International Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

NACELLE – EXHAUST – VENT, COOLING, SLAVE BOOSTER STAGE BLEED VALVE ACTUATOR (BSBVA) COOLING VENT, RIGHT THRUST REVERSER HALF – ADDITION OF FOR COOLING AND COMMONALITY ACROSS ALL A320/A321/A319-A5 AIRCRAFT

MODEL APPLICATION

V2500-A5

BULLETIN INDEX LOCATOR

78-32-00

Compliance Category Code

4

Internal Reference No.

JG 95VN117/A

April 27, 1998

V2500-NAC-78-0127

1. Planning Information

A. Effectivity

(1) Airplane: Airbus A320/A321

(2) Nacelle: V2500-A5 Nacelle right Thrust Reverser halves cum units (C/U) and serial numbers prior to serial number 0627001.

B. Reason

(1) Condition

Due to certification requirements on the A319 and A321-200, the Slave Booster Stage Bleed Valve Actuator (Slave BSBVA) area now requires greater cooling and incorporation is required for commonality across all A320/A321/A319-A5 aircraft.

(2) Background

Certification flight testing for the A319 and the A321-200 has resulted in a requirement for greater cooling air to the Slave BSBVA area.

(3) Objective

To supply more cooling air in the BSBVA area and maintain commonality across all A320/A321/A319-A5 aircraft.

(4) Substantiation

Flight test data has confirmed that the incorporation of this bulletin will provide the necessary ventilation.

(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 change introduced by this Bulletin is to make a vent hole and install a vent in the right thrust reverser half fixed structure.

D. Approval

The part number changes and/or part modifications described in Paragraphs 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA approved for the equipment model(s) listed.

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 component.

F. Manpower

Estimated manhours to incorporate the intent of this Bulletin on one thrust reverser:

VENUE		ESTIMATED MAN HOURS
(1) In Service		
(a) To get access		0.5 M/Hrs
(b) To rework		1.5 M/Hrs
(c) To put Nacelle to service		0.5 M/Hrs
	Total	2.5 M/Hrs

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the manufacturer as kit V2578127-551 at no cost to the operator.

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 Paragraph 3 of this service bulletin. Operators will have one year from the 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-78-0127)

NOTE: Please do not send purchase orders for kits via Spec 2000 ordering system.

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

J. Electrical Load Data

Not affected.

K. References

	Chapter/Section
A320/A321 Aircraft Maintenance Manual	78-32-00
Overhaul Processes and Consumable Index (PCI-V2500-1IA)	
IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)	70-09-00

L. Other Publications Affected

A320/V2500-A5 Engine Illustrated Parts Catalog (S-V2500-2IA)	78-32-79

2. Accomplishment Instructions

A. Pre-requisite Instructions

(1) Open the thrust reverser halves. Refer to the A320/A321 Aircraft Maintenance Manual, Chapter 78-32-00, TASK 78-32-00-010-010).

B. Rework or Modification Instructions

(1) Make a mark at the position for the 740-0550-503 vent on the right thrust reverser half as shown in Figure 1.

(a) Remove the filler from the lower edge of the blocker door fitting.

(b) Put a straight against the bottom edge of the blocker door fitting and make a mark where the straight edge meets the forward edge of the v'blade.

(c) Measure up 2.27 inches (57.66mm) from the mark made in (b) and make a mark on the forward edge of the v-blade.

(d) Perpendicular to the forward edge of the v-blade, from the mark made in (c), measure aft 4.10-4.20 inches (104.1-106.7mm) and make a mark on the panel.

(2) Use a No. 40 or smaller drill to drill a pilot hole through the panel and the heat shield. Hold a backup plate against the heat shield while you drill the hole to prevent damage to the heatshield. Make sure you drill the hole perpendicular to the surface of the panel.

(3) Remove material from the closure as shown in Figure 1 (sheet 2). Put a piece of metal between the closure and the heat shield to prevent damage to the heat shield.

(4) Cut a 1.60±0.030 inch (40.64±0.76 mm) diameter hole through both sides of the heatshield and the filler. Center the hole on the pilot hole drilled in step (2).

