

IAE Propulsion System NON-MODIFICATION SERVICE BULLETIN

Date: August 8, 2000

Subject: Transmittal of Revision 2 to Service Bulletin Number V2500-NAC-78-0151

Service Bulletin Revision History:

| <u>Event</u> | <u>Date</u> |
|--------------|-------------|
| Basic Issue | Jan. 22/99 |
| Revision 1 | Jun. 21/99 |
| Revision 2 | Aug. 08/00 |

Reasons for issuance of Revision:

- (1) While the technical intent of this service bulletin has not changed, it has been revised for the following reasons:
- (a) To change the effectivity statement to indicate that thrust reversers with serial numbers lower than 0693001 need the entire service bulletin while those with serial numbers 0693001 and higher need only the latch access door portion of the service bulletin.
 - (b) To add instructions for determining whether you must do service bulletin V2500-NAC-78-0175 before you do this service bulletin.
 - (c) To add modification instructions for thrust reversers to which service bulletin V2500-NAC-78-0175 has been done.
 - (d) To change the service bulletin kit number from V2578151-551 to V2578151-553.
 - (e) To add part numbers to the "Parts Affected by this Bulletin" list.

Effect on Past Compliance:

(1) None.

NOTE: If repair VRS2643 has been done to a thrust reverser, you will need striker plates without pilot holes for that thrust reverser. If your service bulletin kit does not have striker plates without pilot holes, please submit a purchase order for 290-0761-9 striker plates without pilot holes to the address specified on page 5 of this service bulletin.

List of Effective Pages:

| <u>Page No.</u> | <u>Rev No.</u> | <u>Date</u> |
|-----------------|----------------|-------------|
| 1 thru 20 | 2 | Aug. 08/00 |

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Transmittal
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V2500 Propulsion System - Nacelle
SERVICE BULLETIN

NACELLE - THRUST REVERSER – DOOR, LATCH ACCESS AND LOWER OUTBOARD TRACK
BEAM - MODIFICATION OF

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-00-00

Compliance Category Code

4

Internal Reference No.

JG 97VN325/B

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NACELLE - THRUST REVERSER – DOOR, LATCH ACCESS AND LOWER OUTBOARD TRACK BEAM - MODIFICATION OF

1. Planning Information

A. Effectivity

(1) Aircraft

(a) Boeing MD90

(2) Nacelle

(a) V2500-D5 thrust reverser with serial numbers lower than 0693001 require Paragraphs 2.A., 2.B., 2.C , 2.D. (or 2.E.), and 2.G. of this service bulletin.

(b) V2500-D5 thrust reversers with serial numbers 0693001 and higher, require Paragraphs 2.C. and 2.G. of this service bulletin.

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B. Concurrency Recommendations

It is recommended, for convenience, service bulletin V2500-NAC-78-0167 be done at the same time as this service bulletin.

C. Reason

(1) Condition

The latch access door striker land of the lower thrust reverser outboard track beam can be damaged by the latch striker. This can result in inadvertent opening of the latch access door in flight.

(2) Background

Several operators have experienced inadvertent opening of the latch access door in flight. This has been determined to be the result of damage to the track beam latch access door striker land caused by the latch striker.

(3) Objective

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Install a new latch on the latch access door and modify the track beam latch striker land to prevent damage caused by the latch access door latch striker and subsequent inadvertent opening of the latch access door in flight.

(4) Substantiation

Stress analysis has shown the new latch design to be airworthy by similarity to the previous design and by the increase in strength produced with the change in striker land area from aluminum to steel.

(5) Impact of Bulletin on Workshop Procedures:

| | | |
|-----|----------------------|--------------|
| (a) | Removal/Installation | Not Affected |
| (b) | Disassembly/Assembly | Not Affected |
| (c) | Cleaning | Not Affected |
| (d) | Inspection/Check | Not Affected |
| (e) | Repair | Not Affected |
| (f) | Testing | Not Affected |

D. Description

- (1) If repair VRS2643 was performed, the repair parts are removed.

NOTE: If repair VRS2643 has been done, you will need striker plates without pilot holes. If your service bulletin kit does not have striker plates without pilot holes, please submit a purchase order for striker plates without pilot holes to the address specified on page 5 of this service bulletin.

- (2) The track beam is examined for damage, and, if necessary, service bulletin V2500-NAC-78-0175 is done.
- (3) The latch access door latches are removed and new latches installed.
- (4) The seal on the lower edge of the latch access door is removed and replaced with a new seal.
- (5) Steel latch striker plates are installed on the aluminum track beam assembly.

E. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Boeing Service Bulletin MD90 78-031 which has received exclusive FAA approval for MD-90 Series aircraft.

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F. 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.

