



POWER PLANT - NACELLE - POWERPLANT - GEARBOX BREATHER - OUTLET DUCT - SEALING COMPOUND
- REPLACEMENT OF - CATEGORY CODE 5 - MOD.NAC-71-0133

1. Planning Information

A. Effectivity

(1) Airplane: Airbus A320

- (a) The intent of this Service Bulletin was incorporated at the manufacturer on V2500 Fan Cowl Doors Serial Nos 151 and on.
- (b) The following Fan Cowl Door Serial Nos were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2571133-551.

Fan Cowl Door
Serial Number

131-150

- (c) This Service Bulletin is required on the following units if Service Bulletin V2500-NAC-71-0128 has not been incorporated.

Fan Cowl Door
Serial Number

1-72,75-90,96-126
129,130

(2) Spares

This Service Bulletin is also applicable to the following spare Fan Cowl Doors (RH) and requires the use of Kit V2571133-551.

Fan Cowl Door
Serial Number

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

V2500-NAC-71-0133

**B. Reason****(1) Condition**

Oil mist from the gearbox breather pipe is condensing in the gearbox breather outlet duct and collecting in an oil trap between the outlet duct and gearbox vent. The trapped oil is leaking between the outlet duct flange and the fan cowl door inner skin. The oil escapes through a drain hole in the pandown for the outlet duct and causes staining of the F.C.D.

(2) Background

Not applicable.

(3) Objectives

To prevent staining of fan cowl door.

(4) Substantiation

Not applicable.

(5) Effect of 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 outlet duct is removed and reinstalled using an improved sealant.

D. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification No. P3180/21948 which is under DGAC (Direction Generale de L'Aviation Civile - France) approval.

V2500-NAC-71-0133



SERVICE BULLETIN

E. Compliance

Category 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
(1) In Service	
(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 Service Bulletin are available from the manufacturer as Kit No V2571133-551.

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
PO Box 878
Chula Vista, CA 91912
USA

Attn: Manager, Spares Operations - Warranty
(Service Bulletin No V2500-NAC-71-0133)

H. Tooling - Cost and Availability

None required.

V2500-NAC-71-0133



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.

91VN009A

- (2) Other references

A320/V2500 Aircraft Maintenance Manual, Section 71-13-00.

L. Other Publications Affected

None.



2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) Open the right hand fan cowl door with instructions in the A320/V2500 Aircraft Maintenance Manual, Task 72-13-00-010-010.
- (2) Find the gearbox breather outlet at the bottom, forward 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 outlet duct back 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 nut to 40 lbf in. (4.52NM).

(7) Install the gearbox vent back in position with four NAS7203U-3 bolts, four AN960-C10L washers and four H01-3 nuts. Torque nuts to 40 lbf in (4.52 Nm).

(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):
 - (a) Make a plug equal to the diameter of the outlet duct from 0.25 in.(6mm) thick (approximate) silicone rubber sheet.

V2500-NAC-71-0133



- (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.

