P U B L I C A T I O N T R A N S M I T T A L

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DATE: Feb.20/04

V2500-A1/A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Initial Issue of Service Bulletin EV2500-75-0090

Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 11 of the Service Bulletin	Initial issue

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise Publication Services, Rolls-Royce plc, Derby, England

LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin are as follows:

Page	Revision Number	Revision Date
Bulletin		
1		Feb.20/04
2		Feb.20/04
3		Feb.20/04
4		Feb.20/04
5		Feb.20/04
6		Feb.20/04
7		Feb.20/04
8		Feb.20/04
9		Feb.20/04
10		Feb.20/04
11		Feb.20/04

AIR - ACTIVE CLEARANCE CONTROL VALVE - INTRODUCTION OF AN ACC VALVE WITH REVISED ACTUATING ROD SLEEVE BEARINGS

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V11712

(2) Airbus A320

(a) V2500-A1 Engines prior to Serial No.V0362

(b) V2527-A5, V2527E-A5 Engines prior to Serial No. V11712

(3) Airbus A321

(a) V2530-A5, V2533-A5 Engines prior to Serial No. V11712

(4) Boeing - Longbeach Division MD-90

(a) V2525-D5, V2528-D5 Engines prior to Serial No. V20286

B. Concurrent Requirements

None.

C. Reason

(1) Condition

Accelerated wear of the ACC Valve cam mechanism may occur which results in unacceptable levels of maintenance activity.

The problem has been attributed to softening of the actuating rod support bearings material as a result of the temperature and vibration levels experienced in this application.

(2) Background

The problem has been observed on units in service.

(3) Substantiation

The changes introduced by this Service Bulletin (modification) have been the subject of satisfactory engineering assessment.

(4) Objective

Incorporation of this Service Bulletin is designed to maintain reliability.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) This Service Bulletin (modification) covers the fitment to engines of an Active Clearance Control (ACC) Valve supplied by Parker Aerospace incorporating design changes to prevent accelerated wear of the ACC Valve cam mechanism and resulting inaccurate valve positioning.

(2) The changes introduced are:

(a) A revised ACC Valve is introduced similar to the existing unit except for the following:

(i) The material of the inner and outer bearings of the actuating rod has been changed from Bearium B10 to C63000 per AMS 4640, which is more suitable for this application.

(3) Existing HPT/LPT ACC Valves may be reworked - Refer to Parker Aerospace vendor Service Bulletin.

(4) Units incorporating this Service Bulletin (modification) will be identified by a new type number (see Section 2.D.)

E. Compliance

Category Code 6

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

F. Approval

The part number change and/or part modification 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.

G. Manpower

Refer to Vendor Service Bulletin.

H. Material Price and Availability

Refer to Vendor Service Bulletin.

I. Tooling Price and Availability

Refer to Vendor Service Bulletin.

J. Industry Support Information

Refer to Vendor Service Bulletin.

K. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

None.

(3) Datum

Engine Front Mount Centreline (Power Plant Station PPS 100).

L. Electrical Load Data

Refer to Vendor Service Bulletin.

M. Software Accomplishment Summary

Refer to Vendor Service Bulletin.

N. References

(1) Refer to Parker Aerospace Service Bulletin number 5860016-75-214 for A1 and A5 Models.

(2) Refer to Parker Aerospace Service Bulletin number 5910478-75-216 for D5 Models.

(3) Engine Manual, Chapter/Section 72-00-40, Removal/Installation.

(4) Aircraft Maintenance Manual, Chapter/Section 75-24-51, Removal/Installation.

(5) Engineering Change No. - 02VI001.

(6) ATA Locator - 75-24-51.

O. Other Publications Affected

(1) Illustrated parts catalogue will be revised.

(2) Engine Manual, Chapter/Section 72-00-40, Removal/Installation.

(3) Aircraft Maintenance Manual, Chapter/Section 75-24-51, Removal/Installation.

P. Interchangeability of Parts

Not affected.

2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts to be reworked:

None.

C. New production parts:

None.

D. Vendor Units affected by this Bulletin:

The type of equipment affected by this modification is listed below for information only:

75-24-51

A1 Models

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01100	5860016 -140	1	Valve, Air, HPT/LPT ACC (V92003)	-	5860016 -132	(A)(S1) (1D)
01100	5860016 -141	1	Valve, Air, HPT/LPT ACC (V92003)	-	5860016 -133	(A)(S1) (1D)
01100	5860016 -142	1	Valve, Air, HPT/LPT ACC (V92003)	-	5860016 -134	(A)(S1) (1D)

A1 and A5 Models

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01100	5860016 -139	1	Valve, Air, HPT/LPT ACC (V92003)	-	5860016 -131	(A)(S1) (1D)

D5 Models

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01100	5910478 -104	1	Valve, Air, HPT/LPT ACC (V92003)	-	5910478 -103	(A)(S1) (1D)

E. Instruction disposition code statements:

(A) New standard of unit will be made available from May 2004.

