

International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: March 20, 1997

Subject: Transmittal of Revision 1 to Service Bulletin Number V2500-NAC-24-0010

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jan. 02/96
Revision 1	Mar. 20/97

Reasons for Issuance of Revision

(1) To clarify effectivity statement on page 2.

Effect on Past Compliance

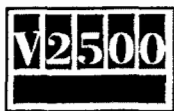
(1) None.

List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1 and 2	1	Mar. 20/97
3 thru 12	Basic	Jan. 02/96

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Transmittal
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NACELLE — ELECTRICAL POWER — POWER FEEDER HARNESS, VARIABLE SPEED
CONSTANT FREQUENCY (VSCF) GENERATOR — GROUND TERMINAL ATTACH BOLT,
AND POWER FEEDER HARNESS SUPPORT CLAMPS — REPLACEMENT OF

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

24-00-00

Compliance Category Code

6

Internal Reference No.

JG/AC 95VN800

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1. Planning Information

A. Effectivity

- (1) Aircraft: MD90
- (2) Nacelle: V2500-D5 engine build up (EBU) serial numbers 0022001 thru 0041001.

B. Concurrency Requirements

This Service Bulletin, V2500-NAC-24-0010 should be worked concurrent with or after Service Bulletin V2500-NAC-24-0006.

C. Reason

(1) Condition

The addition of the overbraid to the VSCF feeder cable introduced in Service Bulletin V2500-NAC-24-0006 increased the diameter of the harness requiring larger clamps. Continued use of the existing clamps may cause wear to the harness.

The depth of thread for the bolt introduced in Service Bulletin V2500-NAC-24-0006 used to attach the VSCF power feeder cable ground terminals to the VSCF generator was incorrectly calculated, which may make the bolt difficult to install.

(2) Background

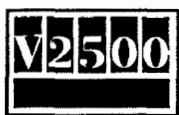
This condition was observed on production units.

(3) Objective

Prevent potential wear of the VSCF power feeder cable and make installation of the ground terminals attach bolt easier.

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(4) Substantiation

Trial fit of the new configuration was proven successful.

(5) Impact of the Bulletin on Workshop Procedures:

Removal/Installation	Not Affected
Disassembly/Assembly	Not Affected
Cleaning	Not Affected
Inspection/Repair	Not Affected
Repair	Not Affected
Testing	Not Affected

(6) Supplemental Information

None.

D. Description

The change introduced by this Bulletin is as follows:

Replace the ground terminal attach bolt with a longer grip length bolt and replace selected power feeder support clamps with larger clamps.

E. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD90-24-015 which has received exclusive FAA approval for MD-90 Series Aircraft.

F. Compliance

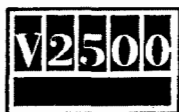
6

Accomplish when the Nacelle subassembly (i.e. accessories, components) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

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G. Manpower

Estimated manhours to incorporate the intent of this bulletin:

VENUE

ESTIMATED MANHOURS

(1) In Service

Not Applicable

(2) In Shop

Not Applicable
(Parts are accessible
at overhaul)

H. Material Cost and Availability

Modification kits not required. Parts are supplied as single line items at no charge to the Operator.

Operators with units listed in Paragraph 1.A should submit a no-charge purchase order for the applicable quantity of parts. The purchase order must specify this service bulletin number and only the parts listed herein. Operators will have one year from the issue date of the Service Bulletin to place an order. After one year Operators will have to order parts at catalog price if they desire to incorporate the change.

Direct Purchase order to:

Rohr Inc.
P.O. Box 878
Chula Vista, CA 91912
U.S.A.

Attn: Airline Support Manager - Bldg. 107A
(Ref. Service Bulletin No. V2500-NAC-24-0010)

I. Tooling Cost and Availability

None required.

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J. Weight and Balance

- (1) Weight change None
- (2) Moment arm No effect
- (3) Datum Engine Front Mount Centerline
..... (Powerplant Station PPS 100.00)

K. Electrical Load Data

Not affected.

