

SERVICE BULLETIN

NACELLE - EXHAUST - THRUST REVERSER CASCADE - IDENTITY OF - CATEGORY CODE 8 -
MOD.NAC-78-0027

1. Planning InformationA. Effectivity

(1) Aircraft: Airbus A320

(2) Nacelle: V2500-A1 Nacelles

- (a) The intent of this Service Bulletin was incorporated at the manufacturer on Thrust Reverser Cum Units 75 and on.

The following Thrust Reverser Cum Units were not changed at the manufacturer. They can be modified by incorporating this Service Bulletin using Kit V2578027-551.

T/R Cum Unit Number	Qty of Kits V2578027-551
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6 thru 74	69
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B. Reason

(1) Condition

Cascade position labels were inadvertantly omitted on original release.

(2) Background

Not applicable.

(3) Objective

To improve maintainability.

(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:

Install cascade position labels on thrust reverser cascade assemblies to help in removal and installation tasks.

D. Approval

The part number changes and/or part modifications described in Paragraphs 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA approved for the equipment model(s) listed.

E. Compliance

Category Code 8

Accomplish based upon experience with the prior configuration.

F. Manpower

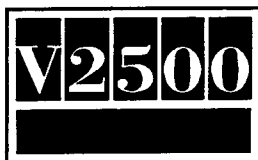
Estimated manhours to incorporate the full intent of this Bulletin:

VENUE	ESTIMATED MAN HOURS
(1) In Service	
(a) To gain access	0.2 M/HRS.
(b) To embody	5.6 M/HRS.
(c) To return nacelle to service	0.2 M/HRS.
TOTAL	6.0 M/HRS.

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the supplier as kit V2578027-551 at no cost to the operator.

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Operators with units listed in Paragraph 1.A should submit a no-charge purchase order for the applicable quantity of kits. The purchase order must specify this service bulletin number and only the parts listed herein. Operators will have one year from the issue date of the Service Bulletin to place an order. 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 the change.

Direct Purchase order to:

Rohr Inc.

P.O. Box 878

Chula Vista, CA 91912

U.S.A.

Attn: Manager, Sales Operations -Warranty, Bldg. 107A
(Ref. Service Bulletin No V2500-NAC-78-0027)

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.

88VN083

- (2) Other references

V2500 Aircraft Maintenance Manual 78-32-00
78-32-19

L. Other Publications Affected

V2500 Nacelle Illustrated Parts Catalog 78-32-19

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2. Accomplishment Instructions

A. Prerequisite Instructions

WARNING: ENSURE THRUST REVERSER HALVES ARE PROPERLY SUPPORTED BEFORE THE START OF THIS PROCEDURE. FAILURE TO DO SO COULD RESULT IN INJURY OR DEATH TO PERSONNEL.

- (1) Manually extend thrust reverser translating sleeve as specified in the A320 Aircraft Maintenance Manual, Task 78-32-00-860-010.

B. Rework or Modification Instructions

NOTE: The following procedure should be done one deflector box at a time to avoid confusion.

- (1) Remove and install deflector boxes (including blank boxes) one at a time from thrust reverser in accordance A320 Aircraft Maintenance Manual, Chapter 78-32-19.
- (2) Install position labels as follows:

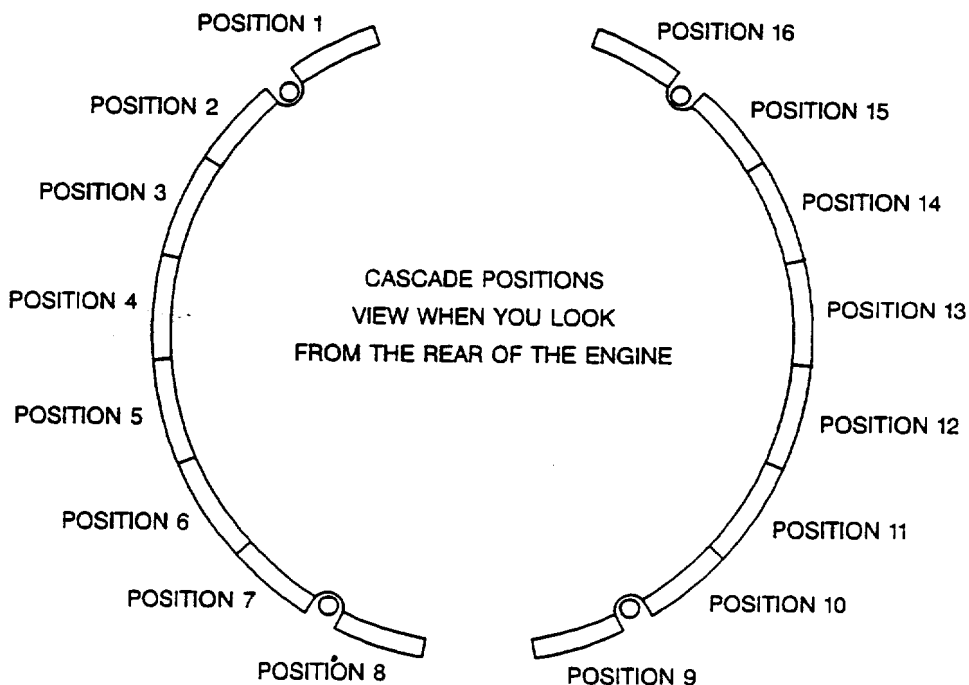
WARNING: METHYL ISOBUTYL KETONE (MIBK) IS FLAMMABLE AND VAPOR IS HARMFUL. USE IN A WELL-VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPOR OR PROLONGED OR REPEATED CONTACT WITH SKIN. MAY CAUSE IRRITATION OF EYES, NOSE, THROAT, AND SKIN. HIGH CONCENTRATIONS MAY CAUSE WEAKNESS, HEADACHE, NAUSEA, DIZZINESS, 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.

