SERVICE BULLETIN REVISION NOTICE

NACELLE - THRUST REVERSER – DOORS, PRESSURE RELIEF, AND LATCH ACCESS – MODIFICATION OF

Turbojet Engine Service Bulletin No. V2500-NAC-78-0114 Revision No. 3 dated May 9, 2017.

Revision History

Original Issue June 19, 1996

Revision 1 January 16, 1997

Revision 2 March 27, 1997

Revision 3 May 9, 2017

Reason for the Revision

(1) The Service Bulletin has been reformatted to the latest format requirement.

(2) To change the Concurrent Requirements statement, to remove Service Bulletin V2500-NAC-78-0110.

(3) To change the Description statement to delete any reference of a previous requirement to replace the pressure relief door lanyards.

(4) To remove the Manpower Note, the reimbursement period has expired.

(5) The Material Information section has been changed and rewritten.

(6) To add latch assembly PN to Accomplishment Instructions section 2.B.

(7) To change gap dimension in Figure 3 to agree with engineering.

(8) To correct Figure 3 reference in Accomplishment Instructions section 2.C.(6) to Figure 5 (Sheet 2).

(9) To change the Accomplishment Instructions. To add NOTE eliminating the requirement to replace the pressure relief door lanyards per section 2.D. of this Service Bulletin.

(10) To change the Accomplishment Instructions to add a statement to section 2.D.(1), indicating that the previous Figure 6, pertaining to the replacement of the pressure relief door lanyards, has been removed.

(11) To add a reference in the Accomplishment Instructions section 2.K. to the MD-90 AMM.

Effect of Revision on Prior Compliance

None.

This is a Complete Revision (Not Applicable to the SGML version)

The format of this Service Bulletin has been changed from previous versions. This revision shows flow bars and the revision date on the bottom of every page. Technical changes incorporated in this revision are marked with revision bars. The contents are in accordance with the list of effective pages.

MODEL APPLICATION

V2525-D5, V2528-D5

BULLETIN ISSUE SEQUENCE

V2500 Series 78-0114

Page	Revision No.	Date
1 thru 21	3	May 9/17

A copy of this Revision Notice and any future revision notices must be filed as a permanent record with your copy of the subject bulletin.

SERVICE BULLETIN

NACELLE - THRUST REVERSER – DOORS, PRESSURE RELIEF, AND LATCH ACCESS – MODIFICATION OF

MODEL APPLICATION

V2525-D5, V2528-D5

BULLETIN ISSUE SEQUENCE

V2500 Series 78-0114

ATA NUMBER

78-32-00

Compliance Category

5

P&W Distribution Code

V2500

Summary

The purpose of this Service Bulletin is to eliminate the possibility of inadvertent pressure relief door openings and possible subsequent delays in aircraft operation.

Planning Information

Effectivity Data

Engine Models Applicable

V2525-D5, V2528-D5 with a Nacelle Thrust Reverser Serial Number listed in Table 1. Any engine as applicable.

Concurrent Requirements

This Service Bulletin must be done before or at the same time as Reference 8, Service Bulletin No. V2500-NAC-78-0124.

Reason

1. Problem: The lack of latch tension adjustment feature may result in excessive pressure relief door latch mechanism preload and possible inadvertent opening of the pressure relief door in flight.
2. Evidence: Operators have experienced excessive latch preload and inadvertent opening of the pressure relief door in flight.
3. Objective: Provide adjustability of the latch tension to control the latch preload and prevent inadvertent opening of the pressure relief door in flight.
4. Substantiation: Fit check of the modified latch access and the pressure relief doors was successful.
5. Effects of Bulletin on:

   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.

Description

The bulb seal on the forward end of the latch access door will be replaced with a blade type seal. On the pressure relief door the perimeter teflon rub strips will be replaced with a compressible gasket, and shims will be installed on the door directly under the latch mechanism cam. Also on the pressure relief door, the latch mechanism cam surface will be ground down. On the lower outboard track assembly, striker plates will be installed where the pressure relief door latch mechanism cam contacts the track assembly.

Compliance

Category 5

Accomplish when the engine is disassembled sufficiently to afford access to the affected subassembly (i.e., modules, accessories, components, build groups) and to all affected spare subassemblies.

Table 1

Nacelle Thrust Reversers Serial Number
0004001 thru 0007001
0009001
0010001
0021001 thru 0108001

Approval Data

The part number changes and/or part modifications specified in the Accomplishment Instructions and Material Information sections of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

Incorporation of this Service bulletin must be accomplished only in conjunction with Reference 9, Douglas Aircraft Company Service Bulletin 78-012 which has received exclusive FAA approval for MD-90 Series aircraft.

Manpower

1. In Service

   ..... 7 hours.

2. At Overhaul

   ..... 6 hours.

Weight and Balance

1. Weight Change

   None.

2. Moment Arm

   No Effect.

3. Datum

   Engine Front Mount Centerline (Power Plant Station (PPS) 100).

Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

Software Accomplishment Summary

Not Applicable.

References

1. ATA Locator — 78-32-00.
2. Internal Reference No. — 95VN349E.
3. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 70-09-00 and 70-42-08.
4. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 78-32-09 and 78-32-10.
5. MD-90 Aircraft Maintenance Manual, AMM, Chapter/Section 78-32-09 and 78-32-10.
6. MD-90 Structural Repair Manual, Chapter/Section 54-30-03.
7. V2500 Consumable Materials Index, P&W Ref. PN 2A4413.
8. V2500 Service Bulletin V2500-NAC-78-0124. Nacelle - Exhaust - Thrust Reverser - Pin, Quick Release - Hold Open, Pressure Relief Door - Relocation Of
9. Douglas Aircraft Company Service Bulletin 78-012.

Other Publications Affected

1. V2500-D5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4426,, Chapter/Section 78-32-09 and 78-32-10.

Interchangeability of Parts

Old and new parts are interchangeable only in full sets.

This Service Bulletin must be done at the same time as Reference 8, Service Bulletin No. V2500-NAC-78-0124.

Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

Material Information

Material — Price and Availability

1. There is no kit provided to do this Service Bulletin.
2. Part availability information is provided in material data Instructions — Disposition.

Industry Support Program

Not Applicable.

The material data that follows is for each thrust reverser.

