

**International  
Aero Engines**

V2500 Propulsion System — Nacelle

# **SERVICE BULLETIN**

NACELLE - POWERPLANT - COWL, AIR INTAKE - ADAPTER RING ATTACHING RIVETS -  
INSPECTION/REPLACEMENT OF

## MODEL APPLICATION

V2527-A5

## BULLETIN INDEX LOCATOR

71-00-00

## COMPLIANCE CATEGORY CODE

4

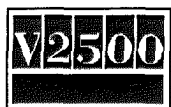
## INTERNAL REFERENCE No

96VN216

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1. Planning Information

A. Effectivity

(1) Aircraft:

(a) Airbus A320-232

(2) Nacelle:

(a) V2527-A5 Inlet Cowls Prior To Cum Unit No 349.

B. Reason

(1) Condition

Operators have found Cherry Buck rivets to be loose or missing from the Engine Intake Adapter Ring.

(2) Objective

The intent of this Service Bulletin is to inspect and identify the rivets. Where Cherry buck rivets are identified, they are to be replaced with Cherry E-Z buck rivets.

(3) Substantiation

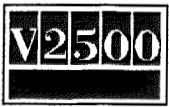
Trial installation of the Cherry E-Z buck rivets has been shown to be satisfactory

(4) 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

(5) Supplemental Information

None.



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C. Description

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

- (a) The Engine Adapter Ring is inspected for Cherry CSR922-6-7R rivets. These rivets are drilled out and new Cherry CSR902B6-10 E-Z rivets installed.

D. Approval

The technical content of this Service Bulletin has been approved under the authority of the DGAC Design Organisation Approval No F.JA.02.

E. Compliance

Category 4

Accomplish at the first visit of the Nacelle or Nacelle component to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action for the Nacelle or Nacelle component.

F. Manpower

Estimated man-hours to incorporate the intent of this Service Bulletin on each engine:

<u>VENUE</u>	<u>ESTIMATED MAN-HOURS</u>
(1) In Service	
(a) To gain access.....	0.25 M/Hr
(a) To embody.....	<u>3.0 M/Hr</u>
Total	3.25 M/Hr

NOTE: Manhours provided for planning purposes only

G. Material Cost and Availability

Modification kit not required.

H. Tooling - Cost and Availability

None required.



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## 2. Accomplishment Instructions

### A. Pre-requisite Instructions

- (1) Open the Fan Cowl Doors as instructed in the A320/V2500-A1,A320/A321/V2500-A5 Aircraft Maintenance Manual,Task 71-13-00-010-010.

### B. Rework Instructions

WARNING: SOLVENT IS FLAMMABLE AND THE VAPOUR IS HARMFUL. USE IN A WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPOURS OR PROLONGED OR REPEATED CONTACT WITH SKIN. HIGH CONCENTRATIONS MAY CAUSE IMPAIRED JUDGEMENT. PROTECTIVE GLOVES SHOULD BE WORN DURING USE. MAY CAUSE DERMATITIS BY REMOVING SKIN OILS. PRIOR TO USE OF THIS PRODUCT, READ THE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (2) Clean the Adapter ring on the Air Intake Cowl with a clean lint-free cloth(CoMat 02-099)made moist with solvent (COMAT 01-076) or (COMAT 01-457). Wipe the area dry before the solvent evaporates.
- (3) Examine the Adapter ring assembly for CSR922-6-7R rivets as shown. Refer to Figures 1 and 2. Proceed with Step 2.B.(4) if any CSR922-6-7R rivets are found, otherwise proceed to Paragraph 2.C.

WARNING: PUT ON PROTECTIVE GOGGLES WHEN YOU DRILL THE RIVETS. PIECES OF RIVET DEBRIS CAN CAUSE DAMAGE TO YOUR EYES.

