



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: April 27, 1998

Subject: Transmittal of Revision 4 to Service Bulletin Number V2500-NAC-78-0109

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Dec. 13/95
Revision 1	Jan. 18/96
Revision 2	Aug. 22/96
Revision 3	Mar. 20/98
Revision 4	Apr. 27/98

Reasons for Issuance of Revision

(1) To clarify the re-work instructions and add illustration on page 18.

Effect on Past Compliance

(1) None.

List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1 thru 27	4	Apr. 27/98

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Transmittal
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**NACELLE - EXHAUST - CASCADES, THRUST REVERSER - MODIFICATION AND
REPLACEMENT OF**

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-00-00

Compliance Category Code

4

Internal Reference No.

LL/AC 94VN417/A/B/C/D

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1. Planning Information

A. Effectivity

- (1) Airplane: MD-90
- (2) Nacelle: V2500-D5 thrust reversers with serial numbers 0004001 through 0007001, 0009001, 0010001, and 0021001 through 0092001.

B. Reason

(1) Condition

Operators will experience reduced tail structure fatigue life as a result of tail rocking.

(2) Background

Current stress levels will not allow the tail structure to attain design fatigue life predictions due to the discharge pattern of the thrust reverser cascades.

(3) Objective

Reduce tail structure stress levels to maintain fatigue life predictions.

(4) Substantiation

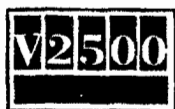
New cascades and rearrangement of the existing cascades on a test unit was successful in reducing tail structure stress.

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(5) Impact of Bulletin on Workshop Procedures:

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

(6) Supplemental Information

None.

C. Description

The discharge pattern of the thrust reverser cascades will be modified by removing two cascades, adding two new cascades, and rearranging/relabeling the existing cascades.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD90 78-008 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

Category 4

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

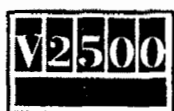
NOTE: This Service Bulletin must be accomplished on both nacelles of an aircraft at the same time to achieve maximum reduction of tail stresses.

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F. Manpower

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

VENUE

ESTIMATED MANHOURS

(1) In Service

(a) To gain access	00.5 M/Hrs.
(b) To rework	15.0 M/Hrs.
(c) To return to service	<u>00.5 M/Hrs.</u>
Total	16.0 M/Hrs. (total span time 8 Hrs x 2 men)

NOTE: After incorporation of this modification, a maximum of 16.0 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.
P.O. Box 878
Chula Vista, CA. 91912
U.S.A.

Attn: Airline Support Manager, Bldg. 107A
Warranty Department
(Service Bulletin V2500-NAC-78-0109)

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the manufacturer as kits V2578109-551 and V2578109-553 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 reference this service bulletin number with applicable Operator serial numbers and list only the parts shown in reference kit. 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: Airline Support Manager, Bldg. 107A
(Service Bulletin V2500-NAC-78-0109)

H. Tooling Cost and Availability

Not applicable.

I. Weight and Balance

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

J. Electrical Load Data

Not affected.

K. References

Chapter/Section

MD-90 Aircraft Maintenance Manual

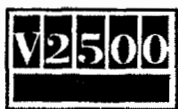
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IAE V2500 Standard Practices Manual
SPP-V2500-1IA

70-09-00

L. Other Publications Affected

MD-90 Engine Illustrated Parts
Catalog S-V2500-3IA

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NOTE: This Service Bulletin should be accomplished concurrently with or after accomplishment of Service Bulletin V2500-NAC-78-0107. This Service Bulletin must be accomplished on both nacelles of an aircraft at the same time to achieve maximum tail stress reduction.

2. Accomplishment Instructions

A. Prerequisite Instructions

- (1) Manually deploy the left and right thrust reversers. Refer to the Aircraft Maintenance Manual, Chapter 78-32-00, page block 201.

B. Rework or Modification Instructions

- (1) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-517 cascade from left hand thrust reverser position 2. Scrap cascade. Retain bolts and washers for installation. Refer to Figure 1.
- (2) Remove and modify 290-0024-503 cascade from left hand thrust reverser position 3.
 - (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-503 cascade from left hand thrust reverser position 3. Retain bolts and washers for installation.

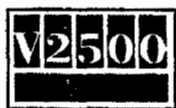
CAUTION: USE CAUTION WHEN REMOVING THE LABELS FROM THE CASCADES. DAMAGE TO THE UNDERLYING CASCADE CARBON FIBERS CAN OCCUR.

- (b) Remove label from 290-0024-503 cascade.
 - (c) Install 290-0030-523 label onto 290-0024-503 cascade.
 - (d) Identify newly labeled cascade as 290-0024-523 cascade with ink stamp and white ink (CoMat 06-073).
- (3) Remove and modify 290-0024-501 cascades from left hand

