

International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: Sep. 26/96

Subject: Transmittal of Revision 1 to Service Bulletin Number
V2500-NAC-78-0104

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jul. 15/95
Revision 1	Sep. 26/96

Reasons for Issuance of Revision

(1) To change the repair reference and make the nomenclature consistent with engineering.

Effect on Past Compliance

None

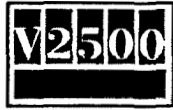
List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1 thru 5	1	Sep. 26/96

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Transmittal

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NACELLE - EXHAUST - TAIL CONE -INTRODUCTION OF PERIODIC
INSPECTIONS FOR CRACKING

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-11-00

Compliance Category Code

3

Internal Reference No.

BC/LL 94VN006B

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NACELLE - ENGINE TAIL CONE -INTRODUCTION OF PERIODIC INSPECTIONS FOR CRACKING

1. Planning Information

A. Effectivity

(1) Aircraft: MD90

(2) Nacelle: V2500-D5 tail cones prior to serial number
0141001 and serial numbers 0143002, 0147002.

B. Reason

Cracking of the outer skin on the acoustically treated tail cone may have occurred on D5 nacelles.

This anomaly has been attributed to a manufacturing procedure and improvements to the manufacturing process have been incorporated.

C. Compliance

Category Code 3.

An inspection of all D5 tail cones is recommended at next "A" check after receipt of this service bulletin.

Thereafter, regular inspections should be accomplished in accordance with the intervals noted in this Service Bulletin.

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D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD90 78-004 which has received exclusive FAA approval for MD-90 Series aircraft.

E. References

- (1) IAE V2500 AOW No. 1031, dated 2/17/94.
- (2) MD90/V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA

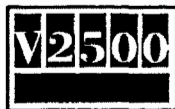
F. Action

- (1) Visually inspect 290-1501-501 tail cone for cracks in zones 1, 2, and 3. Refer to Figure 1.
- (2) If no cracks are found, tail cone is acceptable for further service.
- (3) If cracks are found, use the following criteria for disposition:

<ol style="list-style-type: none">(a) Zone 1 - any length axially or less than 1.00 in. (25,4 mm) long circumferentially	<p>Acceptable. Re-inspect at next A-check and repair at next C-check per VRS2414. Refer to MD90/V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA</p>
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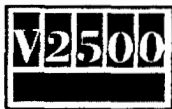
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- (b) Zone 1 - Circumferential cracks more than 1.00 in. (25,4 mm)
- Repair tail cone per VRS2414. Refer to MD90 / V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA.
- (c) Zone 2 -less than 0.50 in. (12,7 mm) from forward flange or more than 1.00 in. (25,4 mm) circumferentially
- Repair per VRS2414. Refer to MD90/V2500D5 Exhaust Cone Component Maintenance Manual CMM-EC-V2500-3IA.
- (d) All other cracks in Zone 2.
- Acceptable. Re-inspect at next "A" check and repair at next "C" check per VRS2414. Refer to MD90 / V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA.
- (e) Zone 3 -if crack reaches the end cap.
- Repair per VRS2414. Refer to MD90/V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA.
- (f) All other cracks in zone 3.
- Acceptable. Re-inspect at next "A" check and repair at next "C" check per VRS2414. Refer to MD90 /V2500D5 Exhaust Cone Component Maintenance Manual, CMM-EC-V2500-3IA.

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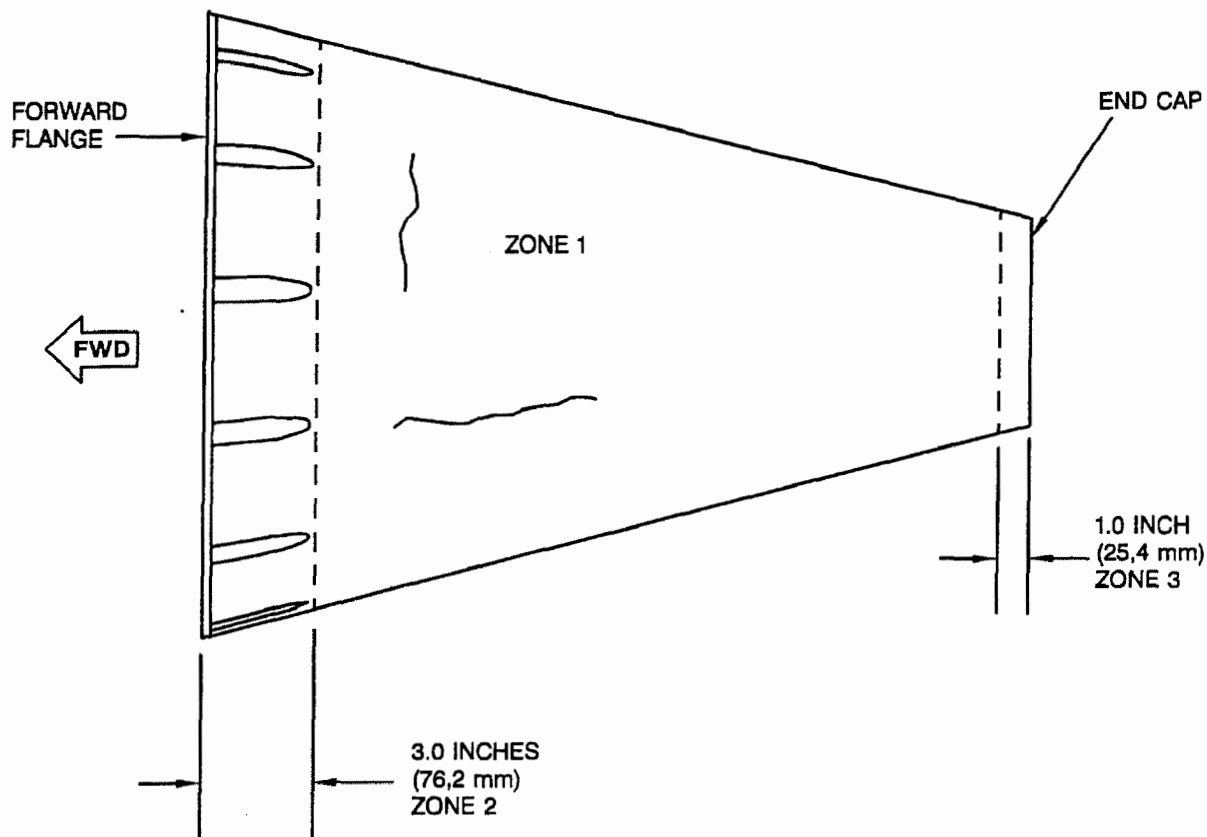
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ZONE 1 - BASIC BOND PANEL

ZONE 2 - WITHIN 3.0 INCHES (76,2 mm) OF FWD FLANGE

ZONE 3 - WITHIN 1.0 INCH (25,4 mm) OF THE END CAP

VSB284A

Tail Cone Inspection Criteria
Figure 1

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