- (4) Replace the CSR922-6-7R rivets with CSR902B6-10 rivets as follows:
  - (a) Carefully drill out the CSR922-6-7R rivets making sure you do not elongate the holes. Do not remove more than ten rivets at one time.
  - (b) Measure the rivet holes to ensure they are between 0,191 in.(4,85mm) and 0,195 in.(4,95mm) diameter.
  - (c) Install the CSR902B6-10 rivets in place of the CSR922-6-7R rivets. Refer to the IAE V2500 Standard Practices/Processes Manual(SPP-V2500-11A)Chapter/Section 70-39-03,Installation of rivets.
  - (d) Remove any unwanted material and metal particles from the Air Intake Cowl.
  - (e) Do steps 4(a) thru 4(d) until all the CSR922-6-7R rivets are replaced.

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**C. Post-requisite Instructions**

- (1) Close the Fan Cowl Doors as instructed in the A320/V2500-A1,A320/A321/V2500-A5 Aircraft Maintenance Manual,Task 71-13-00-410-010.

**D. Recording Instructions**

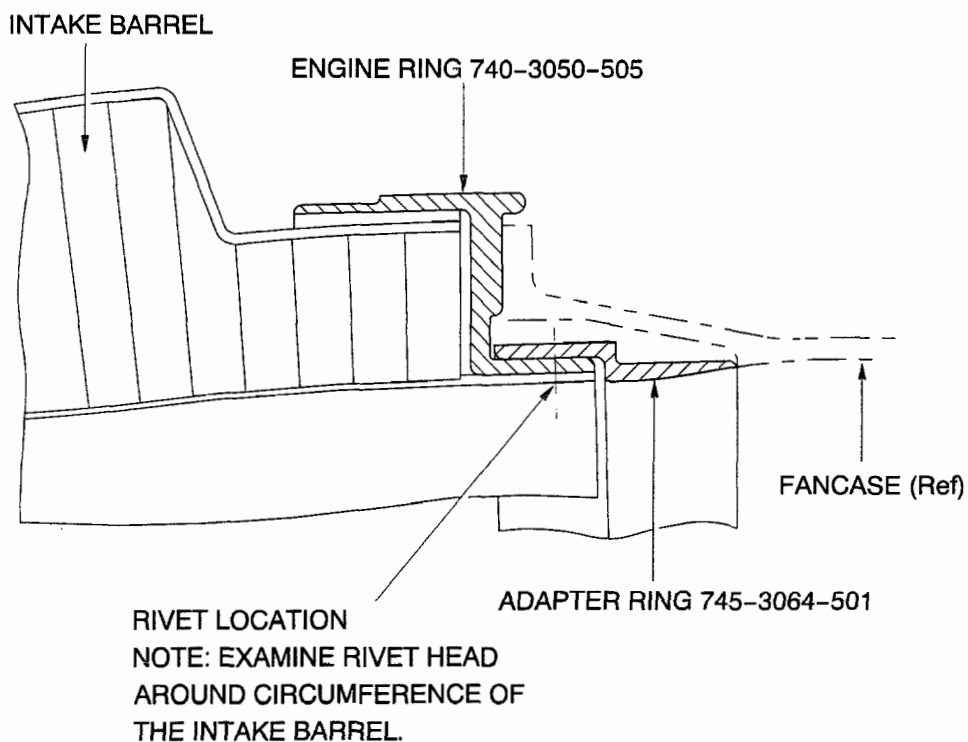
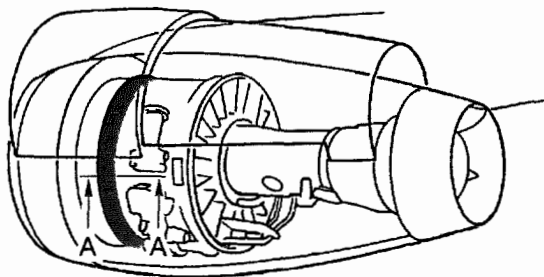
- (1) Write in the Aircraft Log Book and metal stamp,vibroetch or electroetch on the Inlet Cowl data plate that Service Bulletin V2500-NAC-71-0186 has been done. Refer to the IAE V2500 Standard Practices/Processes Manual,Chapter 70-09-00.