L. Reference

Chapter/Section

Service Bulletin

V2500-NAC-24-0006

M. Other Publications Affected

MD-90 Engine Illustrated Parts Catalog
(S-V2500-3IA)

24-21-46

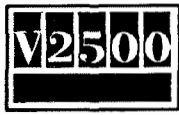
MD-90 Powerplant Buildup Manual
(PPB-V2500-3IA)

71-00-02

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2. Accomplishment Instructions

A. Rework Instructions

None.

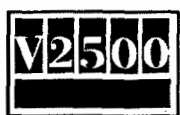
B. Assembly Procedures

- (1) Install the left hand engine NAS6405U16 VSCF power feeder ground terminal bolt.
 - (a) Install the NAS6405U16 bolt (24-21-46, 01-031), four VSCF ground terminals, S700S1258T5-050 spacer (24-21-46, 01-032), two AN960C516L washers (24-21-46, 01-030), and existing plain washer and lock washers on the VSCF generator. Refer to Figure 1.
- (2) Repeat step (1) above for the right hand engine. Refer to Figure 2.
- (3) Install the left hand engine TA12700039 power feeder support clamp.
 - (a) Attach the TA12700039 clamp (24-21-46, 01-062A) to the engine with two NAS1802-4-8 screws (24-21-46, 01-064) and AN960C416L washers (24-21-46, 01-060). Refer to Figure 1.
 - (b) Open the TA12700039 clamp, insert the VSCF power feeder cables, and close the clamp.
- (4) Repeat step (3) above for the right hand engine. Refer to Figure 2.
- (5) Replace the right hand engine TA12700040 power feeder support clamp.

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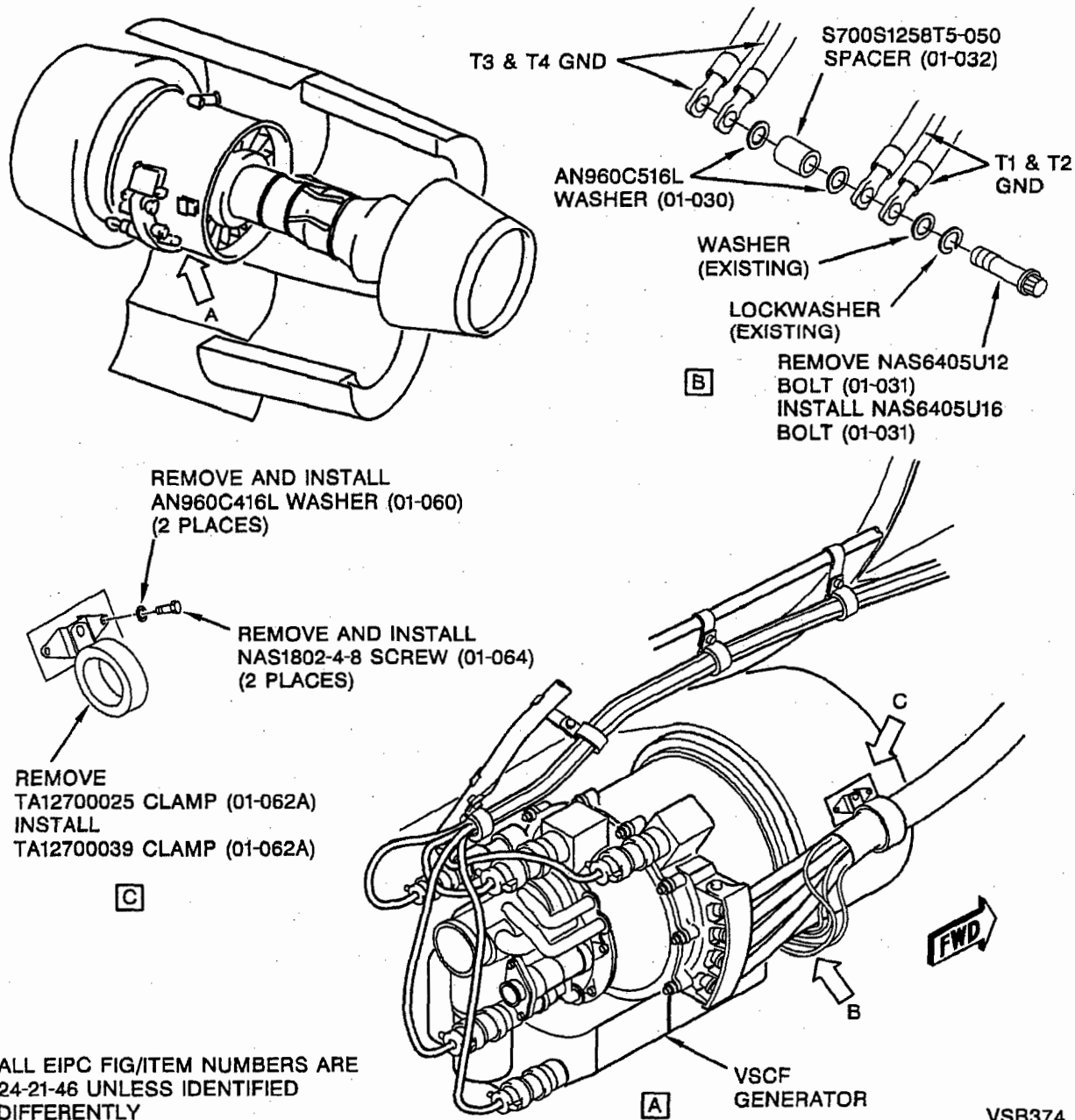
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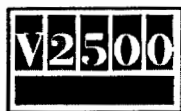


