V2500 International Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: January 22, 1997

Subject: Transmittal of Revision 1 to Service Bulletin Number V2500-NAC-78-0125

Service Bulletin Revision History:

Event	Date
Basic Issue	Apr. 12/96
Revision 1	Jan. 22/97

Reasons for Issuance of Revision

(1) To change the effectivity statement.

Effect on Past Compliance

(1) None.

List of Effective Pages:

Page No.	Rev. No.	Date
1 and 2	n	Jan. 22/97
3 thru 10	Basic	Apr. 12/96

V2500 International Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

NACELLE - EXHAUST - THRUST REVERSER LOWER CROSS TIE ASSEMBLY - MODIFICATION OF

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-32-00

Compliance Category Code

4

Internal Reference No.

LL/AC 96VN800

April 12, 1996
Revision 1 - January 22, 1997

V2500-NAC-78-0125

1. Planning Information

A. Effectivity

(1) Airplane: MD-90

(2) Nacelle: V2500-D5 thrust reverser serial numbers 0004001 through 0007001, 0009001, 0010001, 0021001 through 0089001.

B. Reason

(1) Condition

Possible interference between the hook portion of the lower cross tie assembly on the lower thrust reverser half and the upper cross tie assembly on the upper thrust reverser half may make it difficult to open the thrust reverser.

(2) Background

Operators have experienced difficulty opening the thrust reverser due to interference between the hook portion of the lower cross tie assembly and the upper cross tie assembly.

(3) Objective

Allow the thrust reverser to be opened without interference between the upper and lower cross tie assemblies.

(4) Substantiation

Testing of a modified thrust reverser lower cross tie assembly installed on a production unit was successful.

(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 lower thrust reverser half is opened and material is machined from the hook portion of the lower cross tie assembly to prevent any future interference. The bushing on the upper cross tie assembly is examined for damage and any damage found is removed.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjuction with Douglas Aircraft Company Service Bulletin MD90 78-013 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

Category 4

Accomplish at the first visit of the Nacelle or Nacelle Component to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action for the Nacelle or Nacelle Component.

F. Manpower

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

VENUE		ESTIMATED MANHOURS
(1) In Service		
(a)	To gain access	0.5 M/Hrs.
(b)	To rework	0.5 M/Hrs.
(c)	To return to service	0.5 M/Hrs.
	Total	1.5 M/Hrs.

G. Material - Cost and Availability

None.

H. Tooling - Cost and Availability

Not applicable.

I. Weight and Balance

(1) Weight change .....None

(2) Moment arm .....None

(3) Datum .....Front Engine Mount Centerline

.....(Power Plant Station (PPS) 100.0

J. Electrical Load Data

Not Applicable.

K. References

MD-90 Aircraft Maintenance Manual	78-32-00
IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)	70-09-00
Overhaul Processes/Consumable Index (PCI-V2500-1IA)	

L. Other Publications Affected

Not Applicable.

2. Accomplishment Instructions

A. Prerequisite Instructions

(1) Open the lower thrust reverser half. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-00, page block 201.

B. Rework or Modification Instructions

(1) Modify the 290-0277-503 (LH) or 290-0277-504 (RH) lower cross tie assembly. Refer to Figure 1.

(a) Machine the indicated material from the hook area of the 290-0277-503 (LH) and 290-0277-504 (RH) lower cross tie assemblies.

(2) Inspect the 290-0088-501 bushing on the 290-0276-503 (LH) or 290-0276-504 (RH) upper cross tie assembly for surface damage. If damage is found, remove the damage as instructed in paragraph B.(3). If no damage is found, go to paragraph 2.C. Post Requisite Instructions. Refer to Figure 2.

