



## SERVICE BULLETIN

POWER PLANT - NACELLE - POWERPLANT - GEARBOX BREATHER OUTLET DUCT - REPLACEMENT OF -  
CATEGORY CODE 5 - MOD.NAC-71-0128

### 1. Planning Information

#### A. Effectivity

Airplane: Airbus A320

- (a) The intent of this Service Bulletin was incorporated at the manufacturer on V2500 Fan Cowl Doors Serial Nos 131 and on.
- (b) The following Fan Cowl Door Serial Numbers were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2571128-551.

Fan Cowl Door  
Serial Number

1-72, 75-90,  
92-126, 129, 130

(2) Spares

This Service Bulletin is also applicable to the following spare Fan Cowl Doors (RH) and requires the use of Kit V2571128-551

Fan Cowl Door  
Serial Number

74, 92, 94, 128, 186  
188, 190, 192, 194,  
204, 206, 208

#### B. Reason

##### (1) Condition

Introduction of the gearbox breather vent may cause an oil well to form between it and the breather outlet duct. Trapped oil may then leak and cause staining of the fan cowl door.

##### (2) Background

Not applicable

##### (3) Objectives

To remove the efflux trap from the gearbox breather outlet.

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## (4) Substantiation

Not applicable.

## (5) Effect on Bulletin On:

(a) Removal/Installation	Not affected.
(b) Disassembly/Assembly	Not affected.
(c) Cleaning	Not affected.
(d) Inspection/Check	Not affected.
(e) Repair	Not affected.
(f) Testing	Not affected.

## (6) Supplemental Information

None.

C. Description

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

- (a) The gearbox breather vent, together with associated bolts, nuts and washers are temporarily removed from the fan cowl door. the breather outlet duct is drilled off and replaced with an improved duct. The gearbox vent is then installed back to the door.

D. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification No. P3178/21948 which is under DGAC (Direction Generale de L'Aviation Civile - France) approval.

E. Compliance

Category Code 5

Accomplish when the nacelle or system is disassembled sufficiently to afford access to the affected subassembly (i.e. accessories, components) and to all affected spare subassemblies.

F. Manpower

Estimated Manhours to incorporate the full intent of this Service Bulletin:

VENUE	ESTIMATED MANHOURS
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(1) In Service .....

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- (a) To gain access ..... 0.25 M/Hrs
- (b) To embody .....1.00 M/Hrs
- (c) To return nacelle to service ...0.25 M/Hrs

Total .....1.50 M/Hrs

G. Material - Cost and Availability

The parts to accomplish this alteration are available from the manufacturer as Kit No V2571128-551.

Formal Kit prices and delivery schedules will be furnished to Operators upon receipt of their written request. (Prices shown in Paragraph 3, "MATERIAL INFORMATION", are listed for planning purposes only, and are subject to change without notice.) Operators will have one year to place an order from the issue date of this Service Bulletin. 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 this change

Direct request to:

Rohr International Sales Corporation  
P.O. Box 878  
Chula Vista,  
CA 91912  
USA

Attn: Customer Support Manager, Bldg 107A  
(Service Bulletin No V2500-NAC-71-0128)

H. Tooling - Cost and Availability

None required.

I. Weight and Balance

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

J. Electrical Load Data

Not affected.

K. References

- (1) Internal Reference No.

89VN119D-01

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(2) Other References

A320/V2500 Aircraft Maintenance Manual, Sections 71-13-00-010-010 and 71-13-00-410-010.

This Service Bulletin must be incorporated concurrently with IAE Service Bulletin V2500-NAC-71-0046.

L. Other Publications Affected

None.

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## 2. Accomplishment Instructions

### A. Pre-requisite Instructions

- (1) Open the right hand fan cowl door with instructions in the A320/V2500 Engine Maintenance Manual, Task 71-13-00-010-010.
- (2) Find the gearbox breather outlet at the bottom, aft part of the right hand fan cowl door. Refer to figure 1.

### B. Rework or Modification Instructions

- (1) Remove and retain four NAS7203U-3 bolts, four AN960-C101 washers and four H01-3 nuts to release the gearbox vent. Retain the gearbox vent also. Refer to figure 1.
- (2) Remove the HL11VF-6-4 Hi-lok bolt and HL97V-6 Hi-lok collar from the outlet duct. Discard the Hi-lok collar.
- (3) Drill out two CR3523-5-2 rivets to release the outlet duct. Remove the outlet duct.