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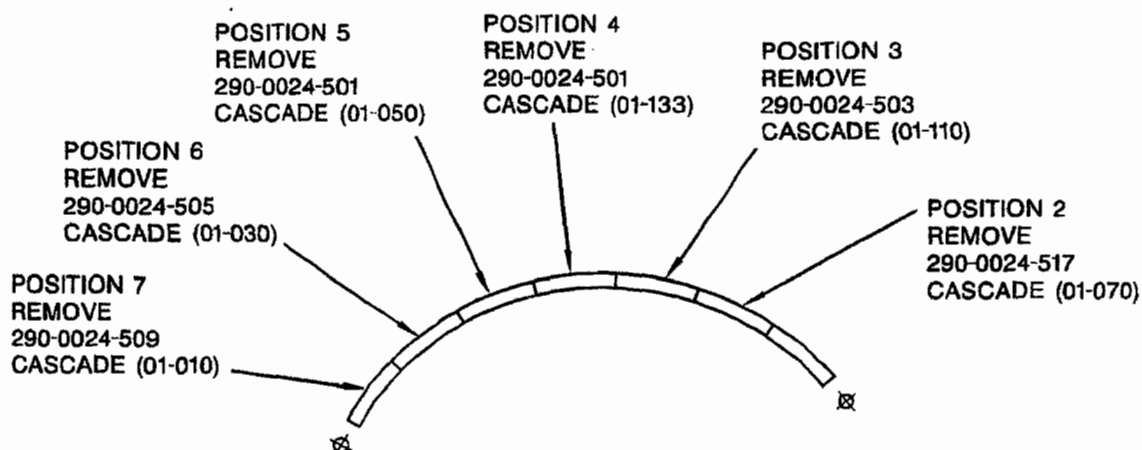
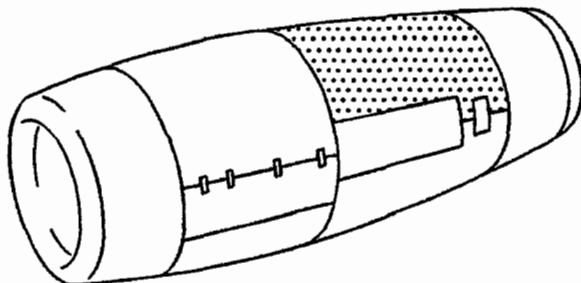
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OUTBRD VIEW LOOKING FROM REAR OF ENGINE INBRD
LEFT ENGINE

ALL EIPC NUMBERS
ARE 78-32-15 UNLESS
IDENTIFIED DIFFERENTLY

VSB389

**LEFT HAND UPPER THRUST REVERSER HALF CASCADE REMOVAL
FIGURE 1**

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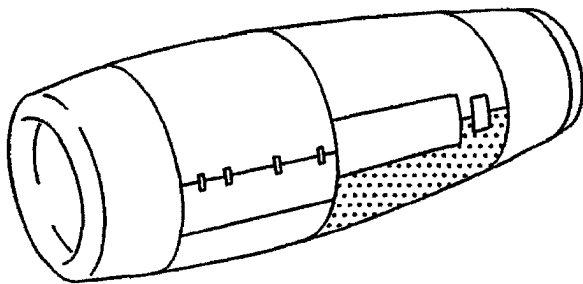
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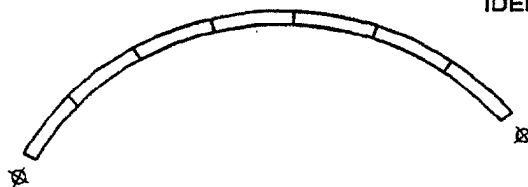
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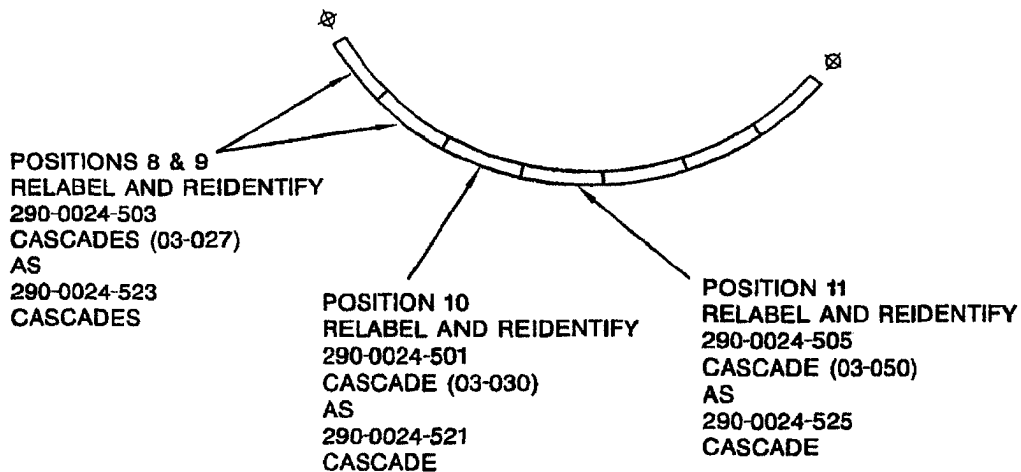
SERVICE BULLETIN



ALL EIPC NUMBERS
ARE 78-32-15 UNLESS
IDENTIFIED DIFFERENTLY



OUTBRD VIEW LOOKING FROM REAR OF ENGINE INBRD
LEFT ENGINE



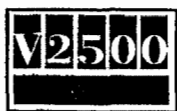
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LEFT HAND LOWER THRUST REVERSER HALF CASCADE REIDENTIFICATION
FIGURE 2

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thrust reverser positions 4 and 5.