G. Manpower

| <u>VENUE</u> | | <u>ESTIMATED MANHOURS</u> |
|--------------|----------------------|---------------------------|
| (1) | In Service | |
| (a) | To gain access | 0.5 M/Hrs. |
| (b) | To rework | 6.0 M/Hrs. |
| (c) | To return to service | <u>0.5 M/Hrs.</u> |
| | Total | 7.0 M/Hrs. |
| (2) | In Shop | |
| (a) | To Rework | <u>6.0 M/Hrs</u> |
| | Total | 6.0 M/Hrs |

NOTE: Labor hours are provided for planning purposes only. No labor reimbursement is provided under the terms of this service bulletin offering.

H. Material Cost and Availability

- R The parts to accomplish this service bulletin are available from the supplier as kit V2578151-553 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 the service bulletin to place an order. After one year, kits will no longer be available and operators will have to order parts individually at catalog prices, if they desire to incorporate the change:

Direct Purchase order to:
Rohr, Inc.
850 Lagoon Drive

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Chula Vista, CA 91910-2098
U.S.A.

Attn: Airline Account Manager – MZ 107A
(Ref. Service Bulletin No. V2500-NAC-78-0151)

NOTE: Please do not submit orders for service bulletin kits via Spec 2000 ordering system.

I. Tooling - Cost and Availability

None required.

J. Weight and Balance

| | | |
|-----|---------------|---|
| (1) | Weight change | None |
| (2) | Moment arm | No effect |
| (3) | Datum | Engine Front Mount Centreline (Powerplant Station PPS 100.0) |

K. Electrical Load Data

Not affected.

L. References

| <u>Manual</u> | <u>Chapter/Section</u> |
|--|------------------------|
| MD90 Aircraft Maintenance Manual | 78-32-10 |
| IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA) | 70-09-00 |
| Overhaul Processes and Consumable Index (PCI- V2500-1IA) | |
| MD90 SRM | 54-30-03 |

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M. Other Publications Affected

Manual

Chapter/Section

MD90/V2500D5 Thrust Reverser Component
Maintenance Manual (CMM-TR-V2500-3IA)

78-32-10
78-32-23

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2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) If repair VRS2643 has been done, remove the rivets and striker plates from the latch access door notches on the lower outboard track assembly.

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NOTE: If repair VRS2643 has been done, you will need striker plates without pilot holes. If your service bulletin kit does not have striker plates without pilot holes, please submit a purchase order for 290-0761-9 striker plates without pilot holes to the address specified on page 5 of this service bulletin.

R B. Determine if it is necessary to do Service Bulletin V2500-NAC-78-0175.

- (1) Open the thrust reverser latch access door.
- (2) Find the two notches for the latch access door latches on the lower outboard track assembly. Refer to Figure 1.
- (3) Remove any sharp edges from the outboard track assembly in the area of the latch access door notches.

WARNING: SOLVENT (COMAT 01-438) 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 RECOMMENDATIONS.

- (4) Clean the track beam in the area of the notches with solvent (CoMat 01-438) and a lint free cloth (02-099). Wipe the surfaces dry before the solvent becomes dry.
- (5) Examine the track beam in the area of the notches for damage. Refer to Figure 1.

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- (a) If the damage is within the limits in Figure 1, you do not need to do service bulletin V2500-NAC-78-0175. Go to Paragraph 2.C.
- (b) If the damage is larger than the limits shown in Figure 1, you must do service bulletin V2500-NAC-78-0175 before you continue with this service bulletin.

C. Replace the latch access door latches and the seal on the lower edge of the latch access door.

- (1) Remove the latch access door. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-10, page block 401.

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NOTE: The following procedure is the same for the left hand nacelle and right hand nacelle latch access door.

- (2) Remove the fasteners and latches from the latch access door. Refer to Figure 2.
- (3) Remove the seal from the lower edge of the latch access door.

WARNING: SOLVENT (COMAT 01-438) 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 RECOMMENDATIONS.

- (4) Clean the latch and seal mounting surfaces of the latch access door with a lint free cloth (CoMat 02-099) and solvent (01-438). Wipe the surface dry before the solvent becomes dry.

WARNING: CONVERSION COATING (COMAT 07-028) 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 RECOMMENDATIONS.

- (5) If bare metal was exposed on the latch access door when you removed the latches and/or seal, apply conversion coating (CoMat 07-028) to the area of bare metal. Refer to the manufacturer's instructions.

WARNING: CATALYST (COMAT 07-139), EPOXY PRIMER (COMAT 07-140), AND THINNER (07-144) ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH 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 SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH RECOMMENDATIONS.

- (6) Mix the catalyst (CoMat 07-139), epoxy primer (CoMat 07-140), and thinner (CoMat 07-0144). Refer to the manufacturer's instructions.
- (7) Apply primer to the bare metal on the latch access door
- (8) Cure the primer. Refer to the manufacturer's instructions.