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RIVET LOCATION  
NOTE: EXAMINE RIVET HEAD  
AROUND CIRCUMFERENCE OF  
THE INTAKE BARREL.

## SECTION A-A

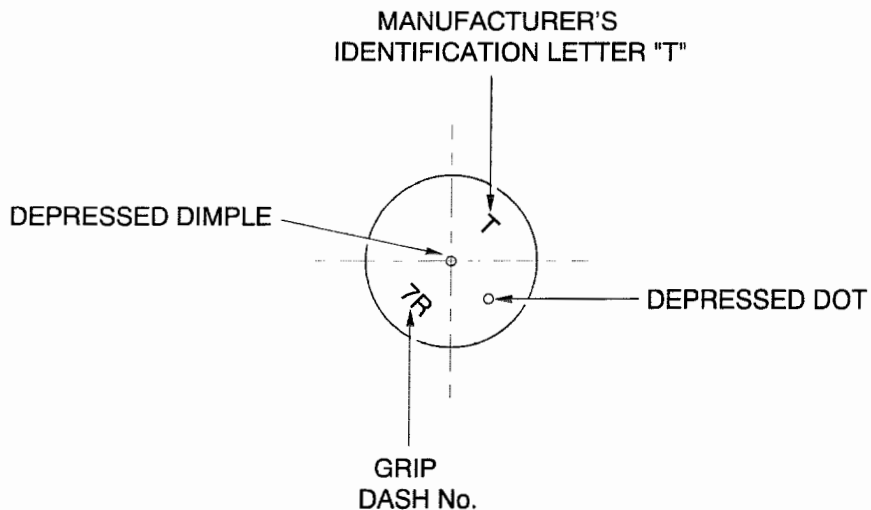
INSPECTION/REPLACEMENT OF AIR INTAKE COWL RIVETS  
FIGURE 1

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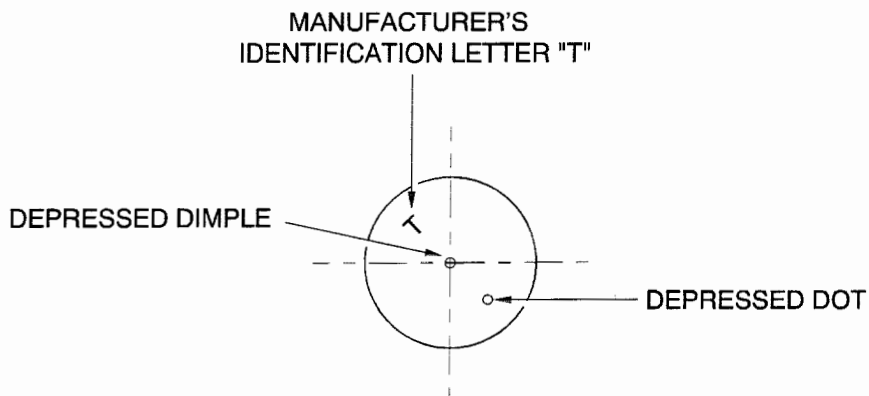
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MARKINGS FOR CHERRY BUCK RIVET CSR922-6-7R (CSK HEAD)



MARKINGS FOR CHERRY E-Z BUCK RIVET CSR902B6-10 (CSK HEAD)

RIVET IDENTIFICATION MARKINGS  
FIGURE 2

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## 3. Material information

Applicability: For each V2500-A5 Nacelle to incorporate this Bulletin.

### A. Kits associated with this Bulletin

None.

### B. Parts affected by this Bulletin:

None.

### C. Materials required to incorporate this Service Bulletin:

CoMat 01-076	Solvent
CoMat 01-457	Solvent
CoMat 02-099	Lint free cloth
CSR902B6-10	Rivet, Cherry E-Z buck

NOTE: To identify consumable materials, refer to the Overhaul Processes and Consumable Index (PCI-V2500-11A).

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