POWER FEEDER GROUND TERMINAL BOLT AND CLAMP REPLACEMENT - LH ENGINE
FIGURE 1.

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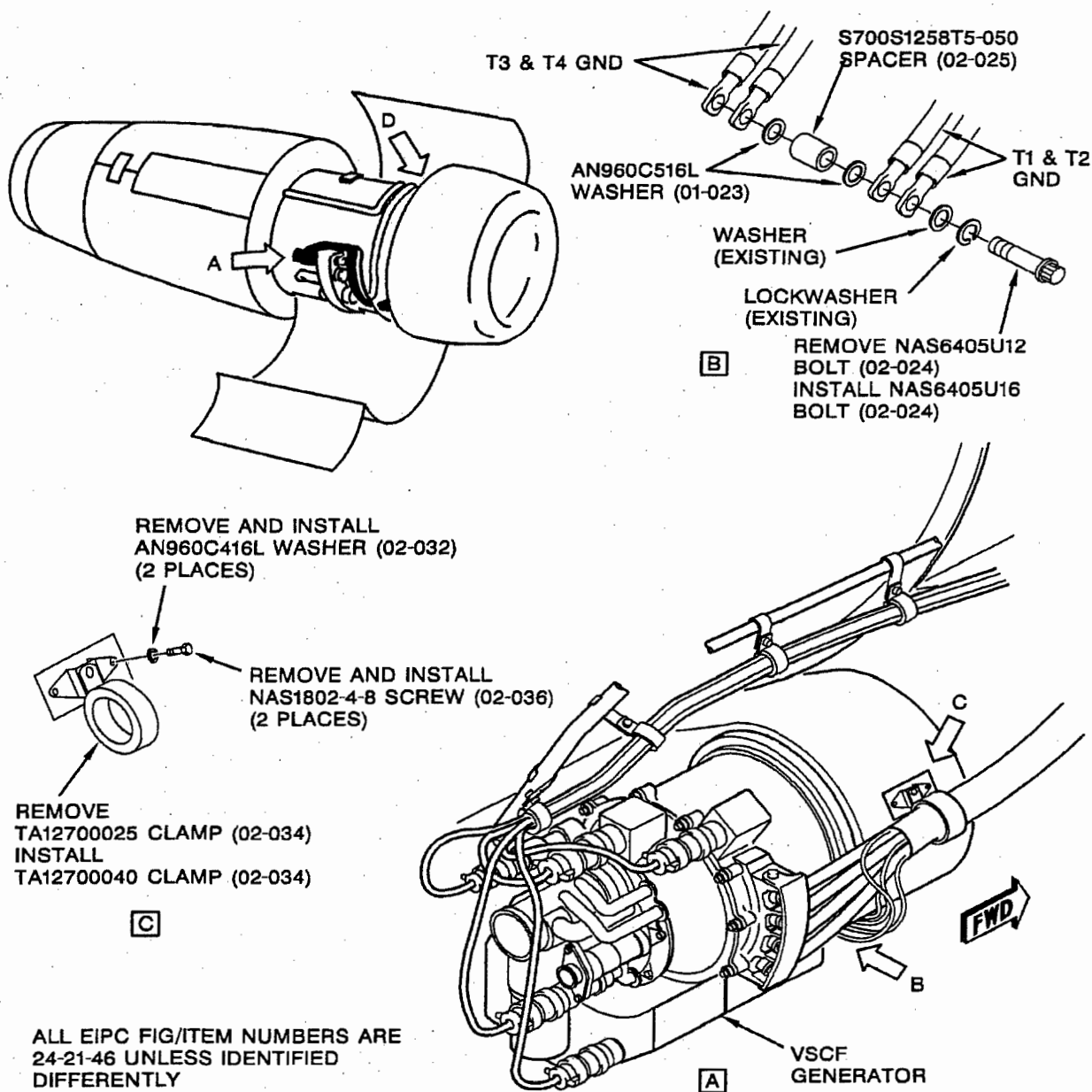
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VSB373

