

**International  
Aero Engines**

V2500 Propulsion System — Nacelle

# **SERVICE BULLETIN**

**NACELLE — PNEUMATIC — FLANGE, FAN AIR VALVE SUPPORT  
— REPLACEMENT OF**

**MODEL APPLICATION**

**V2500-D5**

**BULLETIN INDEX LOCATOR**

**36-00-00**

**Compliance Category Code**

**4**

**Internal Reference No.**

**JG 98VN803**

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## 1. Planning Information

### A. Effectivity

(1) Airplane: MD90

(a) MD-90 aircraft fuselage serial numbers 2222 thru 2228.

(2) Nacelle: V2500-D5

### B. Reason

(1) Condition

The fan air valve support flanges installed on the aircraft listed in paragraph 1.A. are not the correct configuration.

(2) Background

Fan air valve support flanges of a discrepant configuration were installed on the aircraft listed in paragraph 1.A.

(3) Objective

To replace the fan air valve support flanges installed on the aircraft listed in paragraph 1.A. with correctly configured flanges.

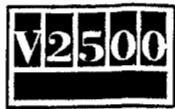
(4) Substantiation

Not applicable.

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(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.

C. Description

The change introduced by this Bulletin is as follows:

Replaces the fan air valve support flange.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD-90-36-015 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

Category 4

Accomplish at the first visit of the aircraft to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action for the aircraft.

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## F. Manpower

Estimated manhours per aircraft to incorporate the full intent of this Bulletin:

### VENUE

### ESTIMATED MANHOURS

#### (1) In Service

(a)	To gain access	1.0 M/Hrs.
(b)	To embody	2.0 M/Hrs.
(c)	To return Nacelle to service	<u>1.0 M/Hrs.</u>

Total 4.0 M/Hrs

#### (2) In Shop

(a)	To Rework	<u>2.0 M/Hrs.</u>
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Total 2.0 M/Hrs

NOTE: Manhour estimate provided for planning purposes only.

## G. Material - Cost and Availability

The parts to accomplish this Service Bulletin are available from the manufacturer as kit V2536005-551 at no cost to the operator.

Operators with units listed in Paragraph 1.A should submit a no-charge purchase order for the applicable quantity of kits. The purchase order must reference this service bulletin number with applicable Operator serial numbers and list only the parts shown in reference kit. Operators will have one year from the issue date of the Service Bulletin to place an order. After one year, kits will no longer be available and Operators will have to order parts individually at catalog price, if they desire to incorporate the change.

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Direct Purchase order to:  
Rohr, Inc.  
850 Lagoon Drive  
Chula Vista, CA. 91910-2098  
U.S.A.

Attn: Airline Support Manager, MZ -107A  
(Service Bulletin V2500-NAC-36-0005)

NOTE: Please do not send purchase orders for service  
bulletin parts via Spec 2000 ordering system.

## H. Tooling Cost and Availability

. None required.

## I. Weight and Balance

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

## J. Electrical Load Data

Not affected.

## K. References

### Chapter/Section

MD90 Aircraft Maintenance Manual	78-32-00
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## L. Other Publications Affected

MD90/V2500D5 Engine Illustrated Parts Catalog (S-V2500-3IA)	36-13-07
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## **2. Accomplishment Instructions**

### **A. Pre-requisite Instructions**

- (1) Open the thrust reverser halves. Refer to the MD90 Aircraft Maintenance Manual, Chapter 78-32-00, Page Block 201.

### **B. Replace the Fan Air Valve Support Flange**

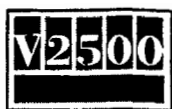
**NOTE:** This procedure is the same for the left and right pylon. The information for the right pylon components is shown in parenthesis.

- (1) Remove the nuts, washers, bushings, and bolts and disconnect the links from the 290-5234-505 (-506) flange. Refer to Figure 1 (Figure 2).
- (2) Loosen the clamp and remove the 290-5234-505 (-506) flange and e-seal from the valve.
- (3) Remove the nuts, washers, bolts, seal, 290-5187-505 (-507) bracket, and 290-5124-503 (-504) bracket from the flange. Discard the flange.
- (4) Install the 290-5124-503 (-504) bracket, 290-5187-505 (-507) bracket, and seal on the 290-5234-509 (-510) flange with the bolts, washers, and nuts.
- (5) Put the e-seal and 290-5234-509 (-510) flange in to position on the valve and loosely tighten the clamp.
- (6) Connect the links to the 290-5234-509 (-510) flange with the bushings, bolts, washers, and nuts.
- (7) Make sure the seal on the flange is aligned with the mating duct on the thrust reverser and there is no pre-load on the duct.
- (8) Tap around the outside of the clamp with a soft face hammer.