- (a) Clean the area of the deflector box or blank box with MIBK where label will be installed.
- (b) Install the appropriate position label on the box. (Refer to Figures 1 and 2.)



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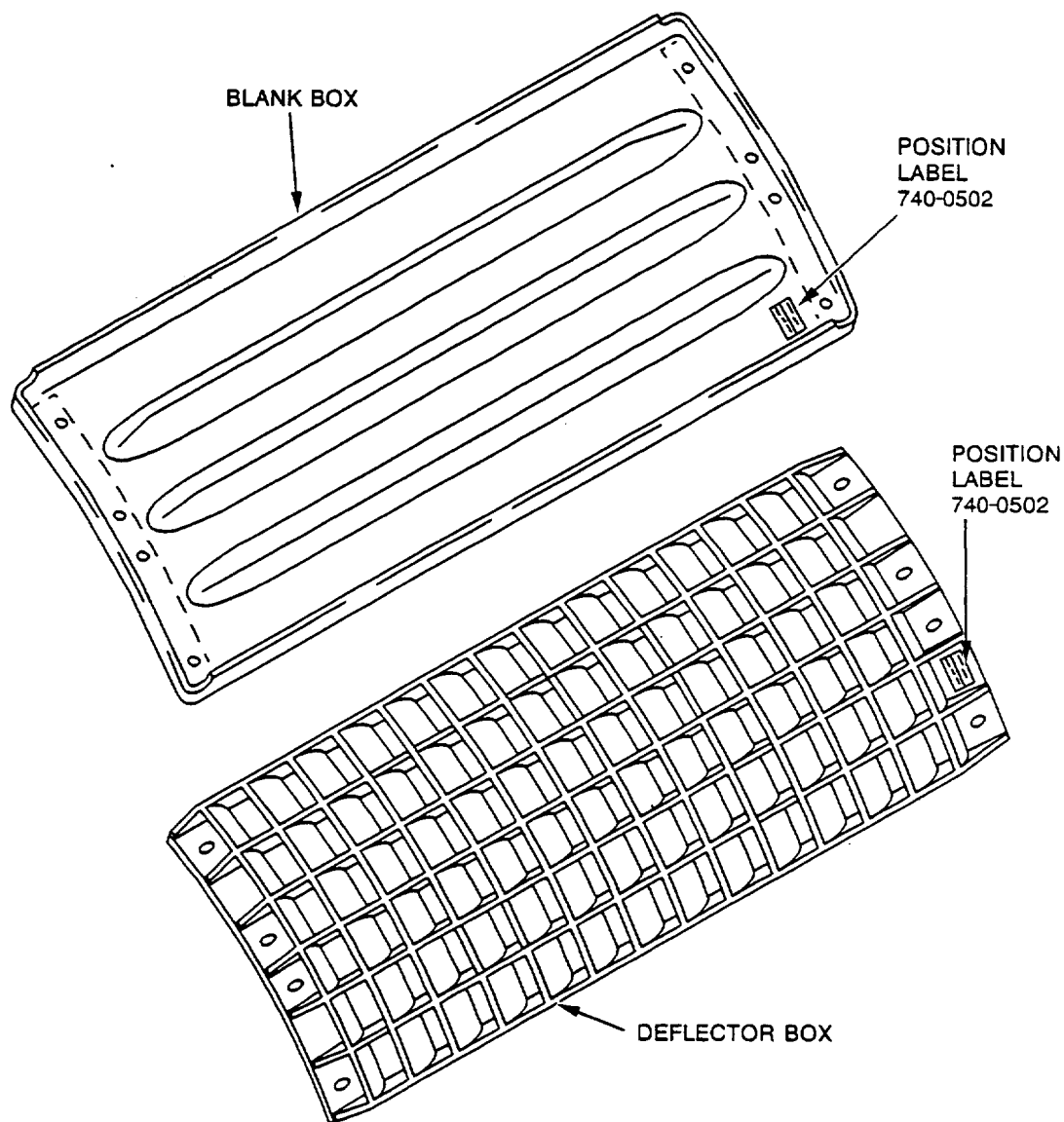


