

International  
Aero Engines

V2500 Propulsion System — Nacelle

# SERVICE BULLETIN

Date: July 24, 1997

Subject: Transmittal of Revision 1 to Service Bulletin Number V2500-NAC-78-0103

## Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	May. 08/97
Revision 1	Jul. 24/97

## Reasons for Issuance of Revision

- (1) To add a note stating this Service Bulletin is issued for parts progression purposes only and has been superseded by the content of Service Bulletin V2500-NAC-78-0114.

## Effect on Past Compliance

- (1) None.

## List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1 thru 3	1	Jul. 24/97
4 thru 8	Basic	May. 08/97

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Transmittal  
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# **SERVICE BULLETIN**

**NACELLE — EXHAUST — BOLT, PRESSURE RELIEF DOOR LANYARD —  
REPLACEMENT OF**

**MODEL APPLICATION**

**V2500-D5**

**BULLETIN INDEX LOCATOR**

**78-32-00**

**Compliance Category Code**

**6**

**Internal Reference No.**

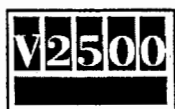
**LL/AC 95VN926**

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## 1. Planning Information

**NOTE:** This Service Bulletin is issued for parts progression history purposes only. The change introduced by this Service Bulletin has been superseded by the change introduced by Service Bulletin V2500-NAC-78-0114.

### A. Effectivity

- (1) Aircraft: MD90
- (2) Nacelle: V2500-D5 thrust reverser serial numbers 0021001 through 0044001.

### B. Reason

#### (1) Condition

Due to possible clamp up condition of lanyard, it may be difficult to fully open pressure relief door.

#### (2) Background

Insufficient grip length of bolt.

#### (3) Objective

Eliminate possible undesirable clamp up of pressure relief door lanyards.

#### (4) Substantiation

Trial fitment of new bolt and laminated washer has proven successful.

#### (5) Impact of Bulletin on Workshop Procedures:

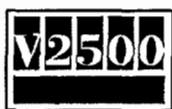
Removal/Installation	Not Affected
Disassembly/Assembly	Not Affected
Cleaning	Not Affected
Inspection/Repair	Not Affected

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Repair  
Testing

Not Affected  
Not Affected

## (6) Supplemental Information

None.

## C. Description

The change introduced by this Bulletin is to replace the existing bolt with a longer grip standard bolt and add a laminated washer.

## D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD-90-78-020 which has received exclusive FAA approval for MD-90 Series aircraft.

## E. Compliance

Category 6

Accomplish when the nacelle subassembly (i.e., accessories, componenets) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

## F. Manpower

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

### VENUE

### ESTIMATED MANHOURS

(1) In Service

Not Applicable

(2) At overhaul

(a) To rework

0.5 M/Hrs.

0.5 M/Hrs.

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**NOTE:** After incorporation of this modification, a maximum of 1.0 manhours for labor will be reimbursed by Rohr, as a labor credit allowance per affected aircraft to obtain a labor credit allowance after procurement of noted material. Labor claims should reference this service bulletin number and aircraft fuselage number and be submitted to:

Rohr, Inc.  
850 Lagoon Drive  
Chula Vista, CA. 91910-2098  
U.S.A.  
Attn: Airline Support Manager, MZ 107A  
Warranty Department  
(Ref. Service Bulletin V2500-NAC-78-0103)

## **G. Material Cost and Availability**

Modification kit not required. Parts are supplied as single line items (Refer to Section 3, Material Information).

Operators with units listed in Paragraph 1.A. should submit a no-charge purchase order for the applicable quantity of parts. The purchase order must reference this service bulletin number with applicable Operator serial numbers and list only the parts shown. Operators will have one year from issue date of the Service Bulletin to place an order. After one year, Operators will have to order parts at catalog price if they desire to incorporate the change.

Direct Purchase Order to:  
Rohr Inc.  
850 Lagoon Drive  
Chula Vista, CA. 91910-2098  
U.S.A.  
Attn: Airline Support Manager, MZ 107A  
(Ref. Service Bulletin V2500-NAC-78-0103)

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## H. Tooling Cost and Availability

Not applicable.

## I. Weight and Balance

- (1) Weight change ..... No effect
- (2) Moment arm ..... No effect
- (3) Datum ..... Front Engine Mount Centerline  
..... (Power Plant Station (PPS) 95.1)

## J. Electrical Load Data

Not affected.

## K. References

### Chapter/Section

IAE V2500 Standard Practices/Processes      70-09-00  
Manual (SPP-V2500-1IA)

## L. Other Publications Affected

V2500/MD90 Engine Illustrated      78-32-09  
Parts Catalog (S-V2500-3IA)

V2500/MD90 Thrust Reverser Component      78-32-09  
Maintenance Manual (CMM-TR-V2500-3IA)

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## **2. Accomplishment Instructions**

### **A. Pre-requisite Instructions**

None.

### **B. Rework or Modification Instructions**

- (1) Remove four NAS1291C4M nuts and four 290-0889-501 bolts from four lanyards and two terminal fork ends on pressure relief door. Refer to Figure 1. Discard bolts. Keep nuts.
- (2) Install four NAS6304U10 bolts and four NAS1291C4M nuts on four lanyards and two terminal fork ends on thrust reverser pressure relief door. Torque nut to 10-20 lbf-in (1.1-2.4 Nm).
- (3) Measure gaps between nuts and lanyards. Gap should be 0.005-0.015 in (0.13-0.38 mm).
- (4) If any gaps are greater than 0.015 inch (0.38 mm), remove applicable NAS1291C4M nut. Install necessary thickness of S700W0029-6 laminated washer on NAS6304U10 bolt to obtain proper gap. Install NAS1291C4M nut and tighten to a torque of 10-20 lbf-in (1.1-2.4 Nm).

