

IAE Propulsion System NON-MODIFICATION SERVICE BULLETIN

Date: July 20, 1999

Subject: Transmittal of Revision 2 to Service Bulletin Number V2500-NAC-78-0167

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jan. 22/99
Revision 1	Apr. 05/99
Revision 2	July 20/99

NOTE: Do not be concerned if you have not received Revision 1 of this service bulletin. This service bulletin has been completely re-written and the changes in Revision 1 have been included in this revision.

Reasons for issuance of Revision:

(1) While the technical intent of this service bulletin has not changed, it has been entirely re-written for the following reasons:

- (a) To change the contents of the service bulletin kits to include parts for the "skin-and-stringer" and the "machined" latch access door. The part numbers of the kits have been changed to V2578167-553 and V2578167-554.
- (b) To add the V2578167-555 kit. This kit is for the operator who has "skin-and-stringer" configuration latch access doors and has received V2578167-551 and V2578167-552 kits. This kit contains parts for the "skin-and-stringer" latch access door which were not included in the V2578167-551 and V2578167-552 kits.

NOTE: If you have received V25780167-551 and V2578167-552 service bulletin kits and you have "skin-and-stringer" configuration latch access doors, you will need to order one V2578167-555 kit for each "skin-and-stringer" door. The "skin-and-stringer" latch access doors can have part numbers 290-0012-3C, 290-0012-4C, 290-0038-507, 290-0038-508, 290-0038-509, or 290-0038-510.

- (c) To add re-work and re-identification instructions for the "skin-and-stringer" configuration latch access door. The basic issue of this service bulletin had instructions only for the "machined" latch access door.

Effect on Past Compliance:

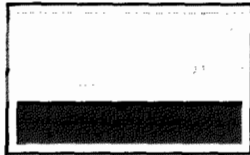
(1) None.

List of Effective Pages:

<u>Page No.</u>	<u>Rev No.</u>	<u>Date</u>
1 thru 24	2	July 20/99

V2500-NAC-78-0167

Transmittal
Page 1



V2500 Propulsion System - Nacelle
SERVICE BULLETIN

NACELLE - EXHAUST – LATCH ACCESS DOOR, THRUST REVERSER – SEALING IMPROVEMENT

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-00-00

Compliance Category Code

4

Internal Reference No.

JG 98VN808

January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 1 of 24



V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

NACELLE - EXHAUST – LATCH ACCESS DOOR, THRUST REVERSER – SEALING IMPROVEMENT

1. Planning Information

A. Effectivity

- (1) Aircraft
 - (a) Boeing MD90
- (2) Nacelle
 - (a) V2500-D5 thrust reverser serial numbers prior to 0700001.

B. Reason

(1) Condition

Operators have found thrust reverser translating sleeves with heat damage in the area around the latch access door and double latch. The cause of this damage is hot air from the engine core section escaping around the latch access door, the aft edge of the track beams, and flowing over the translating sleeves.

(2) Background

There is an inadequate seal between the latch access door, the track beams, and the translating sleeves.

(3) Objective

To provide improved sealing between the latch access door, the track beams, and translating sleeves.

(4) Substantiation

Flight tests have shown the improved sealing, provided by this service bulletin, significantly reduces the amount of hot air that escapes between the latch access door, the track beams, and the translating sleeves.



V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

(5) Effect of Bulletin on:

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

C. Description

The latch access door is removed. New seals are installed on the aft-most corners of the upper and lower thrust reverser outboard track beams. The seals at the forward and aft ends of the latch access door are replaced with longer seals. A new seal is installed on the upper edge of the latch access door. The latch access door is installed and the aft seal is adjusted for the most efficient seal between the door and the translating sleeves.

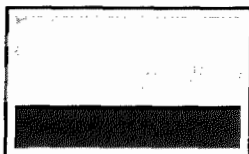
D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Boeing Service Bulletin MD90 78-035 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



V2500 Propulsion System - Nacelle SERVICE BULLETIN

F. Manpower

<u>VENUE</u>		<u>ESTIMATED MANHOURS</u>
(1)	In Service	
(a)	To gain access	0.0 M/Hrs.
(b)	To rework	3.0 M/Hrs.
(c)	To return to service	<u>0.0 M/Hrs.</u>
Total		3.0 M/Hrs.

NOTE: Manhours provided for planning purposes only.

G. Material Cost and Availability

The parts to accomplish this service bulletin are available from the supplier as kits V2578167-553 (left thrust reverser) and V2578167-554 (right thrust reverser) 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:

NOTE: If you have received V25780167-551 and V2578167-552 service bulletin kits and you have some of the "skin-and-stringer" configuration latch access doors, you will need to order one V2578167-555 kit for each "skin-and-stringer" door. The "skin-and-stringer" latch access doors can have part numbers 290-0012-3C, 290-0012-4C, 290-0038-507, 290-0038-508, 290-0038-509, or 290-0038-510.

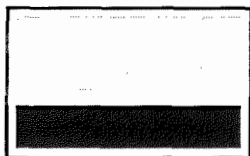
Direct Purchase order to:
Rohr, Inc.
850 Lagoon Drive
Chula Vista, CA 91910-2098
U.S.A.

