



SERVICE BULLETIN

NACELLE - POWER PLANT - FAN COWL DOORS, IDENTIFICATION PLATE - INSTALLATION OF:
REIDENTIFICATION OF - CATEGORY CODE 5 - MOD.NAC-71-0027

1. Planning Information

A. Effectivity

- (1) Airplane: Airbus A320
- (2) Nacelle: V2500-A1 Nacelles
 - (a) Fan Cowl Units

The intent of this Service Bulletin was incorporated at the manufacturer on Fan Cowl Serial Number 41 and on.

The following Left Hand Fan Serial Numbers were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2571027-551.

LH Fan Cowl Serial Number	Qty of Kits V2571027-551
1, 3, 5, 7, 9, 11, 13, 15, 17, 19, 21, 23, 25, 27, 29, 31, 33, 35, 37, and 39	20

The following Right Hand Fan Cowl Serial Numbers were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2571027-552.

RH Fan Cowl Serial Number	Qty of Kits V2571027-552
2, 4, 6, 8, 10, 12, 14, 16, 18, 20, 22, 24, 26, 28, 30, 32, 34, 36, 38, and 40	20

B. Reason

- (1) Condition

Identification plates were not installed on some fan cowl doors. Additionally, some fan cowl doors may have been inadvertently misidentified to a dash number configuration lower than the actual delivered configuration standard.

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(2) Background

The manufacturer did not initially include identification plates on the fan cowl doors. It is necessary to install fireproof identification plates on the fan cowl doors.

(3) Objective

To properly identify the fan cowl doors.

(4) Substantiation

Not applicable.

(5) Impact of Bulletin on:

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.

C. Description

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

A 740-4108-501 identification plate is installed on the left fan cowl door at the location shown in Figure 1. The identification plate is attached to the fan cowl door with four CCR274CS-3-2 cherry rivets.

A 740-4108-501 identification plate is installed on the right fan cowl door at the location shown in Figure 2. The identification plate is attached to the fan cowl door with four CCR274CS-3-2 cherry rivets.

Fan cowl doors are reidentified to the proper configuration dash number.

D. Approval

The part number changes shown in paragraph 3 of this Service Bulletin have been sanctioned under a product development/control system that has been approved by the DGAC (Direction Generale de l'Aviation Civile - France).

E. Compliance

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

F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

VENUE	ESTIMATED MANHOURS
(1) In Service	
(a) To gain access	Not applicable
(b) To embody	0.5 M/HRS.
(c) To return part to overhaul condition.....	Not applicable
TOTAL	0.5 M/HRS.

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the supplier as Kit V2571027-551 or V2571027-552 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 Industries, Inc.
660 Bay Blvd.
Chula Vista, CA 92012-0878 USA
Attn: Customer Support Manager, Bldg. 805A
(Service Bulletin No. V2500-NAC-71-0027)

H. Tooling Cost and Availability

None required.

I. Weight and Balance

- (1) Weight Change None
- (2) Moment Arm No effect

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(3) Datum Engine Front Mount Centerline
..... (Powerplant Station
..... PPS 100.00

J. Electrical Load Data

Not affected.

K. References

(1) Internal References No:

89VN011/A/

89VN027/

90VN905

L. Other Publications Affected

V2500 Power Plant Illustrated Parts Catalog 71-13-11
71-13-16



2. Accomplishment Instructions

A. Rework or Modification Instructions

(1) Rework the 740-4001-507, -515, -517, or -519 left fan cowl door as follows:

- (a) Hold the 740-4108-501 identification plate to the fan cowl door at the approximate location given in Figure 1. Make a mark around the contour of the identification plate.