For V2525-D5, V2528-D5 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
290-0033-61	2	*	Gasket		(2)(3)(A)(D)
290-0033-63	1	*	Gasket		(2)(3)(A)(D)
290-0033-65	1	*	Gasket		(2)(3)(A)(D)
290-0032-3	2	*	Shim		(2)(3)(A)(D)
290-0038-3	1	*	Seal		(2)(3)(A)(D)
290-0035-83	1	*	Retainer		(2)(3)(A)(D)
290-0761-3	2	*	Plate, Striker		(2)(3)(A)(D)
MS20426AD4-7	8	*	Rivet		(2)(3)(A)(D)
NAS1097AD5-8	24	*	Rivet		(2)(3)(A)(D)
NAS1097AD5-5	8	*	Rivet		(2)(3)(A)(D)
290-0032-503	1	*	DOOR, LH	290-0032-501 (01-010)	(1)(M)(N)(S1)
290-0032-503	1	*	DOOR, LH	290-0012-1C (01-010)	(1)(M)(N)(S1)
290-0032-504	1	*	DOOR, RH	290-0032-502 (01-012)	(1)(M)(N)(S1)
290-0032-504	1	*	DOOR, RH	290-0012-2C (01-012)	(1)(M)(N)(S1)
290-0038-509	1	*	DOOR, LH	290-0038-507 (01-010)	(1)(M)(N)(S1)
290-0038-509	1	*	DOOR, LH	290-0012-3C (01-010)	(1)(M)(N)(S1)
290-0038-510	1	*	DOOR, RH	290-0038-508 (01-012)	(1)(M)(N)(S1)
290-0038-510	1	*	DOOR, RH	290-0012-4C (01-012)	(1)(M)(N)(S1)

Instructions/Disposition Code Statements:

Parts Modification Conditions

Estimated part prices are provided when they are available at time of publication. The Estimate of Unit Price is only for planning purposes and does not constitute a firm quotation. An asterisk (*) is shown where part pricing information was unavailable. In either case, contact UTAS Spares for firm quotations.

(1) The new part can be obtained by modification of the old part as specified in the Accomplishment Instructions.

(2) The new part is a replacement part only, and cannot be obtained by modification of the old part.

(3) Kits are not longer available for this service bulletin. Operators can order individual parts from UTAS at current catalog prices. UTAS will provide price and schedule upon receipt of a purchase order.

Direct the purchase order to:

Rohr, Inc., a UTC Aerospace Systems company - Aerostructures

850 Lagoon Drive Chula Vista, CA 91910-2098

Attn: Direct Airline Sales sparesales@goodrich.com

Spare Parts Availability

(A) The new part is available.

(D) The new part is a detail of the assembly. It is available as a replacement part.

(M) It is possible to get the new part only by modification.

(N) The old part is not available.

(S1) New parts coded (S1) must replace old parts coded (S1) as a COMPLETE SET per Aircraft. New parts must be fitted as a set, it is not permitted to mix old and new parts. While it is permissible to continue the use of old parts in sets, it is recommended this Service Bulletin be incorporated to eliminate the possibility of inadvertent relief door openings and possible subsequent delays in aircraft operation.

Cleaning, Inspection and Repair Information

(I) The cleaning, inspection and repair requirements are the same for the old and new part. The applicable engine manuals will be revised.

(R) The cleaning, inspection and repair requirements are different for the old and new part. The applicable engine manuals will be revised to include the new requirements.

Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

Reidentified Parts

Reidentified Parts Data

New PN	Keyword	Old PN
290-0032-503	DOOR, LH	290-0032-501
290-0032-503	DOOR, LH	290-0012-1C

New PN	Keyword	Old PN
290-0032-504	DOOR, RH	290-0032-502
290-0032-504	DOOR, RH	290-0012-2C
290-0038-509	DOOR, LH	290-0038-507
290-0038-509	DOOR, LH	290-0012-3C
290-0038-510	DOOR, RH	290-0038-508
290-0038-510	DOOR, RH	290-0012-4C

Other Material Information Data

Materials Required to Incorporate this Service Bulletin:

CoMat 01-001 — 1.1.1 Trichloroethane, Inhibited and Stabilized

CoMat 02-099 — Lint Free Cloth

CoMat 02-147 — Lockwire

CoMat 06-073 — Metal Marking Ink

CoMat 07-028 — Chemical Conversion Coating for Aluminum

CoMat 07-066 — Thinner

CoMat 07-067 — Primer Converter

CoMat 07-071 — Primer Base

CoMat 08-032 — Adhesive

CoMat N/A — Demineralized Water (Commercially Available)

CoMat 08-098 — DC 730 Fluorosilicone Adhesive/Sealant

NOTE: To identify the consumable materials, refer to Reference 7, Consumable Materials Index.

Accomplishment Instructions

1. Pre-requisite Instructions

   A. Remove the pressure relief doors. Refer to Reference 5, AMM, Chapter/Section 78-32-09.

   B. Remove the latch access doors. Refer to Reference 5, AMM, Chapter/Section 78-32-10.

2. Rework or Modification Instructions

   A. Modify the Latch Access Door, PN 290-0038.

      NOTE: The following procedure can be performed on the left hand nacelle or right hand nacelle latch access door.

      (1) Use a 0.161 - 0.165 in. (4.089 - 4.191 mm) diameter drill to drill out the twelve (12) Rivets, PN NAS1097AD5 used to hold the Seal Assembly, PN 290-0035-81 and Shim, PN 290-0035-127 to the Latch Access Door, PN 290-0038. Remove the Seal Assembly, PN 290-0035-81 and shim from the latch access door. Do not remove the Shim, PN 290-0035-115 from the latch access door. Refer to Figure 1.

      (2) Put the Blade Seal, PN 290-0038-3 and Retainer, PN 290-0035-83 on the Latch Access Door, PN 290-0038. Hold the seal and retainer in place. Refer to Figure 2.

      (3) Use a 0.161 - 0.165 in. (4.089 - 4.191 mm) diameter drill to drill through the existing rivet holes in the Latch Access Door, PN 290-0038 and into the Blade Seal, PN 290-0038-3 and the Retainer, PN 290-0035-83. Remove burrs from drilled holes.

         WARNING: PRIMER BASE, PRIMER CONVERTER, AND THINNER ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH 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 PRECAUTIONS.

      (4) Mix Primer Base (CoMat 07-071), Primer Converter (CoMat 07-067), and Thinner (CoMat 07-066). Refer to the manufacturer's instructions.

      (5) Put the Blade Seal, PN 290-0038-3 and Retainer, PN 290-0035-83 on the Latch Access Door, PN 290-0038 and wet install the twelve (12) Rivets, PN NAS1097AD5-8 with primer mix. Wipe off any excess primer with a clean cloth.

         NOTE: Keep the remaining primer for later use.

WARNING: TRICHLOROETHANE IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

(6) With a Clean Cloth (CoMat 02-099) and Trichloroethane (CoMat 01-001), clean an area on the interior side of the latch access door where the identification mark will be applied.

(7) Identify the Latch Access Door, PN 290-0038-507 or PN 290-0012-3C, as Latch Access Door, PN 290-0038-509 with a rubber stamp and Black Ink (CoMat 06-073). Refer to Reference 3, V2500 Standard Practices and Processes, Chapter/Section 70-09-00.