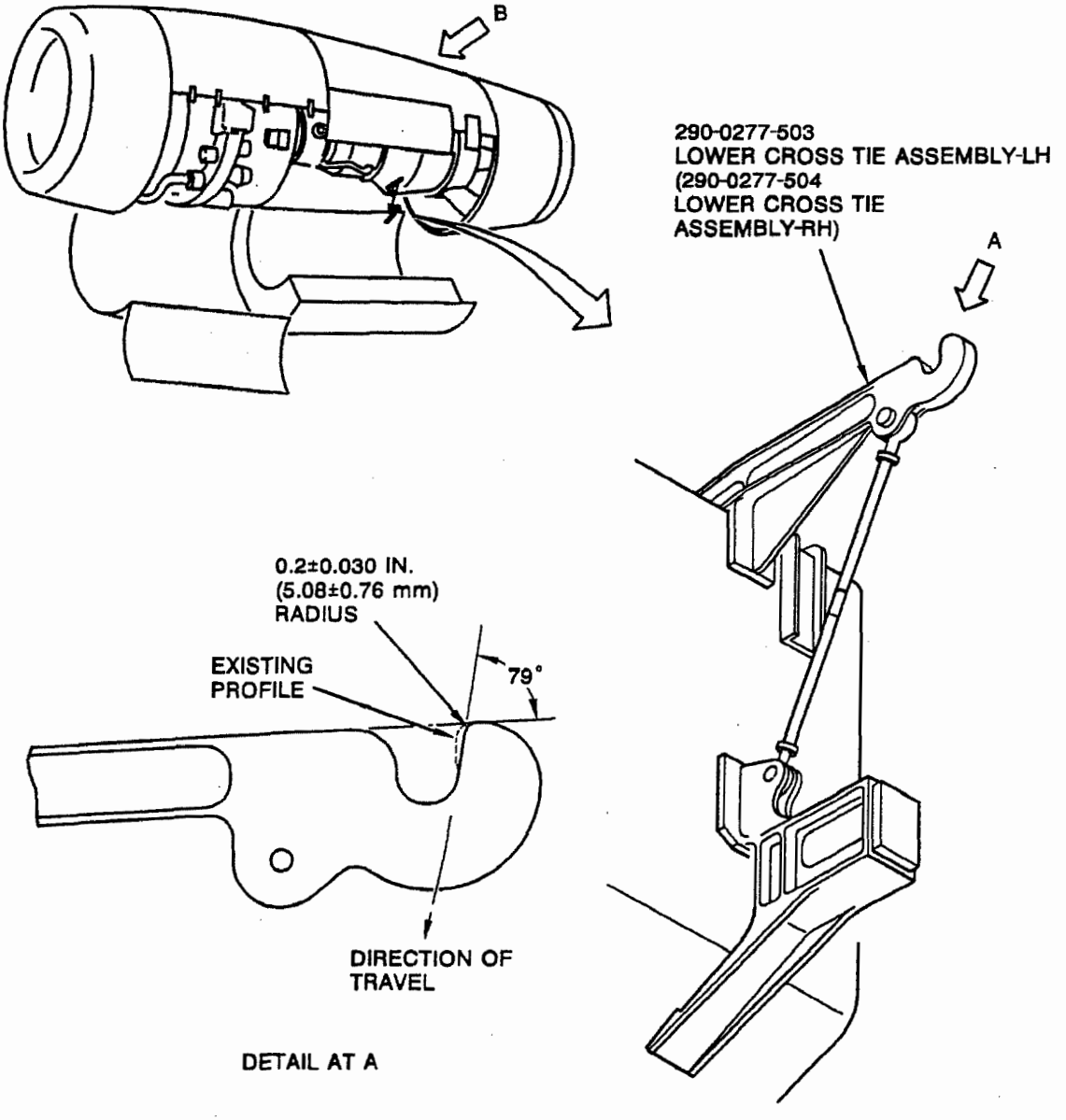
(3) Remove surface damage from the 290-0088-501 bushing. Refer to Figure 1.

(a) Remove the MS21043-6 nut, S700W0131R6H12 washer, NAS 6306U29 bolt, and 290-0088-501 bushing from the upper cross tie assembly.