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- (9) Tighten the clamp to the torque value stamped on the clamp.
- (10) Tap around the outside of the clamp with a soft face hammer.
- (11) Tighten the clamp to the torque value stamped on the clamp.
- (12) Tap around the outside of the clamp with a soft face hammer.
- (13) Tighten the clamp to the torque value stamped on the clamp.
- (14) Torque the four link attach nuts to 50-70 in-lb (5.7-7.9 Nm).

## **C. Post-requisite Instructions**

- (1) Close the thrust reverser halves. Refer to the MD90 Aircraft Maintenance Manual, Chapter 78-32-00, Page Block 201.

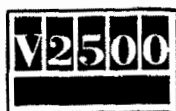
## **D. Recording Instructions**

- (1) A record of accomplishment is necessary. Write in the applicable records that Service Bulletin V2500-NAC-36-0005 has been done.

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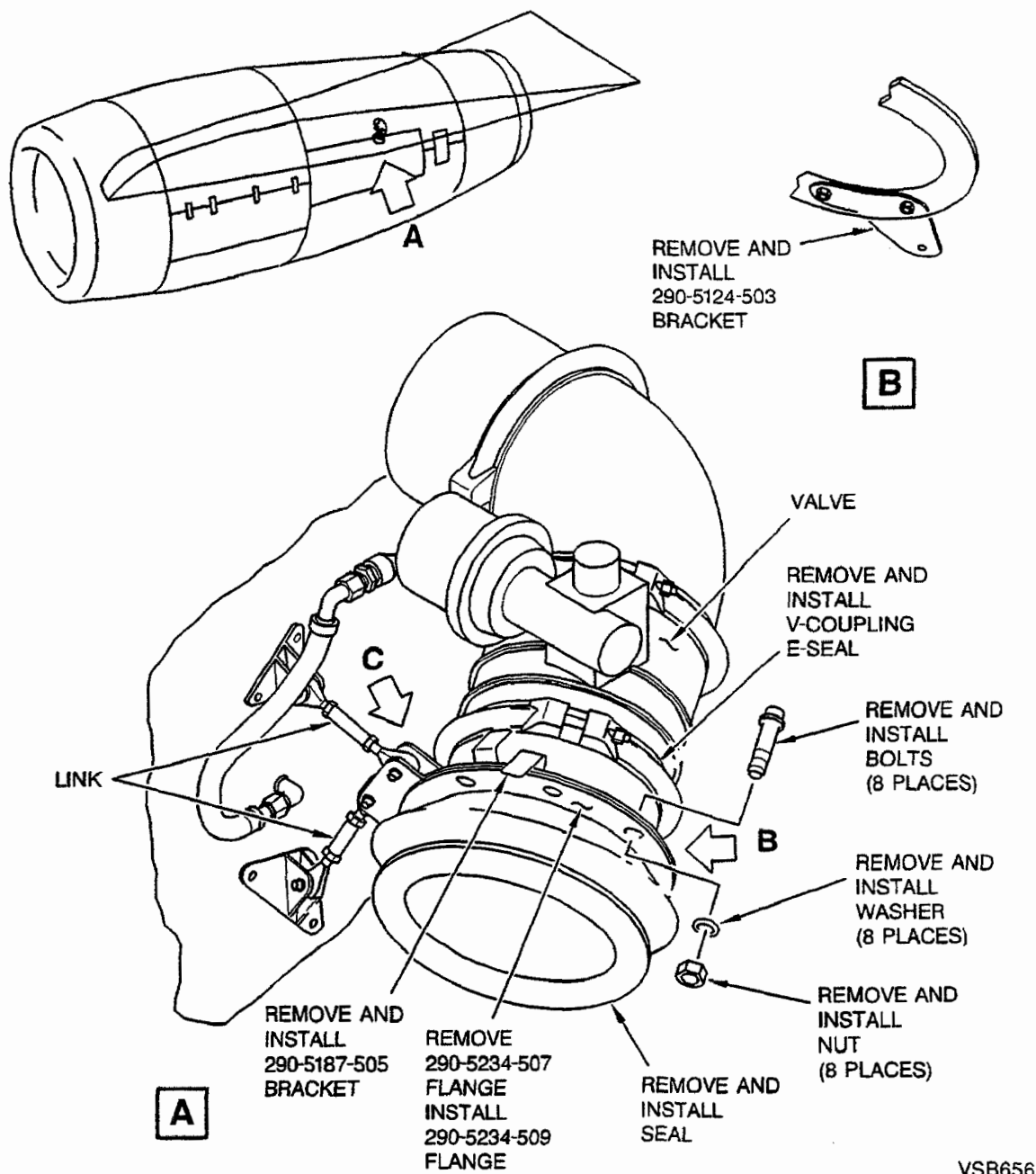
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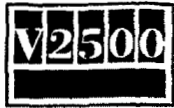
VSB656