Attn: Airline Account Manager – MZ 107A
(Ref. Service Bulletin No. V2500-NAC-78-0167)

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

H. Tooling - Cost and Availability

None required.



V2500 Propulsion System - Nacelle SERVICE BULLETIN

I. Weight and Balance

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

J. Electrical Load Data

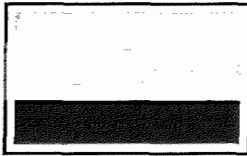
Not affected.

K. References

<u>Manual</u>	<u>Chapter/Section</u>
MD90 Aircraft Maintenance Manual	78-32-00 78-32-10
IAE V2500 Standard Practices/Processes Manual (SPP-V2500-11A)	70-09-00
MD90/V2500D5 Thrust Reverser Component Maintenance Manual (CMM-TR-V2500-3IA)	78-32-16
Overhaul Processes and Consumable Index (PCI-V2500-11A)	
MD90 SRM	54-30-03

L. Other Publications Affected

<u>Manual</u>	<u>Chapter/Section</u>
MD90/V2500D5 Thrust Reverser Component Maintenance Manual (CMM-TR-V2500-3IA)	78-32-10



V2500 Propulsion System - Nacelle SERVICE BULLETIN

2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) Remove the latch access door. Refer to the MD90 Aircraft Maintenance Manual, Chapter 78-32-10, Page Block 401.

B. Modify the latch access door seals.

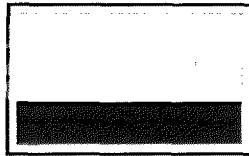
To modify the 290-0038-1V or -2V "skin-and-stringer" latch access doors, perform steps 1 thru 11 and 19 thru 23.

To modify 290-0038-514 or -515 "machined" latch access door, perform steps 12 thru 23.

- (1) Remove the pins, collars, washers, 290-0035-89 retainer, and 290-0035-129 seal from the aft edge of the 290-0038-1V (-2V) latch access door. Discard the retainer, seal, and rivets. Refer to Figure 1 (Sheet 1).
- (2) Remove the rivets, 290-0035-83 retainer, and 290-0035-131 seal from the forward edge of the 290-0038-1V (-2V) latch access door. Discard the retainer, seal, and rivets.
- (3) If damaged, or not made of sponge rubber material, 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 seal mating surfaces of the latch access door with a lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surfaces dry before the solvent becomes dry.
- (5) Remove material from the 290-0035-101 or -102 upper channel and from the 290-0035-103 or -104 lower channel to make space for the new seals.
 - (a) On the upper channel, remove 0.94 inch (2.39 cm) wide by 0.18 inch (0.46 cm) deep material from each upper corner and ensure a 0.16 inch (0.40 cm) corner radius.
 - (b) On the lower channel, remove 0.94 inch (2.39 cm) wide by 0.18 inch (0.46 cm) deep material from aft lower corner only and ensure a 0.16 inch (0.40 cm) corner radius.



V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

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- (c) Clean the modified surfaces of the latch access door with a lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surfaces dry before the solvent becomes dry.

WARNING: CONVERSION COATING (COMAT 07-106) 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.

- (6) Apply conversion coating (CoMat 07-106) to the bare metal in the modification areas of the latch access door. 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.

- (7) Mix the catalyst (CoMat 07-139), epoxy primer (CoMat 07-140), and thinner (CoMat 07-0144). Refer to the manufacturer's instructions.
- (8) Apply primer to exposed areas on the latch access door. Refer to the manufacturer's instructions.
- (9) Cure the primer. Refer to the manufacturer's instructions.
- (10) Install the 290-0038-23 seal on the aft edge of the latch access door. Use the 290-0038-21 retainer, HL41-5-5 pins, NAS1149C0332R washers, and MS21042L08 nuts. Do not torque the nuts at this time.



V2500 Propulsion System - Nacelle SERVICE BULLETIN

- (11) Install the 290-0038-19 seal on the forward edge of the latch access door.
- (a) Put the 290-0038-17 retainer on the 290-0038-19 seal and back drill the holes in the seal for the MS20426AD3-8 rivets.
 - (b) Install the 290-0038-19 seal on the latch access door. Use the 290-0038-17 retainer, and MS20426AD3-8 rivets. Wet install the rivets with primer mix.

NOTE: Steps 12 through 18 are for the 290-0038-514 (-515) "machined" latch access door only.

- (12) Remove the pins, collars, washers, 290-0038-5 or 290-0035-83 retainer, and 290-0038-7 seal from the aft edge of the 290-0038-514 (-515) latch access door. Discard the retainer, seal, and rivets. Refer to Figure 1 (sheet 2).
- (13) Remove the rivets, 290-0038-1 or 290-0035-83 retainer, and 290-0038-3 seal from the forward edge of the 290-0038-514 (-515) latch access door. Discard the retainer, seal, and rivets.
- (14) If damaged, or not made of sponge rubber material, 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.

- (15) Clean the seal mating surfaces of the latch access door with a lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surfaces dry before the solvent becomes dry.
- (16) Install the 290-0038-23 seal on the aft edge of the latch access door. Use the 290-0038-21 retainer, HL41-5-2 pins, NAS1149C0332R washers, and MS21042L08 nuts. Do not torque the nuts at this time.



