



IAE Propulsion System NON-MODIFICATION SERVICE BULLETIN

Date: June 9, 2000

Subject: Transmittal of Revision 2 to Service Bulletin Number V2500-NAC-71-0208

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Mar. 04/99
Revision 1	May 05/99
Revision 2	Jun. 09/00

Reasons for Issuance of Revision:

(1) To correct a typographical error in Figure 1 (Sheets 1 and 2).

Effect on Past Compliance:

(1) None

List of Effective Pages:

<u>Page No.</u>	<u>Rev No.</u>	<u>Date</u>
1	2	Jun. 09/00
2	1	May 05/99
3	Basic	Mar. 04/99
4 and 5	1	May 05/99
6 thru 9	Basic	Mar. 04/99
10 and 11	2	Jun. 09/00
12	Basic	Mar. 04/99
13 and 14	1	May 05/99

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Transmittal

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V2500 Propulsion System - Nacelle
SERVICE BULLETIN

NACELLE – POWERPLANT – SEAL, PYLON APRON, FORWARD UPPER AND LOWER –
REPLACEMENT OF

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

71-14-00

Compliance Category Code

8

Internal Reference No.

JG 96VN336/A

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1. Planning Information

A. Effectivity

- (1) Aircraft: MD90
- (2) Nacelle: V2500-D5 nacelle forward upper and lower pylon apron part
numbers 290-1001-541, 290-1001-542, 290-1001-543, and 290-1001-544, serial
numbers 0011001 thru 0192001.

B. Reason

(1) Condition

R The forward upper pylon apron seals can become damaged in service. This allows air into the
R fan cowls and causes a fan zone ambient pressure fault message.

(2) Background

Operators have experienced damaged upper pylon seals and fan zone ambient pressure fault messages.

(3) Objective

Install forward upper and lower pylon apron seals of an improved design to eliminate possible damage to the seals and prevent fan zone ambient pressure fault messages.

(4) Substantiation

Not applicable.



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(5) Effect of Bulletin on Workshop Procedures:

Removal/Installation	Affected
Disassembly/Assembly	Affected
Cleaning	Not Affected
Inspection/Check	Affected
Repair	Affected
Testing	Not Affected

(6) Supplemental Information

None.

C. Description

The forward upper and lower pylon aprons are removed from the aircraft. The pylon interface seals are removed from the aprons and new seals are installed. The pylon aprons are re-installed with the new instructions for position and overlap of the seals.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Boeing Service Bulletin MD90-71-006 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

Category 8

Accomplished based upon experience with the prior configuration.



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F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin for each nacelle:

<u>VENUE</u>		<u>ESTIMATED MANHOURS</u>
(1)	In Service	
(a)	To gain access	0.25 M/Hrs.
(b)	To modify	1.0 M/Hrs.
(c)	To return to service	<u>0.25 M/Hrs.</u>
Total		1.50 M/Hrs.

R NOTE: Manhours are provided for planning purposes only.



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G. Material Cost and Availability

Operators should obtain one V2571208-555 kit for each left hand nacelle and one V2571208-557 kit for each right hand nacelle from Rohr, Inc. before incorporation of this service bulletin.

R Operators should send a charge purchase order for the applicable quantity of kits for units shown in
R paragraph 1.A. Upon receipt of the purchase order, Rohr will provide a delivery schedule. Operators
R will have one year from service bulletin initial issuance date to place an order for the kits. After one
R year, operators will be required to purchase parts individually at current catalog price if the desire to
R incorporate this change.

Transmit Purchase Order to:

Rohr, Inc.
850 Lagoon Drive
Chula Vista, CA 91910-2098
U.S.A.
Attn: Airline Account Manager – MZ-107A
(Ref. Service Bulletin V2500-NAC-71-0208)

R **NOTE:** Please do not send orders for kits via Spec 2000 ordering system.

H. Tooling - Cost and Availability

Not applicable.



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I. Weight and Balance

- | | | |
|-----|---------------|---|
| (1) | Weight change | No effect |
| (2) | Moment arm | No effect |
| (3) | Datum | Engine Front Mount Centreline
(Powerplant Station PPS 100.0) |

J. Electrical Load Data

Not affected.

K. References

<u>Manual</u>	<u>Chapter/Section</u>
MD-90 Aircraft Maintenance Manual	71-14-00
IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)	70-09-00
Overhaul Processes and Consumable Index (PCI-V2500-1IA)	

L. Other Publications Affected

MD-90 Engine Illustrated Parts Catalog (S-V2500-3IA)	71-14-01 71-14-02
MD-90 /V2500-D5 Engine Manual (E-V2500-3IA)	71-14-01 71-14-02



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2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) Remove the upper and lower forward pylon aprons. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 71-14-01, page block 401.