LH Pylon Valve Support Flange Replacement  
Figure 1 (sheet 1)

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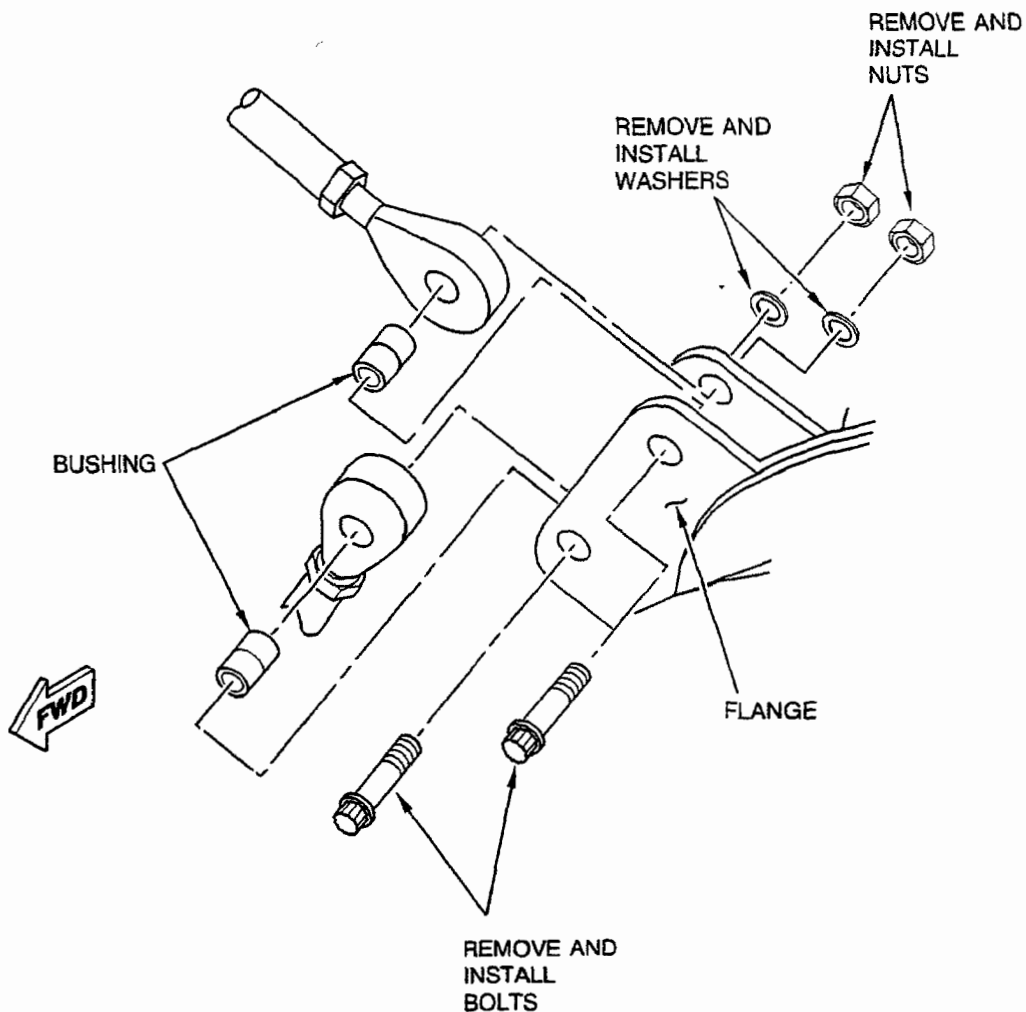
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**C**

