



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

**NACELLE — POWERPLANT — STOWAGE, STOW LOCKOUT PIN, THRUST REVERSER —
MODIFICATION OF**

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-00-00

Compliance Category Code

6

Internal Reference No.

JG/LL 96VN327

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1. Planning Information

A. Effectivity

- (1) Airplane: MD90
- (2) Nacelle: V2500-D5 thrust reverser serial numbers 0021001 thru 0491001.

B. Reason

(1) Condition

The latest configuration thrust reverser dummy stow lockout plug does not fit in the stowage area on the latch access door.

(2) Background

The hole in the stowage area on the latch access door is not large enough for the latest configuration of dummy stow lockout plug.

(3) Objective

Make the hole in the stowage area on the latch access door large enough for the latest configuration of dummy stow lockout plug.

(4) Substantiation

Not applicable.

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(5) Impact of the 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 as follows:

Remove the stow lockout pins and plugs. Make the hole in the stowage area larger. Install the stow lockout pins and plugs.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD-90-78-023 which has received exclusive FAA approval for MD-90 Series aircraft.

E. Compliance

Category 6

Accomplish when the nacelle subassembly (i.e. accessories, components) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

F. Manpower

Not applicable.

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G. Material Cost and Availability

None. Parts are available as single line items.

H. Tooling Cost and Availability

None required.

I. Weight and Balance

(1) Weight change None

(2) Moment arm No effect

(3) Datum Engine Front Mount Centerline
.....(Powerplant Station PPS 185.00)

J. Electrical Load Data

Not affected.

K. Reference

Chapter/Section

IAE V2500 Standard Practices/Processes
Manual (SPP-V2500-1IA)

70-09-00

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

L. Other Publications Affected

None

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2. Accomplishment Instructions

A. Pre-requisite Instructions

NOTE: There are two interchangeable latch access door configurations. One is assembled of many parts and is shown in Figure 1, Sheet 1. The other is machined from one piece of material and is shown in Figure 1, Sheet 2. The Service Bulletin Accomplishment Instructions are the same for both latch access door configurations.

- (1) Remove the bolts, the stow lockout pins, and stow lockout plugs from the latch access door. Refer to Figure 1.

B. Rework or Modification Instructions

- (1) Make the holes 0.562-0.572 inch (14.27-14.53 mm) in diameter. Remove the burrs from the holes. Refer to Figure 1.

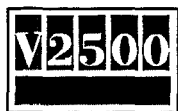
WARNING: SOLVENT (COMAT 01-438) IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (2) Clean all modified areas with a clean lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surfaces dry before the solvent becomes dry.

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WARNING: CONVERSION COATING (COMAT 07-106) IS CLASSIFIED AS A HAZARDOUS MATERIAL AND 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.

- (3) Apply conversion coating (CoMat 07-106) to the exposed aluminum surfaces. Refer to the manufacturer's instructions.

WARNING: PRIMER CONVERTER (COMAT 07-115), THINNER (COMAT 07-116), AND PRIMER BASE (COMAT 08-093) ARE CLASSIFIED AS HAZARDOUS MATERIALS AND 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 SHEETS" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (4) Mix the primer converter (CoMat 07-115), thinner (CoMat 07-116), and primer base (CoMat 08-093). Refer to the manufacturer's instructions.
- (5) Apply the primer mix to the exposed aluminum surfaces. Allow the primer to dry. Refer to the manufacturer's instructions.

C. Post-requisite Instructions

- (1) Install the stow lockout pins, stow lockout plugs, and bolts on the latch access door. Torque the bolts to 20-25 lbfin (2-3 Nm). Refer to Figure 1.

