



SERVICE BULLETIN

NACELLE - POWER PLANT - INLET COWL, ACCESS PANEL NUTPLATES - REWORK OF - CATEGORY CODE
6 - MOD.NAC-71-0126

NOTE: This Service Bulletin is written on the basis that IAE Service Bulletin V2500-NAC-71-0028 has been incorporated.

1. Planning Information

A. Effectivity

- (1) Airplane: Airbus A320
- (2) Nacelle: V2500-A1 Nacelles
 - (a) Engine Buildup Units

The intent of this Service Bulletin was incorporated at the manufacturer on Inlet Cowl Serial Number 40 and on.

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

Inlet Cowl
Serial Number

1 thru 39

B. Reason

(1) Condition

Some bolts which attach the 740-3189-501 probe access panel on the inlet cowl are bottoming out.

(2) Background

Not applicable.

(3) Objective

To add packers to nutplates to prevent bottoming out condition.

(4) Substantiation

Not applicable.

(5) Impact of Bulletin on:

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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:

Thirteen ST1729E20X packers are installed with the nutplates to prevent attach bolts from bottoming out.

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 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.

F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

VENUE	ESTIMATED MANHOURS
(1) In Service	Not applicable
(2) At Overhaul (Note: The parts affected by this Service Bulletin are accessible at Overhaul.)	
(a) To embody	2.0 M/HRS.
TOTAL	2.0 M/HRS.

G. Material Cost and Availability

Not applicable.

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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

- (1) Internal Reference No.

89VN054/89VN054A

L. Other Publications Affected

V2500 Power Plant Illustrated Parts Catalog 71-11-11

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2. Accomplishment Instructions