(8) Identify the Latch Access Door PN 290-0038-508 or PN 290-0012-4C, as Latch Access Door, PN 290-0038-510 with a rubber stamp and Black Ink (CoMat 06-073). Refer to Reference 3, IAE V2500 Standard Practices and Processes, Chapter/Section 70-09-00.

(9) Remove or cover the existing mark that identifies the Latch Access Door as, PN 290-0038-507, PN 290-0012-3C, PN 290-0038-508, or PN 290-0012-4C.

(10) With a Clean Cloth (CoMat 02-099) and Trichloroethane (CoMat 01-001), clean both ends of the Rivets, PN NAS1097AD5-8. Wipe solvent before it becomes dry.

(11) Apply the primer with a brush to both ends of the Rivets, PN NAS1097AD5-8 on the Latch Access Door, PN 290-0038.

NOTE: Keep the remaining primer for later.

(12) Cure the primer for seven (7) hours at room temperature or for 40 minutes at 140 - 180°F (60 - 82°C) with an explosion-proof heat lamp.

(13) Repair the external paint on the latch access door assembly. Refer to Reference 6, MD-90 Structural Repair Manual, Chapter/Section 54-30-03, External Paint Repair VRS2404.

B. Modify the pressure relief door assembly latches. For Latch Assembly PN H3916-1 only.

(1) Measure and make a note of the distance between the pressure relief door latch cam and the rub strip in the latch closed position. Refer to Figure 3. If the measurement is not the same as the dimension shown in Figure 3, perform steps 2.B.(2) thru 2.B.(4) below. If the measurement is the same as the dimension shown in Figure 3, go to step 2.C. below.

(2) Hand grind the latch cam with non-metallic abrasive to get the dimension shown in Figure 3.

(3) Remove metal chips or other unwanted material with a dry air supply.

(4) Clean the latch cam with a Clean Cloth (CoMat 02-099) and Trichloroethane (CoMat 01-001). Wipe the surface dry before solvent becomes dry.

C. Modify the Pressure Relief Door Assembly, PN 290-0032.

NOTE: The following procedure can be performed on the left hand nacelle or right hand nacelle pressure relief door assembly.

(1) Remove the Rub Strips PN 290-0033-3 and PN 290-0033-39 from the Pressure Relief Door Assembly, PN 290-0032. Refer to Figure 4.

(2) Remove any remaining rub strip and/or rub strip adhesive residue from the pressure relief door assembly.

(3) With a Clean Cloth (CoMat 02-099) and Trichloroethane (CoMat 01-001), clean the rub strip mounting surfaces on the Pressure Relief Door Assembly, PN 290-0032. wipe the solvent before it becomes dry.

(4) If bare metal was exposed on the pressure relief door when you removed the rub strip, apply chemical conversion coating and primer to the area of bare metal.

WARNING: CONVERSION COATING IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

(a) Mix the conversion coating in a ratio of 3.0 oz. Conversion Coating (CoMat 07-02S) to 1.0 gal of demineralized water.

(b) Apply the chemical conversion coating to the areas of bare metal on the Pressure Relief Door, PN 290-0032 for two to five minutes. Keep surface wet with fresh solution. Do not allow the solution to dry.

(c) Rinse the chemical conversion coating from all the surfaces with clean water and dry with a Clean Cloth (CoMat 02-099).

(d) Apply the primer with a brush to the exposed bare metal on the Pressure Relief Door Assembly, PN 290-0032.

(e) Cure the primer for seven (7) hours at room temperature or for 40 minutes at 140 - 180°F (60 - 82°C) with an explosion-proof heat lamp.

(5) Put the two Shims, PN 290-0032-3 on the Pressure Relief Door Assembly, PN 290-0032. Hold the shims in position. Refer to Figure 5.

(6) Measure and make a note of the distance between the pressure relief door latch cam and the shims. Remove laminations from the shims as necessary to make a 0.228 - 0.238 in. (5.79 - 6.05 mm) space between the latch cam and the shim as shown in Figure 5 (Sheet 2).

(7) Use a 0.161 - 0.165 in. (4.089 - 4.191 mm) diameter drill to drill through the Shims, PN 290-0032-3 and the Pressure Relief Door Assembly, PN 290-0032. Remove the burrs from the drilled holes.

(8) On the external side of the Pressure Relief Door Assembly, PN 290-0032, countersink the drilled holes to a diameter of 0.226 - 0.236 in. (5.740 - 5.994 mm) x 100 degrees

(9) On the solid (not-laminated) side of the Shims, PN 290-0032-3, countersink the drilled holes to a diameter of 0.226 - 0.236 in. (5.740 - 5.994 mm) x 100 degrees

(10) Put the two (2) Shims, PN 290-0032-3 on the Pressure Relief Door Assembly, PN 290-0032 and install the Rivets, PN NAS1097AD5-5. Install the manufactured head of the rivets on external side of the door assembly. Make sure the rivets on the internal side of the door assembly are fully countersunk into the shims when you install them.

(11) Apply primer with a brush to both ends of the Rivets, PN NAS1097AD5-5 on the Pressure Relief Door Assembly, PN 290-0032.

(12) Cure the primer for seven (7) hours at room temperature or for 40 minutes at 140 - 180°F (60 - 82°C) with an explosion-proof heat lamp.

(13) Install the Gaskets, PN 290-0033 on the pressure relief door.

WARNING: PRIMER IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

(a) Mix the Primer (CoMat 08-032). Refer to the manufacturers instructions.

(b) Apply a thin layer of Primer (CoMat 08-032) to the areas of the pressure relief where you will install the Gaskets, PN 290-0033. Refer to Figure 5. Allow to dry for 30 minutes minimum before you apply DC 730 Fluorosilicone Adhesive/Sealant (CoMat 08-098).

(c) Remove the protective backing from the Gaskets, PN 290-0033-61, 290-0033-63, and 290-0033-65.

WARNING: ADHESIVE IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

(d) Apply a uniform layer of DC 730 Fluorosilicone Adhesive/Sealant (CoMat 08-098), 10 to 30 mils thick, to the sticky side of the Gaskets, PN 290-0033 and make the adhesive smooth.

(e) Install the Gaskets, PN 290-0033 on the Pressure Relief Door, PN 290-0032.

(f) Let the adhesive cure for two (2) hours before you put the pressure relief door into service. Heat will not speed the cure of the adhesive.

(14) With a Clean Cloth (CoMat 02-099) and Trichloroethane (CoMat 01-001), clean an area on the internal side of the pressure relief door assembly door where the identification mark will be applied.

(15) Identify the Pressure Relief Door Assembly, PN 290-0032-501 or PN 290-0012-1C as the Pressure Relief Door Assembly, PN 290-0032-503 with a rubber stamp and Black Ink (CoMat 06-073). Refer to Reference 3, V2500 Standard Practices and Processes, Chapter/Section 70-09-00.