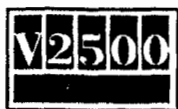
- (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-501 cascades from left hand thrust reverser positions 4 and 5. Retain bolts and washers for installation.
 - (b) Remove labels from 290-0024-501 cascades.
 - (c) Install 290-0030-521 labels onto 290-0024-501 cascades.
 - (d) Identify newly labeled cascades as 290-0024-521 cascades with ink stamp and white ink (CoMat 06-073).
- (4) Remove and modify 290-0024-505 cascade from left hand thrust reverser position 6.
- (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-505 cascade from left hand thrust reverser position 6. Retain bolts and washers for installation.
 - (b) Remove label from 290-0024-505 cascade.
 - (c) Install 290-0030-525 label onto 290-0024-505 cascade.
 - (d) Identify newly labeled cascade as 290-0024-525 cascade with ink stamp and white ink (CoMat 06-073).
- (5) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-509 cascade from left hand thrust reverser position 7. Scrap cascade. Retain bolts and washers for installation.

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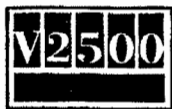
- (6) Modify 290-0024-503 cascades at left hand thrust reverser positions 8 and 9. Refer to Figure 2.
 - (a) Remove labels from 290-0024-503 cascades.
 - (b) Install 290-0030-523 labels onto 290-0024-503 cascades.
 - (c) Identify newly labeled cascades as 290-0024-523 cascades with ink stamp and white ink (CoMat 06-073).
- (7) Modify 290-0024-501 cascade at left hand thrust reverser position 10.
 - (a) Remove label from 290-0024-501 cascade.
 - (b) Install 290-0030-521 label onto 290-0024-501 cascade.
 - (c) Identify newly labeled cascade as 290-0024-521 cascade with ink stamp and white ink (CoMat 06-073).
- (8) Modify 290-0024-505 cascade at left hand thrust reverser position 11.
 - (a) Remove label from 290-0024-505 cascade.
 - (b) Install 290-0030-525 label onto 290-0024-505 cascade.
 - (c) Identify newly labeled cascade as 290-0024-525 cascade with ink stamp and white ink (CoMat 06-073).
- (9) Overcoat newly installed 290-0030 labels and ink stamps with clear polyurethane (CoMat 07-098).
 - (a) Use the manufacturer's instructions to mix the clear polyurethane (CoMat 07-098), catalyst (CoMat 07-097), and thinner (CoMat 07-096). Let the polyurethane stand for 30 minutes before it is used.

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- (b) Use a brush (CoMat 02-102) to apply a uniform layer of polyurethane over the newly installed labels and ink stamps.
 - (c) Let the polyurethane air dry for 15 minutes.
 - (d) Use a heat lamp to cure the polyurethane at 140-180 deg F (60-82 deg C) for 1 hour.
- (10) Install cascades on the left hand thrust reverser.
- (a) At position 2 on the thrust reverser, install a 290-0024-523 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only. Refer to Figure 3.
 - (b) At position 3 on the thrust reverser, install a 290-0024-521 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
 - (c) At position 4 on the thrust reverser, install a 290-0024-525 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
 - (d) At position 5 on the thrust reverser, install a 290-0024-523 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
 - (e) At position 6 on the thrust reverser, install a 290-0024-521 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.

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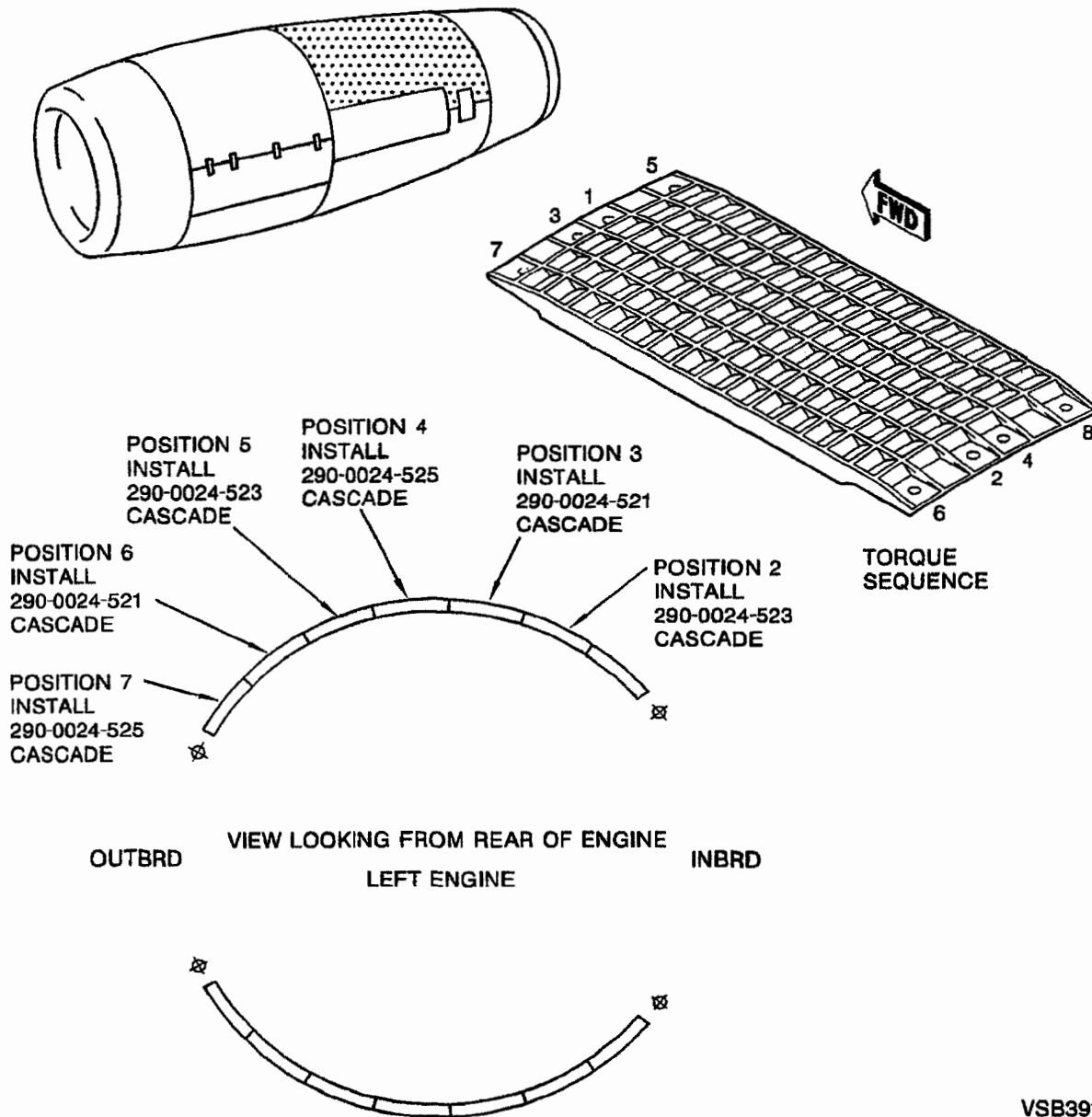
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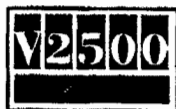
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**LEFT HAND UPPER THRUST REVERSER HALF CASCADE INSTALLATION
FIGURE 3**