(S1) Old and new units are freely and fully interchangeable.

(1D) Old standard of unit may be reworked.

3. Accomplishment Instructions

A. Rework Instructions

Refer to Parker Aerospace Service Bulletin number 5860016-75-214 for A1 and A5 Models.

Refer to Parker Aerospace Service Bulletin number 5910478-75-216 for D5 Models.

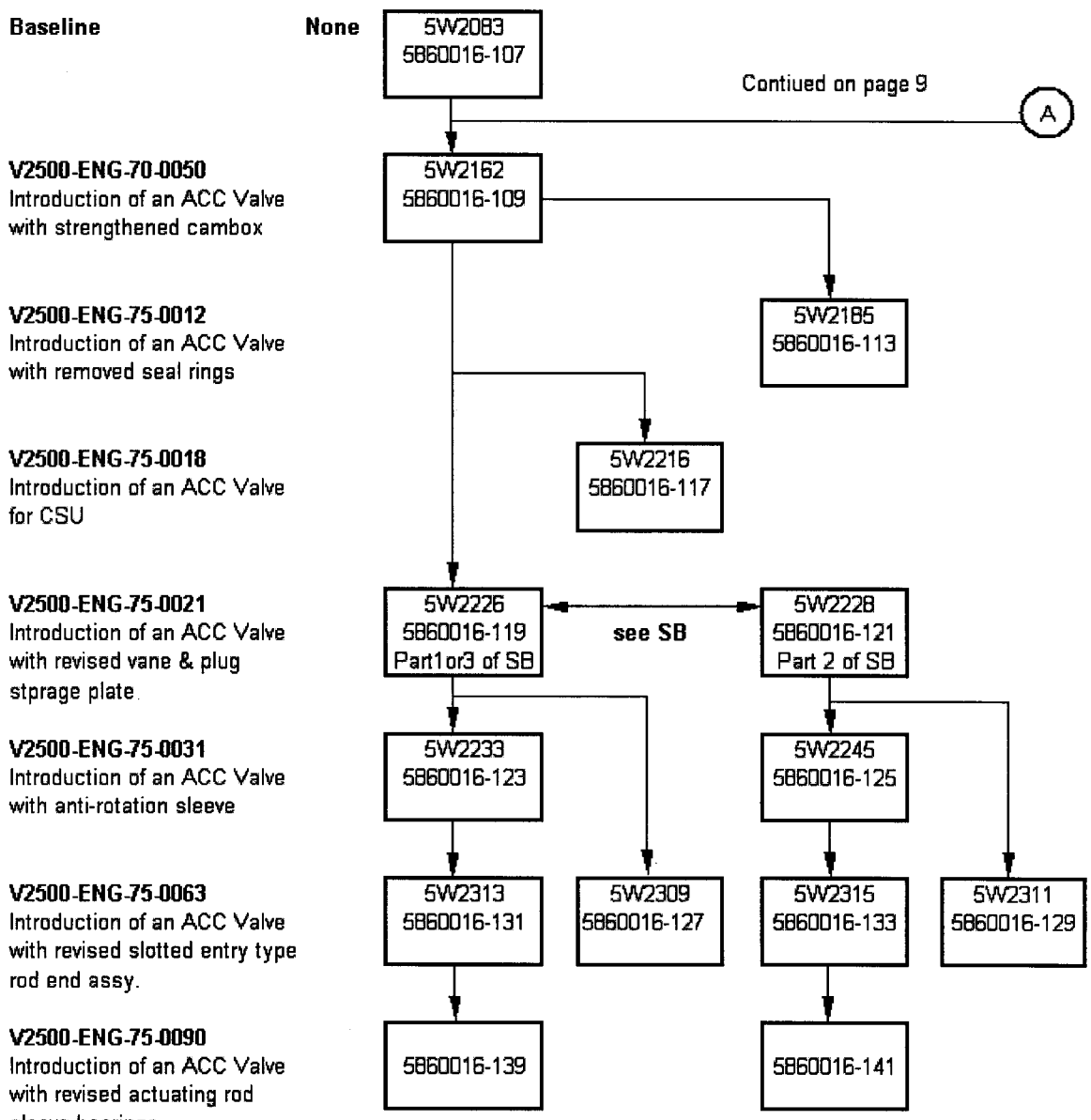
B. Assembly Instructions

For the correct Assembly instructions refer to Engine Manual, Chapter/Section 72-00-40, Removal/Installation or Aircraft Maintenance Manual, Chapter/Section 75-24-51, Removal/Installation.

