



SERVICE BULLETIN

NACELLE - POWER PLANT - MODIFICATION RECORD PLATES - REPLACEMENT OF - CATEGORY CODE 5 - MOD.NAC-71-0015

NOTE: This Service Bulletin is written on the basis that IAE Service Bulletins V2500-NAC-71-0027 and V2500-NAC-71-0126 have been incorporated.

1. Planning Information

A. Effectivity

- (1) Airplane: Airbus A320
- (2) Nacelle: V2500-A1 Nacelles
 - (a) Inlet Cowls

The intent of this Service Bulletin was incorporated at the manufacturer on Inlet Cowl Serial Number 78 and on.

The following Inlet Cowl Serial Numbers were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2571015-553.

Inlet Cowl Serial Number	Qty of Kits V2571015-553
1 thru 77	77

(b) Fan Cowl Units

The intent of this Service Bulletin was incorporated at the manufacturer on Fan Cowl Serial Numbers 55, 56, 115, and on.

The following Fan Cowl Serial Numbers were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kits V2571015-551.

Fan Cowl Serial Number	Qty of Kits V2571015-551
1 thru 54 and 57 thru 114	111

B. Reason

(1) Condition

The modification record plates on the inlet cowl rear bulkhead and on the fan cowl doors are not fire resistant.

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(2) Background

Fire resistant modification record plates were not available in time for production parts. Temporary modification record plates were installed on an interim basis.

(3) Objective

Not applicable

(4) Substantiation

Not applicable.

(5) Impact of Bulletin on:

Removal/Installation	Not affected
Disassembly/Assembly	Not Affected
Cleaning	Not Affected
Inspect/Check	Not Affected
Repair	Not Affected
Testing	Not Affected

(6) Supplemental Information

None.

C. Description

(1) The change introduced by this Bulletin is as follows:

The modification record plates on the left and right fan cowl doors are removed and new plates are installed. Also, the modification record plate on the inlet cowl rear bulkhead is removed and a new plate installed.

D. Approval

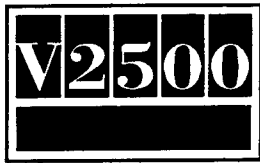
The change in definition subject of this Service Bulletin has been covered by an aircraft modification, approved by the D.G.A.C. (Direction Generale de l'Aviation Civile - France).

E. Compliance

Category 5

Accomplish when the Nacelle or system is disassembled sufficiently to afford access to the affected subassembly and to all affected spare subassemblies.

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F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

VENUE	ESTIMATED MANHOURS
(1) In Service	
(a) To gain access	N/A
(b) To embody	0.6 M/HRS.
(c) To return part to overhaul condition	N/A
TOTAL	0.6 M/HRS.

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the supplier as Kits V2571015-551 and V2571015-553 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 specify this service bulletin number and only the parts listed herein. Delivery schedules will be furnished to operators upon receipt of their written request.

Direct purchase order to:

Rohr International Sales Corporation
P.O. Box 878
Chula Vista, CA 92012-0878 USA
Attn: Manager, Spares Operations - Warranty
(Service Bulletin No. V2500-NAC-71-0015)

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)

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J. Electrical Load Data

Not affected.

K. References

(1) Internal Reference No.