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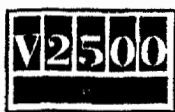
- (f) At position 7 on the thrust reverser, install a 290-0024-525 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
- (g) Tighten the NAS6404U11 bolts on each cascade in positions 2 through 7 to 50-70 in-lb (5.649-7.909 Nm) in the sequence shown in Figure 3.

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- (11) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-507 cascade from right hand thrust reverser position 1. Scrap cascade. Retain bolts and washers for installation. Refer to Figure 4.
- (12) Remove and modify 290-0024-503 cascade from right hand thrust reverser position 2.
 - (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-503 cascade from right hand thrust reverser position 2. Retain bolts and washers for installation.
 - (b) Remove label from 290-0024-503 cascade.
 - (c) Install 290-0030-523 label onto 290-0024-503 cascade.
 - (d) Identify newly labeled cascade as 290-0024-523 cascade with ink stamp and white ink (CoMat 06-073).
- (13) Remove and modify 290-0024-501 cascade from right hand thrust reverser position 3.

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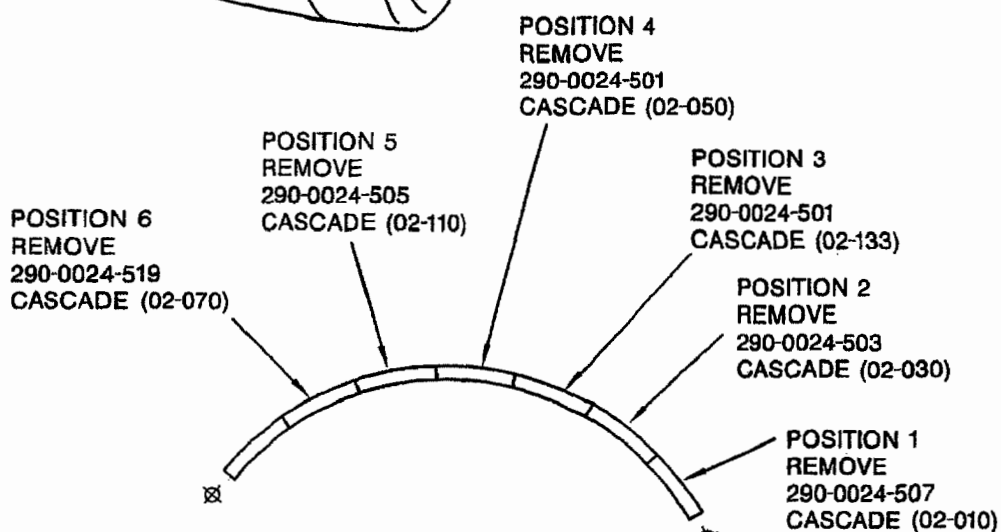
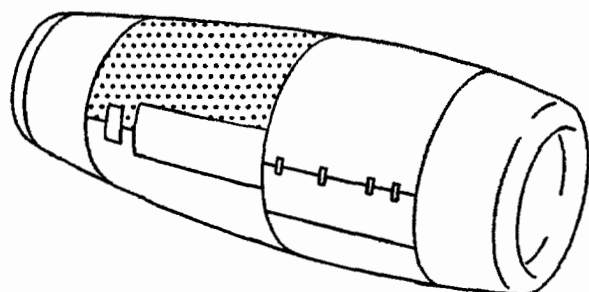
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INBRD VIEW LOOKING FROM REAR OF ENGINE OUTBRD
RIGHT ENGINE