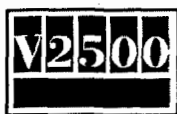
ENGINE POWER FEEDER GROUND TERMINAL BOLT AND CLAMP INSTALLATION - RH
ENGINE

FIGURE 2 (SHEET 1 OF 2)

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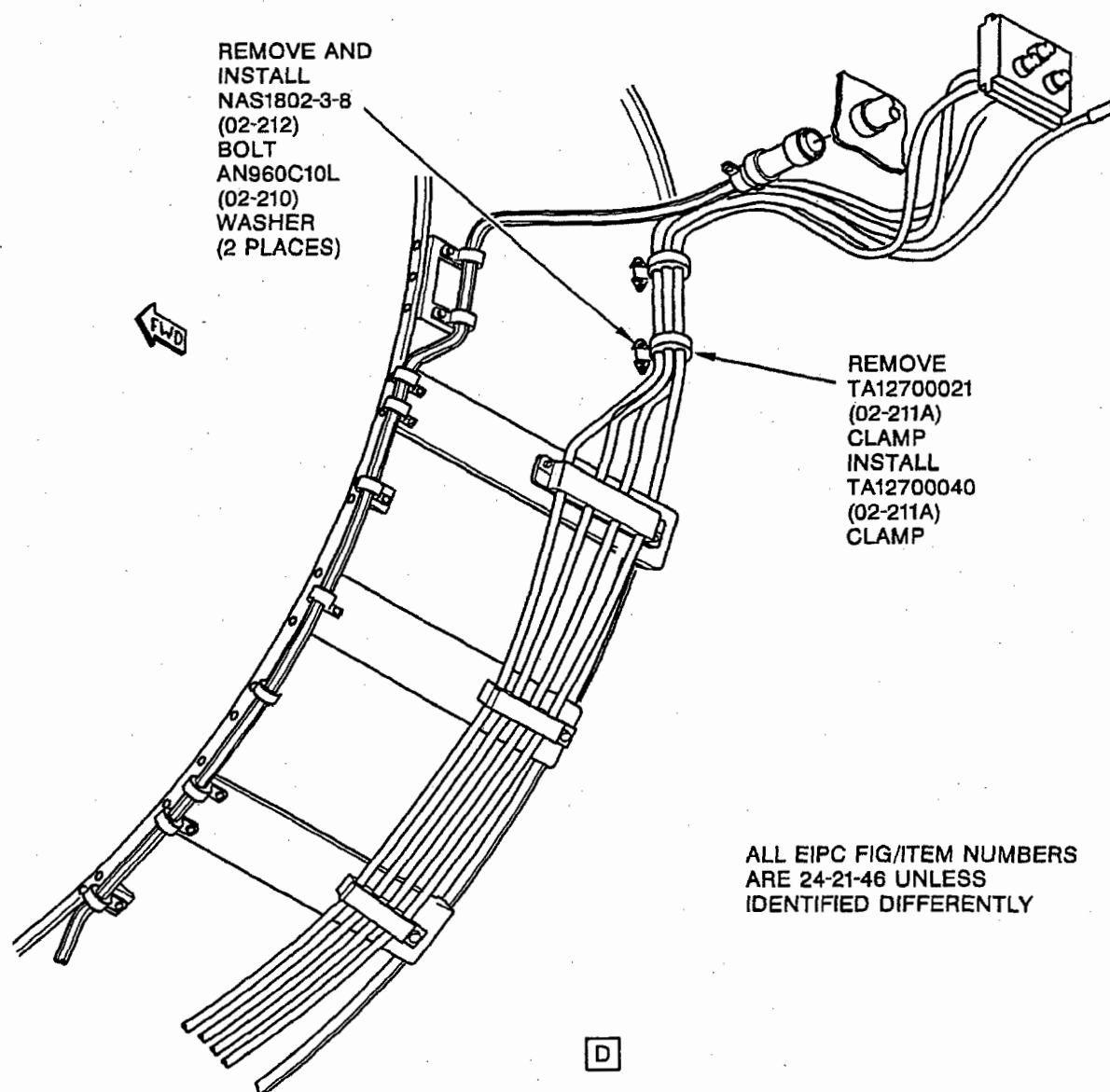
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ALL EIPC FIG/ITEM NUMBERS
ARE 24-21-46 UNLESS
IDENTIFIED DIFFERENTLY