V2500 Propulsion System - Nacelle SERVICE BULLETIN

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.

- (17) Mix the catalyst (CoMat 07-139), epoxy primer (CoMat 07-140), and thinner (CoMat 07-0144). Refer to the manufacturer's instructions.
- (18) Install the 290-0038-19 seal on the forward edge of the latch access door.
 - (a) Put the 290-0038-17 retainer on the 290-0038-19 seal and back drill the holes in the seal for the MS20426AD3-5 rivets.
 - (b) Install the 290-0038-19 seal on the latch access door. Use the 290-0038-17 retainer, and MS20426AD3-5 rivets. Wet install the rivets with primer mix.

NOTE: Steps 19 through 23 are for the "skin-and-stringer" and "machined" latch access doors.

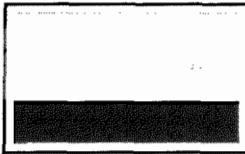
- (19) Install the 290-0003-1S, 290-0038-25, and S700S1552-1 seals on the latch access door.

NOTE: It is necessary to install the S700S1552-1 seal only if it is missing or has been removed.

- (a) Remove material from the seals as necessary to match the shape of the latch access door.

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.

- (b) Apply primer (CoMat 08-032) to the seal mating surface of the latch access door. Refer to the manufacturer's instructions.
- (c) Cure the primer. Refer to the manufacturer's instructions.



V2500 Propulsion System - Nacelle SERVICE BULLETIN

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.

- (d) Apply a thin layer of adhesive (CoMat 08-119) to the seal mating surface of the latch access door. Refer to the manufacturer's instructions.
 - (e) Install the 290-0003-1S and S700S1552-1 seals on the "skin-and-stringer" latch access door. Refer to Figure 1 (sheet 1).
 - (f) Install the 290-0038-25 and S700S1552-1 seals on the "machined" latch access door. Refer to Figure 1 (sheet 2).
 - (g) Cure the adhesive. Refer to the manufacturer's instructions.
- (20) Re-identify the latch access door as follows:

NEW PART NUMBER	OLD PART NUMBER
290-0003-3S	290-0038-509
290-0003-4S	290-0038-510
290-0038-515	290-0038-513
290-0038-516	290-0038-514

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

- (21) Repair the external paint on the latch access door. Refer to the MD-90 Structural Repair Manual, Chapter 54-30-03, External Paint repair VRS2404.
- (22) Examine the upper outboard track beam latch access door hinge point bushings. Replace any damaged or missing bushings. Refer to Figure 2.

NOTE: The track beam latch access door hinge point bushings are press fit installed by the manufacturer but may have become loose in service. If you find the bushings are loose, this is acceptable and will be the subject of a subsequent service bulletin or repair. If you find the bushings are missing, install the replacement bushings supplied with the service bulletin kit. If the bushing holes in the track beam have become larger or are not round, this is acceptable and will be the subject of a subsequent service bulletin or repair.



V2500 Propulsion System - Nacelle SERVICE BULLETIN

- (23) Examine the translating sleeves for heat damage around the latch access door and the double latch and repair as necessary. Refer to Chapter 78-32-16 of the MD90 Thrust Reverser Component Maintenance Manual (CMM-TR-V2500-31A) for inspection and repair instructions.

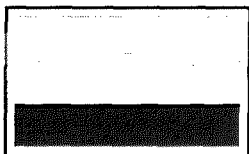
C. Install the 290-0140-17 (-18) and 290-0152-19 (-20) seals on the track beams. Refer to Figure 3.

NOTE: This procedure is the same for the left and right thrust reversers. Right thrust reverser parts are shown in parenthesis.

- (1) Extend the translating sleeves to the deployed position. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-00, Page Block 201.
- (2) Remove material from the lower track beam heatshield to make room for the seal and retainer.
- (3) Remove material to make a radius on the upper and lower track beams. This will prevent damage to the seals.

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.

- (4) Apply sealant (CoMat 08-030) to the cut edges of the track beam heatshield.
- (5) Cure the sealant. Refer to the manufacturer's instructions.
- (6) Put the 290-0140-17 (-18) seal and 290-0140-19 retainer into position on the upper track beam.
- (7) Put the 290-0152-19 (-20) seal and 290-0152-21 retainer into position on the lower track beam.
- (8) Drill the holes for the attaching parts.



V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

WARNING: CONVERSION COATING (COMAT 07-106) 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.

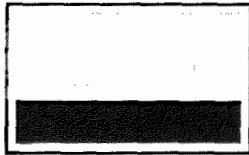
- (9) Apply conversion coating (CoMat 07-106) to the fastener holes and any bare metal in the modification area of the track beams. Refer to the manufacturer's instructions.

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.

