



ENGINE - LP COMPRESSOR - DELETION OF SILVER PLATING ON THE LPC INTERMEDIATE CASE MODULE  
ATTACHING BOLTS - CATEGORY CODE 6 - MOD.ENG-72-0247

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) McDonnell Douglas MD-90
- (2) Engine: (a) V2525-D1 Engines prior to Serial No. V20242  
(b) V2528-D5 Engines prior to Serial No. V20242

B. Concurrent Requirement

None.

D. Reason

(1) Condition

The existing bolts which secure the No.4 and No.5 scavenge tubes, the No.4 and No.5 scavenge adapters, the fuel drain tube and the No.4 scavenge union are plated by silver on the threaded area. This silver plating impedes the proper installation between bolts and inserts.

(2) Background

It was revealed that the silver plating of the bolts is unsuitable at above locations, because the silver plated bolts and the inserts may turn together when the plated bolts are installed to the fan frame. The insert will be displaced inside the fan frame.

(3) Objective

To change silver plated bolt to non-silver plated bolt.

(4) Substantiation

Substantiation testing has been successfully completed.

(5) Effects of Bulletin on Workshop Procedures:

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Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

## (6) Supplemental Information

None

D. Description

- (1) Provide a non-silver plated bolt which secures the No.4 and No.5 scavenge tubes, the No.4 and No.5 scavenge adapters, the fuel drain tube and the No.4 scavenge union.

E. Approval

The part number change described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

F. Compliance

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Accomplish when the subassembly (i.e., modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected parts.

G. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In Service	Not applicable
(2) At Overhaul	Not affected

(Note: The part affected by this Service Bulletin is accessible at overhaul)

H. Material - Price and Availability

- (1) Modification kit is not required.
- (2) See "Material Information" section for price and availability of future spare.

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## I. Tooling - Price and Availability

Special tools are not required.

## J. Weight and Balance

- |     |               |    |    |    |   |
|-----|---------------|----|----|----|---|
| (1) | Weight change | .. | .. | .. | None  |
| (2) | Moment arm    | .. | .. | .. | No effect   |
| (3) | Datum         | .. | .. | .. | Engine front mount centerline<br>(Powerplant Station P.P.S.100) |

## K. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

## L. References

- (1) Internal Reference No.

EC95VJ037

- (2) Other references

V2500 Engine Illustrated Parts Catalog (S-V2500-3IA)

V2500 Engine Manual (E-V2500-3IA)

## M. Other Publications Affected

- (1) The V2500 Engine Illustrated Parts Catalog (S-V2500-3IA, Chapter/Section 72-32-00 and 72-32-03 will be revised to include new part number.

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## 2. Accomplishment Instructions

### A. Rework Instructions

There is no rework instructions necessary to accomplish this Service Bulletin.

### B. Assembly Instructions

- (1) Install the three MS9566-09, Bolts which secure the adapter (72-32-03,01-933) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.
- (2) Install the four MS9566-08, Bolts which secure the adapter (72-32-03,01-920) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.
- (3) Install the three MS9566-11, Bolts which secure the No.4 scavenge union (72-32-03,01-994) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.
- (4) Install the two MS9707-13, Bolts which secure the fuel drain tube (72-32-96,01-300) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.
- (5) Install the four MS9566-13, Bolts which secure the No.4 scavenge tube (72-32-96,01-350) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.
- (6) Install the four MS9707-13, Bolts which secure the No.5 scavenge tube (72-32-06,01-400) by the approved procedure in Reference (2), Chapter/Section 72-32-00, Assembly-11.