B. Modify the Upper Forward Pylon Aprons.

- (1) Remove the collars and pins, the retainers and the seals from the 290-1001-541 and 290-1001-542 pylon aprons. Keep the retainers. Discard the seals and fasteners. Refer to Figure 1 (Details A and C).
- (2) Put the 290-1025-523 and 290-1025-524 seals into position and back drill the fastener holes in the seals. Refer to Figure 1 (Details A and C).

WARNING: THINNER (COMAT 01-116), CATALYST (COMAT 07-139), AND EPOXY PRIMER (COMAT 07-140) ARE CLASSIFIED AS HAZARDOUS MATERIALS AND MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH RECOMMENDATIONS.

- (3) Mix the thinner (CoMat 07-116), catalyst (CoMat 07-139), and epoxy primer (CoMat 07-140). Refer to the manufacturer's instructions.
- (4) Install the 290-1025-523 seal, 290-1028-581 retainer, and 290-1028-597 (or 290-1028-585) retainer on the 290-1001-541 pylon apron with 53 HL11V-5-6 pins and HL94V-5 collars. Wet install the fasteners with the primer mix. Refer to Figure 1 (Details A and C).



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- (5) Install the 290-1025-524 seal, 290-1028-584 retainer, and 290-1028-598 (or 290-1028-586) retainer on the 290-1001-542 pylon apron with 53 HL11V-5-6 pins and HL94V-5 collars. Wet install the fasteners with the primer mix. Refer to Figure 1 (Details A and C).

- (6) Re-identify the upper forward pylon aprons as follows:

290-1001-541 to 290-1001-549

290-1001-542 to 290-1001-550

Use a rubber stamp and ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

C. Modify the Lower Forward Pylon Aprons

- (1) Remove the collars and pins, the retainers and the seals from the 290-1001-543 and 290-1001-544 pylon aprons. Keep the retainers. Discard the seals and fasteners. Refer to Figure 1 (Details B and D).
- (2) Put the 290-1025-525 and 290-1025-526 seals into position and back drill the fastener holes in the seals. Refer to Figure 1 (Details B and D).
- (3) Install the 290-1025-525 seal, 290-1028-599 retainer, and 290-1028-583 (or 290-1028-587) retainer on the 290-1001-543 pylon apron with 54 HL11V-5-6 pins and HL94V-5 collars. Wet install the fasteners with the primer mix. Refer to Figure 1 (Details B and D).
- (4) Install the 290-1025-526 seal, 290-1028-582 retainer, and 290-1028-600 (or 290-1028-588) retainer on the 290-1001-544 pylon apron with 54 HL11V-5-6 pins and HL94V-5 collars. Wet install the fasteners with the primer mix. Refer to Figure 1 (Details B and D).



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- (5) Re-identify the upper forward pylon aprons as follows:

290-1001-543 to 290-1001-551

290-1001-544 to 290-1001-552

Use a rubber stamp and ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

D. Post-requisite Instructions

CAUTION: MAKE SURE THE SEALS ARE SPREAD AGAINST THE PYLON. MAKE SURE THE LOWER SEAL IS OVER THE UPPER SEAL WHERE THE SEALS COME TOGETHER AT THE FORWARD END OF THE PYLON. IF YOU DO NOT DO THIS, THE SEALS CAN GET DAMAGED AND ALLOW TOO MUCH AIR INTO THE FAN COWLS.