VSB407

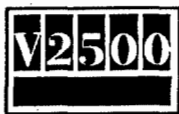
ENGINE POWER FEEDER GROUND TERMINAL BOLT AND CLAMP INSTALLATION - RH
ENGINE

FIGURE 2 (SHEET 2 OF 2)

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- (a) Attach the TA12700040 clamp (24-21-46, 02-211A) to the engine with two NAS1802-4-8 screws (24-21-46, 02-212) and AN960C416L washers (24-21-46, 02-210).
- (b) Open the TA12700040 clamp, insert the VSCF power feeder cables, and close the clamp.

C. Post Requisite Instructions

Not applicable.

D. Recording Instructions

- (1) A record of accomplishment is necessary. Write in engine log or other applicable records that Service Bulletin V2500-NAC-24-0010 has been done.

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3. Material Information

Applicability: For each V2500 Nacelle to incorporate this Bulletin:

A. Kits Associated with this Bulletin:

None.

B. Parts Affected by this Bulletin:

<u>NEW PART NO</u> <u>(ATA NO)</u>	<u>QTY</u>	<u>EST'D</u> <u>UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO</u> <u>(IPC NO)</u>	<u>INSTR/</u> <u>DISPOS</u>
NAS6405U16 (24-21-46)	1		Bolt (LH)	NAS6405U12 (01-031)	(A)(2D)(S1)
TA12700039 (24-21-46)	1		Clamp (LH)	TA12700025 (01-062A)	(A)(2D)(S1)
NAS6405U16 (24-21-46)	1		Bolt (RH)	NAS6405U12 (02-024)	(A)(2D)(S1)
TA12700039 (24-21-46)	1		Clamp (RH)	TA12700025 (02-034)	(A)(2D)(S1)
TA12700040 (24-21-46)	1		Clamp (RH)	TA12700026 (02-211A)	(A)(2D)(S1)

C. Instruction/Disposition Code Statements

(A) New part will be available November 1995.

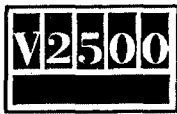
(2D) Old part may be used in other locations.

(S1) New part number is acceptable replacement for the old or new part number.

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NOTE: The estimated 1995 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the Rohr Price Catalog or contact Rohr's Customer Support Department for information concerning firm prices.

D. Materials Required to Incorporate This Bulletin

None.

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