C. Recording Instructions

(1) A record of accomplishment is necessary. Refer to vendor service bulletin.

V2500-A1 ACC Valve Family Tree*



* This family tree is not intended to represent the combination of modifications fitted to units in service

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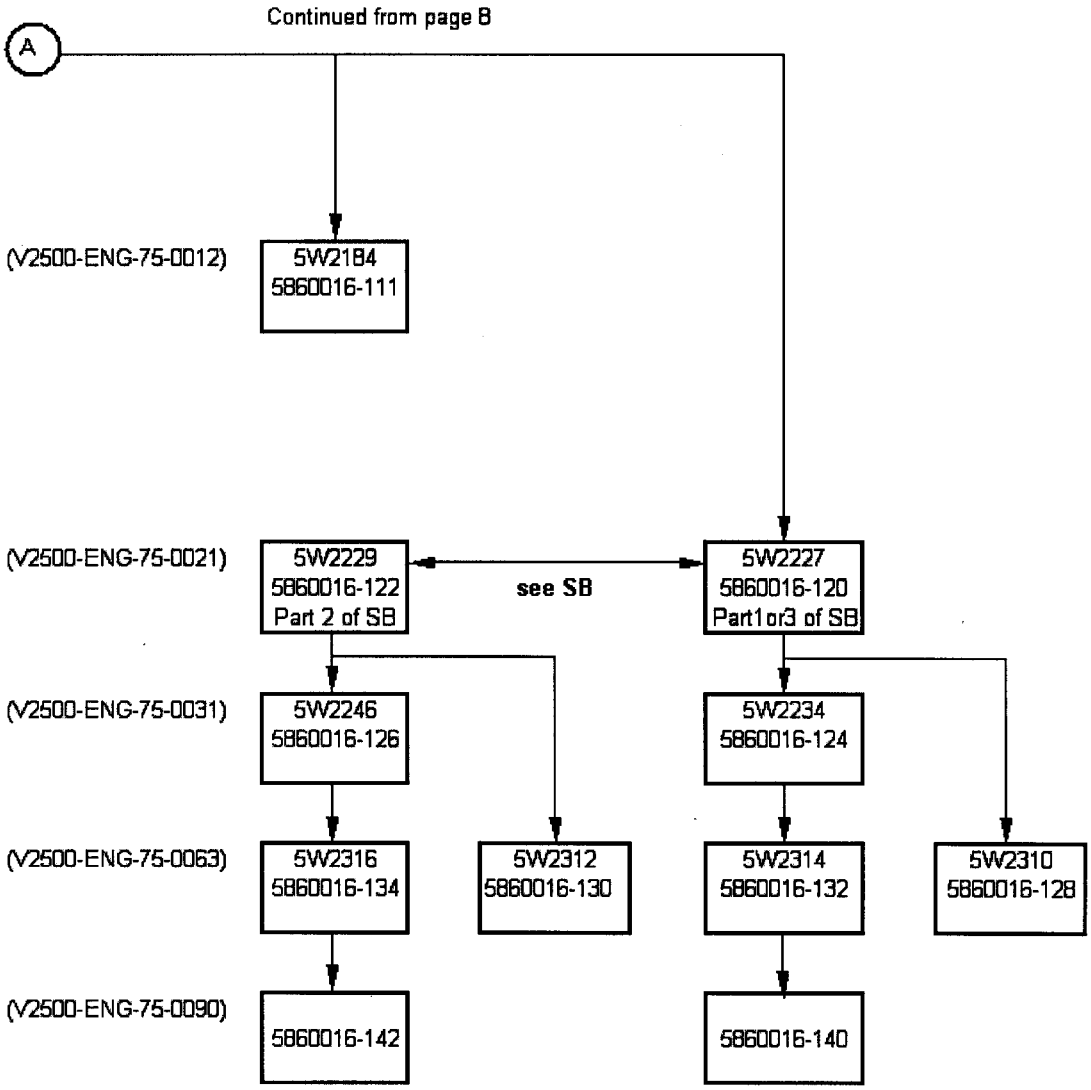
V2500-A1 ACC Valve Family Tree
Figure 1 (sheet 1 of 2)