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- (9) Hold the shims and the latches on the pressure relief door assembly. Refer to Figure 2.
- (10) Measure and make a note of the distance between the latch access door latch cam and the inner surface of the latch access door. Remove the laminations from the shims as necessary to make the distance the same as shown in Figure 2.
- (11) Put the shims in place on the latch access door and back drill the fastener holes through the shims. Remove the burrs from the drilled holes.
- (12) Install the shims and latches on the latch access door with the fasteners. Wet install the fasteners with primer mix. Refer to Figure 2.
- (13) Clean the surface of the latch access door where the seal will be installed with a lint free cloth (CoMat 02-099) and solvent (CoMat 01-438). Wipe the surface 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 RECOMMENDATIONS.

- (14) Mix the primer (CoMat 08-032). Refer to the manufacturer's instructions.
- (15) Apply a thin layer of primer (CoMat 08-032) to the area of the door where you will install the S700S1552-1 seal. Refer to the manufacturer's instructions. Allow the primer to dry for 30 minutes minimum before you apply the adhesive (08-119).

WARNING: ADHESIVE (COMAT 08-119) 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 RECOMMENDATIONS.

- (16) Apply a uniform layer of adhesive (CoMat 08-119), 10 to 30 mils thick, to the mating surface of the S700S1552-1 seal.
- (17) Install the S700S1552-1 seal on the latch access door. Let the adhesive cure for 2 hours before you put the latch access door into service. Heat will not speed the cure of the adhesive.



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- (18) Re-identify the latch access door as follows:

| New Part Number | Old Part Number |
|-----------------|-----------------|
| 290-0003-1V | 290-0003-3S |
| 290-0003-2V | 290-0003-4S |
| 290-0038-513 | 290-0038-511 |
| 290-0038-514 | 290-0038-512 |

Use a rubber stamp and black ink (CoMat 06-073). Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.

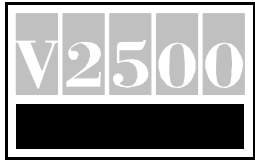
NOTE: The 290-0003-3S and -4S part numbers for the “skin-and-stringer door are post-service bulletin V2500-NAC-78-0167.

- (19) Repair the external paint on the latch access door assembly. Refer to the MD-90 Structural Repair Manual, Chapter 54-30-03, External Paint Repair VRS2404.
- (20) Install the thrust reverser latch access door. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-10, page block 401.

- D. For thrust reversers that do not have service bulletin V2500-NAC-787-0175 – Install the latch access door striker plates on the lower outboard track assembly.

NOTE: For thrust reversers without service bulletin V2500-NAC-78-0175, follow the instructions in paragraph 2.D. For thrust reversers with service bulletin V2500-NAC-78-0175, follow the instructions in paragraph 2.E.

- (1) Find the notches on the lower outboard track assembly. Refer to Figure 3.
- (2) If necessary, at the forward notch, remove material from the heat shield to make space for the shim and striker plate.
- (a) Remove material from the heat shield to make space for the shim and striker plate.
- (b) Clean the edges of the modified heat shield areas with a lint free cloth (CoMat 02-099) and solvent (CoMat 01-438). Wipe the surfaces dry before the solvent becomes dry.



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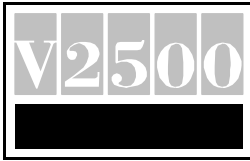
WARNING: PRIMER (COMAT 08-032) IS CLASSIFIED AS A HAZARDOUS MATERIAL WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH RECOMMENDATIONS.

- (c) Apply primer (CoMat 08-032) to the modified areas of the heat shield. Refer to the manufacturer's instructions. Allow the primer to dry for 30 minutes minimum before you apply the adhesive (08-030).

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 RECOMMENDATIONS.

- (d) Mix the sealant (CoMat 08-030). Refer to the manufacturer's instructions.
 - (e) Seal between the edges of the heat shield and the track beam surface with sealant (CoMat 08-030).
 - (f) Cure the sealant. Refer to the manufacturer's instructions.
- (3) Hold the shims and latch access door striker plates on the lower outboard track assembly behind the notches as shown in Figure 3.
 - (4) Measure and make a note of the distance between the outer surface of the track assembly and the inboard surface of the striker plates. Remove laminations from the shims as necessary to make the distance the same as shown in Figure 3.
 - (5) Hold the shims and striker plates on the track assembly and drill the fastener holes. Remove the burrs from the drilled holes.

NOTE: If repair VRS2643 has been done, back drill the fastener holes in the shims and striker plates through the existing holes in the track assembly.



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NOTE: If repair VRS2643 has been done, you will need striker plates without pilot holes. If your service bulletin kit does not have striker plates without pilot holes, please submit a purchase order for 290-0761-9 striker plates without pilot holes to the address specified on page 5 of this service bulletin.

- (6) On the outer surface of the lower outboard track assembly, and the striker plates, countersink the drilled holes to a diameter of 0.128-0.134 inch (3,251-3,404 mm) x 100 degrees.
- (7) Clean the track assembly and striker plates with a lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surface dry before the solvent becomes dry.
- (8) Apply conversion coating (CoMat 07-028) to the clean, bare aluminum surfaces of the track assembly. Refer to the manufacturer's instructions.
- (9) Apply primer to the treated surfaces of the track assembly.
- (10) Cure the primer. Refer to the manufacturer's instructions.