ALL EIPC NUMBERS
ARE 78-32-15 UNLESS
IDENTIFIED DIFFERENTLY

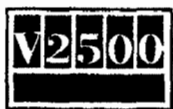
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**RIGHT HAND UPPER THRUST REVERSER HALF CASCADE REMOVAL
FIGURE 4**

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- (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-501 cascade from right hand thrust reverser position 3. Retain bolts and washers for installation.
 - (b) Remove label from 290-0024-501 cascade.
 - (c) Install 290-0030-521 label onto 290-0024-501 cascade.
 - (d) Identify newly labeled cascade as 290-0024-521 cascade with ink stamp and white ink (CoMat 06-073).
- (14) Remove and modify 290-0024-501 cascade from right hand thrust reverser position 4.
- (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-501 cascade from right hand thrust reverser position 4. Retain bolts and washers for installation.
 - (b) Remove label from 290-0024-501 cascade.
 - (c) Install 290-0030-521 label onto 290-0024-501 cascade.
 - (d) Identify newly labeled cascade as 290-0024-521 cascade with ink stamp and white ink (CoMat 06-073).
- (15) Remove and modify 290-0024-505 cascade from right hand thrust reverser position 5.
- (a) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-505 cascade from right hand thrust reverser position 5. Retain bolts and washers for installation.
 - (b) Remove label from 290-0024-505 cascade.
 - (c) Install 290-0030-525 label onto 290-0024-505 cascade.

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(d) Identify newly labeled cascade as 290-0024-525 cascade with ink stamp and white ink (CoMat 06-073).

(16) Remove eight NAS6404U11 bolts, eight NAS1587-4C washers, and the 290-0024-519 cascade from right hand thrust reverser position 6. Scrap cascade. Retain bolts and washers for installation.

(17) Modify 290-0024-503 cascade at right hand thrust reverser position 11. Refer to Figure 5.

(a) Remove label from 290-0024-503 cascade.

(b) Install 290-0030-523 label onto 290-0024-503 cascade.

(c) Identify newly labeled cascade as 290-0024-523 cascade with ink stamp and white ink (CoMat 06-073).

(18) Modify 290-0024-501 cascade at right hand thrust reverser position 12.

(a) Remove label from 290-0024-501 cascade.

(b) Install 290-0030-521 label onto 290-0024-501 cascade.

(c) Identify newly labeled cascade as 290-0024-521 cascade with ink stamp and white ink (CoMat 06-073).

(19) Modify 290-0024-505 cascade at right hand thrust reverser positions 13 and 14.

(a) Remove label from 290-0024-505 cascade.

(b) Install 290-0030-525 labels onto 290-0024-505 cascades.

(c) Identify newly labeled cascades as 290-0024-525 cascades with ink stamp and white ink (CoMat 06-073).

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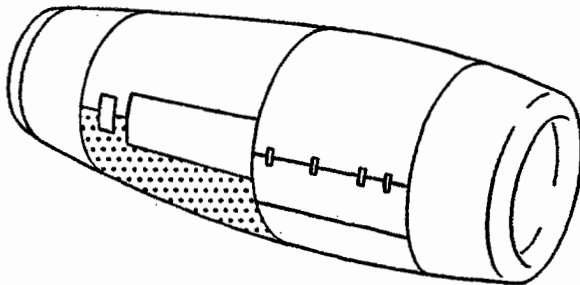
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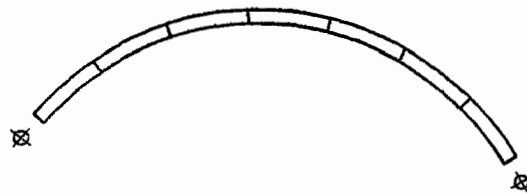
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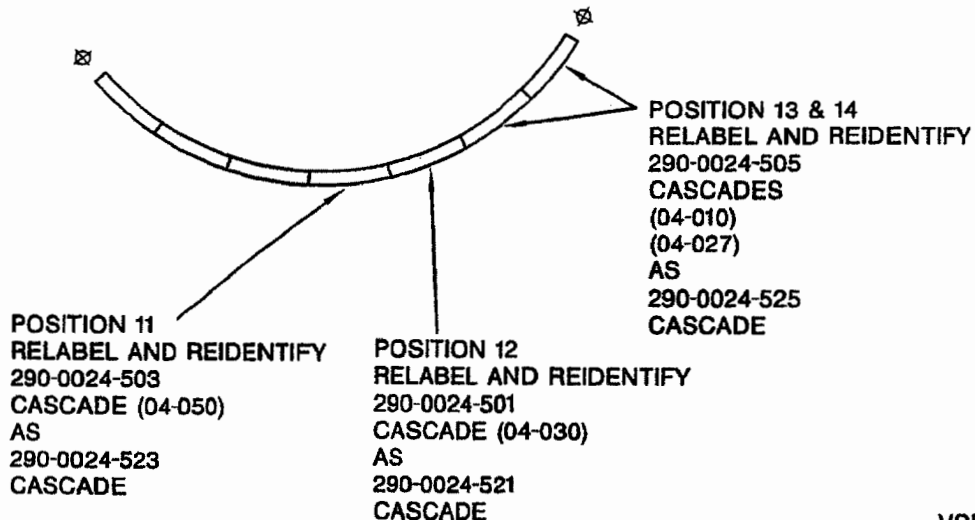
ALL EIPC NUMBERS
ARE 78-32-15 UNLESS
IDENTIFIED DIFFERENTLY