- (10) Mix the catalyst (CoMat 07-139), epoxy primer (CoMat 07-140), and thinner (CoMat 07-0144). Refer to the manufacturer's instructions.
- (11) Apply the primer to the bare metal in the modification area of the track beams. Refer to the manufacturer's instructions.
- (12) Cure the primer. Refer to the manufacturer's instructions.
- (13) Install the seals on the track beams. Use the retainers, the screws, and the nuts. Do not torque the nuts at this time.
- (14) Retract the translating sleeves to the stowed position. Refer to the MD-90 Aircraft Maintenance Manual, Chapter 78-32-00, Page Block 201.
- (15) Move the 290-0140-17 (-18) and 290-0152-19 (-20) seals until they are 10% to 30% compressed against the translating sleeve.
- (16) Torque the MS21042L04 nuts to 12 to 16 inlbs.

D. Post-requisite instructions

- (1) Install the latch access door. Refer to the MD90 Aircraft Maintenance Manual, Chapter 78-32-09, Page Block 401. Make sure all the track beam bushings and door installation bushings are present and installed correctly. Refer to Figures 2 and 3.



V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

- (2) Check for excessive looseness or "free-play" at the latch access door attach points.

CAUTION: EXCESSIVE LOOSENESS OR "FREE-PLAY" AT THE LATCH ACCESS DOOR ATTACH POINTS MAY CAUSE PREMATURE WEAR OF THE DOOR AND/OR THE LATCH LAND AND IMPAIR DOOR FUNCTION.

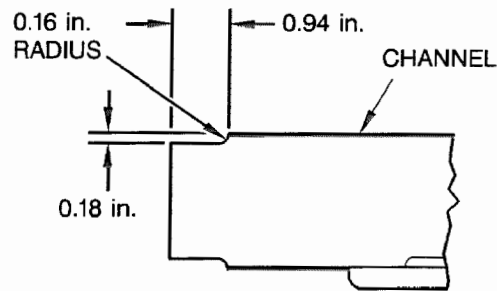
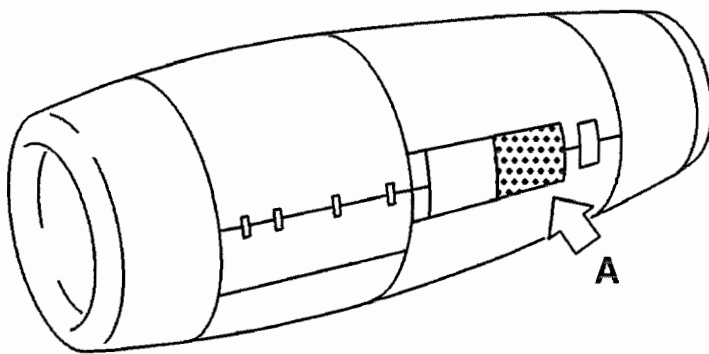
- (a) If there is excessive looseness or "free-play", check for proper installation of the attach hardware and replace any worn, damaged, or missing bushings. Refer to Figure 2.
- (3) Adjust the latch access door aft seal. Refer to Figure 1 (sheets 1 and 2).
- (a) Move the 290-0038-23 aft seal until it is compressed 10% to 30% against the translating sleeve when the latch access door is closed.
- (b) Torque the MS21042L08 nuts to 12 to 16 inlbs.

E. Recording Instructions

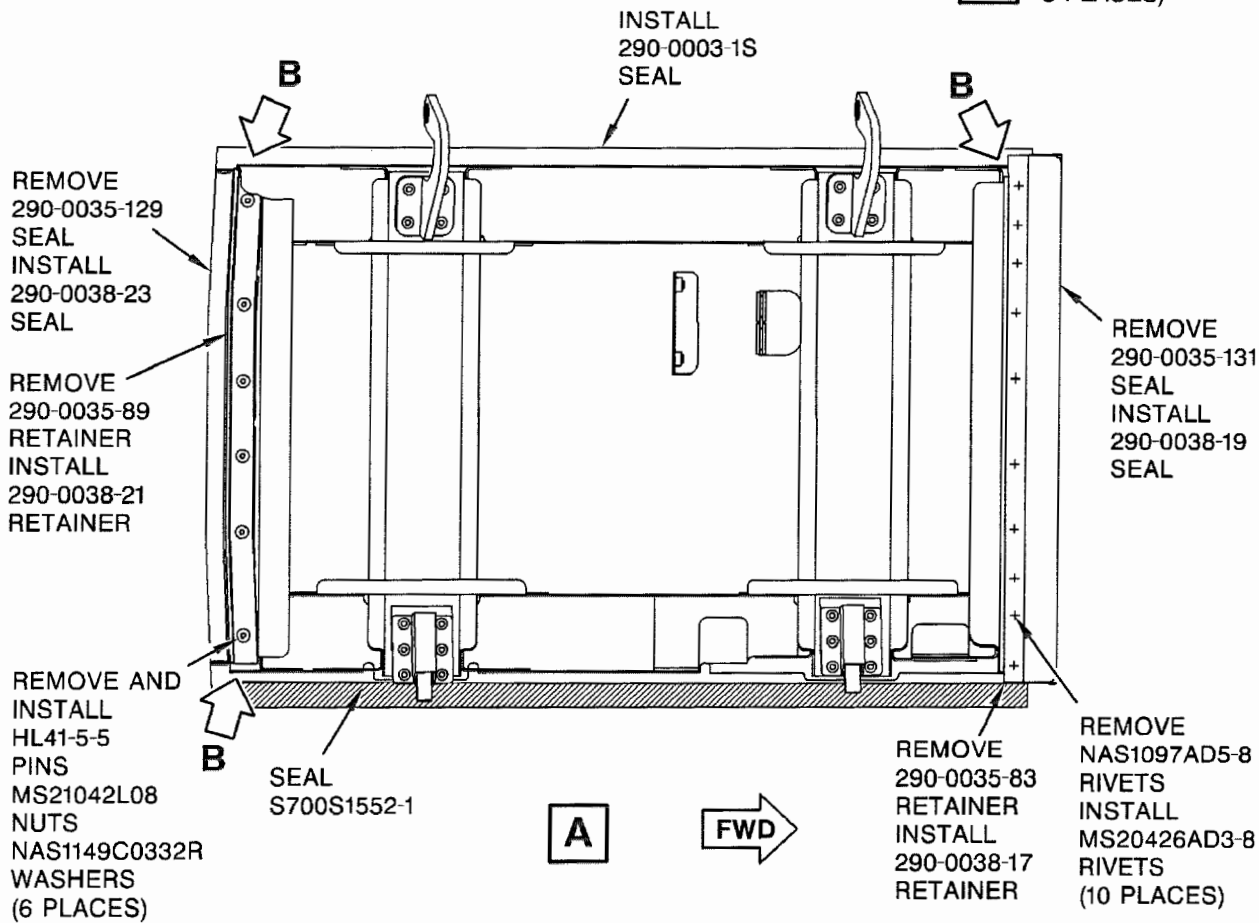
A record of accomplishment is necessary. Write in the applicable records and metal stamp, vibroetch, or electro etch on the thrust reverser assembly data plate that Service Bulletin V2500-NAC-78-0167 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.