WARNING: ADHESIVE (COMAT 08-078) 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 RECOMMENDATIONS.

- (11) Mix the adhesive (CoMat 08-078). Refer to the manufacturer's instructions.
- (12) Apply a thin layer of adhesive (CoMat 08-078) to the mating surfaces of the shims and the track assembly.
- (13) Install the shims and 290-0761-9 striker plates on the lower outboard track assembly with rivets. Wet install the rivets with adhesive (CoMat 08-078). Install the rivets double flush.
- (14) Cure the adhesive (CoMat 08-078). Refer to the manufacturer's instructions.
- (15) Make sure the distance between the outer surface of the track assembly and inboard surface of the striker plate is the same as shown in Figure 3 after you install the rivets. If necessary, remove material from the striker plate to get the proper dimension.
- (16) Apply primer to both ends of the MS20426AD4-7 rivets installed on the lower outboard track assembly.
- (17) Cure the primer. Refer to the manufacturer's instructions.



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(18) Make sure the latch access door opens and closes properly.

(19) Go to paragraph 2.G.

R E. For thrust reversers that have service bulletin V2500-NAC-78-0175 – Install the latch access door
R striker plates on the lower outboard track assembly fittings.

R NOTE: For thrust reversers without service bulletin V2500-NAC-78-0175, follow the instructions
R in paragraph 2.D. For thrust reversers with service bulletin V2500-NAC-78-0175, follow
R the instructions in paragraph 2.E.

R (1) Hold the shims and latch access door striker plates on the lower outboard track assembly fitting
R as shown in Figure 4.

R (2) Measure and make a note of the distance between the outer surface of the track assembly
R fittings and the inboard surface of the striker plates. Remove laminations from the shims as
R necessary to make the distance the same as shown in Figure 4.

R (3) Hold the shims and striker plates on the track assembly fittings and drill the fastener holes.
R Remove the burrs from the drilled holes.

R (4) On the outer surface of the lower outboard track assembly fittings and the striker plates,
R countersink the drilled holes to a diameter of 0.128-0.134 inch (3,251-3,404 mm) x 100
R degrees.

R (5) Clean the track assembly fittings and striker plates with a lint free cloth (CoMat 02-099) made
R moist with solvent (CoMat 01-438). Wipe the surface dry before the solvent becomes dry.

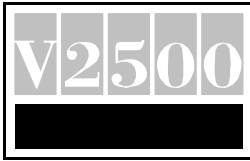
R WARNING: ADHESIVE (COMAT 08-078) IS CLASSIFIED AS A HAZARDOUS MATERIAL
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R RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY
R READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW
R ALL LISTED SAFETY AND HEALTH RECOMMENDATIONS.

R (6) Mix the adhesive (CoMat 08-078). Refer to the manufacturer's instructions.

R (7) Apply a thin layer of adhesive (CoMat 08-078) to the mating surfaces of the shims and the
R track assembly fittings.

R (8) Install the shims and 290-0761-9 striker plates on the lower outboard track assembly fittings
R with rivets. Wet install the rivets with adhesive (CoMat 08-078). Install the rivets double flush.
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R (9) Cure the adhesive (CoMat 08-078). Refer to the manufacturer's instructions.