### **C. Post-requisite Instructions**

None.

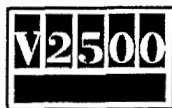
### **D. Recording Instructions**

A record of accomplishment is necessary. Write in applicable records and metal stamp, vibroetch, or electroetch on thrust reverser data plate that Service Bulletin V2500-NAC-78-0103 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

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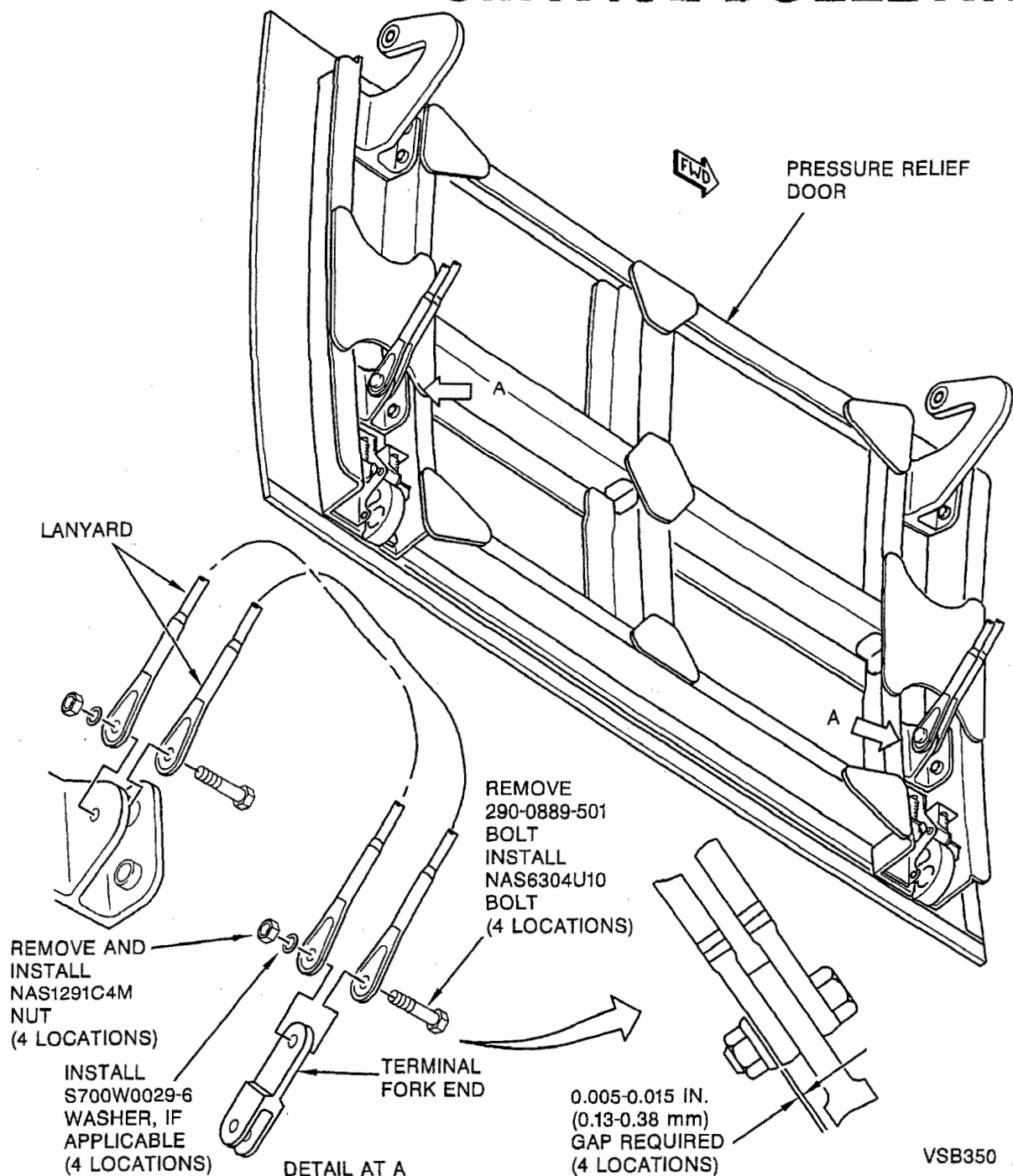
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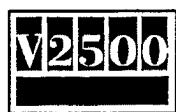
PRESSURE RELIEF DOOR LANYARD BOLT REPLACEMENT  
FIGURE 1

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## 3. Material Information

Applicability: For each V2500-D5 thrust reverser to incorporate this Bulletin.

### A. Kits Associated with this Bulletin:

None.

### 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>
NAS6304U10 (78-32-09)	4		Bolt	290-0889-501 (01-065)	(A)(1D) (S1)
S700W0029-6 (78-32-09)	4		Washer	- - - (01-063)	(A)(S1)

### C. Instruction/Disposition Code Statements

(A) New part is currently available.

(1D) Discard old part.

(S1) New parts coded (S1) are interchangeable in complete sets.

NOTE: The estimated 1997 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 Bulletin:

None.

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