

International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: June 19/96

Subject: Transmittal of Revision 1 to Service Bulletin Number
V2500-NAC-78-0128

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Apr. 12/96
Revision 1	Jun. 19/96

Reasons for Issuance of Revision

(1) To revise the instructions to allow the use of an alternate bolt.

Effect on Past Compliance

None

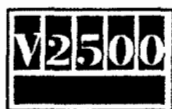
List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1	1	Jun. 19/96
2 to 5	Basic	Apr. 12/96
6 and 7	1	Jun. 19/96
8	Basic	Apr. 12/96

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Transmittal

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**NACELLE — EXHAUST — COMMON NOZZLE ASSEMBLY, STRUT ATTACH BOLT, -
REPLACEMENT OF**

MODEL APPLICATION

V2500 - D5

BULLETIN INDEX LOCATOR

78-11-00

Compliance Category Code

4

Internal Reference No.

LL/AC 96VN803

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1. Planning Information

A. Effectivity

- (1) Aircraft: MD90
- (2) Nacelle: V2500-D5 common nozzle assembly serial numbers 0021001 through 0071001.

B. Reason

(1) Condition

Due to incorrect grip length, the CNA strut attach bolts may loosen and cause damage to the thrust reverser translating sleeve.

(2) Background

Operators have experienced loose CNA strut attach bolts and damage to the thrust reverser translating sleeves.

(3) Objective

Eliminate possible loosening of CNA strut attach bolts.

(4) Substantiation

Installation of new longer bolts on a production CNA has proven 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

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(6) Supplemental Information

None.

C. Description

The four CNA strut attach bolts, two each at the top and bottom of the CNA are removed and replaced with longer grip length bolts installed with loctite.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD90 78-014 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.

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F. Manpower

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

<u>VENUE</u>	<u>ESTIMATED MANHOURS</u>
(1) In Service	
(a) To gain access	0.0 M/Hrs.
(b) To rework	0.5 M/Hrs.
(c) To return to service	<u>0.0 M/Hrs.</u>
Total	0.5 M/Hrs.

G. Material Cost and Availability

Modification kit not required. Parts supplied as single line items (Refer to Section 3, Material Information).

H. Tooling Cost and Availability

Not applicable.

I. Weight and Balance

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

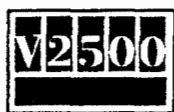
J. Electrical Load Data

Not affected.

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K. References

Chapter/Section

IAE V2500 Standard Practices/Processes
Manual

70-09-00

Overhaul Processes and Consumable Index
(PCI-V2500-1IA)

L. Other Publications Affected

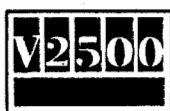
MD90/V2500D5 Common Nozzle Component
Maintenance Manual (CMM-CN-V2500-1IA)

78-11-11

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2. Accomplishment Instructions

A. Prerequisite Instructions

None.

B. Rework or Modification Instructions

- (1) Remove four NAS8704U23 CNA strut attach bolts from the top and bottom of the CNA. Refer to Figure 1.
- (2) Apply anaerobic compound sealant (loctite) (CoMat 04-008) to the threads of the four NAS8704U24 bolts.
- (3) Install the four NAS8704U24 CNA strut attach bolts in the top and bottom of the CNA. Tighten the bolts to a torque of 36-40 inlb (4-4.5 Nm). Refer to Figure 1.

NOTE: If the NAS8704U24 bolts are too long, re-install the NAS8704U23 bolts with the anaerobic compound sealant (loctite) (CoMat 04-008) as instructed in steps (2) and (3).

C. Post-requisite Instructions

None.

D. Recording Instructions

A record of accomplishment is necessary. Write in the applicable records and metal stamp, vibroetch, or electroetch on the common nozzle assembly data plate that Service Bulletin V2500-NAC-78-0128 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

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REMOVE
NAS8704U23
BOLT
INSTALL
NAS8704U24
BOLT
(4 PLACES)

NOTE: IF THE NAS8704U24 BOLTS ARE TOO LONG, REINSTALL THE NAS8704U23 BOLTS.

STRUT

COMMON
NOZZLE
ASSEMBLY

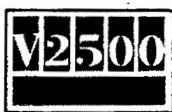
VSB456

CNA Strut Attach Bolt Replacement
Figure 1

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3. Material Information

Applicability: For each V2500-D5 common nozzle assembly to incorporate this Bulletin.

A. Kits Associated with this Bulletin:

None.

B. Parts Affected by this Bulletin:

NEW PART NO. (ATA NO.)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
NAS8704U24 (78-11-11)	4	\$40.00	Bolt	NAS8704U23 (05-310)	(A)(1D)

C. Instruction/Disposition Code Statements

(A) New part is currently available.

(1D) Old part may be used on other aircraft installations.

NOTE: The estimated 1996 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the Rohr Price Catalog or contact Rohr's Customer Support Department for information concerning firm prices.

D. Materials Required to Incorporate this Service Bulletin:

CoMat 04-008 Anaerobic Compound Sealant

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

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