INBRD

VIEW LOOKING FROM REAR OF ENGINE
RIGHT ENGINE

OUTBRD



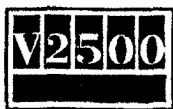
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RIGHT HAND LOWER THRUST REVERSER HALF CASCADE REIDENTIFICATION
FIGURE 5

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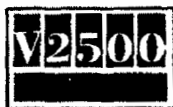
- (20) Overcoat newly installed 290-0030 labels and ink stamps with clear polyurethane (CoMat 07-098).
- (a) Use the manufacturer's instructions to mix the clear polyurethane (CoMat 07-098), catalyst (CoMat 07-097), and thinner (CoMat 07-096). Let the polyurethane stand for 30 minutes before it is used.
 - (b) Use a brush (CoMat 02-102) to apply a uniform layer of polyurethane over the newly installed labels and ink stamps.
 - (c) Let the polyurethane air dry for 15 minutes.
 - (d) Use a heat lamp to cure the polyurethane at 140-180 deg F (60-82 deg C) for 1 hour.
- (21) Install cascades on the right hand thrust reverser.
- (a) At position 1 on the thrust reverser, install a 290-0024-523 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only. Refer to Figure 6.
 - (b) At position 2 on the thrust reverser, install a 290-0024-521 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
 - (c) At position 3 on the thrust reverser, install a 290-0024-525 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.

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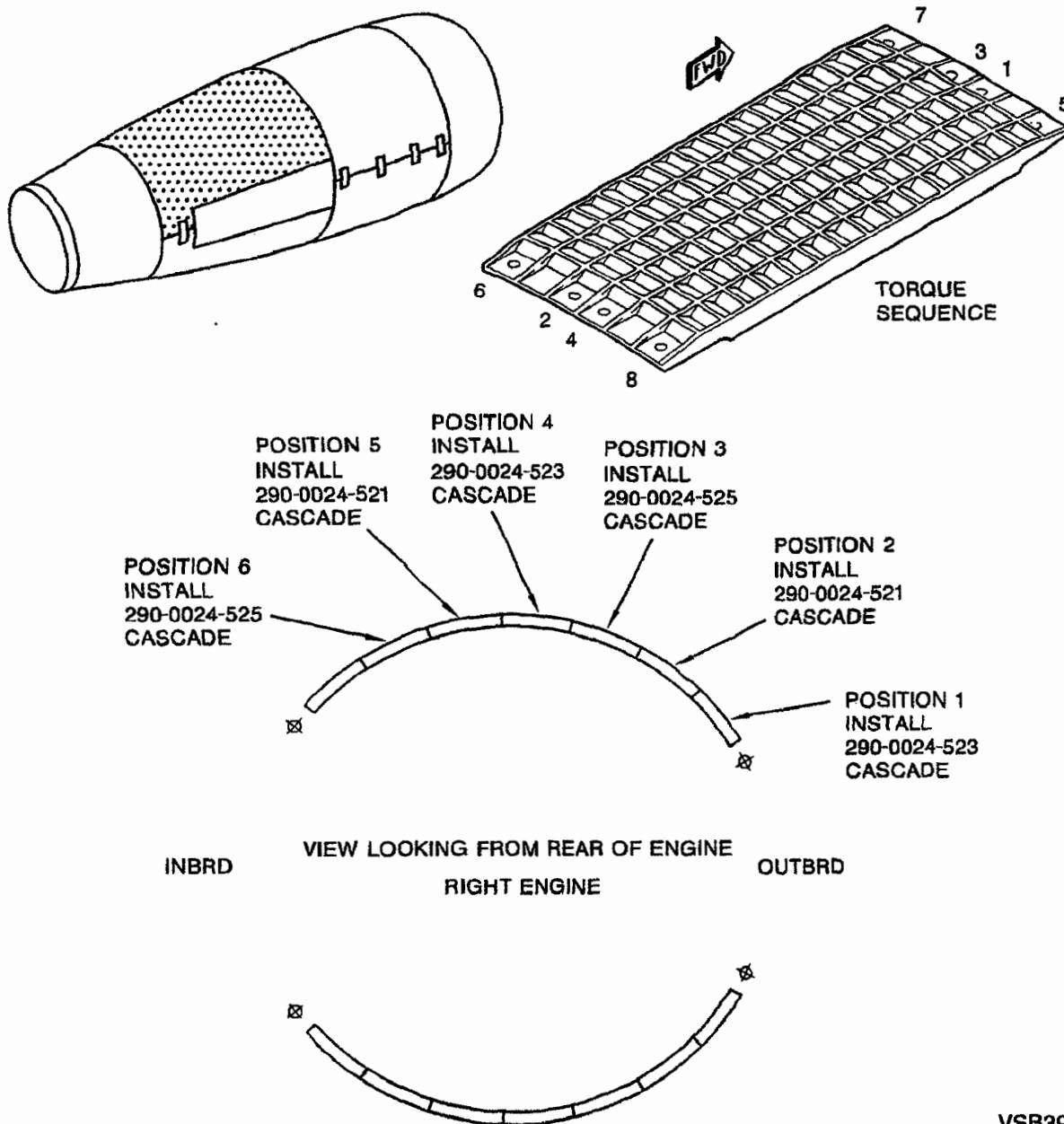
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RIGHT HAND UPPER THRUST REVERSER HALF CASCADE INSTALLATION
FIGURE 6