V2500 Propulsion System - Nacelle SERVICE BULLETIN



B (TYPICAL
3 PLACES)

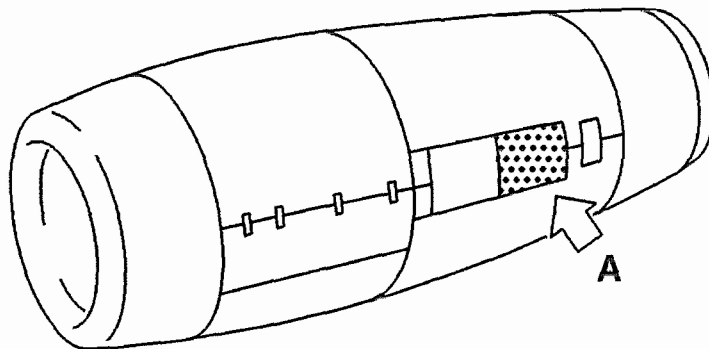


VSB693

Latch Access Door Seal Installation ("Skin-and-Stringer")
Figure 1 (sheet 1)



V2500 Propulsion System - Nacelle SERVICE BULLETIN



REMOVE
290-0038-7
SEAL
INSTALL
290-0038-23
SEAL

REMOVE
290-0038-5
RETAINER
INSTALL
290-0038-21
RETAINER

REMOVE AND
INSTALL
HL41-5-2
PINS
MS21042L08
NUTS
NAS1149C0332R
WASHERS
(6 PLACES)

SEAL
S700S1552-1

A

INSTALL
290-0038-25
SEAL

REMOVE
NAS1097AD5-8
RIVETS
INSTALL
MS20426AD3-5
RIVETS
(10 PLACES)

REMOVE
290-0038-3
SEAL
INSTALL
290-0038-19
SEAL

REMOVE
290-0038-1 OR
290-0035-83
RETAINER
INSTALL
290-0038-17
RETAINER

VSB675

Latch Access Door Seal Installation ("Machined")
Figure 1(sheet 2)