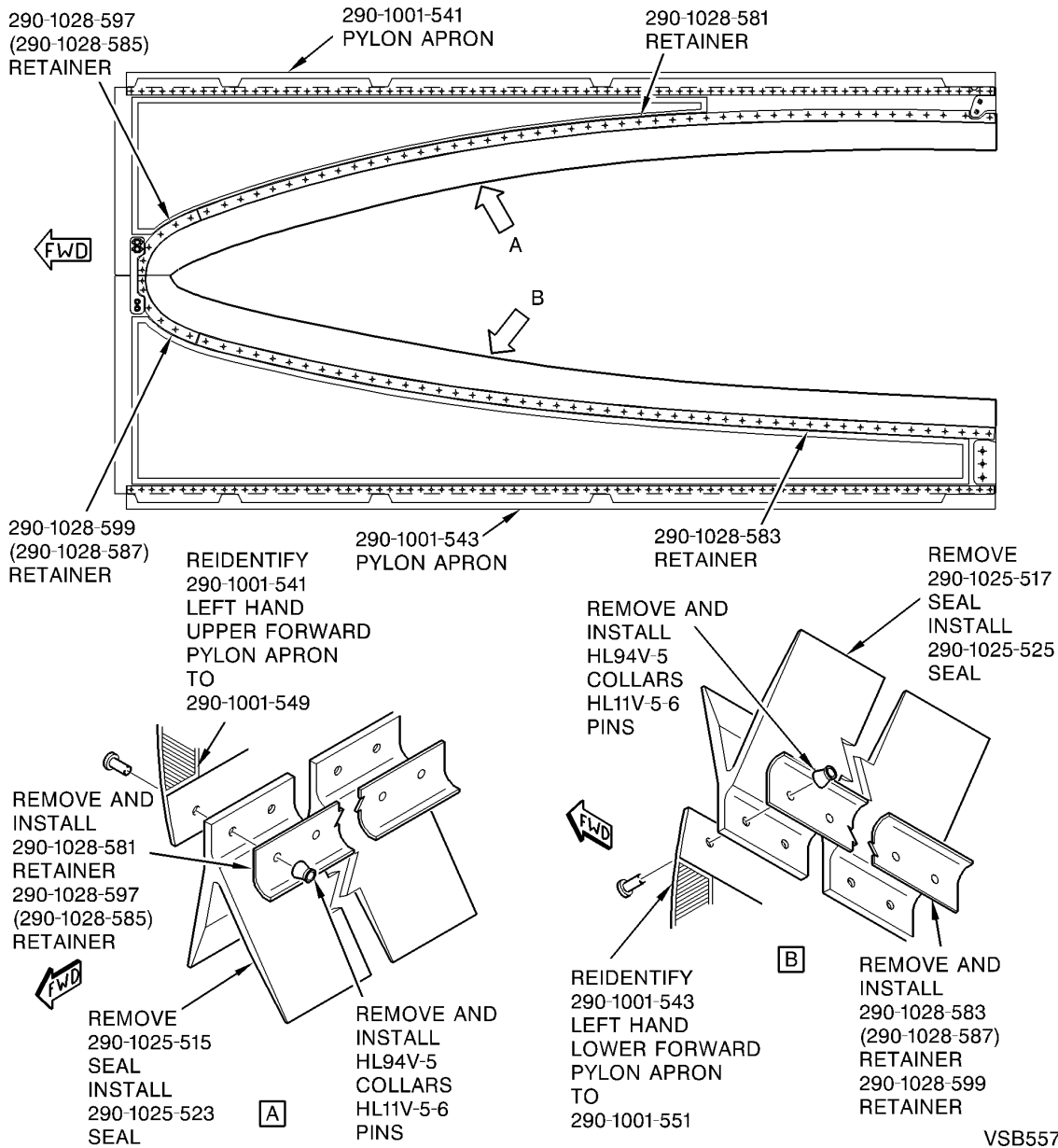
- (1) Install the upper and lower forward pylon aprons. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 71-14-01, page block 401. Make sure the seals are spread against the pylon. Make sure the seals of the lower pylon aprons are over the seals of the upper aprons where they come together at the forward end of the pylon. Refer to Figure 2.

E. Recording Instructions

A record of accomplishment is necessary. Mark on the forward upper and lower pylon aprons that Service Bulletin V2500-NAC-71-0208 has been done. Use a rubber stamp and ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.