(16) Identify the Pressure Relief Door Assembly, PN 290-0032-502 or PN 290-0012-2C as the Pressure Relief Door Assembly, PN 290-0032-504 with a rubber stamp and Black Ink (CoMat 06-073). Refer to Reference 3, V2500 Standard Practices and Processes, Chapter/Section 70-09-00.

(17) Remove or cover the existing mark that identifies the pressure relief door assembly as PN 290-0032-501, PN 290-0012-1C, PN 290-0032-502, or PN 290-0012-2C pressure relief door assembly.

(18) Repair the external paint on the pressure relief door assembly. Refer to Reference 6, MD-90 Structural Repair Manual, Chapter/Section 54-30-03, External Paint Repair VRS2404.

NOTE: This section of the Service Bulletin removes what was installed per SB V2500-NAC-78-0103. This section of the Service Bulletin is issued for parts progression history purposes only. No incorporation action per this section is required. Parts described in this section are not required. The change introduced by this section of this Service Bulletin has been superseded by the change introduced by Service Bulletin V2500-NAC-78-0184.

D. Replace the pressure relief door assembly lanyards and lanyard bolts.

(1) At the forward end of the pressure relief door assembly, remove two NAS1291C4M nuts, two S700W0029-6 washers, two 290-0889-501 bolts or two NAS6304U10 bolts, and two S700M1392A193 lanyards. Do not remove the bushing from the lanyard bracket on the pressure relief door assembly. Keep the two NAS1291C4M nuts for installation. Discard the 290-0889-501 bolts (or NAS6304U10 bolts), S700W0029-6 washers, and S700M1392A193 lanyards. Refer to Figure 6 (Figure was removed from this Service Bulletin, see above note).

(2) At the forward end of the pressure relief door assembly, install two S700M1392A170 lanyards, two 290-0889-503 bolts, and two NAS1291C4M nuts. Tighten the NAS1291C4M nuts to a torque of 10-20 in-lbs (1.13 - 2.26 Nm).

(3) At the aft end of the pressure relief door assembly, remove two NAS1291C4M nuts, two S700W0029-6 washers, two 290-0889-501 bolts (or two NAS6304U10 bolts), and two S700M1392A186 lanyards. Do not remove the bushing from the lanyard bracket on the pressure relief door assembly. Keep the two NAS1291C4M nuts for installation. Discard the 290-0889-501 bolts (or NAS6304U10 bolts), S700W0029-6 washers, and S7001392A186 lanyards.

(4) At the aft end of the pressure relief door assembly, install two S700M1392A161 lanyards, two 290-0889-503 bolts, and two NAS1291C4M nuts. Tighten the NAS1291C4M nuts to a torque of 10-20 in-lbs (1.13 - 2.26 Nm).

E. Install the pressure relief door Striker Plates, PN 290-0761-3 on the lower outboard track assembly.

(1) Find the two notches for the pressure relief door latches on the Lower Outboard Track Assembly, PN 290-0761. Refer to Figure 6.

(2) Put the two (2) pressure relief door Striker Plates, PN 290-0761-3 on the Lower Outboard Track Assembly, PN 290-0761 behind the notches. Hold the plates in the position as shown in Figure 6.

(3) Use a 0.128 - 0.134 in. (3.251 - 3.404 mm) diameter drill to back drill through the pressure relief door Striker Plates, PN 290-0761-3 and the Lower Outboard Track Assembly, PN 290-0761. Remove the burrs from the drilled holes.

(4) On the external side of the Lower Outboard Track Assembly, PN 290-0761, countersink the drilled holes to a diameter of 0.128 - 0.134 in. (3.251 - 3.404 mm) x 100 degrees.

(5) Put the two (2) pressure relief door Striker Plates, PN 290-0761-3 on the lower outboard track assembly and wet install the Rivets, PN MS20426AD4-7 with primer.

(6) Apply primer with a brush to both ends of the Rivets, PN MS20426AD4-7 installed on the lower outboard track assembly.

(7) Cure the primer for seven (7) hours at room temperature or for 40 minutes at 140 - 180° F (60 - 82° C) with an explosion-proof heat lamp.

(8) Make sure the 0.050 - 0.070 in. (1.27 - 1.78 mm) dimension in view B of Figure 6 is the same after you install the rivets. If necessary, remove material from the pressure relief door striker plate to get the proper dimension.