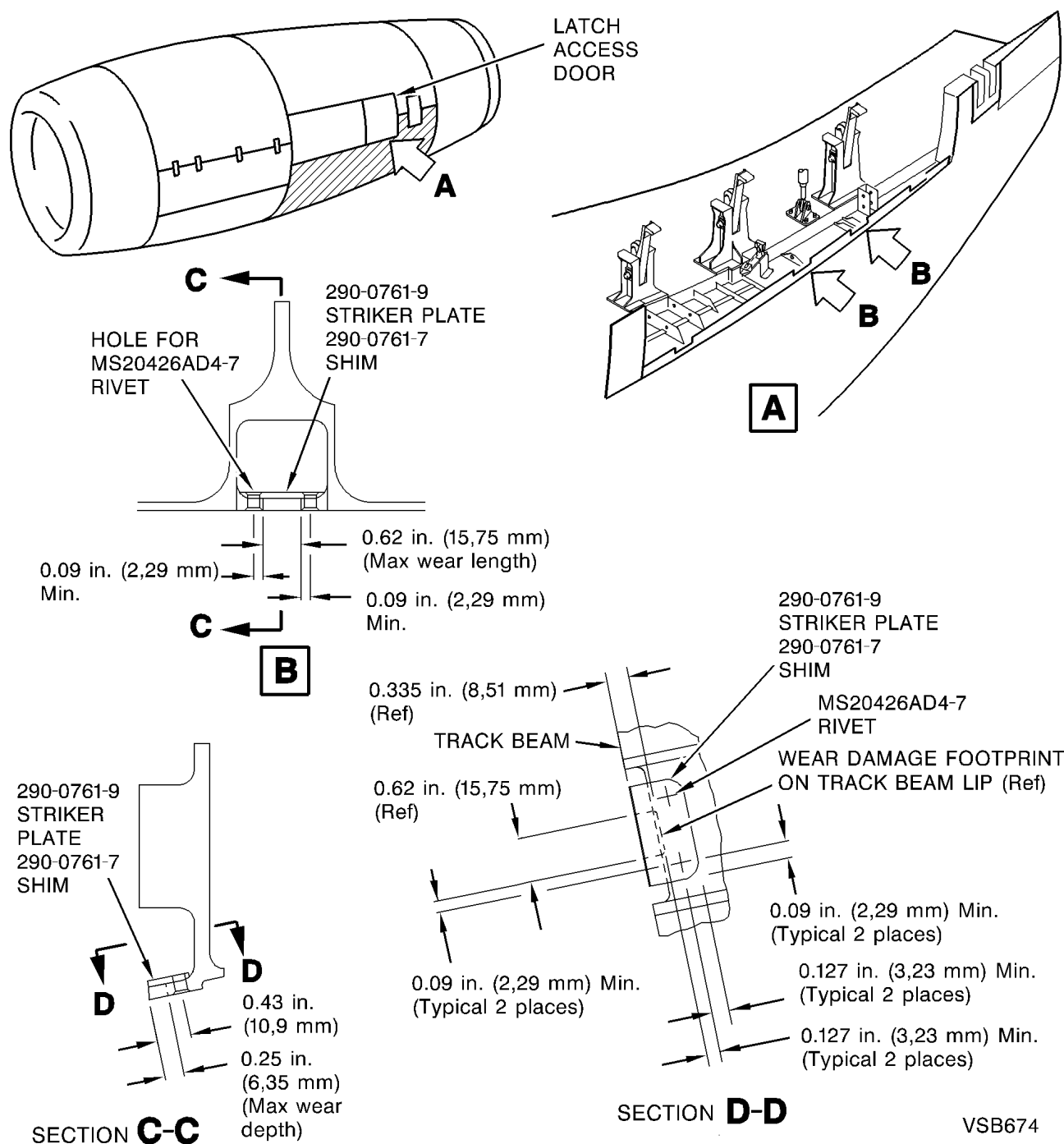
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- R (10) Make sure the distance between the outer surface of the track assembly fittings and inboard
R surface of the striker plate is the same as shown in Figure 4 after you install the rivets. If
R necessary, remove material from the striker plate to get the proper dimension.
- R (11) Apply primer to both ends of the MS20426AD4-7 rivets installed on the lower outboard track
R assembly fitting.
- R (12) Cure the primer. Refer to the manufacturer's instructions.
- R (13) Make sure the latch access door opens and closes properly.
- R (14) Go to paragraph 2.G.
- R F. Post-requisite instructions
- R None.
- R G. Recording Instructions

A record of accomplishment is necessary. Write in the applicable records and metal stamp, vibroetch, or electro etch on the thrust reverser assembly data plate that Service Bulletin V2500-NAC-78-0151 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.



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Lower Outboard Track Beam Door Land Inspection
Figure 1