WARNING: DO NOT GET THE CLEANING FLUID ON YOUR SKIN OR IN YOUR EYES. PUT ON PROTECTIVE CLOTHING, GOGGLES AND A FACE MASK. USE THE FLUID IN A WELL VENTILATED AREA. DO NOT BREATHE THE GAS. IF YOU GET THE CLEANING FLUID ON YOUR SKIN OR IN YOUR EYES FLUSH IT AWAY WITH WATER. GET MEDICAL HELP IF YOUR SKIN OR EYES BECOME IRRITATED.

- (4) Clean the mating faces of the outlet duct with trichloroethylene solvent and leave to dry. Apply a liberal coat of PR1422B2 sealant to the mating faces.
- (5) Rivet the new outlet duct in position with two CR3523-5-2 rivets.
- (6) Install the HL11VF-6-4 Hi-lok bolt and safety with an AN960-C10L washer and H01-3 nut. Torque the nut to 40 lbf in.(4.522 Nm).
- (7) Install the gearbox vent back in position with five NAS7203U-3 bolts, four AN960-C10L washers and four H01-3 nuts. Torque bolts to 40 lbf in (4.52Nm).
- (8) Remove any unwanted sealant with a clean rag and leave to cure in accordance with the manufacturers recommendations.

### C. Post-requisite Instructions

- (1) Do a pressure test of the gearbox breather outlet duct as follows (Refer to Figure 2):

