



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: October 30, 1997

Subject: Transmittal of Revision 1 to Service Bulletin Number V2500-NAC-78-0141

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jun. 10/97
Revision 1	Oct. 30/97

Reasons for Issuance of Revision

(1) To change the item number references in the Material Information section.

Effect on Past Compliance

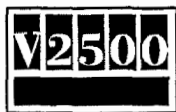
(1) None.

List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1	1	Oct. 30/97
2 thru 9	Basic	Jun. 10/97
10 and 11	1	Oct. 30/97

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Transmittal
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**NACELLE — EXHAUST - ACTUATION SYSTEM HARNESS RE-ROUTE AND
CLIPPING POINT HARDWARE REPLACEMENT**

MODEL APPLICATION

V2500 - D5

BULLETIN INDEX LOCATOR

78-32-00

Compliance Category Code

4

Internal Reference No.

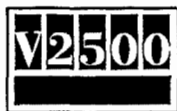
MM/JG 97VN805

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1. Planning Information

A. Effectivity

- (1) Aircraft: MD90
- (2) Nacelle: V2500-D5 left hand lower thrust reverser half serial numbers 0021001 thru 0244001.

B. Reason

(1) Condition

Interference may exist between the left hand lower thrust reverser half actuation system harness and the fuel flow meter mounted on the engine fan case.

(2) Background

Operators have experienced wear to the left hand lower thrust reverser half actuation system harness, P/N 6A6460, caused by interference with the engine fuel flow meter.

(3) Objective

Revise routing and clamping of the LH harness to eliminate possible interference and wear to components.

(4) Substantiation

Not applicable.

(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

Part 1

Inspect the harness for interference with the fuel flow meter. Re-routing of the harness and installation of new clamp attach hardware should be done, whether or not interference is found, as directed in Part 2 of this Service Bulletin

Part 2

Re-route the actuation system harness and install new clamp attach hardware at the appropriate clipping point.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD-90-78-022 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

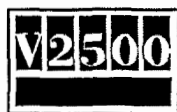
Category 4

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:

VENUE

ESTIMATED MANHOURS

Part 1

(1) In Service

(a)	To gain access	0.25 M/hr
(b)	To examine hardware for wear	0.25 M/hr
(c)	To return to service	<u>0.25 M/hr</u>
Total		0.75 M/hr

Part 2

(1) In Service

(a)	To gain access	0.25 M/hr
(b)	To rework	0.50 M/hr
(c)	To return to service	<u>0.25 M/hr</u>
Total		1.00 M/hr

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NOTE: After incorporation of this modification, a maximum of 1.75 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.
850 Lagoon Drive
Chula Vista, CA. 91910-2098
U.S.A.
Attn: Airline Support Manager, MZ 107A
Warranty Department
(Ref. Service Bulletin V2500-NAC-78-0141)

G. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the supplier as kit V578141-551, 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 specify this Service Bulletin number and only the parts listed herein. Operators will have one year from the issue date of this Service Bulletin to place an order. After one year, kits will no longer be available at no charge. After that date, Operators will have to 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: Manager, Spares Operations -Warranty, MZ 107A
(Ref. Service Bulletin No. V2500-NAC-78-0141)

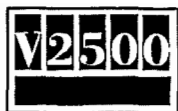
H. Tooling Cost and Availability

Not applicable.

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I. Weight and Balance

- (1) Weight change No effect
- (2) Moment arm No effect
- (3) Datum Front Engine Mount Centerline
..... (Power Plant Station (PPS) 100.00)

J. Electrical Load Data

Not affected.

K. References

Chapter/Section

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

L. Other Publications Affected

V2500/M90 Engine Illustrated Parts Catalog (S-V2500-3IA)	78-33-12
V2500/M90 Thrust Reverser Component Maintenance Manual (CMM-TR-V2500-3IA)	78-33-12

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2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) Open the left hand lower fan cowl door. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 71-13-00, page block 201.

B. Part 1 - Examine the left hand lower thrust reverser actuation system harness, P/N 6A6460, near the engine fuel flow meter.

- (1) If the actuation harness interferes with the fuel flow meter or if there is wear on either the harness or the fuel flow meter, you must inspect for damage/wear and then perform Part 2 of this Service Bulletin. Refer to Figure 1.
- (2) If the harness has damage/wear, contact the local IAE representative for disposition.

C. Part 2 - Revise the left hand lower thrust reverser actuation system harness clipping point attach hardware.

- (1) Remove the TA027029-05 clamp, TA027029-02 clamp, two NAS1057T3-050 spacers, and S700B1327-3D22 bolt from the clipping point. Discard the clamps, spacer and bolt. Keep the washers and nuts for installation. Refer to Figure 1.
- (2) Re-route the branch of the harness removed from the lower inboard discarded TA027029-05 clamp and install both branches of the harness into the TA027029-06 clamp (outboard position).
- (3) Install the S700B1327-3D14 bolt, NAS1057T3-060 spacer, and TA027029-06 clamp at the clipping point. Torque the bolt to 50-70 inch-pounds (5.6 -7.9 Nm).

D. Post-requisite Instructions

- (1) Close the left hand lower fan cowl door. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 71-13-00, page block 201.