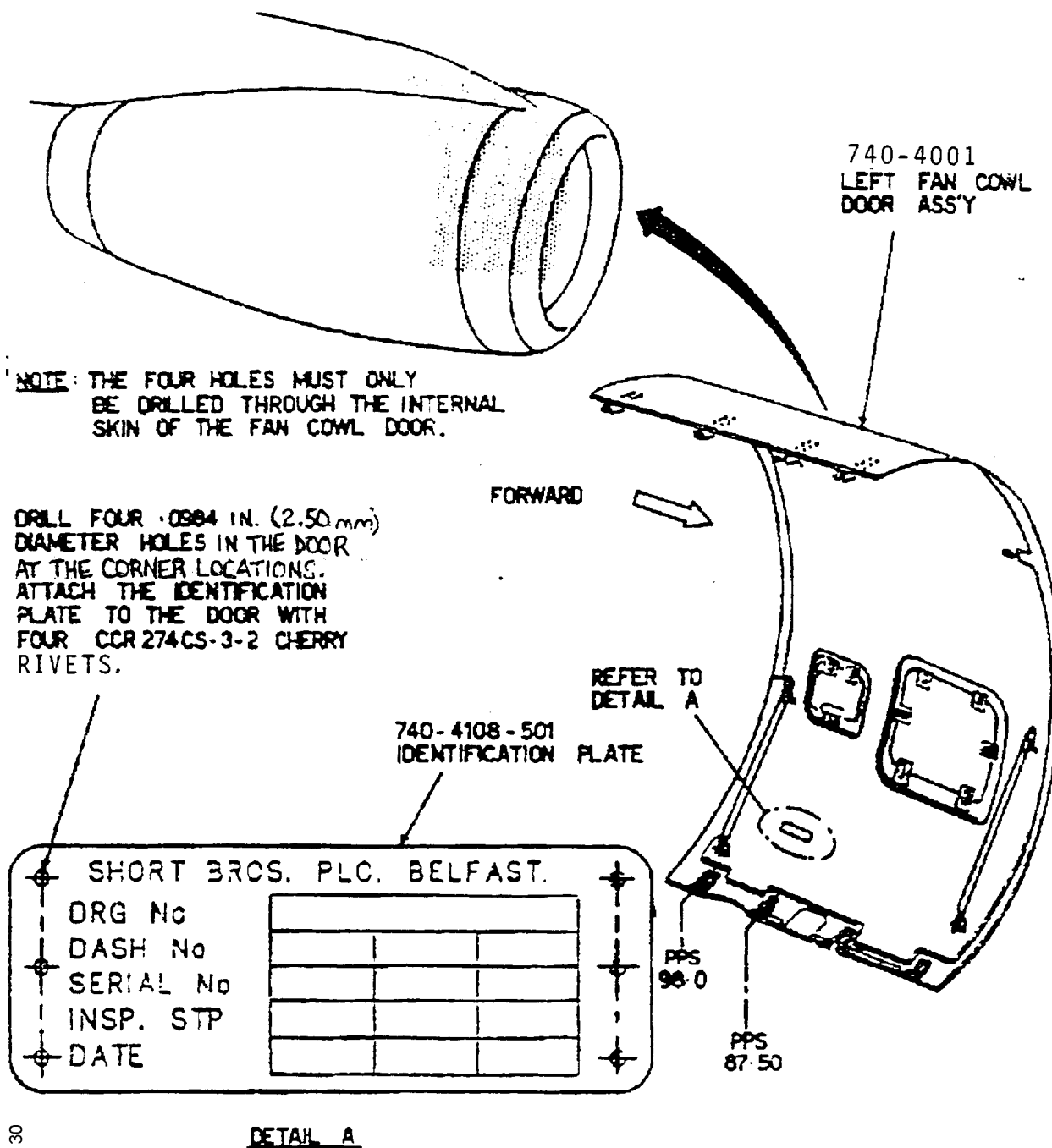
NOTE: The fan cowl door has a rounded surface and the identification plate has a flat surface. The identification plate must be hand adjusted to allow it to be satisfactorily installed on the fan cowl door.

- (b) Put the identification plate on the fan cowl door at the position marked in paragraph 2.B (1) (a). Hold the 740-4108-501 identification plate in position. Drill four 0.0984 inch (2.50 mm) diameter holes through the internal skin only of the fan cowl door at the corner locations. Use the 740-4108-501 identification plate as a template to do this task. (Refer to Figure 1.)

- (c) Remove the identification plate. Remove all burrs from around the four holes drilled in the internal skin of the fan cowl door.

CAUTION: MIX AND APPLY THE TVZ119 and TVZ121 COMPOUND TO THE MANUFACTURER'S SPECIFICATIONS.