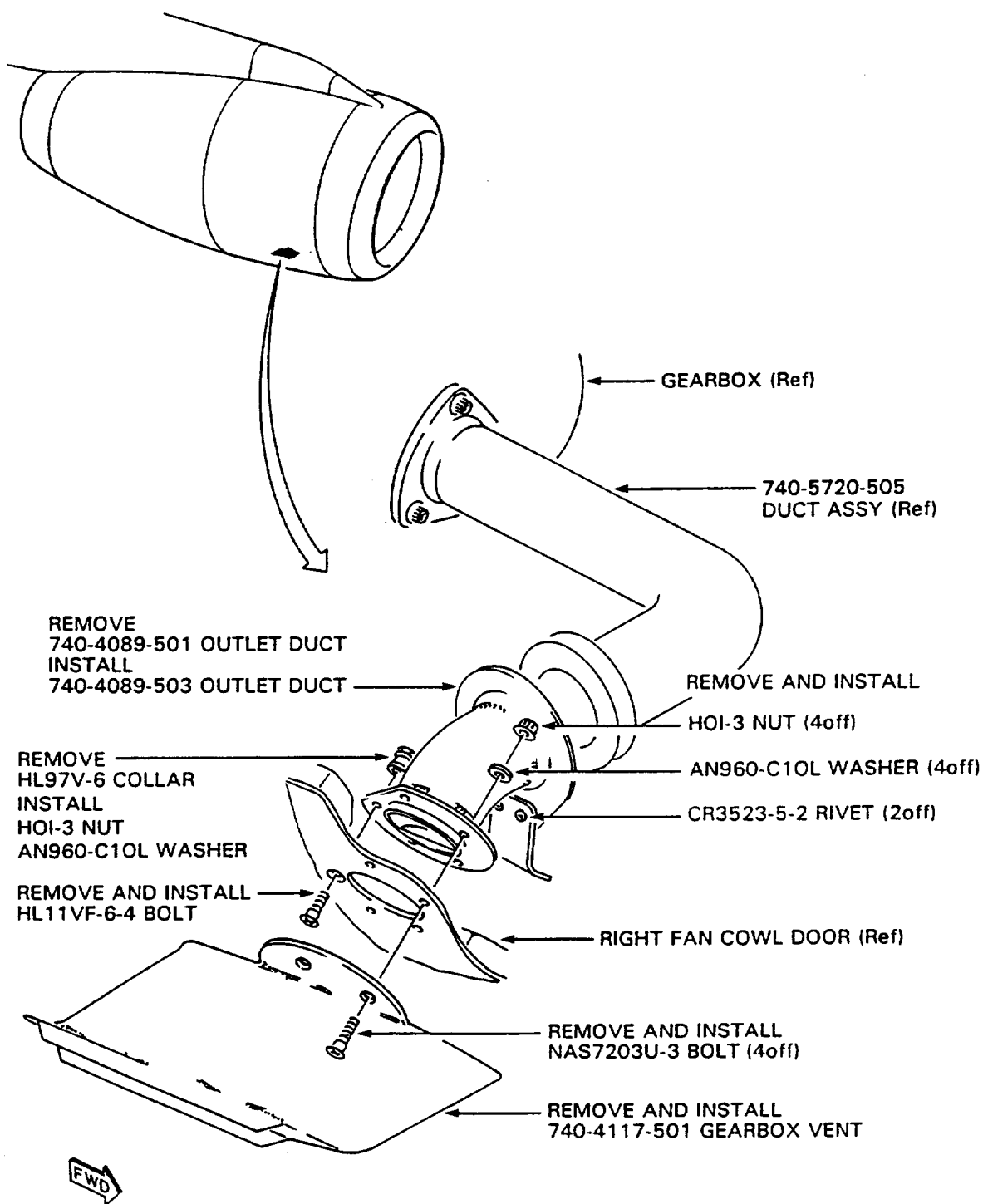
# V2500-NAC-71-0128



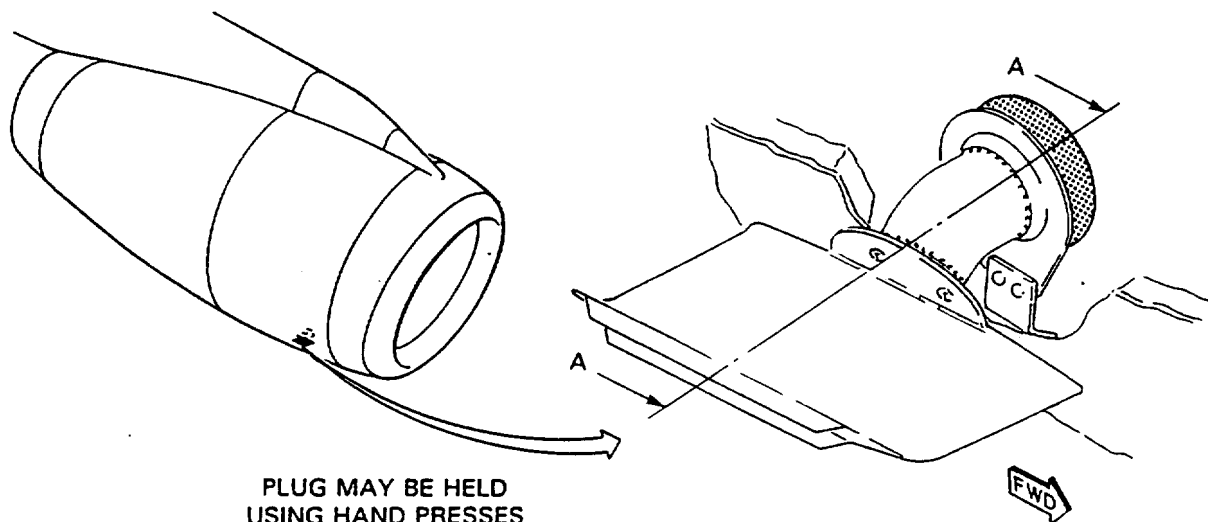
- (a) Make a plug equal to the diameter of the outlet duct from 0.25 in.(6mm) thick (approximate) silicone rubber sheet.
  - (b) Put the plug on the end of the gearbox breather outlet duct (GBOD) as shown. Use hand presses as necessary to provide an effective seal.
  - (c) Put soapy water around the sealed edge of the GBOD as shown.
  - (d) Blow forced air through the gearbox vent and examine for leaks around the sealed edge of the GBOD.
  - (e) If air leaks are found, remove the GBOD and apply sealant again with instructions in step 2.B.
- (2) Close the right fan cowl door with instructions in the A320/V2500 Aircraft Maintenance Manual, Task 71-13-00-410-010.