F. Install the latch access door. Refer to Reference 5, AMM, Chapter/Section 78-32-10.

G. Install the pressure relief door. Refer to Reference 5, AMM, Chapter/Section 78-32-09.

H. Open the thrust reverser pressure relief door.

I. Make sure that the latch and contact surfaces are clean.

J. Close and latch the thrust reverser pressure relief door.

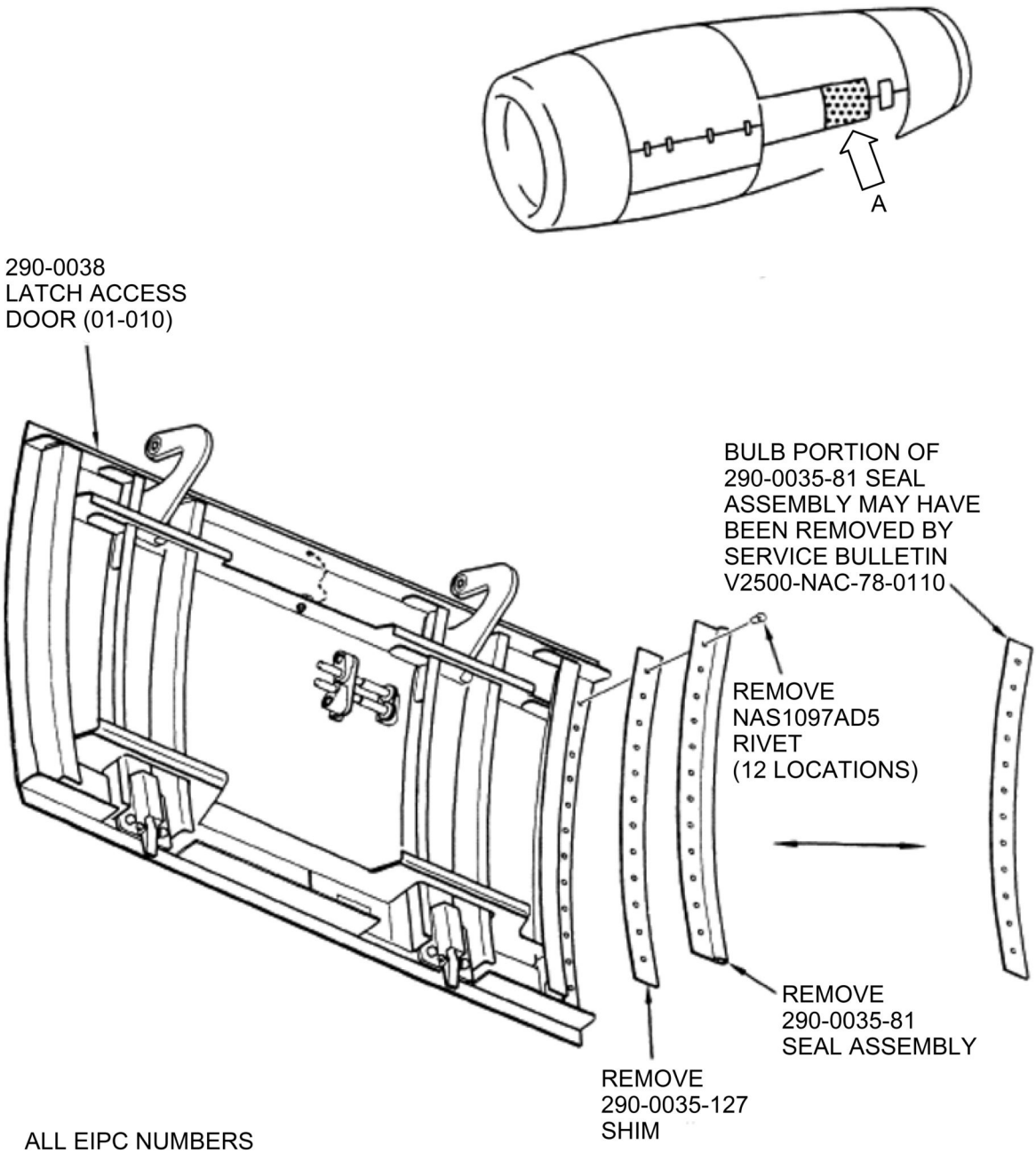
K. Check the pressure relief door closed-door latch-release load. Refer to Reference 5, AMM, TASK 78-32-09-720-801, Functional Test Of The Pressure Relief Door Latches.

3. Post-requisite Instructions

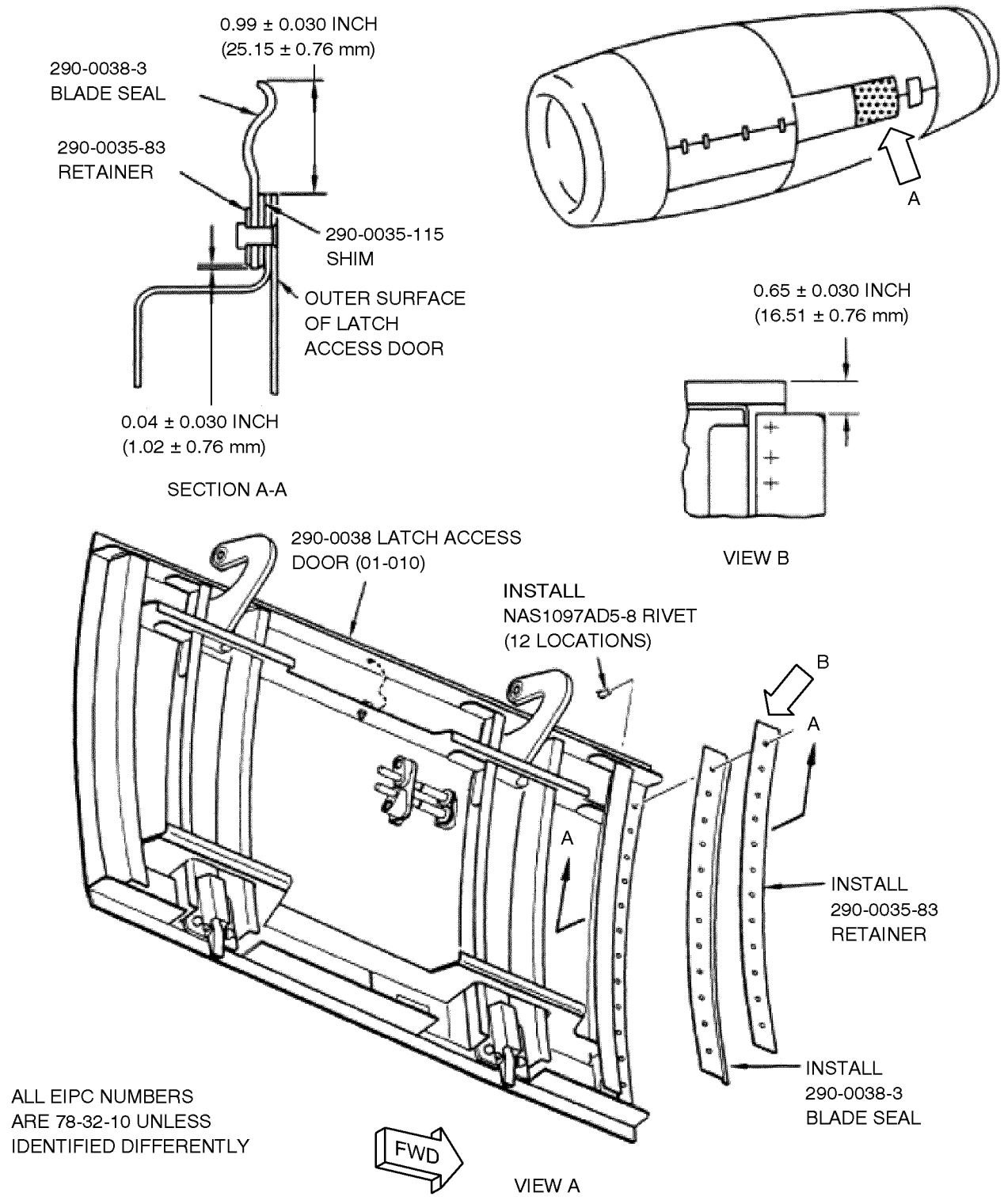
None.