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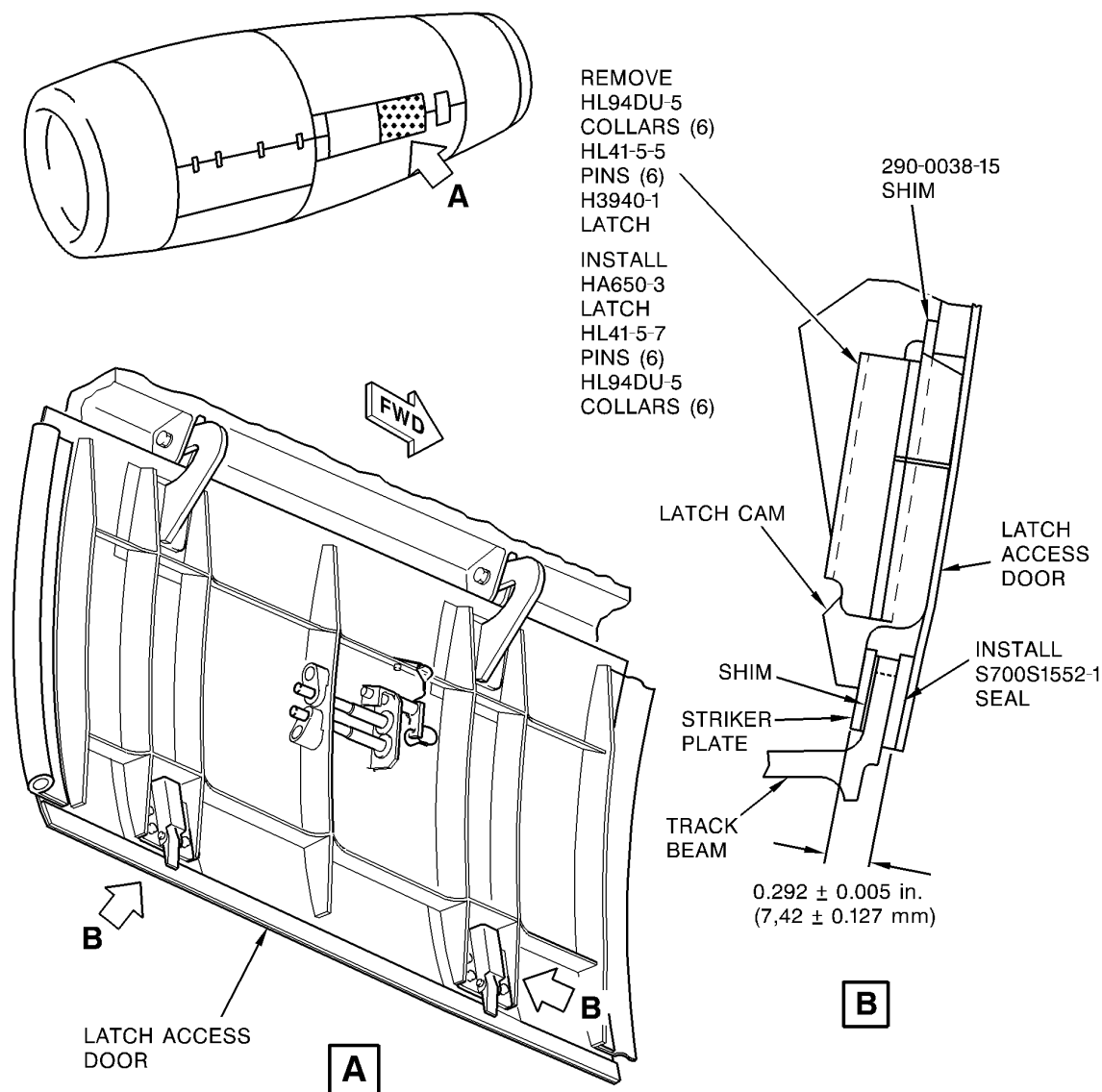
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VSB626

Latch Access Door Latch Replacement and Seal Installation
Figure 2

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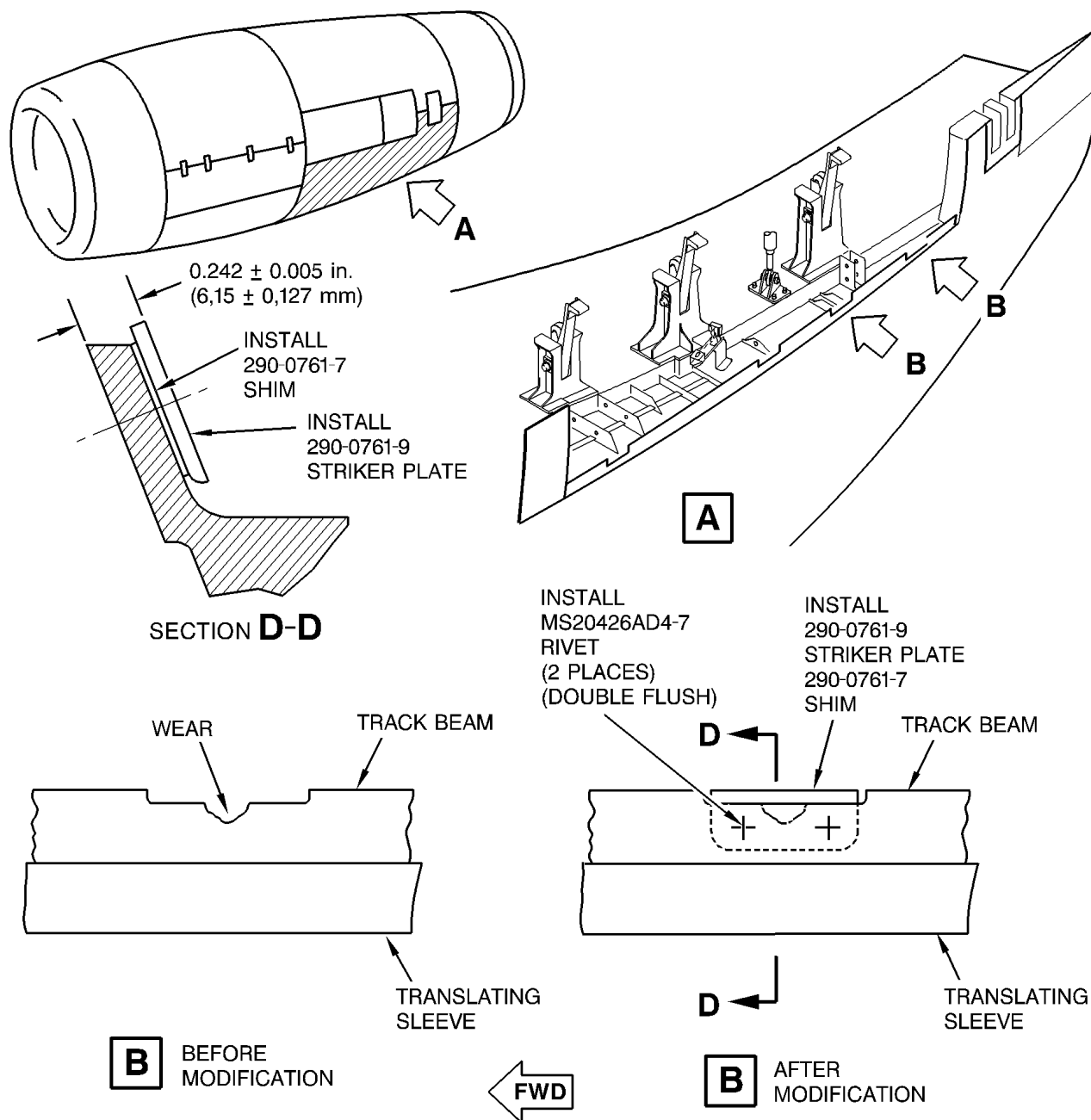
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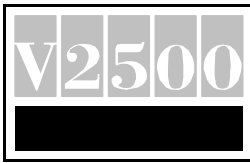
Latch Access Door Track Beam Striker Plate Installation –
Thrust Reversers without Service Bulletin V2500-NAC-78-0175
Figure 3