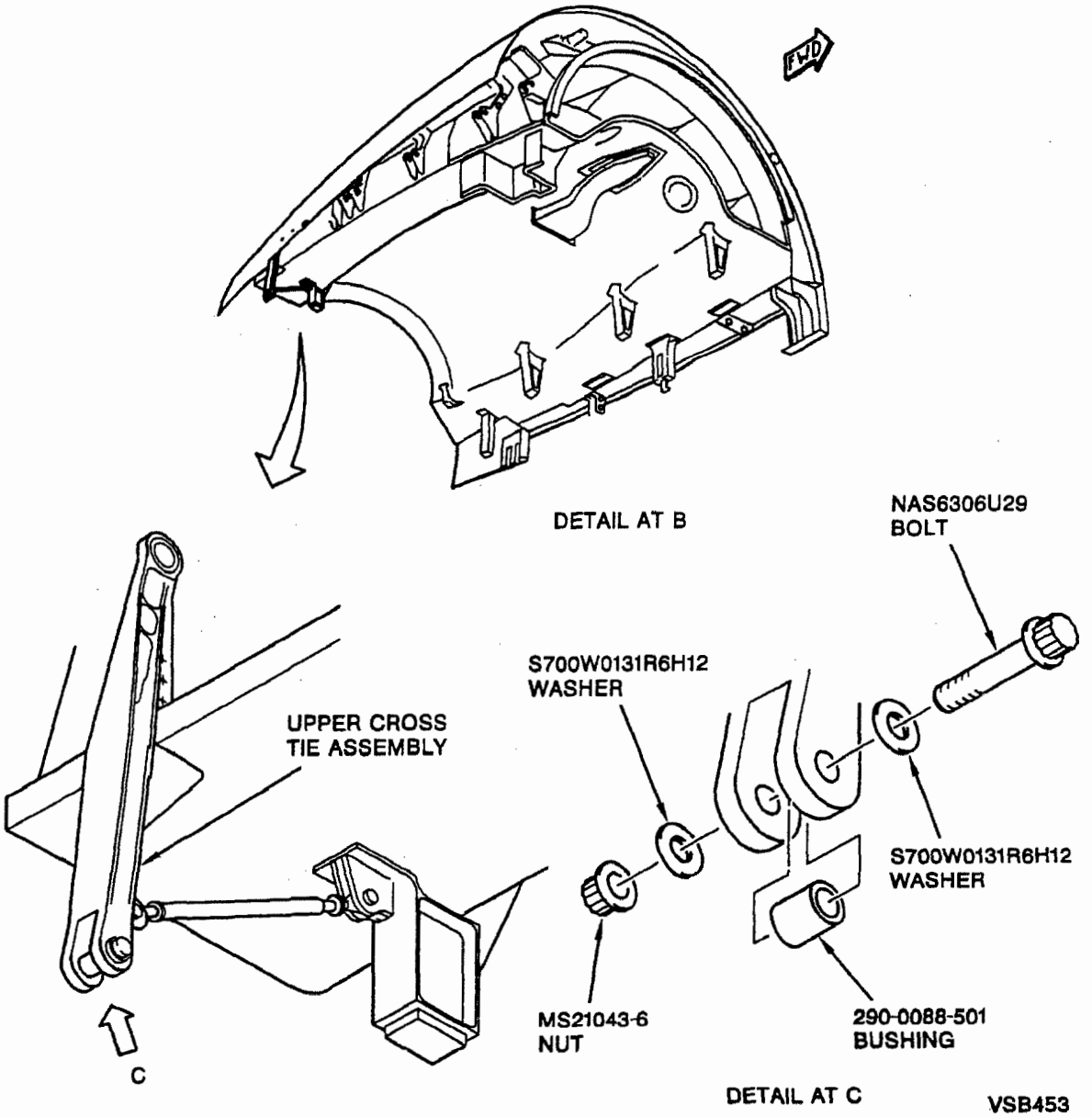
NOTE: You only need to remove the bushing if necessary for access.

(b) Remove any surface damage from the 290-0088-501 bushing with CoMat 05-082 aluminum oxide abrasive paper.

(c) Install the MS21043-6 nut, S700W0131R6H12 washer, NAS 6306U29 bolt, and 290-0088-501 bushing on the upper cross tie assembly.



Lower Cross Tie Assembly Modification/Upper Cross Tie Assembly Bushing Inspection and Damage Removal
Figure 1 (Sheet 1)



Lower Cross Tie Assembly Modification/Upper Cross Tie Assembly Bushing Inspection and Damage Removal
Figure 1 (Sheet 2)

C. Post-requisite Instructions

(1) Close the lower thrust reverser half. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-00, page block 201.

D. Recording Instructions

A record of accomplishment is necessary. Metal stamp, vibroetch, or electroetch on thrust reverser data plate that Service Bulletin V2500-NAC-78-0125 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

3. Material Information

Applicability: For each nacelle to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None.

B. Parts affected by this Bulletin:

None.

C. Materials required to incorporate this Service Bulletin

CoMat 05-082	Aluminum Oxide Abrasive Paper

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