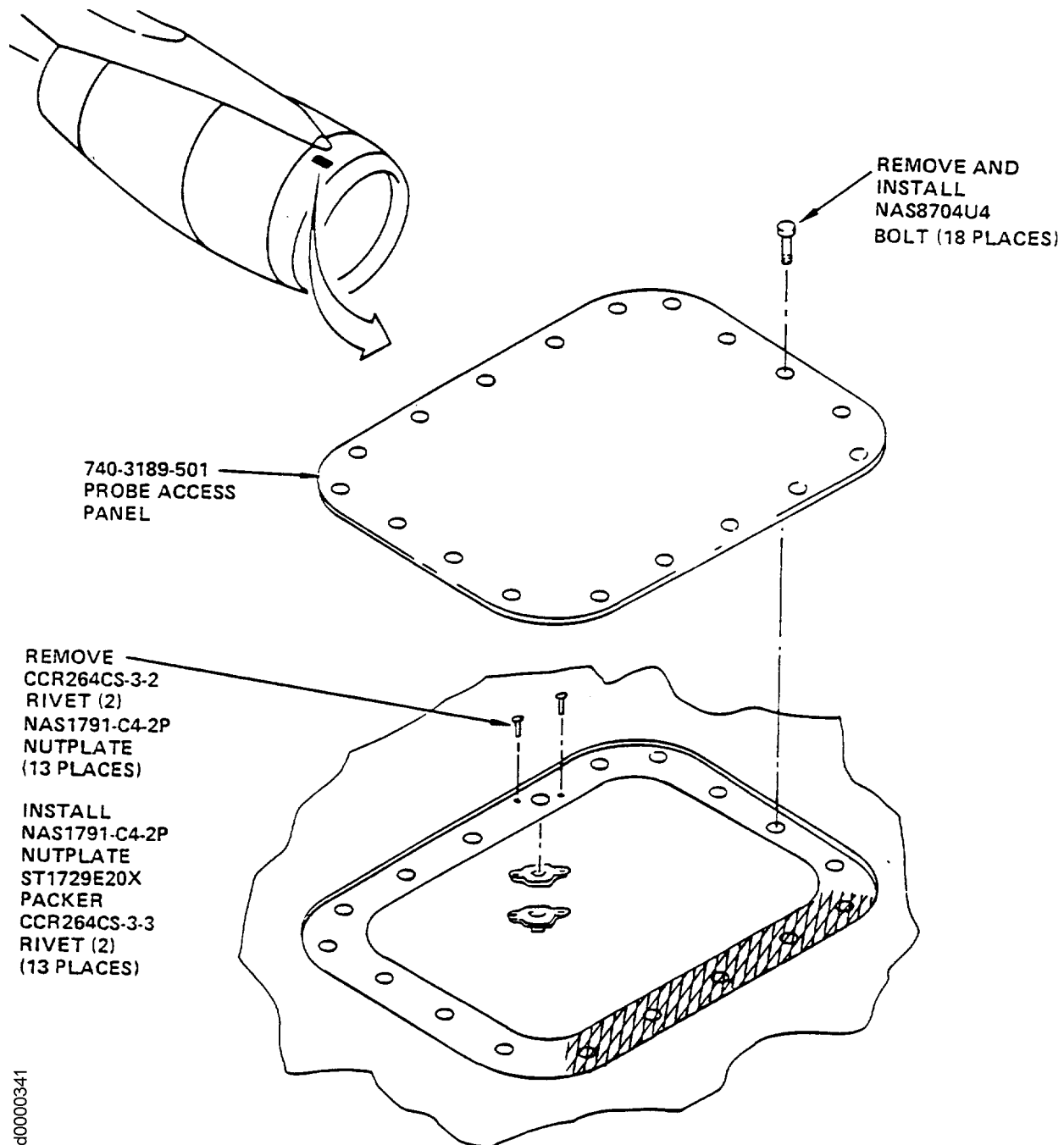
A. Rework or Modification Instructions

- (1) Find the 740-3189-501 probe access panel on the 740-3000-565 inlet cowl. (Refer to Figure 1.)
- (2) Remove NAS8704U4 bolts (18 off) which attach the probe access panel to the inlet cowl. Keep bolts and cover. (Refer to Figure 1.)
- (3) Drill out CCR264CS-3-2 rivets (2 off) which attach the NAS1791-C4-2P nutplates (13 off) to the access panel. Remove only those nutplates shown in Figure 1. Keep nutplates.

WARNING: METHYL ISOBUTYL KETONE (MIBK) IS FLAMMABLE AND VAPOR IS HARMFUL. USE IN A WELL-VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPOR OR PROLONGED OR REPEATED CONTACT WITH SKIN. MAY CAUSE IRRITATION OF EYES, NOSE, THROAT, AND SKIN. HIGH CONCENTRATIONS MAY CAUSE WEAKNESS, HEADACHE, NAUSEA, DIZZINESS, AND IMPAIRED JUDGEMENT. PROTECTIVE GLOVES SHOULD BE WORN DURING USE. MAY CAUSE DERMATITIS BY REMOVING SKIN OILS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (4) Clean fastener holes and nutplates with a clean cloth dampened in MIBK. Wipe off before solvent dries.

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Addition of Packer Plates to P2T2 Access Panel Attach Land
Fig.1

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WARNING: 463-6-27 BASE, X337 CONVERTER, AND TL52 THINNER ARE FLAMMABLE AND VAPOR IS HARMFUL. INHALATION OF SPRAY MIST MAY CAUSE SERIOUS BODILY HARM. AVOID SOURCES OF IGNITION. USE ONLY IN AREAS WITH ADEQUATE VENTILATION. WORK PERFORMED IN CONFINED AREAS REQUIRES THE USE OF ADDITIONAL FORCED MECHANICAL VENTILATION. AVOID BREATHING OF VAPOR AND CONTACT WITH SKIN AND EYES. MAY CAUSE IRRITATION TO SKIN AND EYES. SEVERE OVEREXPOSURE MAY CAUSE FATIGUE, WEAKNESS, CONFUSION, HEADACHE, DIZZINESS, DROWSINESS, AND IMPAIRED JUDGEMENT. USE REGULATORY AGENCY APPROVED RESPIRATORY PROTECTION FOR SPRAY APPLICATION. THIS PRODUCT CONTAINS LEAD, A CUMULATIVE POISON. WASH HANDS WELL BEFORE EATING, DRINKING, OR SMOKING. PROTECTIVE GLOVES SHOULD BE WORN DURING MIXING AND APPLICATION. PROLONGED OR REPEATED CONTACT WITH THIS EPOXY PRIMER MAY RESULT IN A PERMANENT SKIN ALLERGY TO 463-6-27 BASE AND X337 CONVERTER. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (5) Mix 463-6-27 primer, X337 converter, and TL52 thinner with suppliers's instructions.
- (6) Wet install ST1729E20X packers, NAS1791-C4-2P nutplates, and CCR264CS-3-3 rivets in 13 locations. (Refer to Figure 1.)
- (7) Wet install 18 bolts which attach the probe access panel to the inlet cowl.
- (8) Reidentify the 740-3000-565 inlet cowl as 740-3000-573.

B. Recording Instructions

- (1) A record of accomplishment is necessary.

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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:

No Kit required.

B. Parts Affected by this Service Bulletin:

740-3000-573 (71-11-11)	1	Inlet Cowl	740-3000-565 (01-005)	(1D)
CCR264C53-2 (71-11-11)	36	.Rivet	-- (04-015)	(3D)
CCR264CS3-2 (71-11-11)	26	.Rivet	CCR264CS-3-2 (04-015)	(2D)
CCR264CS3-3 (71-11-11)	26	.Rivet	-- (04-020)	(B)
ST1729E20X (71-11-11)	13	.Packer	-- (04-025)	(B)
-- (71-11-11)	18	.Nutplate	NAS1791C4-2P (04-030)	(B)

C. Instruction/Disposition Code Statements:

(B) Obtain from operator stock.

(1D) Rework the old part number to the new part number.

(2D) Quantity decreased.

(3D) Original hardware not added in this modification.

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

Part Number	Keyword	Qty	Source	Vendor Code
Methyl Isobutyl Ketone (MIBK)	Solvent	AN	Commercially Available	---
463-6-27	Primer	AN	Akzo Coatings America Inc.	98502
X337	Converter	AN	Sikkens Aerospace	
TL52	Thinner	AN	Finishes Division 20846 S. Normandie Ave. Torrance, CA 90502-1601	

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ST17229E20X	Packer	13	Rohr Industries, Inc. P.O. Box 878 Chula Vista, CA 92012	51563
CCR264CS-3-3	Rivet	26	Cherry/Textron, Inc. Division of Textron, Inc. 1224 E. Warner St. P.O. Box 2157 Santa Ana, CA 92707	11815

Printed in Great Britain

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