4. Recording Instructions

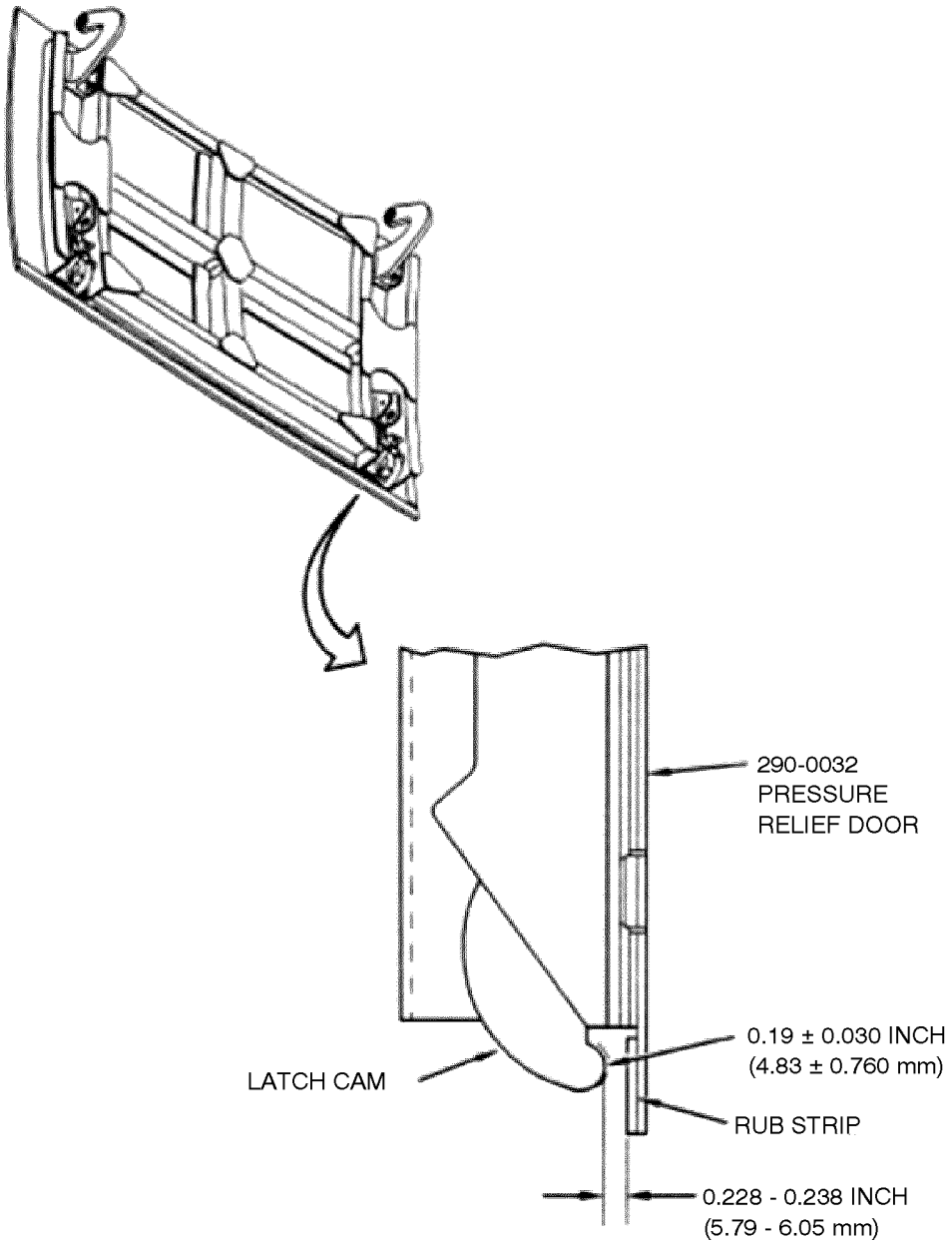
A. A record of accomplishment is necessary. Write in the engine log and metal stamp, vibroetch, or electro etch on the thrust reverser data plate that Service Bulletin V2500-NAC-78-0114 has been done. Refer to Reference 3, V2500 Standard Practices and Processes, Chapter/Section 70-09-00.



LATCH ACCESS DOOR SEAL ASSEMBLY AND SHIM REMOVAL
FIGURE 1



LATCH ACCESS DOOR BLADE SEAL AND RETAINER INSTALLATION
FIGURE 2



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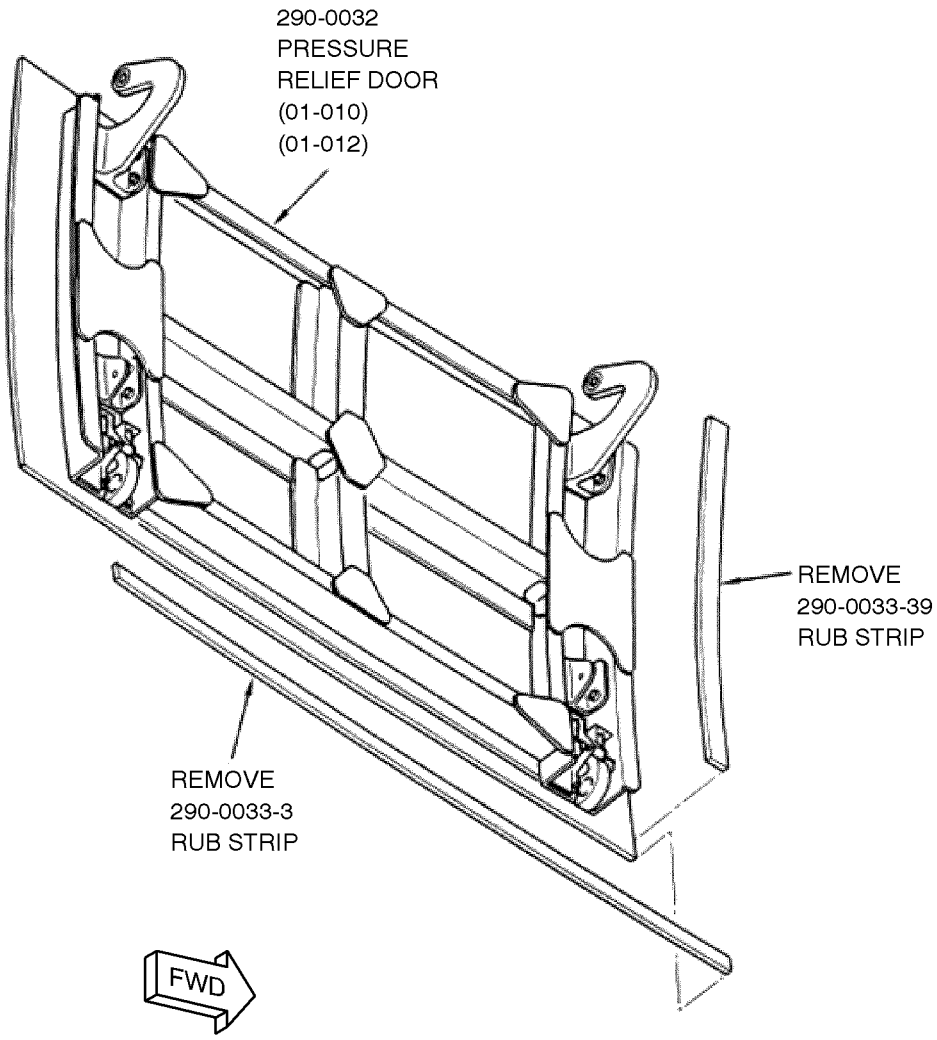
PRESSURE RELIEF DOOR ASSEMBLY LATCH CAM MODIFICATION
FIGURE 3