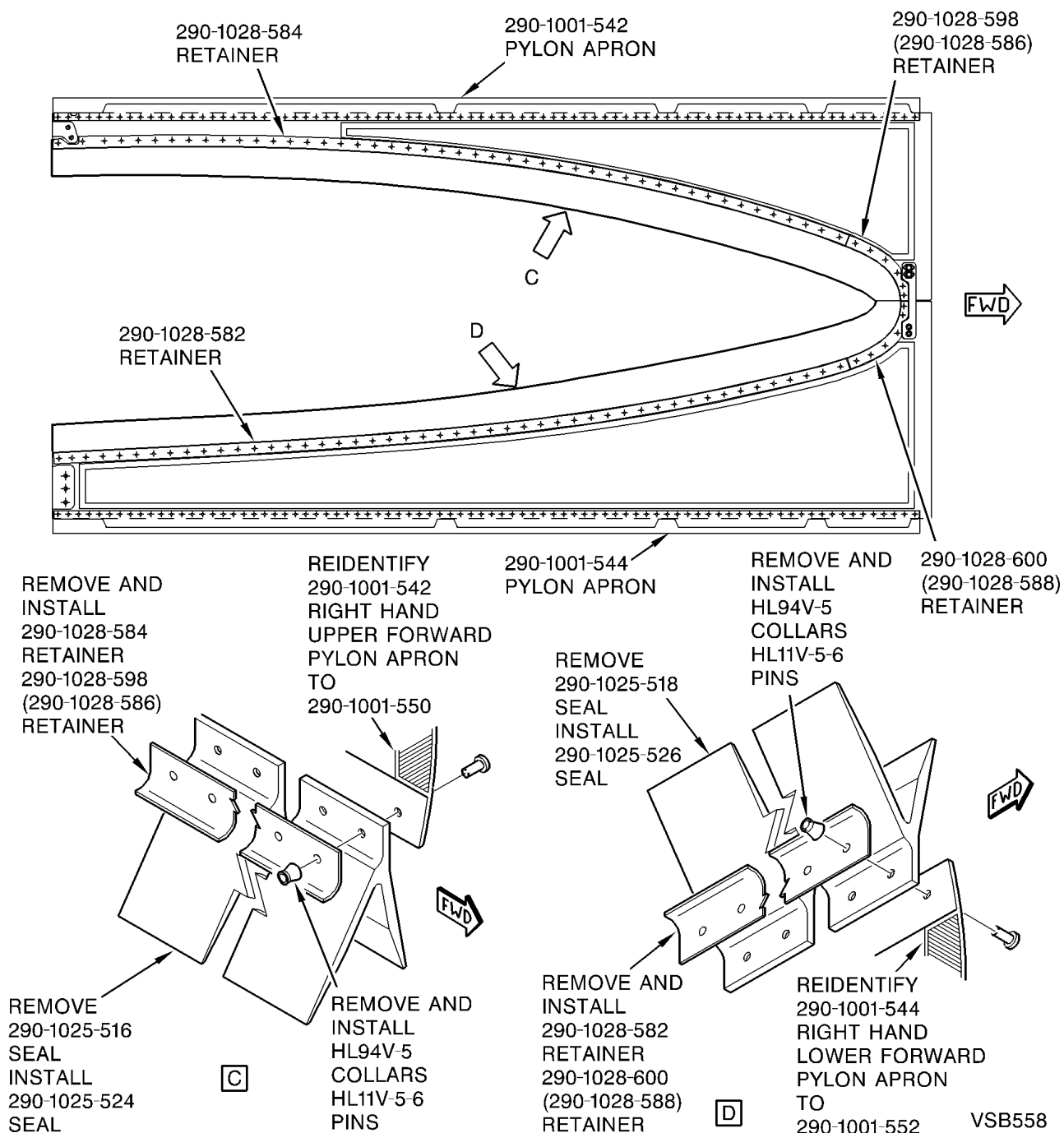
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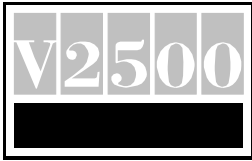
Modify the Left Forward Pylon Aprons
Figure 1 (Sheet 1)