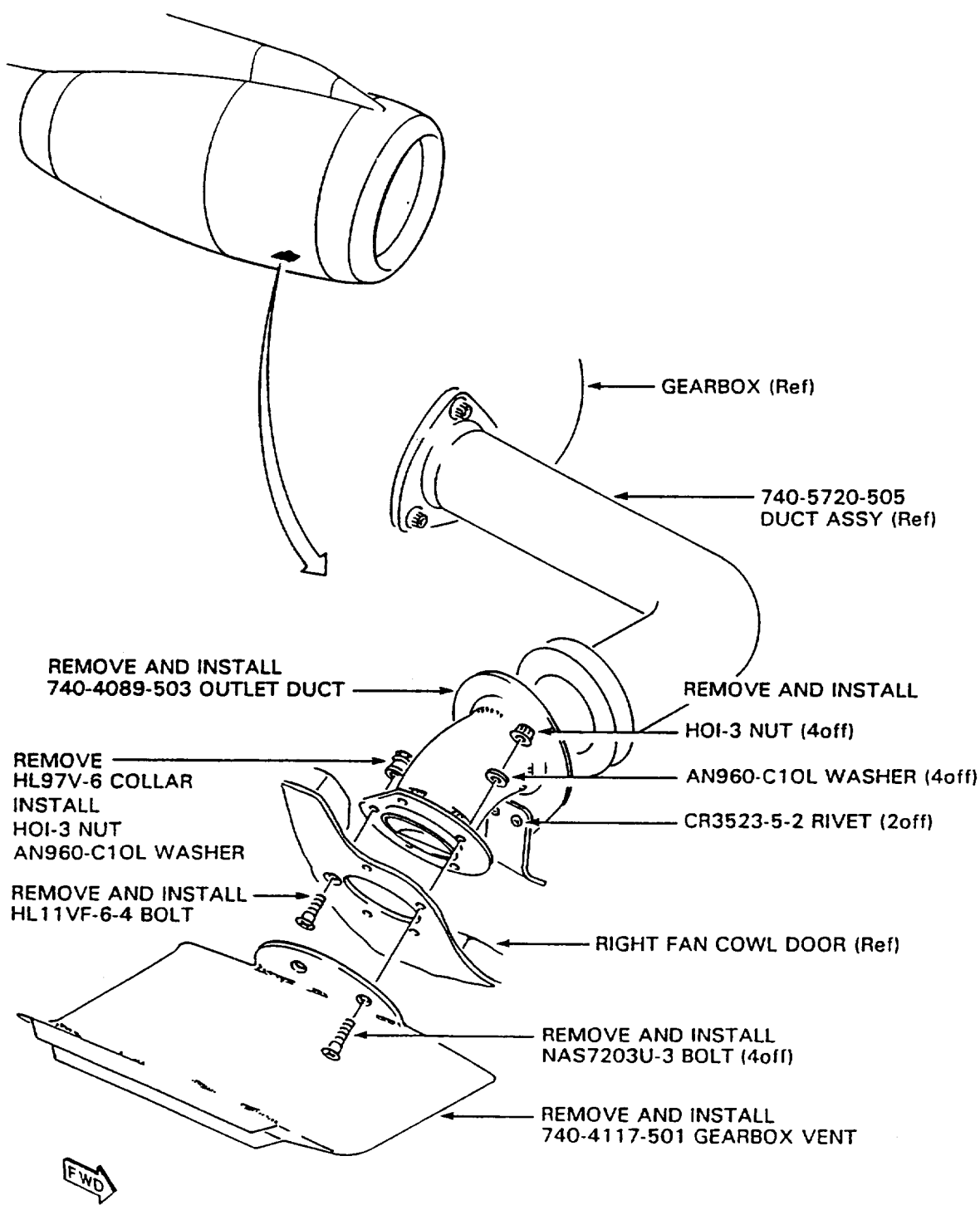
D. Recording Instructions

- (1) A record of accomplishment is necessary.