(5) Use a drill to make the diameter of the pilot hole 1.125-1.165 inch (28.6-29.6 mm) through the panel.

(6) Remove the honeycomb core to make a 1.75 inch (44.5 mm) diameter hole in the core.

(7) Remove any burrs from the holes as necessary.

(8) Remove metal chips and unwanted material from the panel with a vacuum cleaner.

WARNING: CLEANING SOLVENT (COMAT 01-438) IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IS 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.

(9) Use a lint free cloth (CoMat 02-099) and solvent (CoMat 01-438) to clean the areas. Wipe the surfaces dry before the solvent becomes dry.

WARNING: ADHESIVE (COMAT 08-021) 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.

(10) Prepare the adhesive (CoMat 08-021). Refer to the manufacturer's instructions.

(11) Put the adhesive (CoMat 08-021) into the hole. Leave space for the vent.

(12) Put the 740-0550-503 vent into the hole until the flange contacts the panel surface.

(13) Put adhesive (CoMat 08-021) into one vent injection hole until it comes out of the other injection holes.

(14) Cure the adhesive for 168 hours at room temperature or for two hours at 200 degrees F.

(15) Use a lint free cloth (CoMat 02-099) and solvent (CoMat 01-438) to clean around the vent and the heatshield cutout. Wipe the surfaces dry before the solvent becomes dry.

WARNING: PRIMER (CoMat 08-032) 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.

(16) Apply the primer (CoMat 08-032) to the space around the vent and the heat shield cutout edges. Allow to dry for 20 minutes.

WARNING: SEALANT (CoMat 08-030) 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.

(17) Mix the sealant (CoMat 08-030). Refer to the manufacturer's instructions.

(18) Apply sealant (CoMat 08-030) to the space between the vent and the heat shield. Make sure all edges of the heat shield cutout are covered with sealant.

(19) Reidentify the 740-0220-337 heat shield to 745-0220-9 with a rubber stamp and ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

(20) Reidentify the 740-0220-43 closure to 740-0220-7 with a rubber stamp and ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

(21) Reidentify the 745-0012-507 right fixed duct assembly as 745-0012-509. Use vibroetch or electroetch method. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