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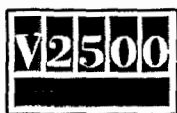
D. Recording Instructions

- (1) A record of accomplishment is necessary. Write in the applicable records and metal stamp, electroetch, or vibroetch on the thrust reverser data plate that Service Bulletin V2500-NAC-78-0142 has been done. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

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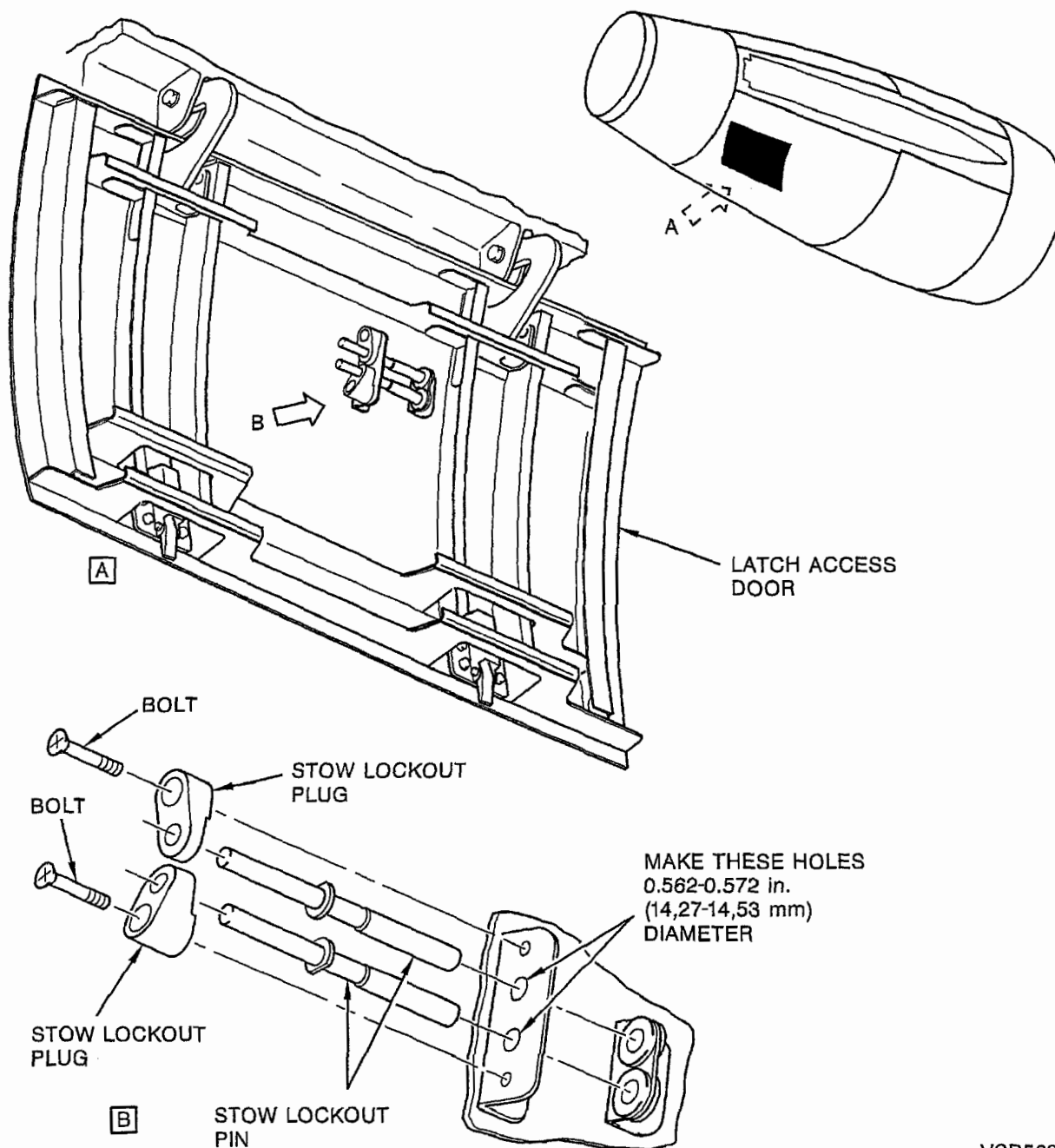
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VSB563

Latch Access Door Stow Lockout Pin and Plug Stowage Modification
Figure 1 (Sheet 1)