V2500-A1 ACC Valve Family Tree* (continued)



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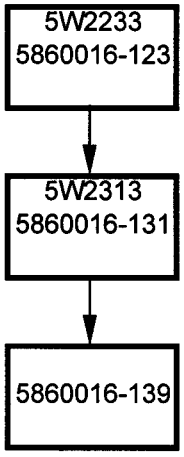
* This family tree is not intended to represent the combination of modifications fitted to units in service

V2500-A1 ACC Valve Family Tree
Figure 1 (sheet 2 of 2)

V2500-A5 ACC Valve Family Tree*

Service Bulletin Number	Unit Mod Plate Endorsement
Baseline	**None**
V2500-ENG-75-0063 Introduction of an ACC Valve with revised slotted entry type rod end assy.	
V2500-ENG-75-0090 Introduction of an ACC Valve with revised actuating rod sleeve bearings	

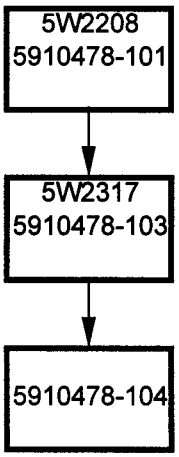


* This family tree is not intended to represent the combination of modifications fitted to units in service

V2500-A5 ACC Valve Family Tree
Figure 2

V2500-D5 ACC Valve Family Tree*

Service Bulletin Number	Unit Mod Plate Endorsement
Baseline	**None**
V2500-ENG-75-0063 Introduction of an ACC Valve with revised slotted entry type rod end assy.	
V2500-ENG-75-0090 Introduction of an ACC Valve with revised actuating rod sleeve bearings	



* This family tree is not intended to represent the combination of modifications fitted to units in service

V2500-D5 ACC Valve Family Tree
Figure 3

Customer Support Inc.

SERVICE BULLETIN

AIR	HIGH PRESSURE TURBINE/LOW PRESSURE TURBINE ACTIVE CLEARANCE CONTROL VALVE	UPGRADE TO CONFIGURATIONS 5860016-139 THROUGH -142 BY INCORPORATING NEW BEARINGS.

1. PLANNING INFORMATION

A. Effectivity

This service bulletin is applicable to the High Pressure Turbine / Low Pressure Turbine Active Clearance Control (ACC) Valve P/N's 5860016-131 through -134.

B. Concurrent Requirements

Not applicable.

C. Reason

Wear on the bearings used to support the shaft in the tube and fitting assembly has been caused by the extreme vibration and temperature environment of the engine. Replacing the existing bearings, P/N 5863144-101 and 5913115-101, with improved bearings, P/N 5863144-102 and 5913115-102, will help reduce wear on the bearings.

D. Description

(1) This service bulletin provides instructions to return ACC Valves, 5860016-131 through -134, to Parker for modification, testing, and re-identification.

(a) Modified ACC Valves, 5860016-131 or -133, will be upgraded to a 5860016-139 or -141 configuration respectively.

(b) Modified ACC Valves, 5860016-132 or -134, will be upgraded to a 5860016-140 or -142 configuration respectively.

OR

(2) This service bulletin provides instructions to modify, test, and re-identify the ACC Valves, 5860016-131 through -134. Modification consists of removing old bearings, 5863144-101 and 5913115-101, and replacing them with new bearings 5863144-102 and 5913115-102 respectively.

(a) Modified ACC Valves, 5860016-131 or -133, will be upgraded to a 5860016-139 or -141 configuration respectively.

(b) Modified ACC Valves, 5860016-132 or -134, will be upgraded to a 5860016-140 or -142 configuration respectively.

E. Compliance – Code 6

This service bulletin is classified as a Maintenance Reliability element. The compliance recommendation, therefore, falls into the Operator's Decision category, as defined by the ATA Implementation Guideline Manual (IGM), July 1994. Parker Hannifin Corporation recommends that this service bulletin be accomplished at the earliest practical maintenance period.

F. Approval

This service bulletin has been reviewed by the appropriate governmental authority, and the repairs and modifications herein comply with the applicable Aviation Regulations.

G. Manpower

This modification may be accomplished, by a crew of 1, in the following approximate man-hours:

NOTE: This service bulletin assumes the ACC Valve has been removed from the engine.

WORK PHASES	**MAN-HOURS**
Disassemble the ACC Valve per CMM ATA 75-24-51.	1.0
Assemble the ACC Valve per CMM ATA 75-24-51.	2.0
Test the ACC Valve per CMM ATA 75-24-51.	2.0
Total Man-Hours	**5.0**

H. Weight and Balance

None.