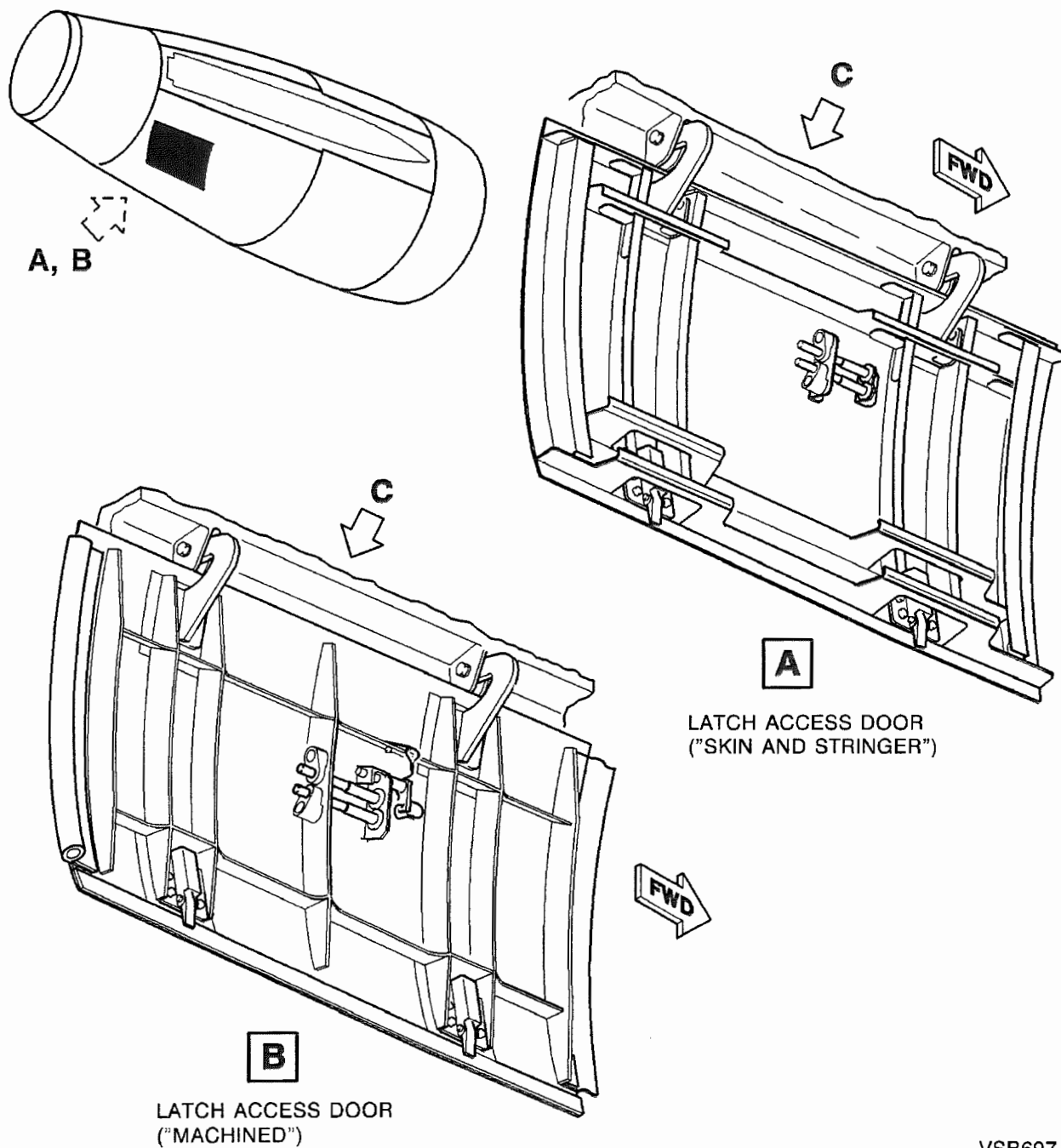
January 22, 1999
Revision 2 - July 20, 1999

V2500-NAC-78-0167

Page 15 of 24



V2500 Propulsion System - Nacelle
SERVICE BULLETIN



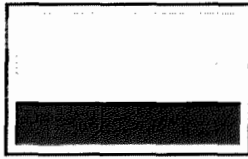
VSB697

Latch Access Door Hinge Point Attach Hardware
Figure 2 (sheet 1)

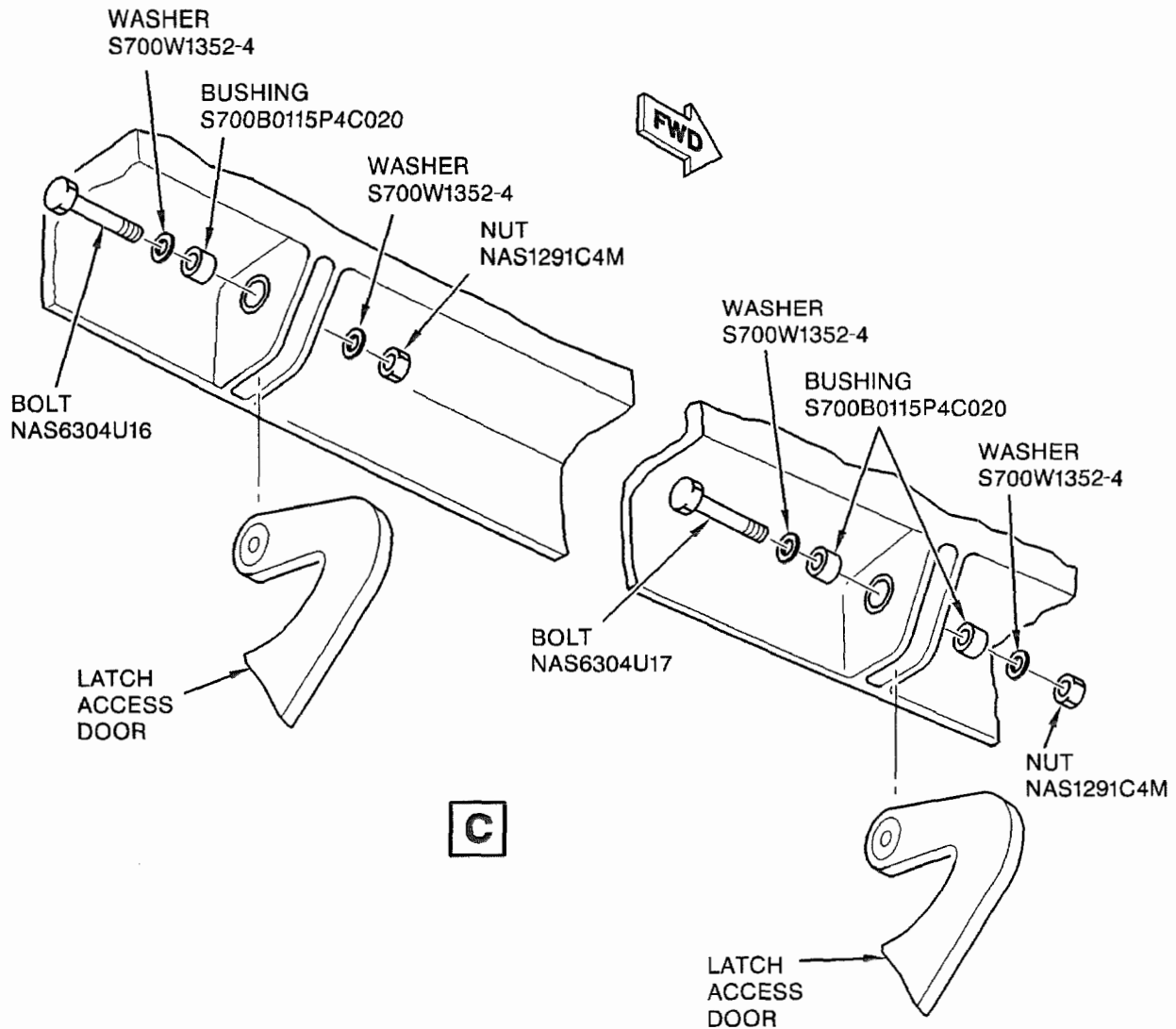
January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 16 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN



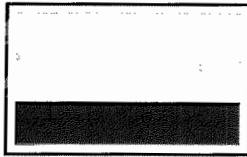
VSB698

Latch Access Door Hinge Point Attach Hardware
Figure 2 (sheet 2)

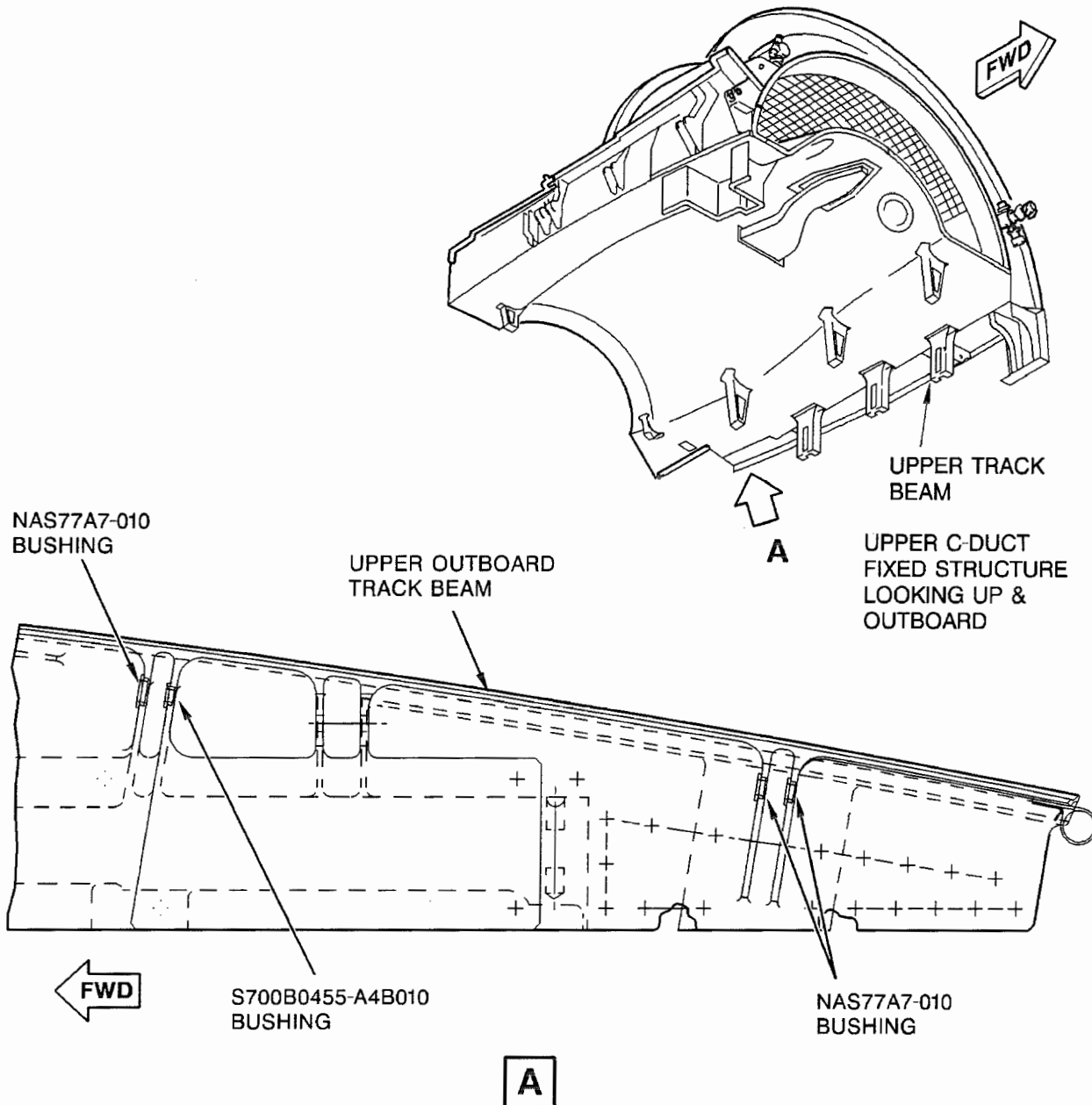
January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 17 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN