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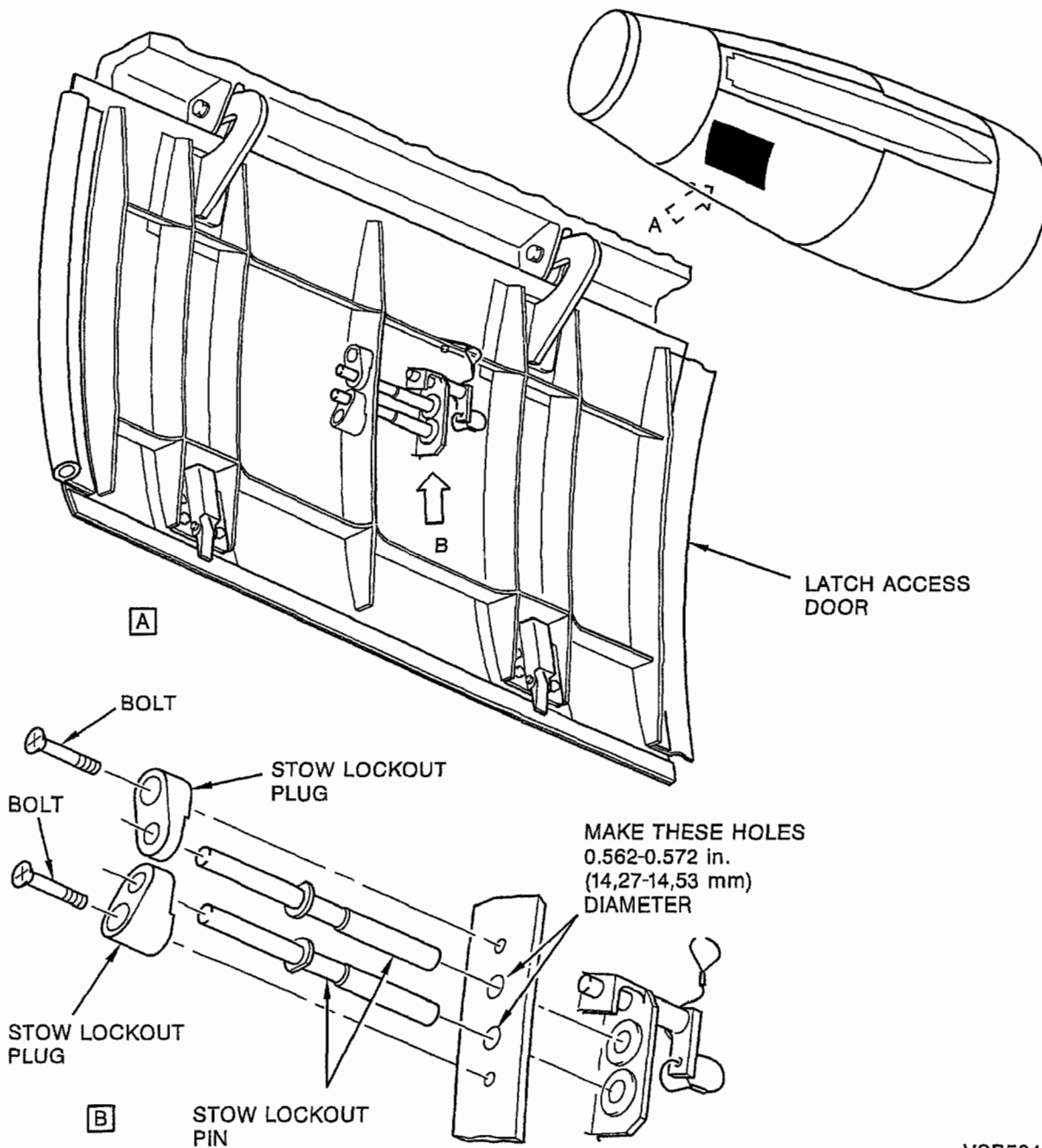
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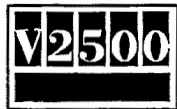
VSB564

Latch Access Door Stow Lockout Pin and Plug Stowage Modification
Figure 1 (Sheet 2)

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3. Material Information

Applicability: For each V2500-D5 Nacelle to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None.

B. Parts affected by this Bulletin:

None.

C. Instructions/Disposition Code Statements:

None.

D. Materials Required to Incorporate This Service Bulletin:

CoMat 01-438 Solvent

CoMat 02-099 Lint free cloth

CoMat 06-073 Metal marking ink

CoMat 07-106 Chromate conversion coating 1000 for aluminum

CoMat 07-115 Primer converter

CoMat 07-116 Thinner

CoMat 08-093 Primer base

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

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