



ENGINE - ATTACHING PARTS AND FITTINGS - LP TURBINE MODULE - INTRODUCTION OF REVISED ECS  
SENSE LINE BRACKETS - CATEGORY CODE 6 - MOD.ENG-72-0281

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) McDonnell Douglas MD-90
- (2) Engines: (a) V2525-D5 Engines prior to Serial No.V20158  
(b) V2528-D5 Engines prior to Serial No.V20158

B. Concurrent Requirements

This Service Bulletin must only be installed to engines which have IAE V2500 Service Bulletin NAC-36-0002 (See 1.L.).

C. Reason

(1) Condition

The clearance between the bracket of the Environmental Control System (ECS) sense line and the ECS cross-over duct is not always sufficient. This occurs at both the inboard and outboard positions.

(2) Background

The problem was found during a maintenance demonstration. It was then found on subsequent production line checks by the airframe manufacturer.

(3) Objective

The purpose of this Service Bulletin is to make the installation of the ECS easier.

(4) Substantiation

A satisfactory engineering analysis and successful trial installation on a test aircraft has been done for the changes in this Service Bulletin.

(5) Effect of Bulletin on Workshop Procedures

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## SERVICE BULLETIN

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) The changes introduced are as follows:

- (a) The height of the ECS sense line brackets has decreased to give additional clearance with the ECS cross-over duct.

E. Approval

The part number changes and/or part modification are given in Section 2 and 3 of this Service Bulletin. They obey the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

F. Compliance

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This Service Bulletin can be done when the subassembly (That is, modules, accessories, components, build groups) is disassembled sufficiently to get access to the affected parts.

G. Manpower

Estimate of manhours necessary to do this Service Bulletin in full:

Venue	Estimated Manhours
(1) In service .. ..	Not applicable
(2) At overhaul .. ..	No more time is necessary to do this Service Bulletin

NOTE: It is possible to get access to the parts affected by this Service Bulletin at overhaul.

H. Material - Price and Availability

(1) A modification kit is not necessary.

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(2) See "Material Information" section for prices and availability of spares.

I. Tooling – Price and Availability

Special tools are not necessary.

J. Weight and Balance

- |     |               |    |    |    |  |
|-----|---------------|----|----|----|--|
| (1) | Weight change | .. | .. | .. | None   |
| (2) | Moment        | .. | .. | .. | No effect  |
| (3) | Datum         | .. | .. | .. | Engine front mount centreline<br>(Power Plant Station (PPS) 100) |

K. Electrical Load Data

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

L. References

- (1) Internal Reference No.

EC96VR039

- (2) Other References

The IAE V2500 Service Bulletin that follows must be installed at the same time as this Service Bulletin:

NAC-36-0002 ECS SYSTEM SENSE LINE/CROSS OVER DUCT INTERFERENCE

M. Other Publications Affected

- (1) Illustrated parts catalogue (IPC), Chapter/Section 72-00-50.



2. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

For the correct removal/installation procedures refer to the V2500-D5 Engine Manual (EM), Chapter/Section 72-00-50, Removal/Installation

Remove the old brackets and install the new brackets (Refer to Section 3. Material Information).

C. Recording Instructions

(1) A record of accomplishment is necessary.

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## SERVICE BULLETIN

3. Material Information

Applicability: For each V2500 engine to incorporate this Bulletin.

A. Kits necessary for this Bulletin:

None

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
6A5540 (72-00-50)	1	27.20	Bracket, stub	6A5543 (01-540)	(A)(B)(S1)
6A5540 (72-00-50)	1		Bracket, stub	6A5543 (01-550)	(A)(B)(S1)
6A5540 (72-00-50)	1		Bracket, stub	6A5543 (01-560)	(A)(B)(S1)

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For information about actual prices, refer to the IAE Price Catalog or contact IAE's Spare Parts Sales Department.

C. Instructions Disposition Codes:

- (A) Old part will be discontinued.
- (B) New part is currently available.
- (S1) Old and new parts are freely and fully interchangeable.

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