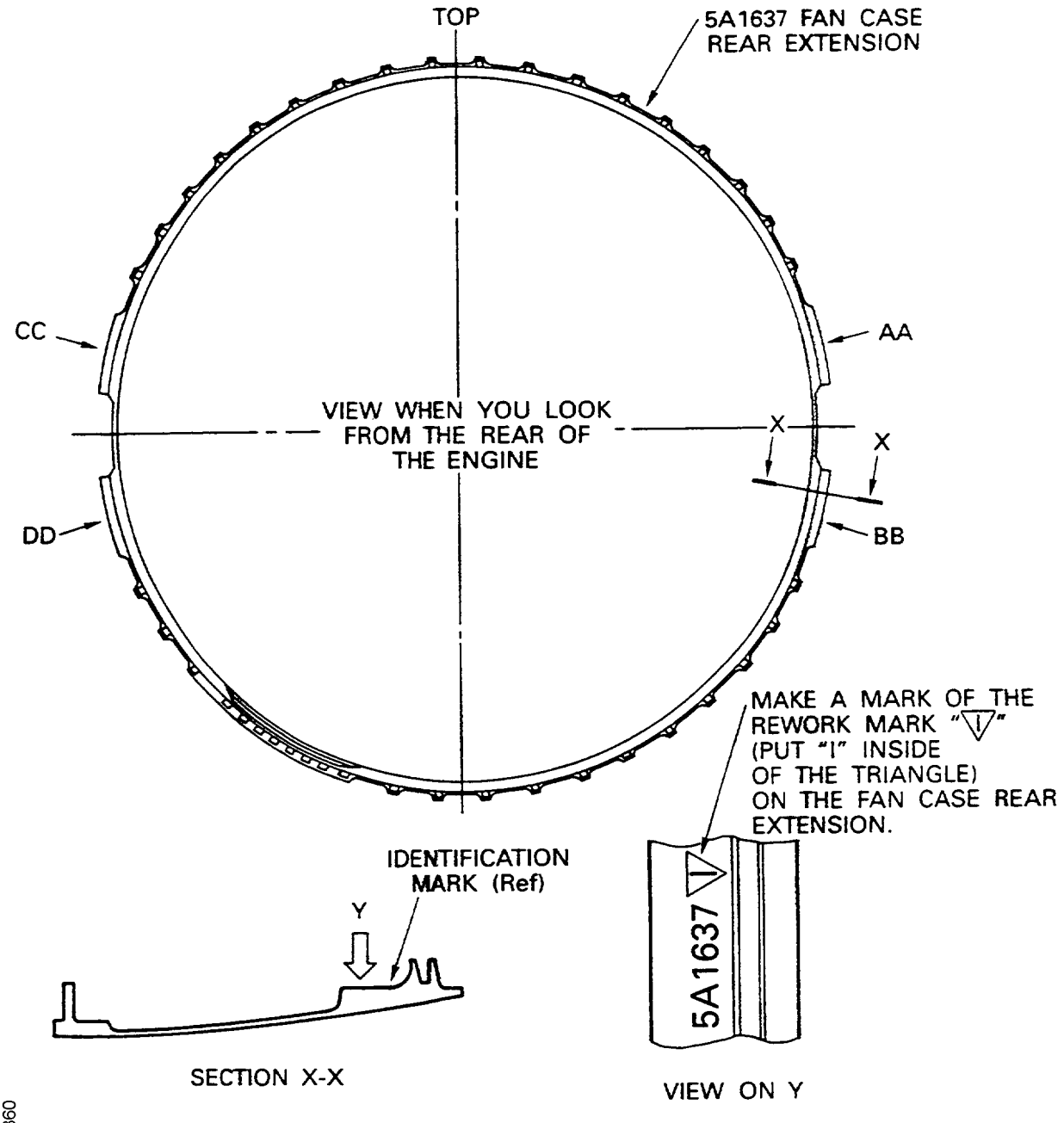
Procedure	Supplementary Information
(a) Find the 16 holes which are to be enlarged on the fan case rear extension.	See Figure 1.
(b) Put the applicable covers on all of openings.	
(c) Clean the 16 holes	Use a soft clean cloth.
(d) Machine the holes in accordance with following methods; (You can select the following two methods)	See Figure 2

NOTE: Diameter of the enlarged hole shall not exceed 0.316 in (8,04 mm).

(i) Reaming operation method	Use 0.312 - 0.316 in (7,94 - 8,04 mm) hand reamer. remove small amounts of material per side for hole. See Reference (2),Control No./ TASK No. 70-32-01-320-501, Machine Reaming.
(ii) Hand drill method	Use 0.312 - 0.316 in (7,94 - 8,04 mm) drill. Keep the center line to existing holes.
(e) De-burr and remove sharp edges.	Use basic workshop tools.
(f) Examine	See Figure 2. Measure the dimension and ensure that the edges are smooth.