ALL EIPC NUMBERS
ARE 78-32-09 UNLESS
IDENTIFIED DIFFERENTLY

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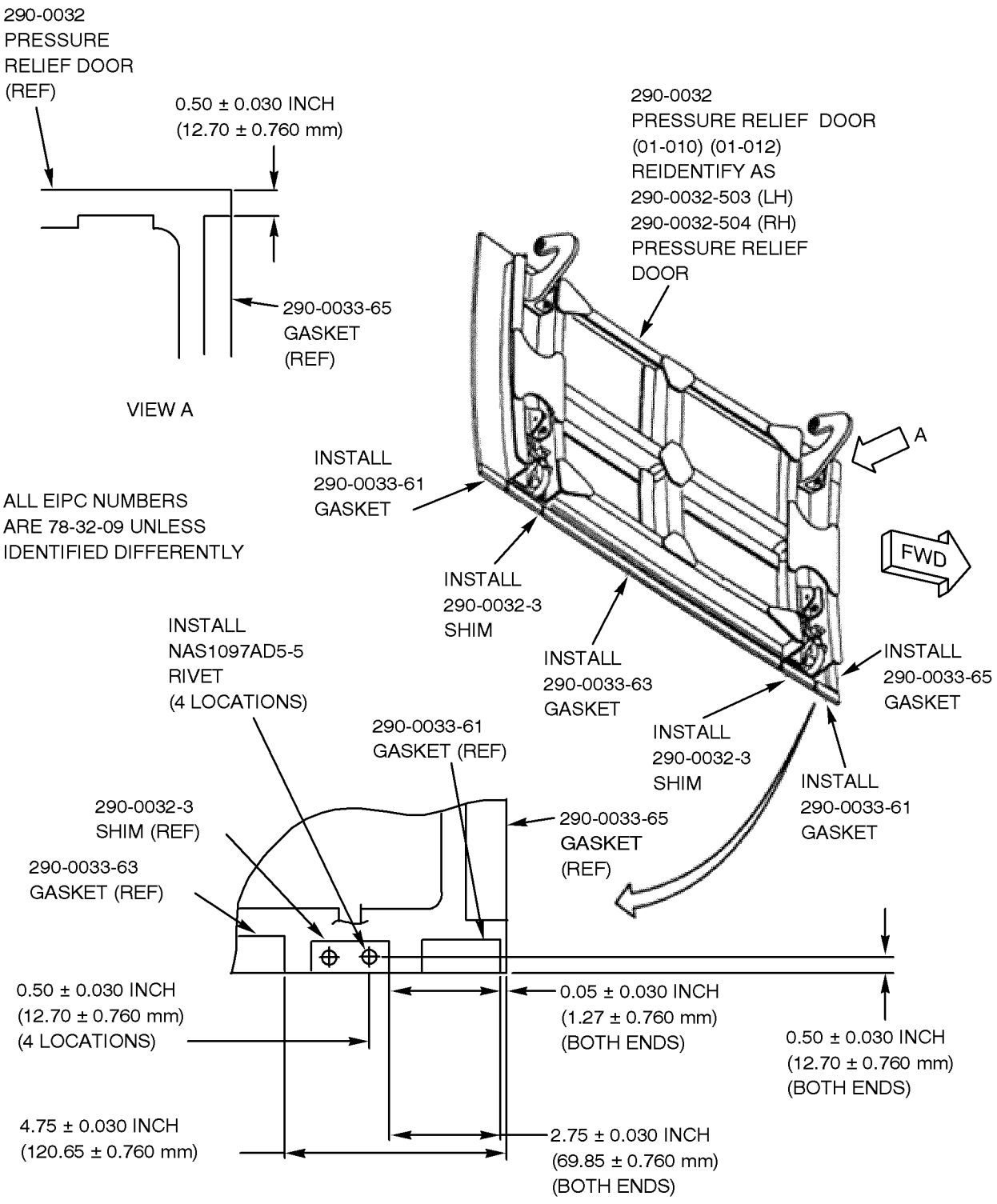
PRESSURE RELIEF DOOR ASSEMBLY RUB STRIP REMOVAL
FIGURE 4



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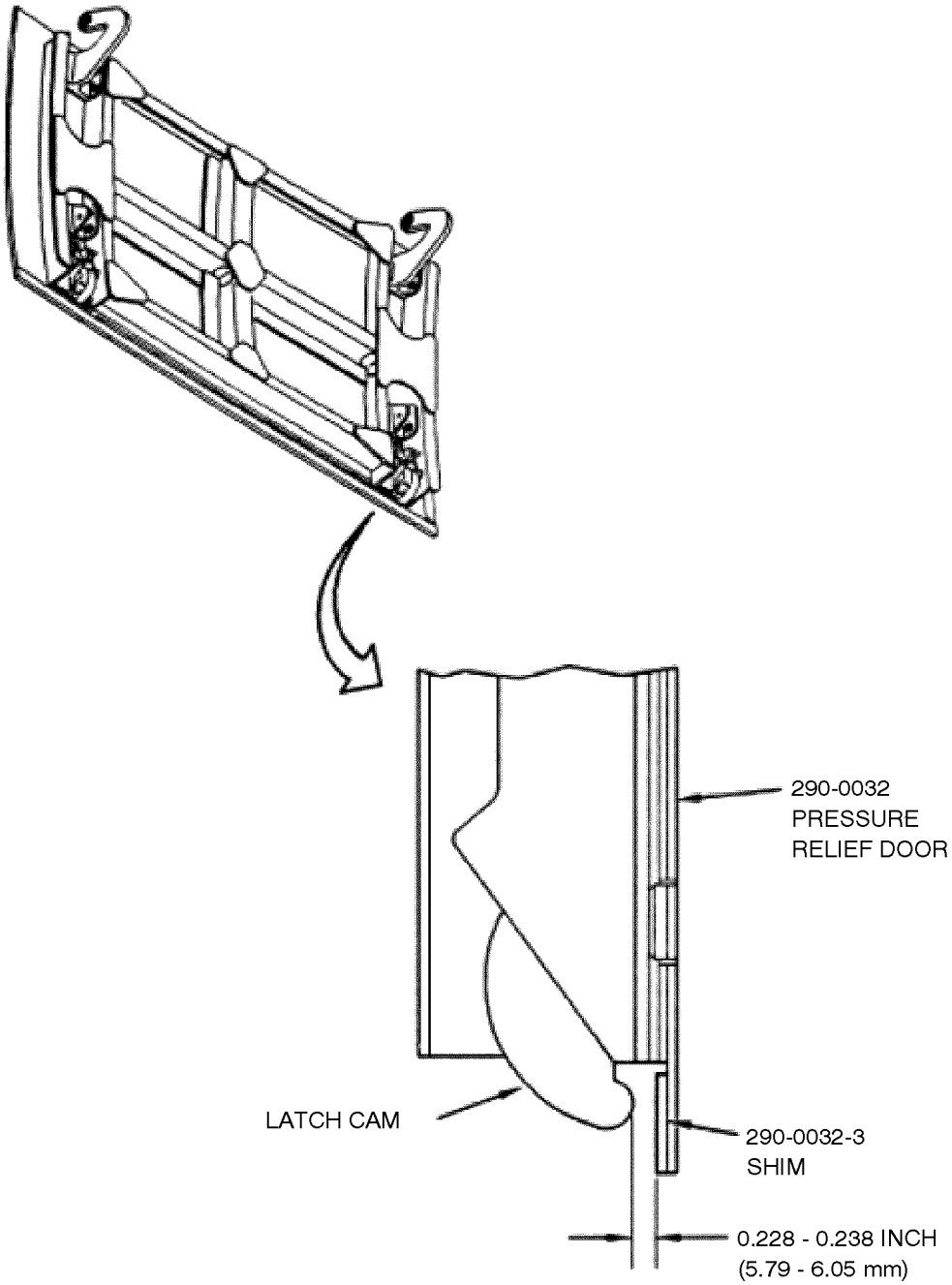
PRESSURE RELIEF DOOR ASSEMBLY SHIM AND GASKET INSTALLATION
FIGURE 5 (SHEET 1)