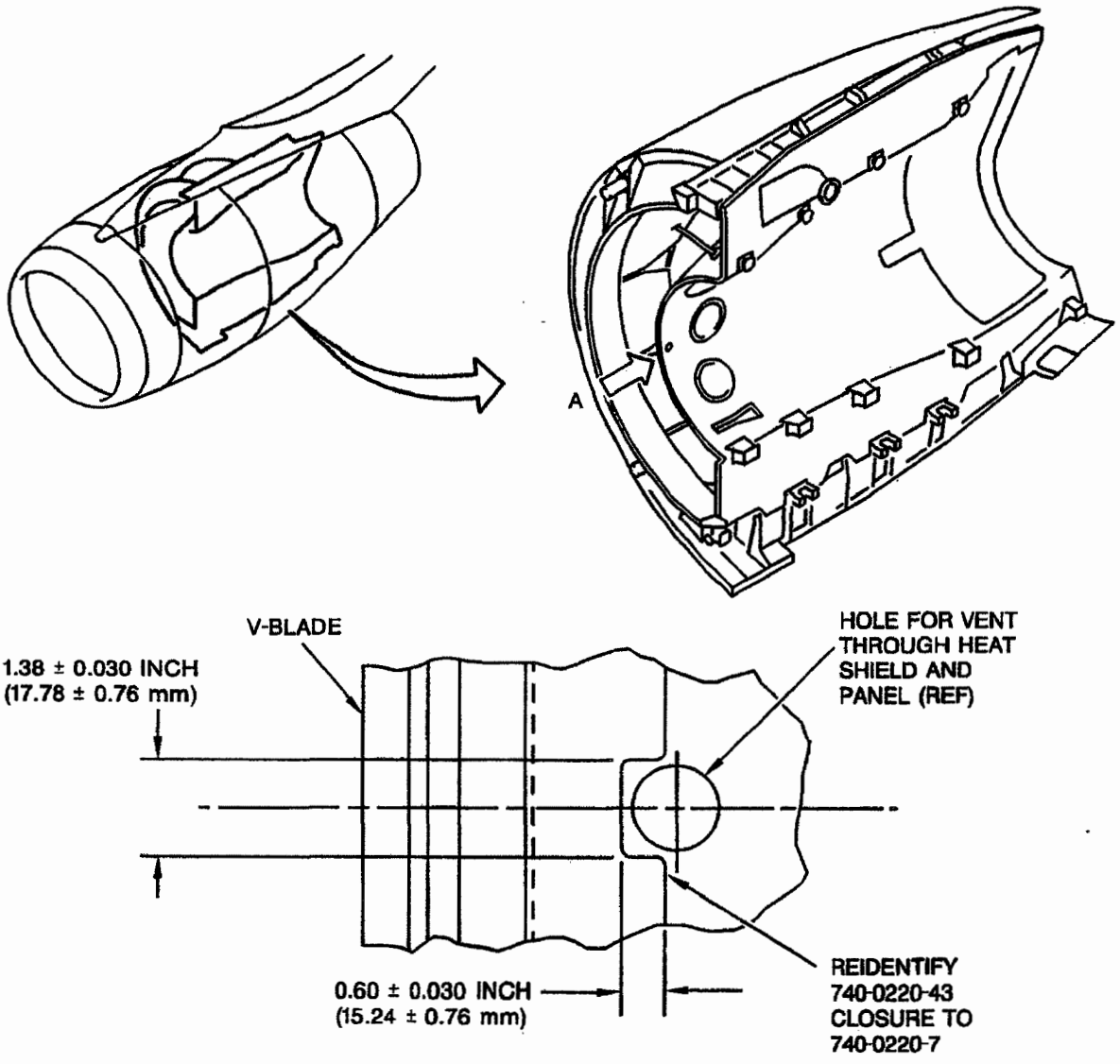
(22) Reidentify the 745-0002-503 thrust reverser assembly as 745-0002-509. Reidentify the 745-0002-507 thrust reverser assembly as 745-0002-511. Use vibroetch or electroetch method. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