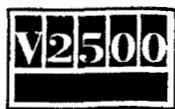
VSB657

LH Pylon Valve Support Flange Replacement  
Figure 1 (sheet 2)

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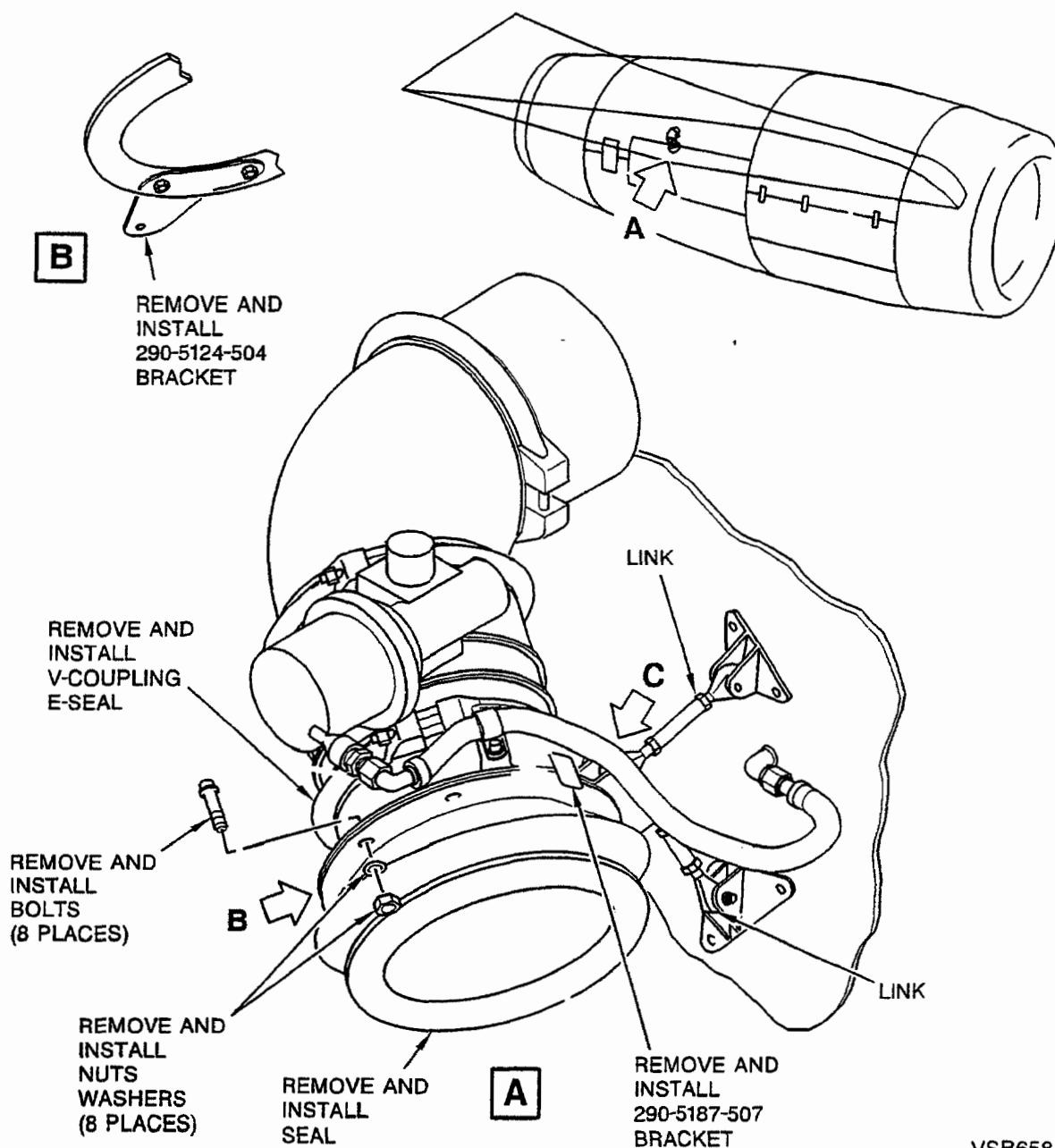
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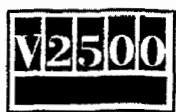