- (d) Apply a layer of TVZ119 varnish and TVZ121 activator compound to the cut edges around the four holes.



Installation of the Identification Plate on the Left Fan Cowl Door
Fig.1

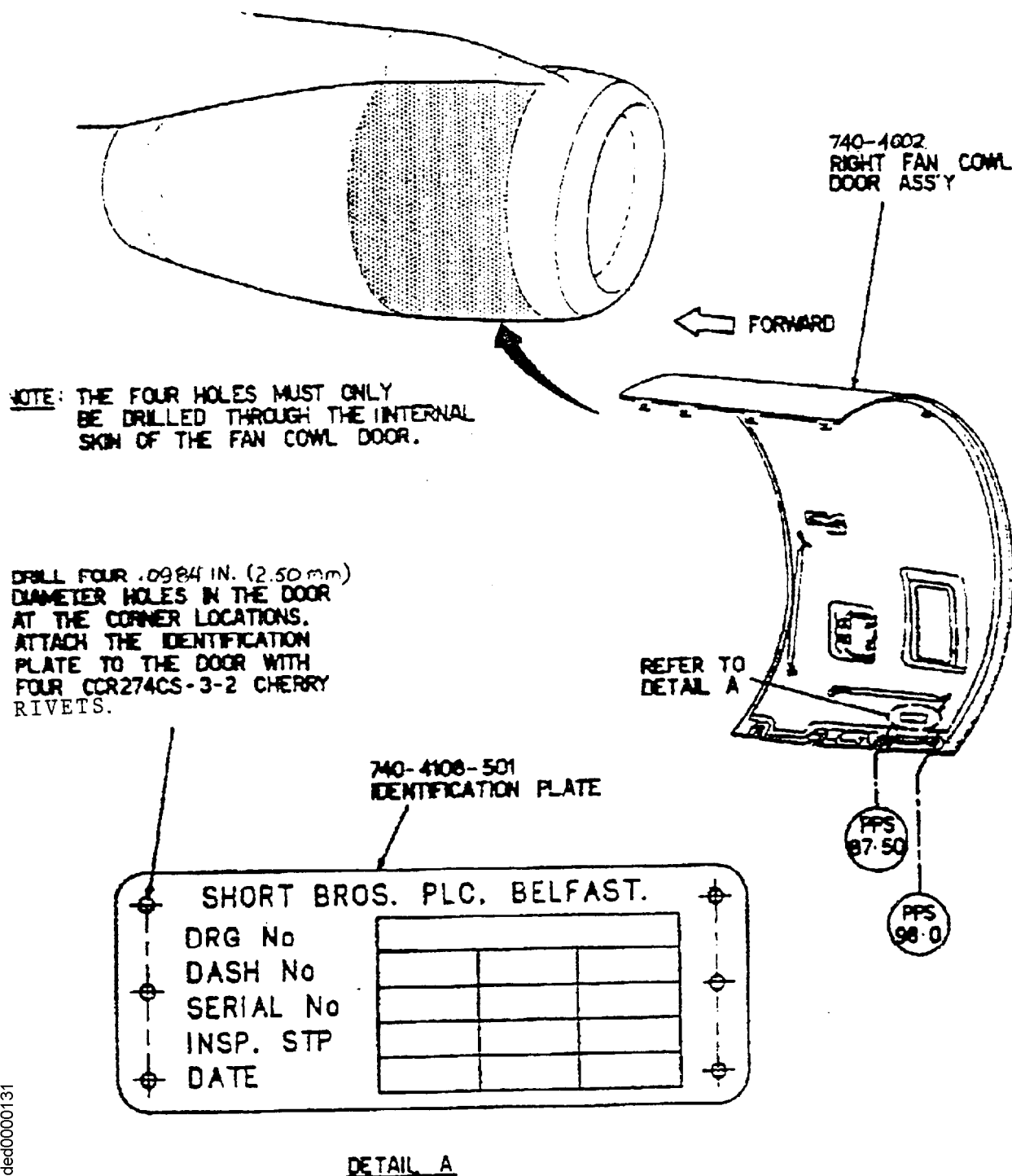
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- (e) Apply a layer of PL32 Hylomar to the rear of the 740-4108-501 identification plate. Attach the identification plate to the door with four CCR274CS-3-2 cherry rivets. Remove any excess Hylomar with a clean cloth.
- (f) Reidentify the 740-4001-507, -55, -517, or -519 left fan cowl door as 740-4001-551.
- (2) If left fan cowl door is identified as 740-4001-551, -555, or -563, reidentify as 740-4001-571.
- (3) Rework the 740-4002-519, -521, or -523 right fan cowl door as specified in paragraphs 2.B.(1)(a) through 2.B.(1)(e). (Refer to Figure 2.) Reidentify 740-4002-519, -521, or -523 as 740-4002-563.
- (4) If right fan cowl door is identified as 740-4002-535, -543, Or -551, reidentify as 740-4003-563.