C. Post-requisite Instructions

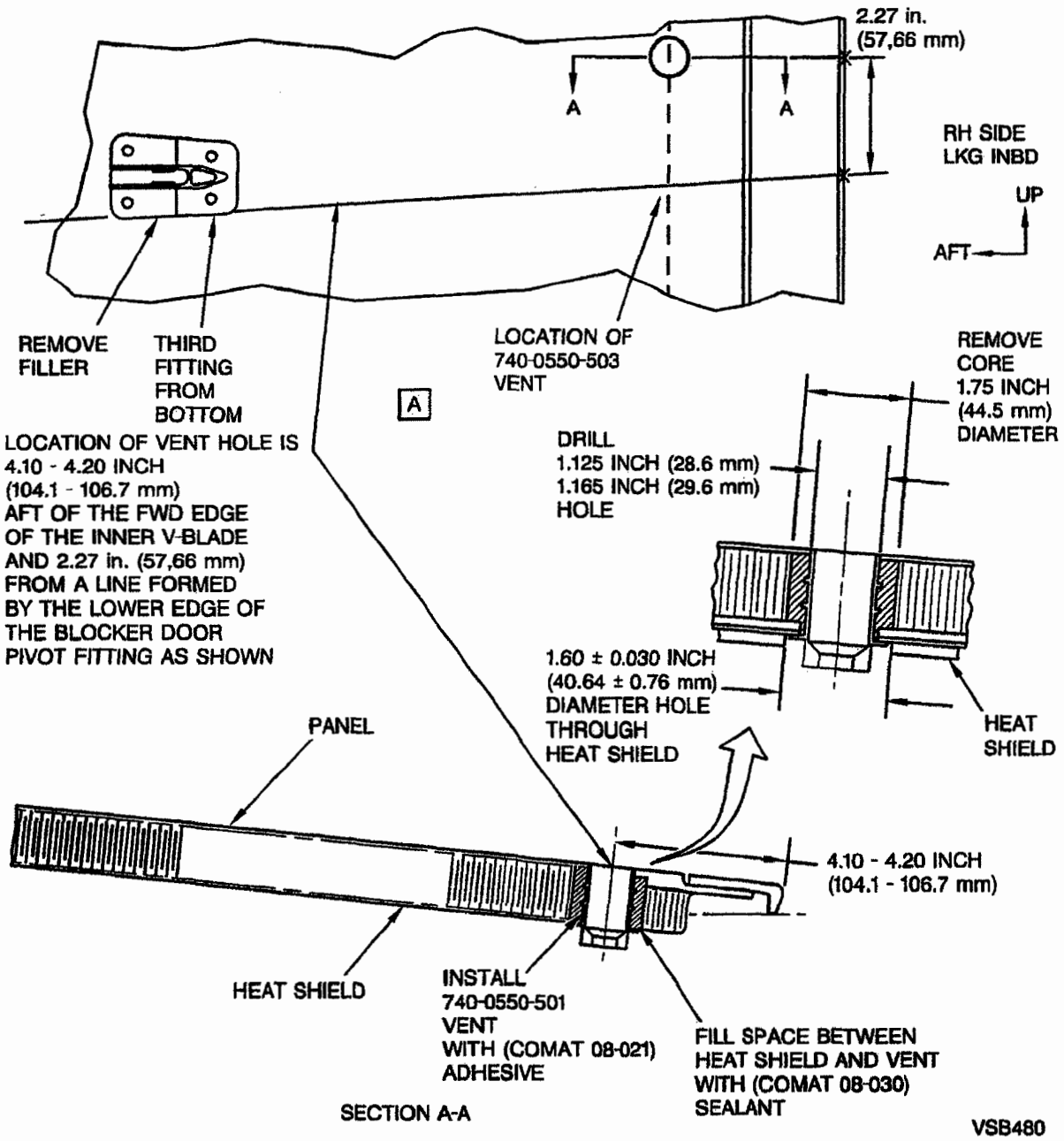
(1) Close the thrust reverser halves. Refer to the A320/A321 Aircraft Maintenance Manual, Chapter 78-32-00, TASK 78-32-00-410-010.

D. Recording Instructions

(1) A record of accomplishment is necessary. Write in the aircraft log and metal stamp, vibroetch, or electroetch on the thrust reverser data plate that Service Bulletin V2500-NAC-78-0127 has been done. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.



Right Thrust Reverser Half Modification
Figure 1 (Sheet 1)



Right Thrust Reverser Half Modification
Figure 1 (Sheet 2)

3. Material Information

Applicability: For each V2500-A5 Nacelle right thrust reverser half to incorporate this Bulletin.

A. Kits Associated with this Bulletin:

NEW PART NO. (ATA NO.)	EST'D UNIT QTY	PRICE ($)	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
V2578127-551 Consisting of:			Kit		(A)
740-0550-503	1		Vent		

B. Parts Affected by this Bulletin:

NEW PART NO. (ATA NO.)	EST'D UNIT QTY	PRICE ($)	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
745-0220-9 (78-32-79)	1		Heatshield	740-0220-337 (30-230)	(B)(C) (1D)
745-0220-7 (78-32-79)	1		Closure, Fwd	740-0220-43 (30-255)	(B)
745-0002-509 (78-32-03)	1		T/R Assy, RH	745-0002-503 (01-010)	(B)(C) (1D)
745-0002-511 (78-32-04)	1		T/R Assy, RH	745-0002-507 (01-010)	(B)(C) (1D)

C. Instruction/Disposition Code Statements

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

(A) Kit will be available TBD.

(B) New part is available.

(C) Old part will no longer be available.

D. Materials Required to Incorporate This Bulletin:

CoMat 01-076	Methylethylketone
CoMat 02-099	Lint Free Cloth
CoMat 06-073	Metal Marking Ink
CoMat 08-021	Adhesive
CoMat 08-030	Sealant
CoMat 08-032	Primer

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