(g) Make a mark of the Rework Mark adjacent to the identify marking area.	See Figure 1 and Reference (2), Control No./ TASK 70-09-00-400-501, Marking of Parts.
(h) Clean the surface of marked area and reworked area.	See Reference (2), Control No./ TASK No. 70-11-26-300-503, Chemical Cleaning.
(i) Apply the chromate conversion coatings to the reworked area.	See Reference (2), Control No./ TASK No. 70-38-02-300-503, Surface Treating.
(j) Examine.	See Figure 2. Measure the dimension of the enlarged holes.
(k) Remove the applicable cover from all of openings.	

H. A record of accomplishment is necessary.



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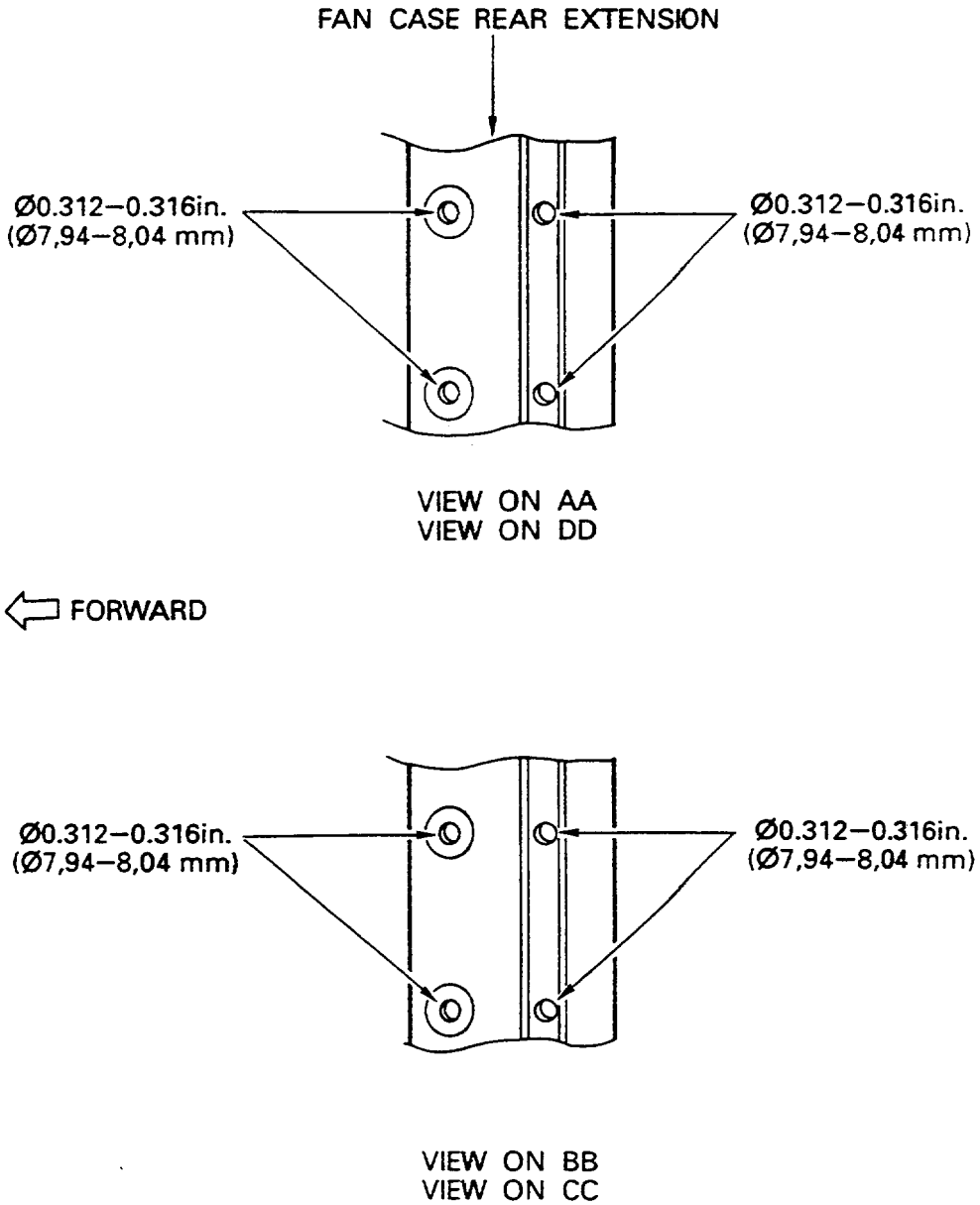
Rework of the Fan Case Rear Extension
Fig.1



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Rework of the Fan Case Rear Extension
Fig.2