**D. Recording Instructions**

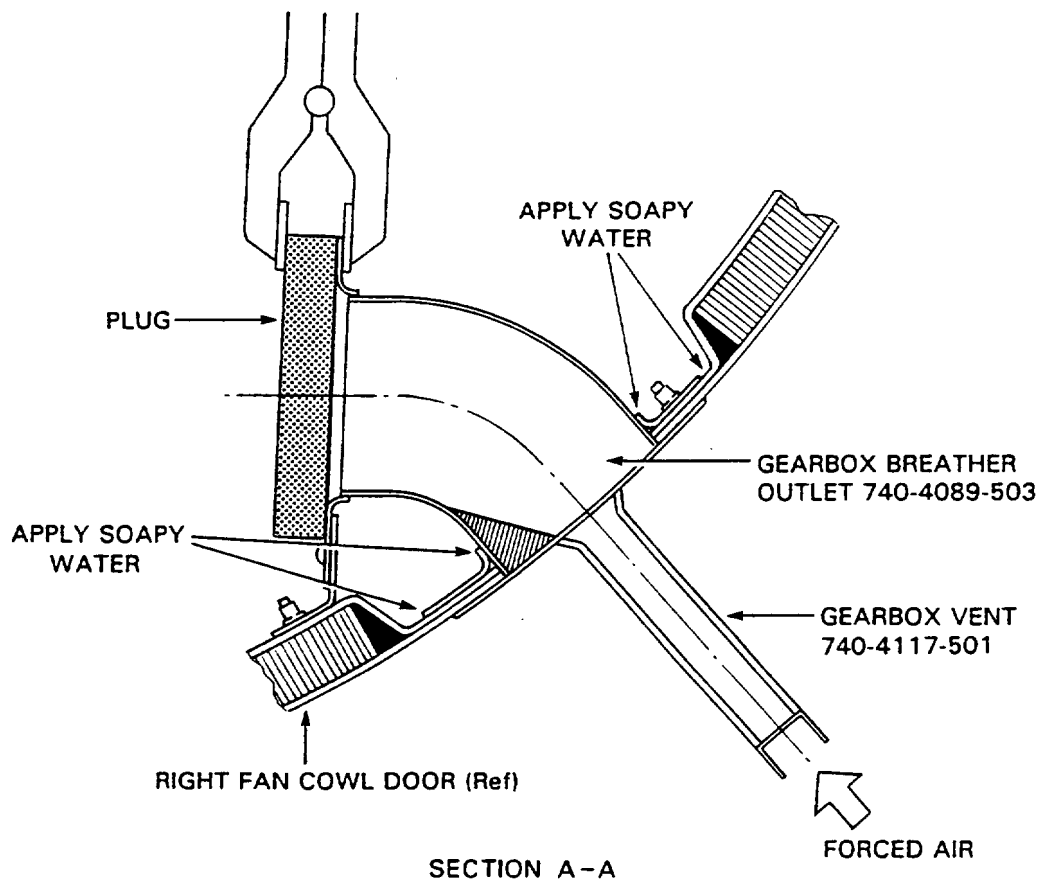
- (1) A record of accomplishment is necessary.



REPLACEMENT OF THE GEARBOX BREATHER OUTLET DUCT  
Fig.1



PLUG MAY BE HELD  
USING HAND PRESSES



SECTION A-A

LEAK TEST  
Fig.2

ded0000343

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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 Bulletin:

V2571128-551 consisting of:	1	Mod Kit	(A)
740-4089-503	1	Outlet Duct	
H01-3	1	Kay-Lok Nut	
AN960-C10L	1	Washer	
CR3532-5-2	2	Rivet	

B. Parts affected by this Bulletin:

740-4002-585 (71-13-16)	1	Cowl, Fan (RH)	740-4002-575 (01-010)	(C)
740-4089-503 (71-13-16)	1	Outlet Duct	740-4089-501 (01-630)	(B)(D)
H01-3 (71-13-16)	1	Kay-Lok Nut )	HL97V-6 (01-634)	(B)(1D)
AN960-C10L (71-13-16)	1	Washer )	---	
			(01-640)	
CR3532-5-2 (71-13-16)	2	Rivet	CR3532-5-2 (01-645)	(B)(1D)

C. Instruction/Disposition Code Statements:

- (A) Kit is available.
- (B) New part supplied as detail of kit.
- (C) Old and new parts are interchangeable both physically and functionally.
- (1D) Discard old part.

The following materials is to be procured by the Operator or obtained from his stock for use in conjunction with Kit No V2571128-551.

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Part No	Keyword	Qty	Source	Vendor Code
PR1422B2	Sealant	A/N	Products Research and Chemical Co. 5454 San Fernando Rd PO Box 1800 Glendale, CA 912103	V83574
	Silicone Rubber Sheet or equivalent	A/N	Commercially Available	
1,1,1	Trichloro-	A/N	Commercially Available	

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