89VN051/A/89VN052/A

L. Other Publications Affected

V2500 Power Plant Illustrated Parts Catalog

71-11-11

71-13-11

71-13-12

71-13-16

71-13-17

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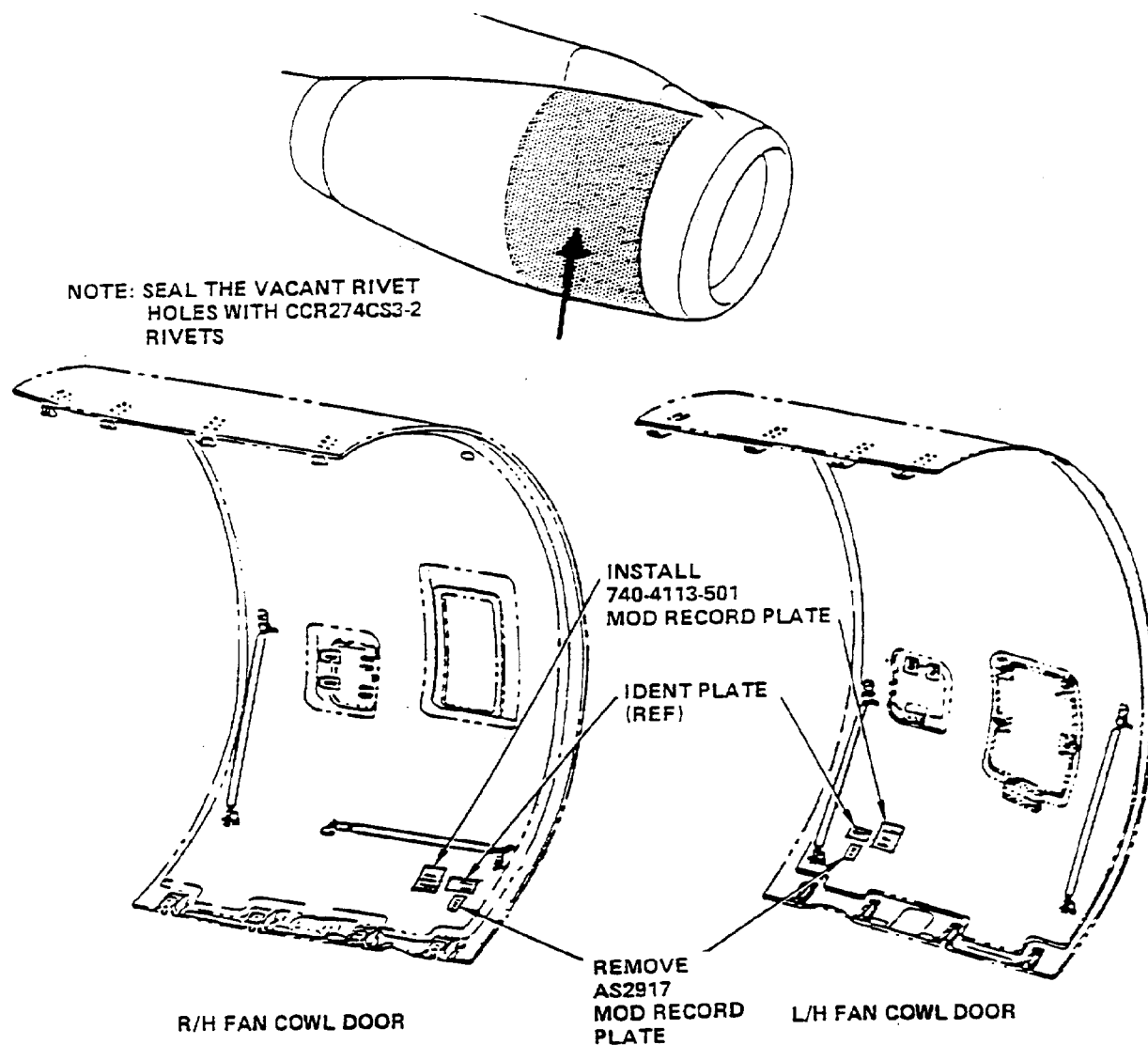


2. Accomplishment Instructions

A. Rework or Modification Instructions

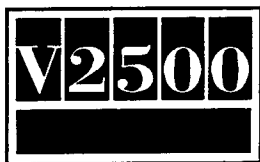
(1) Change of Fan Cowl Doors with Kit V2571015-551

- (a) Find the AS2917 modification (mod) record plate on the 740-4002-563 right fan cowl door and 740-4001-571 left fan cowl door. (Refer to Figure 1.) Remove four rivets to release the mod record plate.
- (b) Seal the four rivet holes in each fan cowl door with four CCR274CS3-2 rivets.
- NOTE: Use a 'drill stop' to make sure that the drill goes through the inside skin only.
- (c) Hold the new 740-4113-501 mod record plate in the approximate position shown on the fan cowl door. Use the mod record plate as a template and drill four holes 0.098 inch (2.50 mm) diameter into the fan cowl door. Remove any burrs from the holes.
- (d) Apply PL32 Hylomar jointing compound to the bottom face of the 740-4113-501 mod record plate. Rivet the mod record plate in position with four CCR274CS3-2 rivets. Remove any unwanted Hylomar with a clean rag.
- (e) Copy the modification record onto the new mod record plate from the old. Discard the old mod record plate.
- (f) Reidentify the left fan cowl door to 740-4001-575. Reidentify the right fan cowl door to 740-4001-567.