RH Pylon Valve Support Flange Replacement  
Figure 2 (sheet 1)

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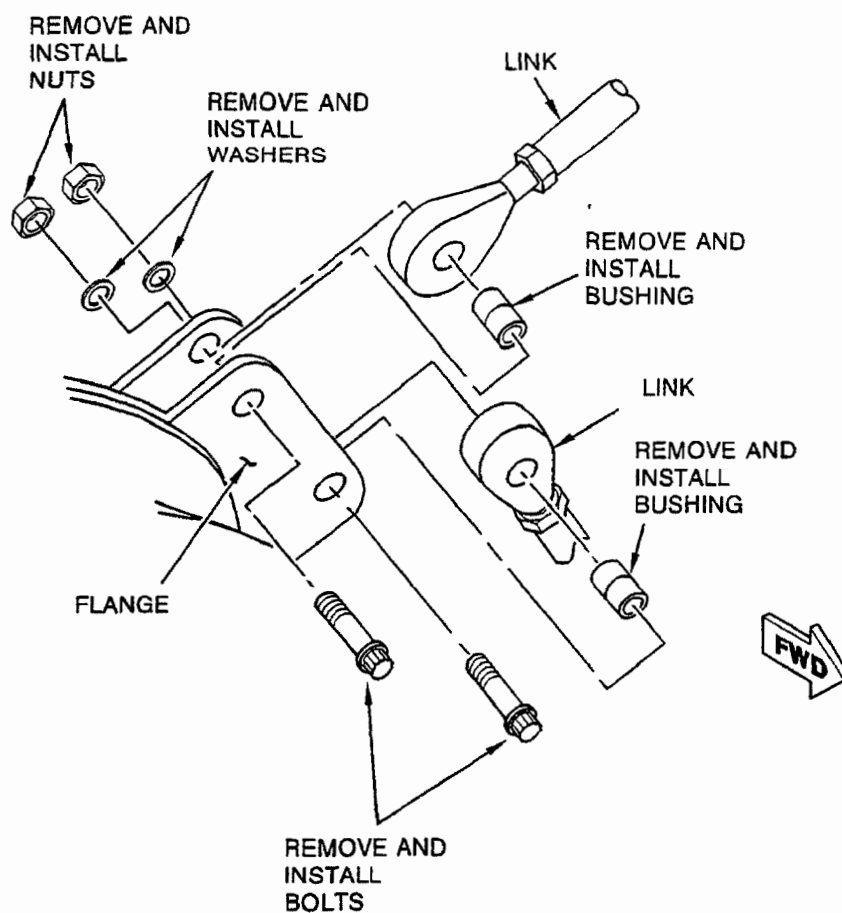
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**C**

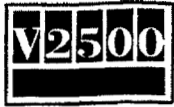
VSB659

RH Pylon Valve Support Flange Replacement  
Figure 2 (sheet 2)

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## 3. Material Information

Applicability: For each affected aircraft to incorporate this Bulletin.

### A. Kits associated with this Bulletin:

NEW PART NO (ATA NO)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO (IPC NO)	INSTR/ DISPOS
V2536005-551			Kit		(A)
Consisting of:					
290-5234-509	1		Flange		
290-5234-510	1		Flange		

### B. Parts affected by this Bulletin:

NEW PART NO (ATA NO)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO (IPC NO)	INSTR/ DISPOS
290-5234-509 (36-13-07)	1		Flange	290-5234-505 (01-060)	(1D)(S1) (B)(C)
290-5234-507 (36-13-07)	1		Flange	- - -	(D)
290-5234-510 (36-13-07)	1		Flange	290-5234-506 (02-060)	(1D)(S1) (B)(C)
290-5234-508 (36-13-07)			Flange	- - -	(E)

### C. Instruction/Disposition Code Statements

(A) Kit will be available November 1998.

(B) New part will be available November 1998.

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- (C) Old part will no longer be available.
- (D) Optional to the 290-5234-509.
- (E) Optional to the 290-5234-510.
- (1D) Discard old part (for Aircraft listed in Paragraph 1.A. only).
- (S1) Old and new parts are freely and fully interchangeable (except for the parts removed from the Aircraft listed in Paragraph 1.A.).

D. Materials Required to Incorporate this Service Bulletin:

None.

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