I. Electrical Load Data

Not Affected.

J. Software Accomplishment Summary

Not applicable.

K. References

Parker Hannifin Corporation Component Maintenance Manual (CMM), ATA 75-24-51.

L. Other Publications Affected

This service bulletin will be incorporated into the Parker Hannifin Corporation CMM, ATA 75-24-51, at the next scheduled revision of the manual.

M. Interchangeability or Intermixability of Parts

Old parts and new parts are interchangeable.

2. MATERIAL INFORMATION

A. Material Price and Availability

NOTE: Inventories will be available 12 weeks after the release of this service bulletin.

(1) For operators requiring Parker to upgrade the ACC Valve:

(a) For Parker Hannifin to upgrade one ACC Valve, 5860016-131 or -133 to a 5860016-139 or -141, forward the ACC Valve to the address listed below. This option is available at a discounted cost of $4992.00, including the $500.00 exchange credit for the actuator rod assembly, 5903375-101, with a delivery time of 30 days from receipt of unit and purchase order.

(b) For Parker Hannifin to upgrade one ACC Valve, 5860016-132 or -134 to a 5860016-140 or -142, forward the ACC Valve to the address listed below. This option is available at a discounted cost of $4992.00, including the $500.00 exchange credit for the actuator rod assembly, 5903375-101, with a delivery time of 30 days from receipt of unit and purchase order.

PARKER HANNIFIN CORPORATION	PHONE:	(949) 833-3000
Customer Support Inc.	FAX:	(949) 809-8390
16666 Von Karman Avenue	SITA:	SNAPHCR
Irvine, California 92606-4917 USA	REPAIR STATION NO.	AU4R063M

(2) For operators to upgrade the ACC Valve, order the applicable Parts Kit:

(a) Parts Kit, 3KIT5860016-103, is available for operators who wish to upgrade the ACC Valve, 5860016-131 or -133 to a 5860016-139 or -141. Order one parts kit per assembly from the address listed above. Parts kit, 3KIT5860016-103, is available at a discounted cost of $5292.00, with a delivery time of 30 days from receipt purchase order. See Paragraph 2.C. for detailed breakdown of parts kit.

NOTE: A $500.00 credit will be provided for returned actuator rod assembly, 5903375-101.

(b) Parts Kit, 3KIT5860016-104, is available for operators who wish to upgrade the ACC Valve, 5860016-132 or -134 to a 5860016-140 or -142. Order one parts kit per assembly from the address listed above. Parts kit, 3KIT5860016-104, is available at a discounted cost of $5292.00, with a delivery time of 30 days from receipt purchase order. See Paragraph 2.C. for detailed breakdown of parts kit.

NOTE: A $500.00 credit will be provided for returned actuator rod assembly, 5903375-101.

B. Industry Support Information

(1) Operators are requested to contact their respective Parker Hannifin Customer Service Administrator to schedule implementation of this service bulletin.

(2) The prices and provisions contained in this service bulletin are valid until December 31, 2004. After that date, request a quotation from Parker Hannifin Corporation, Customer Support.

C. Material Necessary for Each Component

(1) Parts Kit, 3KIT5860016-103, is required to upgrade one ACC Valve, 5860016-131 or -133 to 5860016-139 or -141. See Table 1:

Parts Kit, 3KIT5860016-103 – Table 1

NEW P/N	IPL/ITEM	KEYWORD	OLD P/N	QTY	DISPOSITION
5008-75	1/50	SNAP RING	SAME	3	SCRAP
5863144-102	1/55	BEARING	5863144-101	1	SCRAP
5883677-101	1/300	NAMEPLATE	SAME	1	SCRAP
5903375-101	1/60	ACTUATOR ROD ASSEMBLY	SAME	1	See Paragraph 2.A.
5913115-102	1/58	BEARING	5913115-101	1	SCRAP

(2) Parts Kit, 3KIT5860016-104, is required to upgrade one ACC Valve, 5860016-132 or -134 to 5860016-140 or -142. See Table 2:

Parts Kit, 3KIT5860016-104 – Table 2

NEW P/N	IPL/ITEM	KEYWORD	OLD P/N	QTY	DISPOSITION
5008-75	1/50	SNAP RING	SAME	3	SCRAP
5863144-102	1/55	BEARING	5863144-101	1	SCRAP
5883677-102	1/300	NAMEPLATE	SAME	1	SCRAP
5903375-101	1/60	ACTUATOR ROD ASSEMBLY	SAME	1	See Paragraph 2.A.
5913115-102	1/58	BEARING	5913115-101	1	SCRAP

(3) The following materials and/or equipment must be procured from operator's stock or sources indicated:

NOTE: Equivalent substitutes may be used for items listed below.