Removal and Installation of the Mod Record Plate
Fig.1

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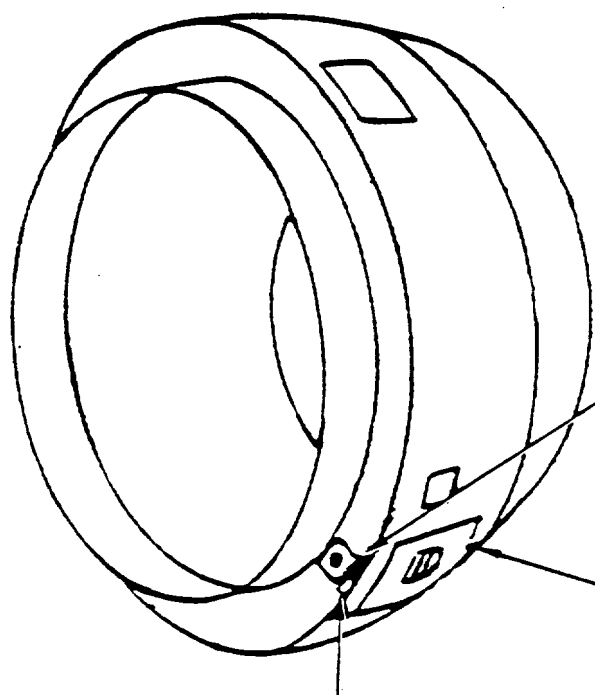
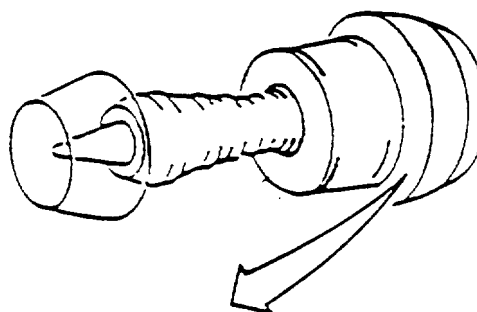
(2) Change of Inlet Cowl assembly with Kit V2571015-553

- (a) Find the AS2917 mod record plate on the 740-3000-573 inlet cowl rear bulkhead. (Refer to Figure 2.) Remove four rivets to release the mod record plate.
- (b) Seal the four rivet holes in the bulkhead with four CR3523-5-4 rivets.
- (c) Remove rivets as necessary from the 1-07752-00-00 insulation blanket to gain access to rivets at locations (A) and C. (Refer to Figure 3.)
- (d) Remove rivets from locations C and (A).
- (e) Increase the hole dimension at location (A) to 0.200 inches (5.1 mm) diameter in the insulation blanket and the bulkhead. Remove any burrs from the holes.
- (f) Install the 740-3254-501 mod record plate with the 1-07752-00-00 insulation blanket to the bulkhead as follows:
 - 1 Apply PL32 Hylomar jointing compound to the bottom face of the mod record plate.
 - 2 Use the fasteners shown on Figure 3 to install the insulation blanket with the mod record plate on the bulkhead.
 - 3 Remove any unwanted material or debris from inside the inlet cowl; get access through the TAI exhaust panel.
- (g) Reidentify the 740-3000-573 inlet cowl to 740-3000-585.

C. Recording Instructions

- (1) A record of accomplishment is necessary.