C. Recording Instructions

- (1) A record of accomplishment is necessary.



Installation of the Identification Plate on the Right Fan Cowl Door
Fig.2

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3. Material Information

NEW PN (ATA NO.)	QTY	EST'D UNIT 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:

V2571027-551	1		Kit		(A)
consisting of:					
740-4108-501	1		Plate,		
			Identification		
CCR274CS-3-2	4		Rivet, Cherry		
V2571027-552	1		Kit		(A)
consisting of:					
740-4108-501	1		Plate,		
			Identification		
CCR274CS-3-2	4		Rivet, Cherry		

B. Parts Affected by this Service Bulletin:

740-4001-571	1	Left Fan Cowl	740-4001-563	(1D)
(71-13-11)			(01-010)	
740-4001-571	1	Left Fan Cowl	740-4001-555	(1D)
(71-13-11)			(01-010)	
740-4001-571	1	Left Fan Cowl	740-4001-551	(1D)
(71-13-11)			(01-010)	
740-4001-571	1	Left Fan Cowl	740-4001-519	(2D)
(71-13-11)			(01-010)	
740-4001-571)	1	Left Fan Cowl	740-4001-517	(2D)
(71-13-11)			(01-010)	
740-4001-571	1	Left Fan Cowl	740-4001-515	(2D)
(71-13-11)			(01-010)	
740-4001-571	1	Left Fan Cowl	740-4001-507	(2D)
(71-13-11)			(01-010)	
740-4108-501	1	.Plate, ID	--	(B)
(71-13-11)			(01-005)	
CCR274CS-3-2	4	.Rivet	--	(B)
(71-13-11)		-	(01-006)	
740-4002-563	1	Right Fan Cowl	740-4001-551	(1D)
(71-13-16)			(01-010)	
740-4002-563	1	Right Fan Cowl	740-4002-543	(1D)
(71-13-16)			(01-010)	
740-4002-563	1	Right Fan Cowl	740-4002-535	(1D)
(71-13-16)			(01-010)	
740-4002-563	1	Right Fan Cowl	740-4002-523	(2D)
(71-13-16)			(01-010)	

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740-4002-563	1	Right Fan Cowl	740-4002-521	(2D)
(71-13-16)			(01-010)	
740-4002-563	1	Right Fan Cowl	740-4002-519	(2D)
(71-13-16)			(01-010)	
740-4002-563	1	Right Fan Cowl	740-4002-511	(2D)
(71-13-16)			(01-010)	
740-4108-501	1	.Plate, ID	--	(B)
(71-13-16)			(01-150)	
CCR274CS-3-2	4	.Rivet	--	(B)
(71-13-16)			(01-155)	

C. Instruction/Disposition Code Statements:

- (A) Kits are available.
- (B) New part supplied as detail of the Kits.
- (1D) Reidentify the old part number to the new part number.
- (2D) Rework the old part number and reidentify as new part number.

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

Part Number	Keyword	Qty	Source	Code
TVZ119	Varnish	AN	Internal Paint	---
TVZ121	Activator	AN	Aviation Division Ladyswood Works Ratton Part Street Birmingham B16 0AD England	
PL32	Hylomar Jointing Compound	AN	Marston Bently Ltd. 9 Naylor Street Liverpool L3 6DS England	K3237

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