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- (d) At position 4 on the thrust reverser, install a 290-0024-523 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
- (e) At position 5 on the thrust reverser, install a 290-0024-521 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
- (f) At position 6 on the thrust reverser, install a 290-0024-525 cascade with eight NAS6404U11 bolts and eight NAS1587-4C washers. Tighten bolts finger tight only.
- (g) Tighten the NAS6404U11 bolts on each cascade in positions 2 through 6 to 50-70 in-lb (5.649-7.909 Nm) in the sequence shown in Figure 6.
- (h) Re-identify the thrust reversers as follows:
 - 290-0003-517 as 290-0003-525
 - 290-0003-519 as 290-0003-527
 - 290-0003-521 as 290-0003-529
 - 290-0003-523 as 290-0003-531

Metal stamp, electroetch, or vibroetch on thrust reverser data plate. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

C. Postrequisite Instructions

- (1) Manually stow thrust reverser. Refer to MD-90 Aircraft Maintenance Manual, Chapter 78-32-00, page block 201.

D. Recording Instructions

A record of accomplishment is necessary. Write in engine log and metal stamp, vibroetch, or electroetch on thrust reverser data plate that Service Bulletin V2500-NAC-78-0109 has been done. Refer to IAE V2500 Standard Practices Manual, Chapter 70-09-00.

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3. Material Information

Applicability: For each V2500-D5 Nacelle Thrust Reverser 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</u> <u>UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO</u> <u>(IPC NO)</u>	<u>INSTR/</u> <u>DISPOS</u>
V2578109-551			Kit		(A)
Consisting of:					
290-0030-521	3	Label			
290-0030-523	3	Label			
290-0030-525	2	Label			
290-0024-523	1	Cascade			
290-0024-525	1	Cascade			
V2578109-553			Kit		(A)
Consisting of:					
290-0030-521	3	Label			
290-0030-523	2	Label			
290-0030-525	3	Label			
290-0024-523	1	Cascade			
290-0024-525	1	Cascade			

B. Parts affected by this Bulletin:

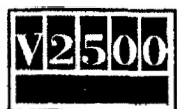
<u>Part No.</u> <u>(ATA No.)</u>	<u>Old</u> <u>Unit</u> <u>Qty Price</u>	<u>Keyword</u>	<u>Part No.</u> <u>(IPC No.)</u>	<u>Instructions/</u> <u>Disposition</u>
290-0003-529 (78-32-05)	1	.Thrust Reverser Assy, LH Upper	290-0003-521 (01-005)	(B)(C)(1D)(S1)
290-0003-531 (78-32-06)	1	.Thrust Reverser Assy, RH Upper	290-0003-523 (01-005)	(B)(C)(1D)(S2)
290-0003-525 (78-32-07)	1	.Thrust Reverser Assy, LH Lower	290-0003-517 (01-005)	(B)(C)(1D)(S3)
290-0003-527 (78-32-08)	1	.Thrust Reverser Assy, RH Lower	290-0003-519 (01-005)	(B)(C)(1D)(S4)

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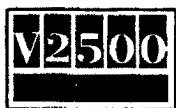
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Part No. (ATA No.)	Qty	Old Unit Price	Keyword	Part No. (IPC No.)	Instructions/ Disposition
290-0024-525 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-509 (01-010)	(B)(C)(2D)(S5)
290-0030-525 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-509 (01-027)	(B)(C)(S5)
290-0024-521 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-505 (01-030)	(B)(C)(3D)(S5)
290-0030-521 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-505 (01-047)	(B)(C)(S5)
290-0024-523 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-501 (01-050)	(B)(C)(E) (3D)(S5)
NAS6404U11 (78-32-15)	8		...Bolt	NAS6404U11 (01-055)	(B)(F)(G)(S5)
NAS1587-4C (78-32-15)	8		...Washer	NAS1587-4C (01-065)	(B)(F)(G)(S5)
290-0030-523 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-501 (01-067)	(B)(C)(E)(S5)
290-0024-523 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-517 (01-070)	(B)(C)(2D)(S5)
290-0030-523 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-517 (01-087)	(B)(C)(S5)
290-0024-521 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-503 (01-110)	(B)(C)(3D)(S5)
290-0030-521 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-503 (01-127)	(B)(C)(S5)
290-0024-525 (78-32-15)	1		..Cascade Assy, LH Upper	290-0024-501 (01-133)	(B)(7D)(S5)
NAS6404U11 (78-32-15)	8		...Bolt	- - - (01-141)	(B)(S5)
NAS1587-4C (78-32-15)	8		...Washer	- - - (01-144)	(B)(S5)
290-0030-525 (78-32-15)	1		...Label (Decal) LH Upper	290-0030-501 (01-149)	(B)(S5)