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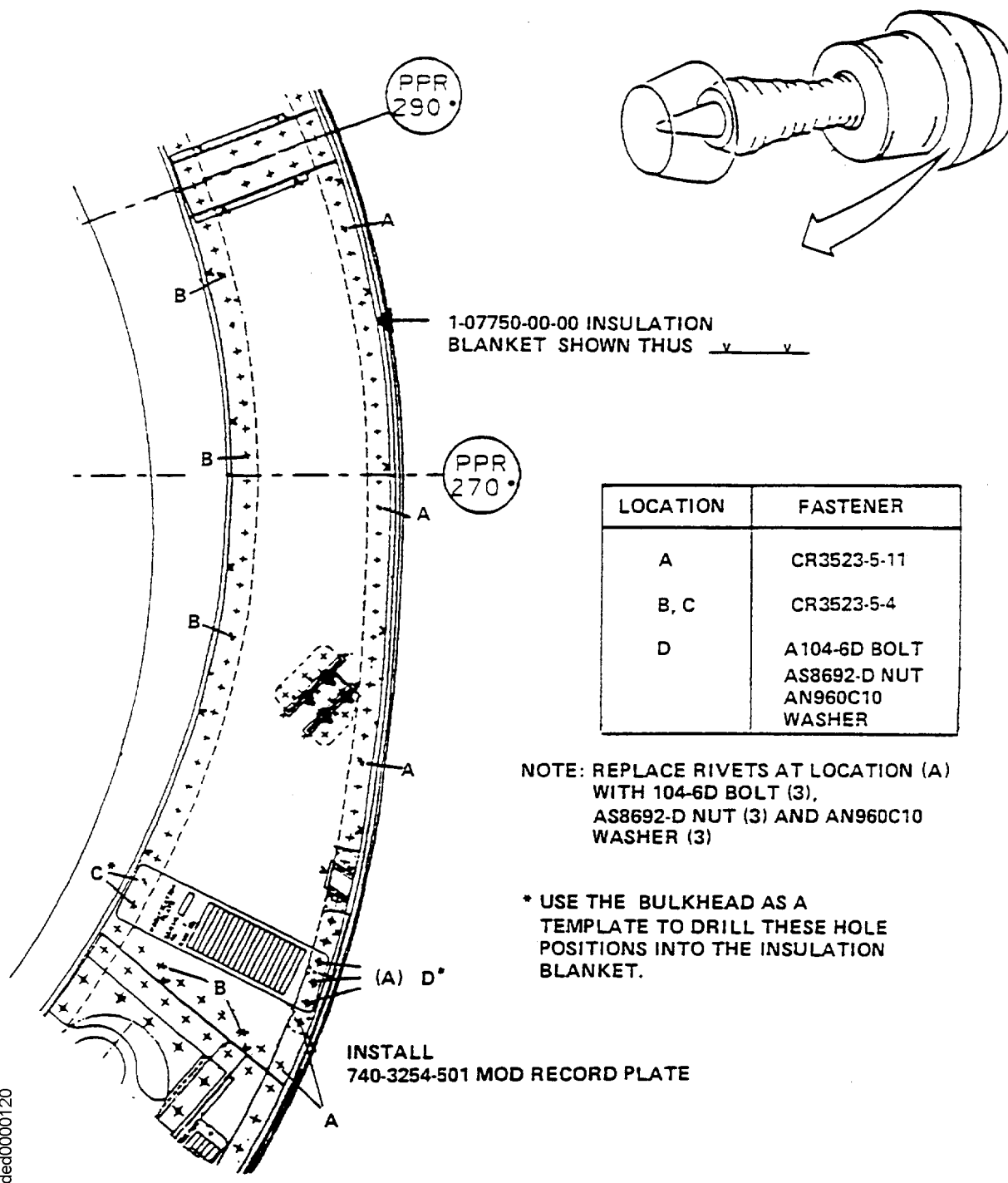
REMOVE
AS2917 MOD RECORD PLATE
(SEAL THE VACANT RIVET HOLES
WITH CR3523-5-4 RIVETS)

T.A.I. EXHAUST PANEL (REF)

IDENT PLATE (REF)

Removal of the Mod Record Plate (Non Fire Resistant)
Fig.2

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Modification of the Insulation Blanket (to Install the Mod Record Plate)
Fig.3



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3. Material Information

NEW PN (ATA No.)	QTY	EST'D PRICE (\$)	KEYWORD	OLD PN (IPC No.)	INSTR/ DISPOS
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Applicability: For each V2500 Nacelle to incorporate this Bulletin.

A. Kits Associated with this Service Bulletin:

V2571015-551	1	Kit	(A)
consisting of:			
740-4113-501	1	Mod Record	
		Plate	
CCR274CS3-2	20*	Rivet	
V2571015-553	1	Kit	(A)
consisting of:			
740-3254-501	1	Mod Record	
		Plate	
A104-6D	3	Bolt	
AS8692-D	3	Nut	
AN960C10	3	Washer	
CR3523-5-4	15*	Rivet	
CR3523-5-11	12*	Rivet	740-3000-573 (2D)