SERVICE BULLETIN

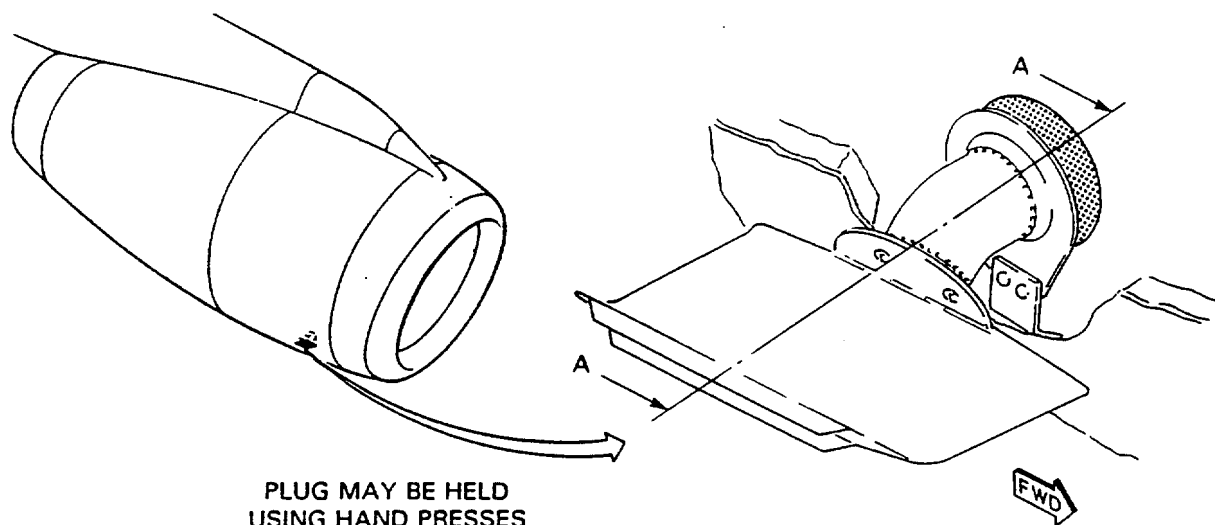
Printed in Great Britain



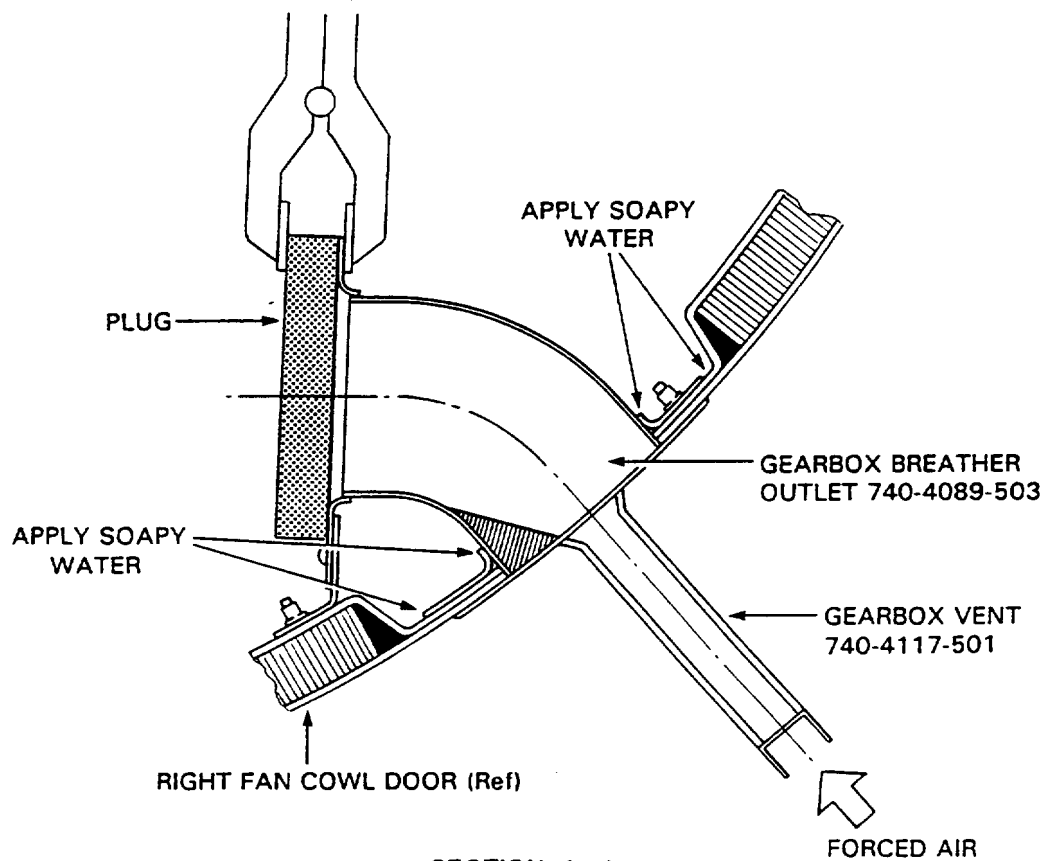
ded0000344

REPLACEMENT OF SEALANT
Fig.1

V2500-NAC-71-0133



PLUG MAY BE HELD
USING HAND PRESSES



SECTION A-A

LEAK TEST
Fig.2

V2500-NAC-71-0133



SERVICE BULLETIN

3. Material Information

NEW PN (ATA NO)	QTY	EST'D UNIT PRICE (\$)	KEYWORD	OLD PN (IPC NO)	INSTR/ DISPOS
--------------------	-----	--------------------------	---------	--------------------	------------------

Applicability: For each V2500 Nacelle to incorporate this Bulletin.

A. Kits associated with this Bulletin:

V2571133-551			Mod Kit		(A)
consisting of:					

H01-3	1		Kay-Lok Nut		
-------	---	--	-------------	--	--

AN960-C10L	1		Washer		
------------	---	--	--------	--	--

CR3523-5-2	2		Rivet		
------------	---	--	-------	--	--

B. Parts Affected by this Bulletin:

H01-3	1	Kay-Lok Nut)	HL97V-6	(B)(1D)
(71-13-16))	(01-634)	
)		
AN960-C10L	1	Washer)	---	
(71-13-16)				(01-640)	

C. Instruction/Disposition Code Statements:

- (A) Kit is available.
- (B) New part supplied as detail of the kit.
- (1D) Discard old part.

The following material is to be procured by the Operator or obtained from his stock for use in conjunction with Kit No V2571133-551.

Part Number	Keyword	Qty	Source	Vendor Code
PR1422B2	Sealant	A/N	Products Research and Chemical Co. 5454 San Fernando Rd PO Box 1800 Glendale, CA 91203	V83574
	Silicone Rubber Sheet or equivalent	A/N	Commercially Available	

V2500-NAC-71-0133



International Aero Engines

SERVICE BULLETIN

1,1,1

Trichloro-
ethylene

A/N

Commercially Available

Printed in Great Britain

V2500–NAC–71–0133

Sep.27/93

Page 10