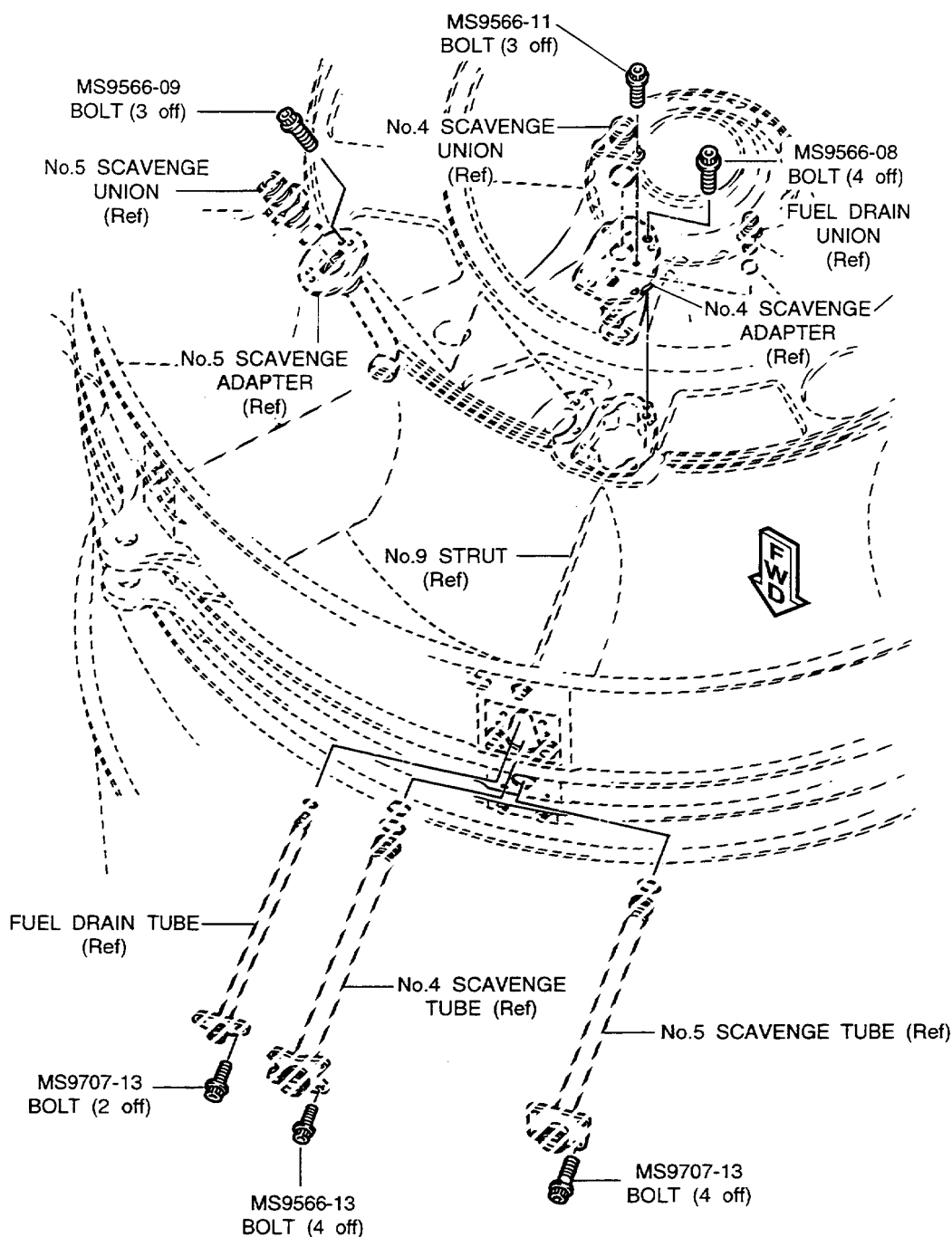
### C. Recording Instructions

A record of accomplishment is necessary.



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Install the LPC Intermediate Case Module Attaching Bolts  
Fig.1

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3. Material InformationA. Kits associated with this Bulletin:

None

B. Parts affected with this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
MS9707-13 (72-32-00)	2		.Bolt, Wire Lock Double Hex	AS43417 (01-137)	(A)(B)(S1)
MS9566-13 (72-32-00)	4		.Bolt, Wire Lock Double Hex	AS43715 (01-140)	(A)(B)(S1)
MS9707-13 (72-32-00)	4		.Bolt, Wire Lock Double Hex	AS43417 (01-413)	(A)(B)(S1)
MS9566-08 (72-32-03)	4		.Bolt, Bihex HD	AS43310 (01-922)	(A)(B)(S1)
MS9566-09 (72-32-03)	3		.Bolt, Bihex HD	AS43311 (01-935)	(A)(B)(S1)
MS9566-11 (72-32-03)	3		.Bolt, Bihex HD	AS43313 (01-996)	(A)(B)(S1)

C. Instructions/Disposition Code Statements:

- (A) New part will be available approximately Mar 1998.
- (B) Old part will continue to be available until the new part is supplied.
- (S1) New part and old part are freely and fully interchangeable, both physically and functionally.

NOTE: The estimated 1997 unit price shown are provided for planning purposes only and does not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

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