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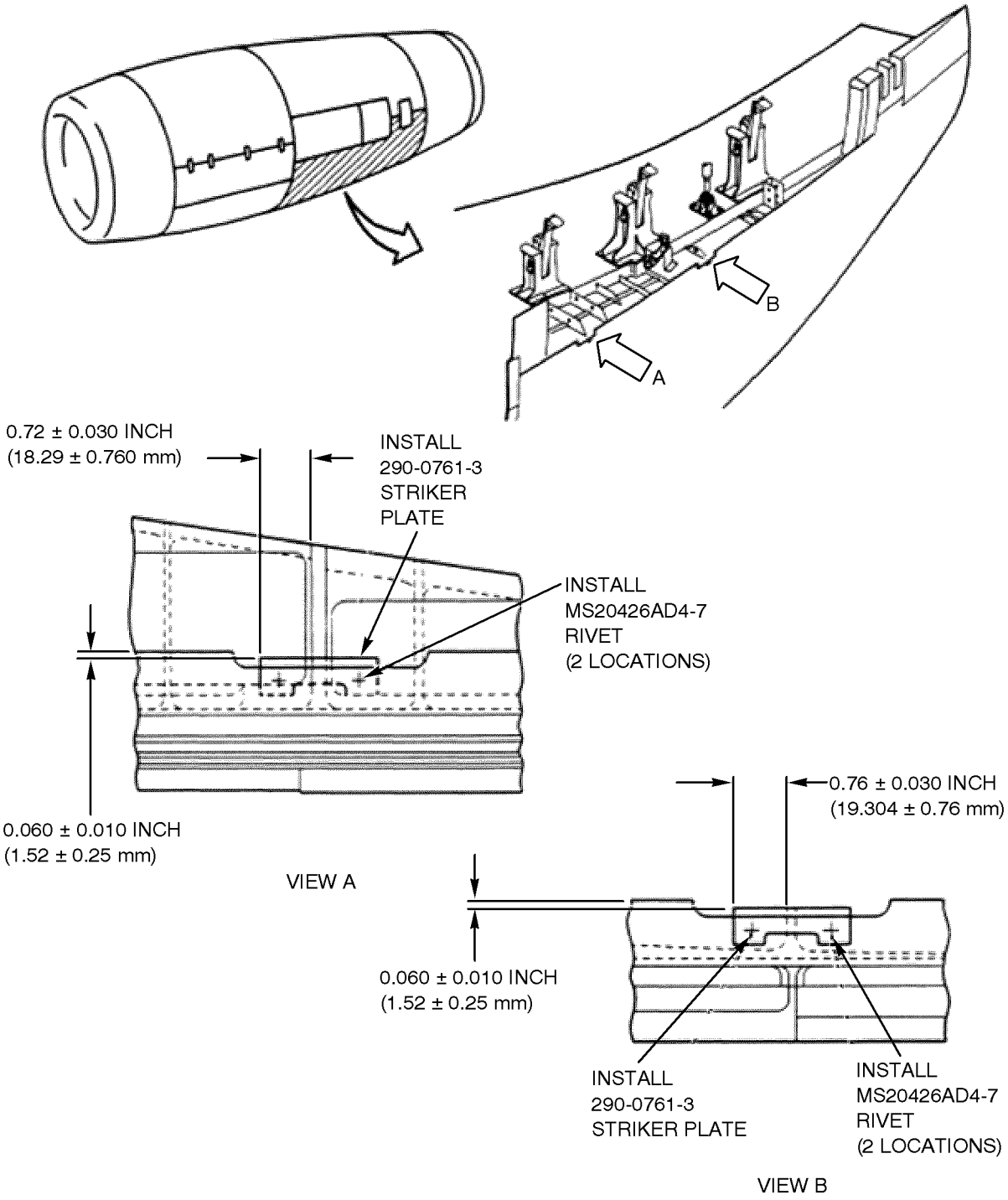
PRESSURE RELIEF DOOR ASSEMBLY SHIM AND GASKET INSTALLATION
FIGURE 5 (SHEET 2)



STRIKER PLATE INSTALLATION
FIGURE 6

Appendix

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC 95VN349	MF/RCM
1	EC 95VN349	MF/RCM
2	EC 95VN349	JG/LL
3	EC 95VN349	MF/RCM

Number values shown in parenthesis adjacent to U.S. values are System International equivalents.

NOTE: In 2014 IAE coverted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service bulletin, the following Technical Publications cross reference table is provided.

Technical Publications Cross Reference Table

Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
ENGINE MANUAL — D5	All	E-V2500-3IA	2A4416
CMM-EHC — D5	All	EHC-V2500-31A	2A4418
CMM-FN — D5	All	FN-V2500-3IA	2A4419
CMM-MMC — D5	All	MECH-V2500-3IA	2A4420
CMM-THD — D5	All	THD-V2500-3IA	2A4423
TLM — D5	All	T-V2500-3IA	2A4417

Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
SPPM (SPM) — D5	All	SPP-V2500-1IA	2A4414
EPIC — D5	V2525/V2528-AQ02	S-V2500-3IA	2A4426
	V2525/V2528-AQ03	S-V2500-3IB	
	V2525/V2528-AQ04	S-V2500-3IC	