NOMENCLATURE	PART NO./TYPE	SOURCE
Isopropyl Alcohol	Federal Specification, TT-I-735	Commercially Available

D. Material Necessary for Each Spare

Not applicable.

E. Re-identified Parts

After the ACCOMPLISHMENT INSTRUCTIONS in Paragraph 3 are complete, the ACC Valve will be identified as shown in Table 3.

Re-identification
Table 3

OLD CONFIGURATION NUMBER	NEW CONFIGURATION NUMBER
5860016-131	5860016-139
5860016-132	5860016-140
5860016-133	5860016-141
5860016-134	5860016-142

F. Tooling - Price and Availability

All tooling required is listed in Parker Hannifin, Component Maintenance Manual, 75-24-51.

3. ACCOMPLISHMENT INSTRUCTIONS

A. The following instructions are provided to modify, test, and re-identify the ACC Valve, 5860016-131 through -134 to the 5860016-139 through 142 configuration respectively:

(1) Disassemble the ACC Valve according to CMM ATA 75-24-51, DISASSEMBLY section.

(2) Assemble the ACC Valve using the applicable parts kit according to CMM ATA 75-24-51, ASSEMBLY section.

(3) Perform the functional testing of the ACC Valve according to CMM 75-24-51, TESTING AND FAULT ISOLATION section.

(4) Re-identify the ACC Valve according to CMM 75-24-51, ASSEMBLY section and these instructions:

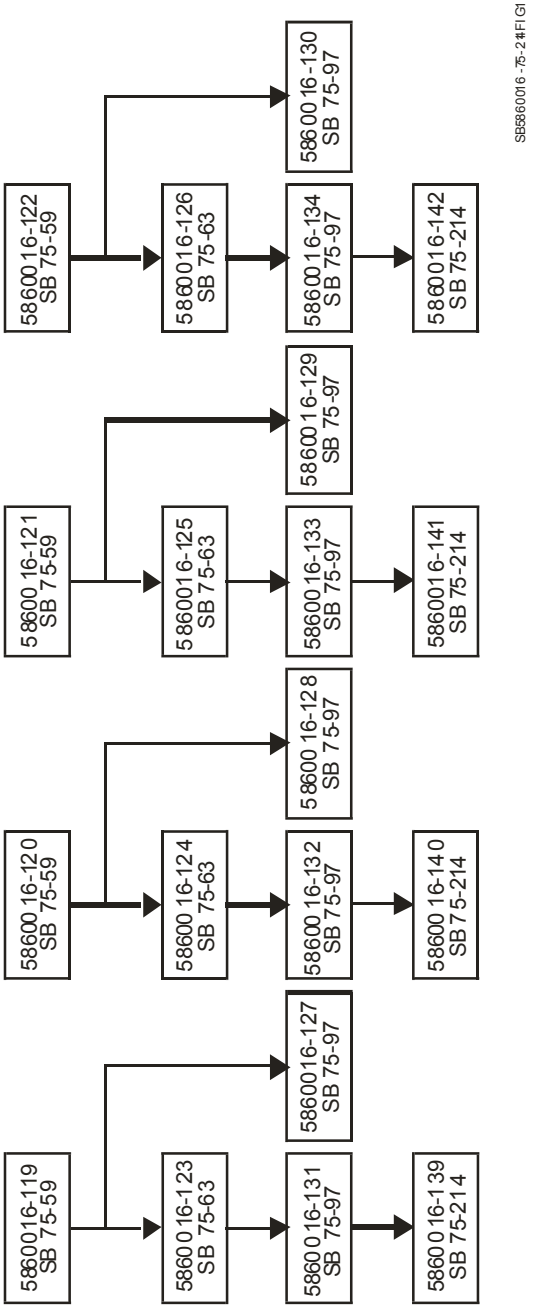
(a) Remove the old nameplate, P/N 5883677-101 or 5883677-102.

(b) Re-identify the ACC Valve by impression stamping the new configuration number (refer to Table 2) in the spaces provided on a new nameplate, P/N 5883677-101 or 5883677-102. Copy the remaining data from the old nameplate onto the new nameplate.