*includes excess

B. Parts Affected by this Service Bulletin:

740-3000-585	1	Inlet Cowl	740-3000-573 (2D)
(71-11-11)			(01-005)
740-3254-501	1	.Mod Record	AS2917 (1D)(B)
(71-11-11)		Plate	(01-225) (C)(D)
A104-6D	3	.Bolt	CR3523-5-11 (B)(C)(D)
(71-11-11)			(01-240)
AS8692-D	3	.Nut	CR3523-5-11 (B)(C)(D)
(71-11-11)			(01-230) (5D)
AN960C10	3	.Washer	CR3523-5-11 (B)(C)(D)
(71-11-11)			(01-235)
CR3523-5-4	12*	.Rivet	-- (B)
(71-11-11)			(01-230)
740-4001-575	1	Fan Cowl	740-4001-571 (2D)
(71-13-11)		Door (LH)	(01-010)
--	1	.Mod Record	AS2917 (1D)
(71-13-12)		Plate	(01-007)
740-4113-501	1	.Mod Record	-- (1D)(B)
(71-13-11)		Plate	(01-820) (C)(D)
--	1	.Mod Record	740-4113-501 (4D)

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(71-13-11		Plate	(01-820)	
740-4113-501	1	.Mod Record	--	(3D)
(71-13-12)		Plate	(01-007)	
CCR274CS3-2	4	.Rivet	--	(B)
(71-13-12)			(01-008)	
740-4002-567	1	Fan Cowl	740-4002-547	(2D)
(71-13-16)		Door (RH)	(01-010)	
--	1	.Mod Record	AS2917	(1D)
(71-13-17)		Plate	(01-160)	
740-4002-567	1	Fan Cowl	740-4002-563	(2D)
(71-13-16)		Door (RH)	(01-010)	
740-4113-501	1	.Mod Record	--	(B)(C)
(71-13-16)		Plate	(01-820)	(D)(1D)
--	1	.Mod Record	740-4113-501	(4D)
(71-13-16)		Plate	(01-820)	
740-4113-501	1	.Mod Record	--	(3D)
(71-13-17)		Plate	(01-160)	
CCR274CS3-2	4	.Rivet	--	(B)
(71-13-17)			(01-165)	

*Includes excess

C. Instruction/Disposition Code Statements:

- (A) Kits are available.
- (B) New part supplied as detail of the Kits.
- (C) Old part no longer available for sale.
- (D) New part is available for sale
- (1D) Discard the old part number.
- (2D) Rework old part and reidentify to new part number.
- (3D) New part; part catalog sequence number (CSN) revised.
- (4D) Part not deleted but transferred to new catalog sequence number. See item (3D).
- (5D) Part number AS8600-D may be used as an alternative to AS8692-D.

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D. These materials are to be procured by the Operator or obtained from his stock.

Part Number	Keyword	Qty	Source	Vendor Code
PL32 (CoMat 04-005)	Jointing Compound	AN	Commercially Available	---

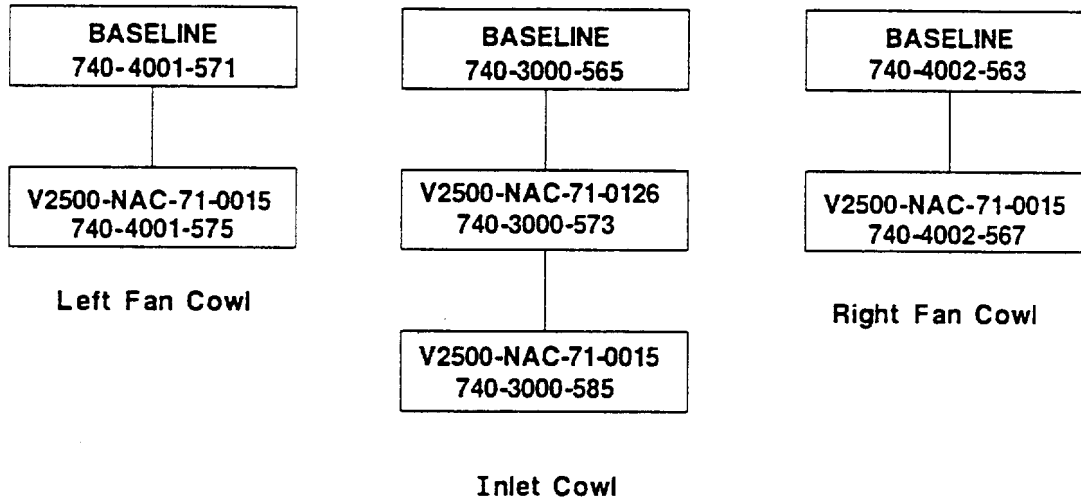
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Family Tree - Inlet Cowl and Fan Cowls Ref. Catalog Sequence Nos. 71-11-11 Fig. 01, Item 005, 71-13-11, Fig. 01, Item 010, 71-13-16 Fig. 01, Item 010 Fig.4

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International Aero Engines

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