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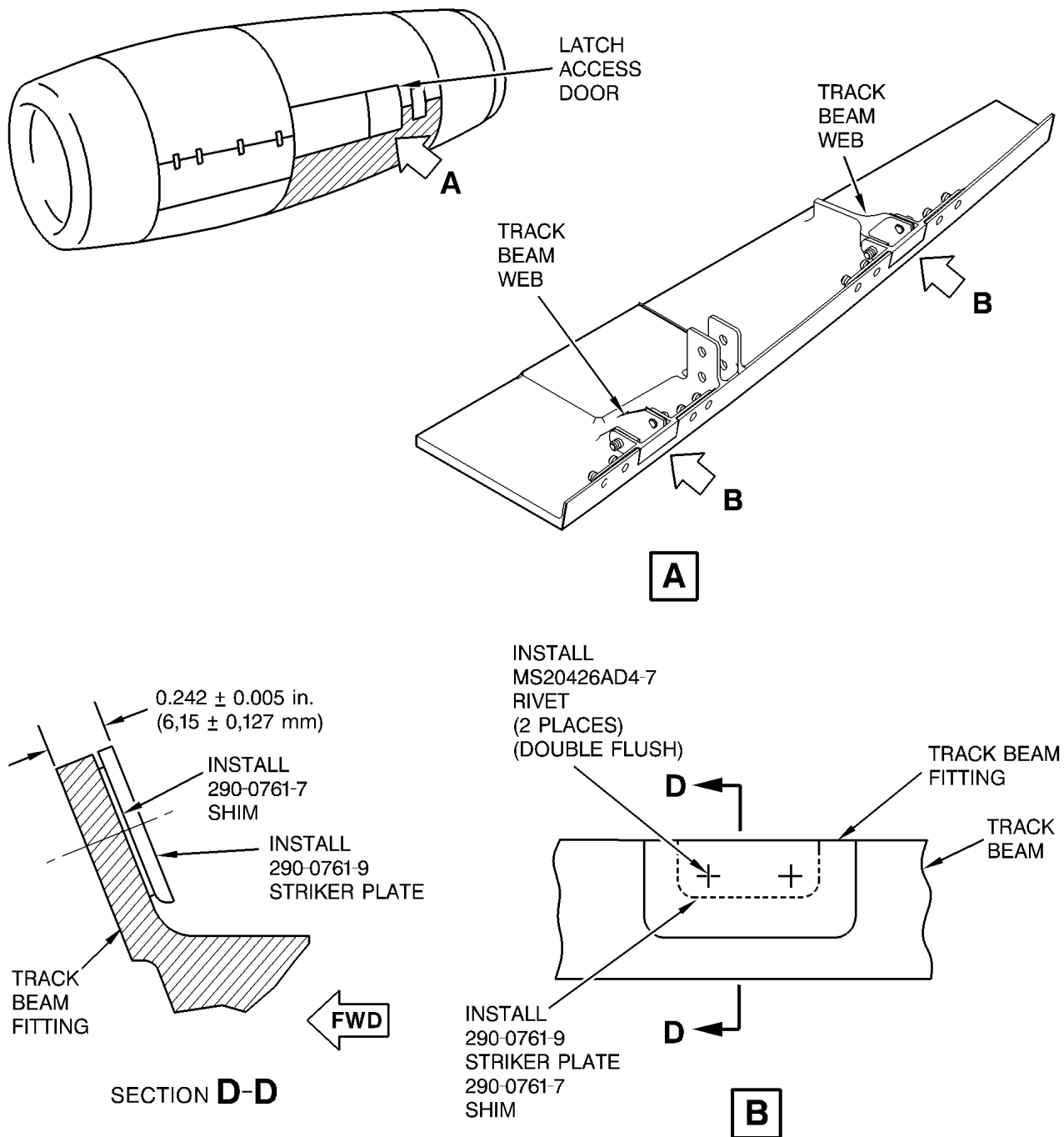
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VSB724