NOTE: To upgrade from P/N 5860016-131, or -133 to 5860016-139 or -141, use nameplate, P/N 5883677-101. To upgrade from P/N 5860016-132 or -134 to 5860016-140, or -142, use nameplate, P/N 5883677-102.

SERVICE BULLETIN

4. APPENDIX



Family Tree
Figure 1

Customer Support Inc.

SERVICE BULLETIN

AIR	HIGH PRESSURE TURBINE/LOW PRESSURE TURBINE ACTIVE CLEARANCE CONTROL VALVE	UPGRADE CONFIGURATIONS 5910478-101 THROUGH -103 TO A 5910478-104 CONFIGURATION BY INCORPORATING NEW BEARINGS.

1. PLANNING INFORMATION

A. Effectivity

This service bulletin is applicable to the High Pressure Turbine / Low Pressure Turbine Active Clearance Control (ACC) Valve P/N's 5910478-101 through -103.

B. Concurrent Requirements

Service Bulletins 5910478-75-98, which incorporates a new slotted-entry rod end assembly, must be accomplished prior to or in conjunction with this service bulletin.

C. Reason

Wear on the bearings used to support the shaft in the tube and fitting assembly has been caused by the extreme vibration and temperature environment of the engine. Replacing the existing bearings, P/N 5863144-101 and 5913115-101, with improved bearings, P/N 5863144-102 and 5913115-102, will help reduce wear on the bearings.

D. Description

(1) This service bulletin provides instructions to modify, test, and re-identify the ACC Valves, 5910478-101 through -103. Modification consists of removing old bearings, 5863144-101 and 5913115-101, and replacing them with new bearings 5863144-102 and 5913115-102.

(a) Modified ACC Valves, 5910478-101, will be upgraded to a 5910478-104 configuration incorporating service bulletin 5910478-75-98.

(b) Modified ACC Valves, 5910478-103, will be upgraded to a 5910478-104 configuration.

E. Compliance – Code 6

This service bulletin is classified as a Maintenance Reliability element. The compliance recommendation, therefore, falls into the Operator's Decision category, as defined by the ATA Implementation Guideline Manual (IGM), July 1994. Parker Hannifin Corporation recommends that this service bulletin be accomplished at the earliest practical maintenance period.

F. Approval

This service bulletin has been reviewed by the appropriate governmental authority, and the repairs and modifications herein comply with the applicable Aviation Regulations.

G. Manpower

This modification may be accomplished, by a crew of 1, in the following approximate man-hours:

NOTE: This service bulletin assumes the ACC Valve has been removed from the engine.

WORK PHASES	MAN-HOURS
Disassemble the ACC Valve per CMM ATA 75-24-71.	1.0
Assemble the ACC Valve per CMM ATA 75-24-71.	2.0
Test the ACC Valve per CMM ATA 75-24-71.	2.0
Total Man-Hours	**5.0**

H. Weight and Balance

None.

I. Electrical Load Data

Not Affected.

J. Software Accomplishment Summary

Not applicable.

K. References

Parker Hannifin Corporation Component Maintenance Manual (CMM), ATA 75-24-71.

Parker Hannifin Service Bulletin 5910478-75-98.

L. Other Publications Affected

This service bulletin will be incorporated into the Parker Hannifin Corporation CMM, ATA 75-24-71, at the next scheduled revision of the manual.

M. Interchangeability or Intermixability of Parts

Old parts and new parts are interchangeable.

2. MATERIAL INFORMATION

A. Material Price and Availability

NOTE: Inventories will be available 12 weeks after the release of this service bulletin.

(1) For operators requiring Parker to upgrade the ACC Valve:

(a) For Parker Hannifin to upgrade one ACC Valve, 5910478-101 to a 5910478-104, forward the ACC Valve to the address listed below. This option is available at a discounted cost of $4992.00, including the $500.00 exchange credit for the actuator rod assembly, 5913049-101, with a delivery time of 30 days from receipt of unit and purchase order.

(b) For Parker Hannifin to upgrade one ACC Valve, 5910478-103 to a 5910478-104, forward the ACC Valve to the address listed below. This option is available at a discounted cost of $4992.00, including the $500.00 exchange credit for the actuator rod assembly, 5913049-101, with a delivery time of 30 days from receipt of unit and purchase order.