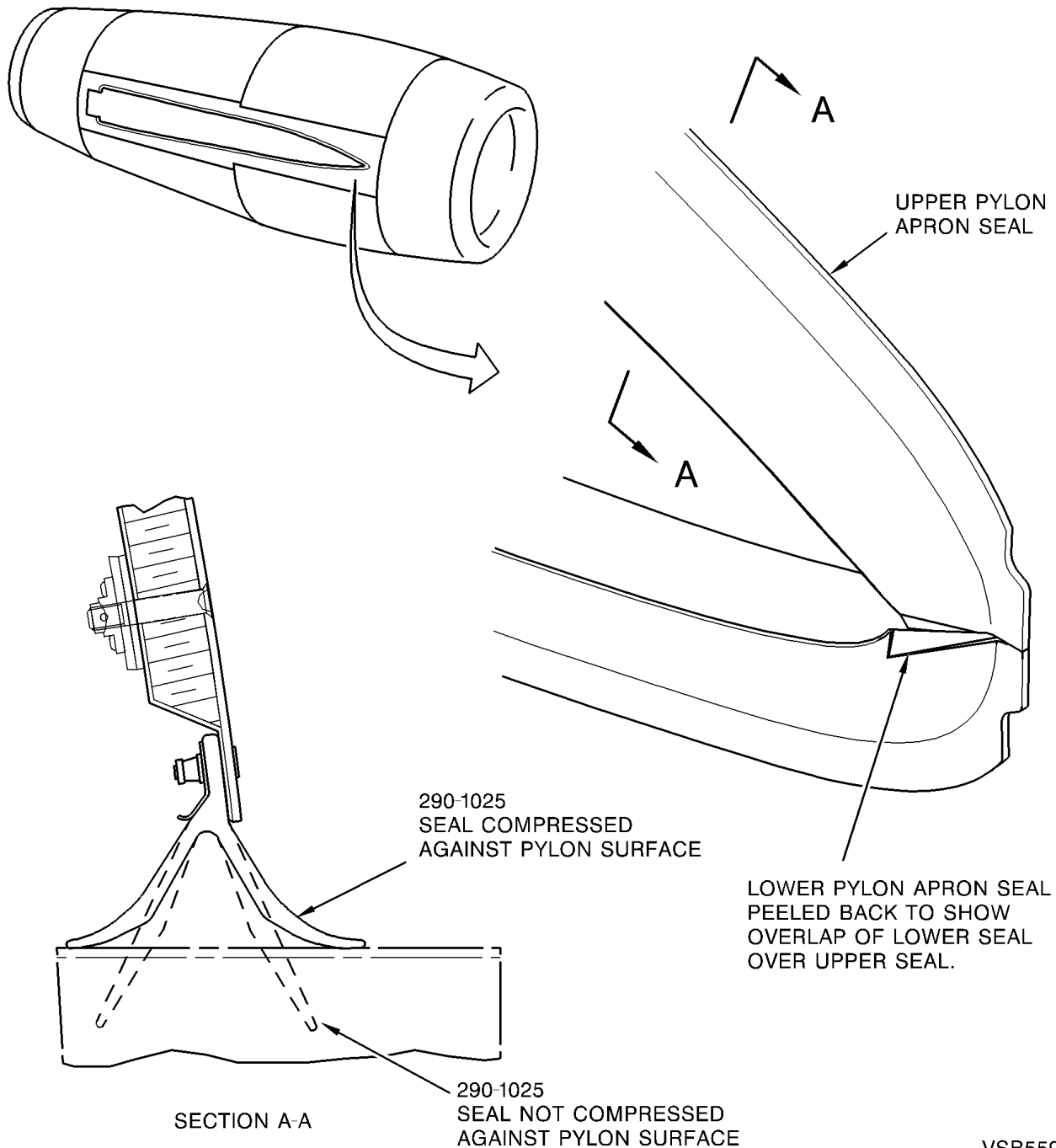
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Modify the Right Forward Pylon Aprons
Figure 1 (Sheet 2)



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VSB559

Install the Upper and Lower Forward Pylon Aprons
Figure 2

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3. Material Information

Applicability: For each MD-90 aircraft to incorporate this Bulletin.

A. Kits Associated with this Bulletin:

	<u>NEW PART NO.</u> <u>(ATA NO.)</u>	<u>QTY</u>	<u>EST'D UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
R	V2571208-555 Consisting of:	1	\$3821.00	Kit		(A)
	290-1025-523	1		Seal, Upper		
	290-1025-525	1		Seal, Lower		
	HL11V-5-6	107		Pin		
	HL94V-5	107		Collar		
R	V2571208-557 Consisting of:	1	\$3821.00	Kit		(A)
	290-1025-524	1		Seal, Upper		
	290-1025-526	1		Seal, Lower		
	HL11V-5-6	107		Pin		
	HL94V-5	107		Collar		

B. Parts affected by this Bulletin:

	<u>NEW PART NO.</u> <u>(ATA NO.)</u>	<u>QTY</u>	<u>EST'D UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
	290-1001-549 (71-14-01)	1		Apron, Fwd, Upper	290-1001-541 (01-010)	(B)(C)(1D) (S1)(S2)
	290-1001-551 (71-14-01)			Apron, Fwd Lower	290-1001-543 (01-030)	(B)(C)(1D) (S1)(S2)



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NEW PART NO. (ATA NO.)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
290-1001-550 (71-14-02)	1		Apron, Fwd, Upper	290-1001-542 (01-010)	(B)(C)(1D) (S1)(S2)
290-1001-552 (71-14-02)			Apron, Fwd Lower	290-1001-544 (01-030)	(B)(C)(1D) (S1)(S2)

C. Instruction/Disposition Code Statements

- (A) Kit will be available March 1, 1999.
- (B) Old part will no longer be available.
- (C) New part is currently available.
- (1D) Old part can be re-worked to new part configuration.
- (S1) New parts coded S1 must replace old parts as a complete set.
- (S2) New part may be used in place of old part but not vice versa.

R NOTE: The estimated 1999 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the Rohr Price Catalog or contact Rohr's Customer Support Department for information concerning firm prices.

D. Materials Required to Incorporate this Service Bulletin:

CoMat 06-073	Metal Marking Ink
CoMat 07-116	Thinner
CoMat 07-139	Catalyst
CoMat 07-140	Epoxy Primer

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