LABEL DASH NO.	POSITION LABEL LOCATION	
	LH NACELLE POSITION	RH NACELLE POSITION
-501	2, 6, 15	2, 11, 15
-503	1	1
-505	16	16
-507	3, 7	3
-509	14	10, 14
-511	4	4
-513	13	13
-515	10	6
-517	11	7
-519	8	—
-521	—	9
-523	5, 12	5, 12
-525	9	—
-527	—	8

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Deflector Box Label Location Left and Right Hand Nacelle
Fig.1

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Deflector Label Location
Fig.2

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- (c) Reidentify deflector boxes by use of rubber stamp (blank boxes are not reidentified). Use the part numbers specified in paragraph 3, Material information.

C. Post-requisite Instructions

- (1) Manually retract the translating sleeve as specified in the A320 Aircraft Maintenance Manual, Task 78-32-00-860-011.

D. Recording Instructions

- (1) Write on the thrust reverser mod record plate that this Service Bulletin has been incorporated.
- (2) A record of accomplishment is necessary.



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3. Material Information

NEW PART NO. (ATA NO)	QTY	EST'D UNIT PRICE (\$)	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
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Applicability: For each V2500 Nacelle to incorporate this Bulletin

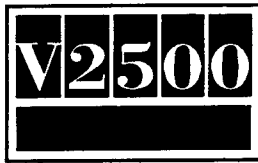
A. Kits associated with this Bulletin:

V2578027-551	1	Kit	(A)
Consisting of:			
740-0502-501	6	Label	
740-0502-503	2	Label	
740-0502-505	2	Label	
740-0502-507	3	Label	
740-0502-509	3	Label	
740-0502-511	2	Label	
740-0502-513	2	Label	
740-0502-515	2	Label	
740-0502-517	2	Label	
740-0502-519	1	Label	
740-0502-521	1	Label	
740-0502-523	4	Label	
740-0502-525	1	Label	
740-0502-527	1	Label	

B. Parts affected by this Bulletin:

740-0235-531	1	Cascade	740-0106-507	(1D)
(78-32-01)			(02-110)	
740-0235-538	1	Cascade	740-0235-524	(1D)
(78-32-01)			(02-120)	
740-0235-529	1	Cascade	740-0235-521	(1D)
(78-32-19)			(01-010)	
740-0235-527	2	Cascade	740-0105-507	(1D)
(78-32-19)			(01-070)	
740-0235-532	2	Cascade	740-0106-508	(1D)
(78-32-19)			(01-100)	
740-0235-534	1	Cascade	740-0107-508	(1D)
(78-32-19)			(01-130)	
740-0235-537	1	Cascade	740-0235-523	(1D)
(78-32-19)			(01-280)	
740-0235-529	1	Cascade	740-0235-521	(1D)
(78-32-19)			(02-010)	
740-0235-527	1	Cascade	740-0105-507	(1D)
(78-32-19)			(02-070)	
740-0235-532	1	Cascade	740-0106-508	(1D)
(78-32-19)			(02-100)	

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740-0235-534 (78-32-19)	1	Cascade	740-0107-508 (02-130)	(1D)
740-0235-535 (78-32-19)	1	Cascade	740-0184-507 (02-280)	(1D)
740-0235-536 (78-32-19)	1	Cascade	740-0184-508 (02-310)	(1D)
740-0235-530 (78-32-19)	1	Cascade	740-0235-522 (03-010)	(1D)
740-0235-527 (78-32-19)	1	Cascade	740-0105-507 (03-070)	(1D)
740-0235-531 (78-32-19)	1	Cascade	740-0106-507 (03-100)	(1D)
740-0235-533 (78-32-19)	1	Cascade	740-0107-507 (03-130)	(1D)
740-0235-535 (78-32-19)	1	Cascade	740-0184-507 (03-160)	(1D)
740-0235-536 (78-32-19)	1	Cascade	740-0184-508 (03-190)	(1D)
740-0235-530 (78-32-19)	1	Cascade	740-0235-522 (04-010)	(1D)
740-0235-527 (78-32-19)	2	Cascade	740-0105-507 (04-070)	(1D)
740-0235-531 (78-32-19)	2	Cascade	740-0106-507 (04-100)	(1D)
740-0235-533 (78-32-19)	1	Cascade	740-0107-507 (04-130)	(1D)
740-0235-538 (78-32-19)	1	Cascade	740-0235-524 (04-280)	(1D)

C. Instructions/Disposition Code Statements

- (A) Kit is available
- (B) New part supplied as detail of Kit
- (1D) Old part can be reworked and reidentified.

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