PARKER HANNIFIN CORPORATION	PHONE:	(949) 833-3000
Customer Support Inc.	FAX:	(949) 809-8390
16666 Von Karman Avenue	SITA:	SNAPHCR
Irvine, California 92606-4917	REPAIR STATION NO.	AU4R063M
USA		

(2) For operators to upgrade the ACC Valve, order the applicable Parts Kit:

(a) Parts Kit, KIT5910478, is available for operators who wish to upgrade the ACC Valve, 5910478-101 to a 5910478-104. Order one parts kit and rod end assembly, 5952015-101 per assembly from the address listed above. Parts kit, KIT5910478, is available at a discounted cost of $5292.00, with a delivery time of 30 days from receipt purchase order. See Paragraph 2.C. for detailed breakdown of parts kit.

NOTE: A $500.00 credit will be provided for returned actuator rod assembly, 5913049-101.

(b) Parts Kit, KIT5910478, is available for operators who wish to upgrade the ACC Valve, 5910478-103 to a 5910478-104. Order one parts kit per assembly from the address listed above. Parts kit, KIT5910478, is available at a discounted cost of $5292.00, with a delivery time of 30 days from receipt purchase order. See Paragraph 2.C. for detailed breakdown of parts kit.

NOTE: A $500.00 credit will be provided for returned actuator rod assembly, 5913049-101.

B. Industry Support Information

(1) Operators are requested to contact their respective Parker Hannifin Customer Service Administrator to schedule implementation of this service bulletin.

(2) The prices and provisions contained in this service bulletin are valid until December 31, 2004. After that date, request a quotation from Parker Hannifin Corporation, Customer Support.

C. Material Necessary for Each Component

(1) Parts Kit, KIT5910478 and rod end assembly, 5952015-101 (Refer to S/B 5910478-75-98), are required to upgrade one ACC Valve, 5910478-101 to a 5910478-104. See Table 1:

(2) Parts Kit, KIT5910478, is required to upgrade one ACC Valve, 5910478-103 to a 5910478-104. See Table 1:

Parts Kit, KIT5910478 - Table 1

NEW P/N	IPL/ITEM	KEYWORD	OLD P/N	QTY	DISPOSITION
5008-75	1/50	SNAP RING	SAME	3	SCRAP
5863144-102	1/55	BEARING	5863144-101	1	SCRAP
5913054-101	1/300	NAMEPLATE	SAME	1	SCRAP
5913049-101	1/60	ACTUATOR ROD ASSEMBLY	SAME	1	SCRAP
5913115-102	1/58	BEARING	5913115-101	1	SCRAP

(3) The following materials and/or equipment must be procured from operator's stock or sources indicated:

NOTE: Equivalent substitutes may be used for items listed below.

NOMENCLATURE	PART NO./TYPE	SOURCE
Isopropyl Alcohol	Federal Specification, TT-I-735	Commercially Available

D. Material Necessary for Each Spare

Not applicable.

E. Re-identified Parts

After the ACCOMPLISHMENT INSTRUCTIONS in Paragraph 3 are complete, the ACC Valve will be identified as shown in Table 3.

Re-identification
Table 2

OLD CONFIGURATION NUMBER	NEW CONFIGURATION NUMBER
5910478-101	5910478-104
5910478-103	5910478-104

F. Tooling - Price and Availability

All tooling required is listed in Parker Hannifin, Component Maintenance Manual, 75-24-71.

3. ACCOMPLISHMENT INSTRUCTIONS

A. The following instructions are provided to modify, test, and re-identify the ACC Valve, 5910478-101 and -103 to the 5910478-104 configuration:

(1) Disassemble the ACC Valve according to CMM ATA 75-24-71, DISASSEMBLY section.

(2) Assemble the ACC Valve according to CMM ATA 75-24-71, ASSEMBLY section.

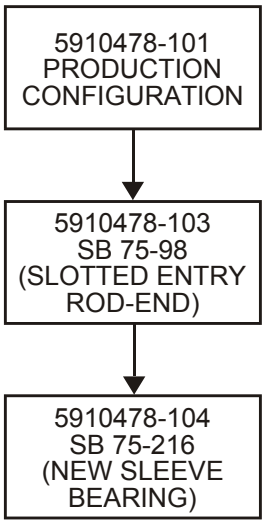
(3) Perform the functional testing of the ACC Valve according to CMM 75-24-71, TESTING AND FAULT ISOLATION section.

(4) Re-identify the ACC Valve according to CMM 75-24-71, ASSEMBLY section and these instructions:

(a) Remove the old nameplate, P/N 5913054-101.

(b) Re-identify the ACC Valve by impression stamping the new configuration number (refer to Table 2) in the spaces provided on a new nameplate, P/N 5913054-101. Copy the remaining data from the old nameplate onto the new nameplate.

4. APPENDIX



SB5910478-75-216FIG1

Family Tree
Figure 1