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E. Recording Instructions

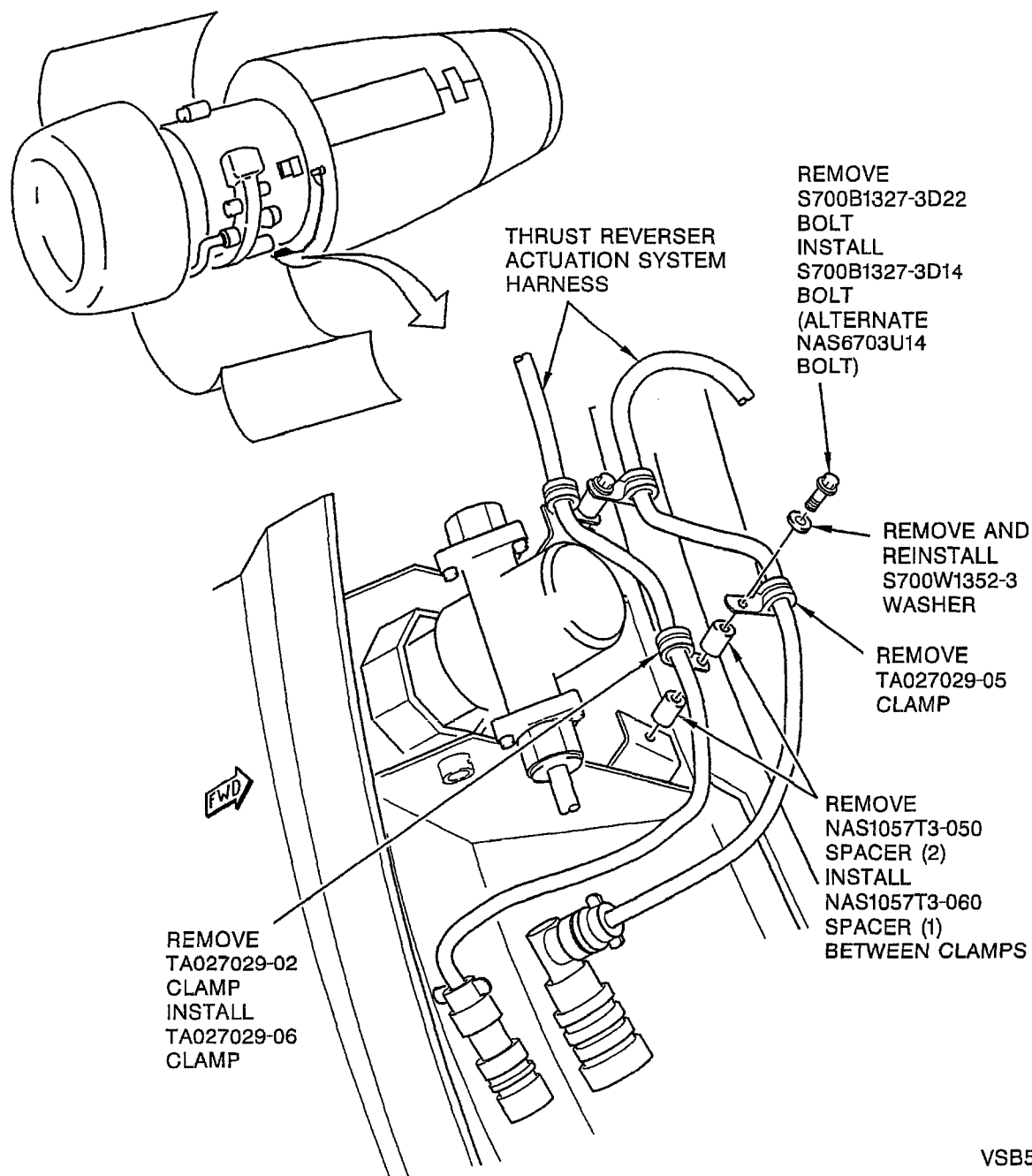
A record of accomplishment is necessary. Write in the applicable records and metal stamp, vibroetch, or electroetch on the thrust reverser data plate that Service Bulletin V2500-NAC-78-0141 has been done. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

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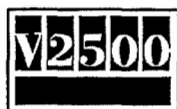
VSB545A

Re-route T/R Actuation Harness & Replace Attach Hardware
Figure 1

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3. Material Information

Applicability: For each V2500-D5 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>
V2578141-551	1		Kit		(A)
Consisting of:					
NAS1057T3-060	1		Spacer		
TA027029-06	1		Clamp		
S700B1327-3D14	1		Bolt		
(NAS6703U14)					

B. Parts affected by 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>
TA027029-02 (78-33-12)	1		Clamp	TA027029-02 (02-013)	(B)
--- (78-33-12)	1		Clamp	TA027029-05 (02-016)	
--- (78-33-12)	2		Spacer	NAS1057T3-050 (02-018)	
--- (78-33-12)	1		Bolt	S700B1327-3D22 (02-022)	
TA027029-06 (78-33-12)	1		Clamp	--- (02-023)	(S1)

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NEW PART NO (ATA NO)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO (IPC NO)	INSTR/ DISPOS
NAS1057T3-060 (78-33-12)	1		Spacer	--- (02-024)	(S1)
S700B1327-3D14 (78-33-12)	1		Bolt	--- (02-025)	(S1)
NAS6703U14 (78-33-12)	REF		Bolt (Alternate)	--- (02-025)	(S1)

C. Instruction/Disposition Code Statements

(A) Kit will be available July 15, 1997.

(B) Quantity changed from 2 to 1 at this location.

(S1) Parts coded (S1) must be installed in complete sets.

NOTE: The estimated 1997 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

None.

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