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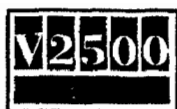
Part No. (ATA No.)	Qty	Old Unit Price	Keyword	Part No. (IPC No.)	Instructions/ Disposition
290-0024-523 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-507 (02-010)	(B)(C)(2D)(S6)
290-0030-523 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-507 (02-027)	(B)(C)(S6)
290-0024-521 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-503 (02-030)	(B)(C)(3D)(S6)
290-0030-521 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-503 (02-047)	(B)(C)(S6)
290-0024-525 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-501 (02-050)	(B)(C)(E) (3D)(S6)
NAS6404U11 (78-32-15)	8		...Bolt	NAS6404U11 (02-055)	(B)(F)(G)(S6)
NAS1587-4C (78-32-15)	8		...Washer	NAS1587-4C (02-065)	(B)(F)(G)(S6)
290-0030-525 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-501 (02-067)	(B)(C)(E)(S6)
290-0024-525 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-519 (02-070)	(B)(C)(2D)(S6)
290-0030-525 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-519 (02-087)	(B)(C)(S6)
290-0024-521 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-505 (02-110)	(B)(C)(3D)(S6)
290-0030-521 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-505 (02-127)	(B)(C)(S6)
290-0024-523 (78-32-15)	1		..Cascade Assy, RH Upper	290-0024-501 (02-133)	(B)(4D)(S6)
NAS6404U11 (78-32-15)	8		...Bolt	- - - (02-141)	(B)(S6)
NAS1587-4C (78-32-15)	8		...Washer	- - - (02-144)	(B)(S6)
290-0030-523 (78-32-15)	1		...Label (Decal) RH Upper	290-0030-501 (02-149)	(B)(S6)

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Part No. (ATA No.)	Qty	Old Unit Price	Keyword	Part No. (IPC No.)	Instructions/ Disposition
290-0024-523 (78-32-15)	2		..Cascade Assy, LH Lower	290-0024-503 (03-010)	(B)(C)(1D)(S7)
290-0030-523 (78-32-15)	2		...Label (Decal) LH Lower	290-0030-503 (03-027)	(B)(C)(S7)
290-0024-521 (78-32-15)	1		..Cascade Assy, LH Lower	290-0024-501 (03-030)	(B)(C)(1D)(S7)
290-0030-521 (78-32-15)	1		...Label (Decal) LH Lower	290-0030-501 (03-047)	(B)(C)(S7)
290-0024-525 (78-32-15)	1		..Cascade Assy, LH Lower	290-0024-505 (03-050)	(B)(C)(1D)(S7)
290-0030-525 (78-32-15)	2		...Label (Decal) LH Lower	290-0030-505 (03-067)	(B)(C)(S7)
290-0024-525 (78-32-15)	2		..Cascade Assy, RH Lower	290-0024-505 (04-010)	(B)(C)(1D)(S8)
290-0030-525 (78-32-15)	1		...Label (Decal) RH Lower	290-0030-505 (04-027)	(B)(C)(S8)
290-0024-521 (78-32-15)	1		..Cascade Assy, RH Lower	290-0024-501 (04-030)	(B)(C)(1D)(S8)
290-0030-521 (78-32-15)	1		...Label (Decal) RH Lower	290-0030-501 (04-047)	(B)(C)(S8)
290-0024-523 (78-32-15)	1		..Cascade Assy, RH Lower	290-0024-503 (04-050)	(B)(C)(1D)(S8)
290-0030-523 (78-32-15)	1		...Label (Decal) RH Lower	290-0030-503 (04-067)	(B)(C)(S8)

C. Instructions/Dispositions Code Statements

(A) Kit is currently available.

(B) New part is currently available.

(C) Old part is no longer available.

(1D) Old part may be reworked and reidentified to the new part number.

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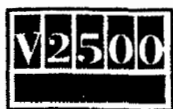
- (2D) New part may be obtained by rework and reidentification from an existing old number. See Accomplishment Instructions. Old part cannot be reworked.
- (3D) New part can be obtained by rework and reidentification from an existing old part number. Old part can be reworked and reidentified to a new part number. See Accomplishment Instructions.
- (4D) New part may be obtained by rework and reidentification from an existing old part number. See Accomplishment Instructions.
- (E) Quantity reduced from 2 to 1.
- (F) Quantity reduced from 16 to 8.
- (G) Old parts may be used up on other applications.
- (S1) Old and new parts coded (S1), (S2), (S3), (S4) are interchangeable in complete sets.
- (S2) See Note (S1).
- (S3) See Note (S1).
- (S4) See Note (S1).
- (S5) Old and new parts are interchangeable in complete sets with old and new parts coded (S1).
- (S6) Old and new parts are interchangeable in complete sets with old and new parts coded (S2).
- (S7) Old and new parts are interchangeable in complete sets with old and new parts coded (S3).
- (S8) Old and new parts are interchangeable in complete sets with old and new parts coded (S4).

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D. Materials Required to Incorporate This Bulletin

CoMat 06-073	White ink
CoMat 07-096	Thinner
CoMat 07-097	Catalyst
CoMat 07-098	Clear Polyurethane

NOTE: To identify the consumable materials , refer to the
Overhaul Processes and Consumable Index PCI-V2500-1IA.

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