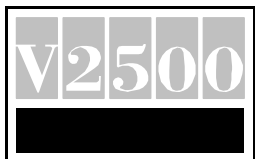
Latch Access Door Track Beam Striker Plate Installation –
Thrust Reversers with Service Bulletin V2500-NAC-78-0175
Figure 4

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3. Material Information

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

A. Kits Associated with this Bulletin:

| | NEW PART NO. (ATA NO.) | QTY | EST'D UNIT PRICE | KEYWORD | OLD PART NO. (IPC NO.) | INSTR/ DISPOS |
|---|---------------------------|-----|---------------------|---------|---------------------------|------------------|
| R | V2578151-553 | 1 | \$6322.00 | Kit | | (A) |
| | Consisting of: | | | | | |
| | HA650-3 | 2 | | Latch | | |
| | S700S1552-1 | 1 | | Seal | | |
| | 290-0038-15 | 2 | | Shim | | |
| | 290-0761-7 | 2 | | Shim | | |
| | 290-0761-9 | 2 | | Plate | | |
| | HL41-5-7 | 12 | | Pin | | |
| | HL94DU-5 | 12 | | Collar | | |
| | MS20426AD4-7 | 4 | | Rivet | | |

B. Parts affected by this Bulletin

| | NEW PART NO. (ATA NO.) | QTY | EST'D UNIT PRICE | KEYWORD | OLD PART NO. (IPC NO.) | INSTR/ DISPOS |
|---|------------------------------|-----|---------------------|----------|---------------------------|------------------|
| | 290-0003-1V | 1 | | Door, LH | 290-0003-3S | (1D) |
| | (78-32-10): | | | | (01-010) | |
| | 290-0003-2V | | | Door, RH | 290-0003-4S | (1D) |
| | (78-32-10) | 1 | | | (01-012) | |
| | 290-0038-513 | 1 | | Door, LH | 290-0038-511 | (B)(C)(1D) |
| | (78-32-10) | 2 | | | (01-010) | |
| | 290-0038-514 | 1 | | Door, RH | 290-0038-512 | (B)(C)(1D) |
| | (78-32-10) | | | | (01-012) | |
| R | HL41-5-7 | 12 | | Pin | --- | |
| R | (78-32-10) | | | | (01-071) | |
| R | HL94DU-5 | 12 | | Collar | --- | |
| R | (78-32-10) | | | | (01-074) | |
| R | HA650-3 | 2 | | Latch | H3940-1 | (B)(C) |
| R | (78-32-10) | | | | (01-091) | |
| R | 290-0038-15 | 2 | | Shim | --- | (C) |
| R | (78-32-10) | | | | (01-093) | |
| R | S700S1552-1 | 2 | | Seal | --- | (C) |
| R | (78-32-10) | | | | (01-119) | |
| R | | | | | | |

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| | | | | | |
|---|--------------|---|-------|----------|-----|
| R | 4S20426AD4-7 | 4 | Rivet | --- | (C) |
| R | 78-32-23) | | | (18-152) | |
| R | 90-0761-9 | 2 | Plate | --- | (C) |
| R | 78-32-23) | | | (18-160) | |
| R | 90-0761-7 | 2 | Shim | --- | (C) |
| R | 78-32-23) | | | (18-165) | |

C. Instruction/Disposition Code Statements

- (A) Kit will be available December 2000.
- (B) Old part will no longer be available.
- (C) New part is currently available.
- (1D) Old part may be reworked and reidentified as the new part number.

NOTE: The estimated 2000 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 01-438 | Solvent |
| CoMat 02-099 | Lint free cloth |
| CoMat 02-158 | Metal marking ink |
| CoMat 07-028 | Chromate conversion coating for aluminum |
| CoMat 07-139 | Catalyst |
| CoMat 07-140 | Epoxy primer |
| CoMat 07-144 | Thinner |
| CoMat 08-032 | Primer |
| CoMat 08-078 | Adhesive |
| CoMat 08-119 | Adhesive |

NOTE: To identify the consumable materials, refer to the Overhaul Processes and Consumable Index PCI-V2500-11A.

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