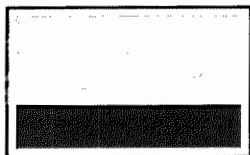
VSB684

Upper Outboard Track Beam Latch Access Door Hinge Point Bushings
Figure 3

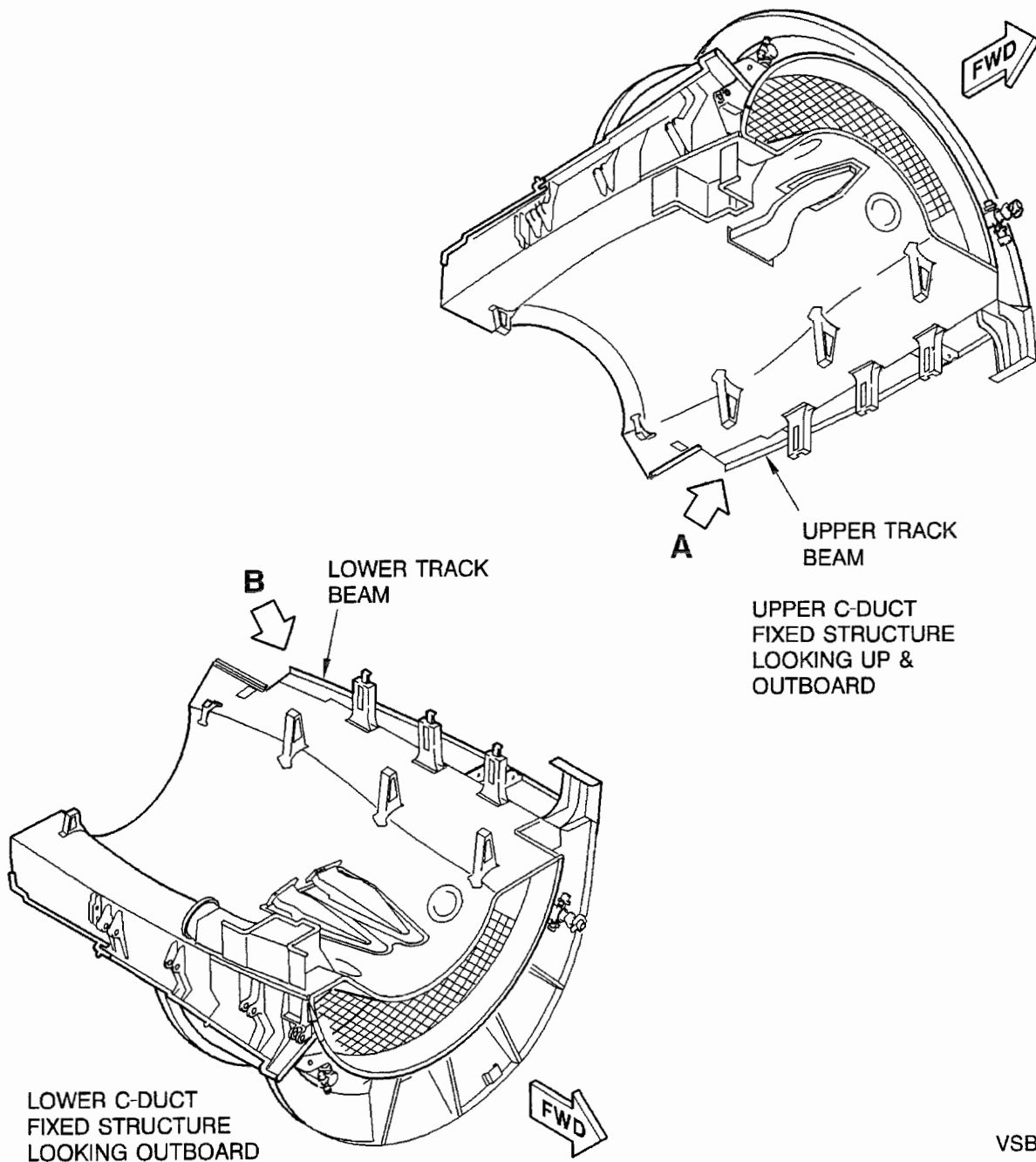
January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 18 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN



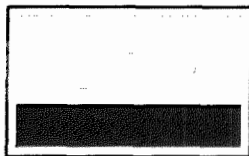
VSB680

Track Beam Seal Installation
Figure 4 (sheet 1)

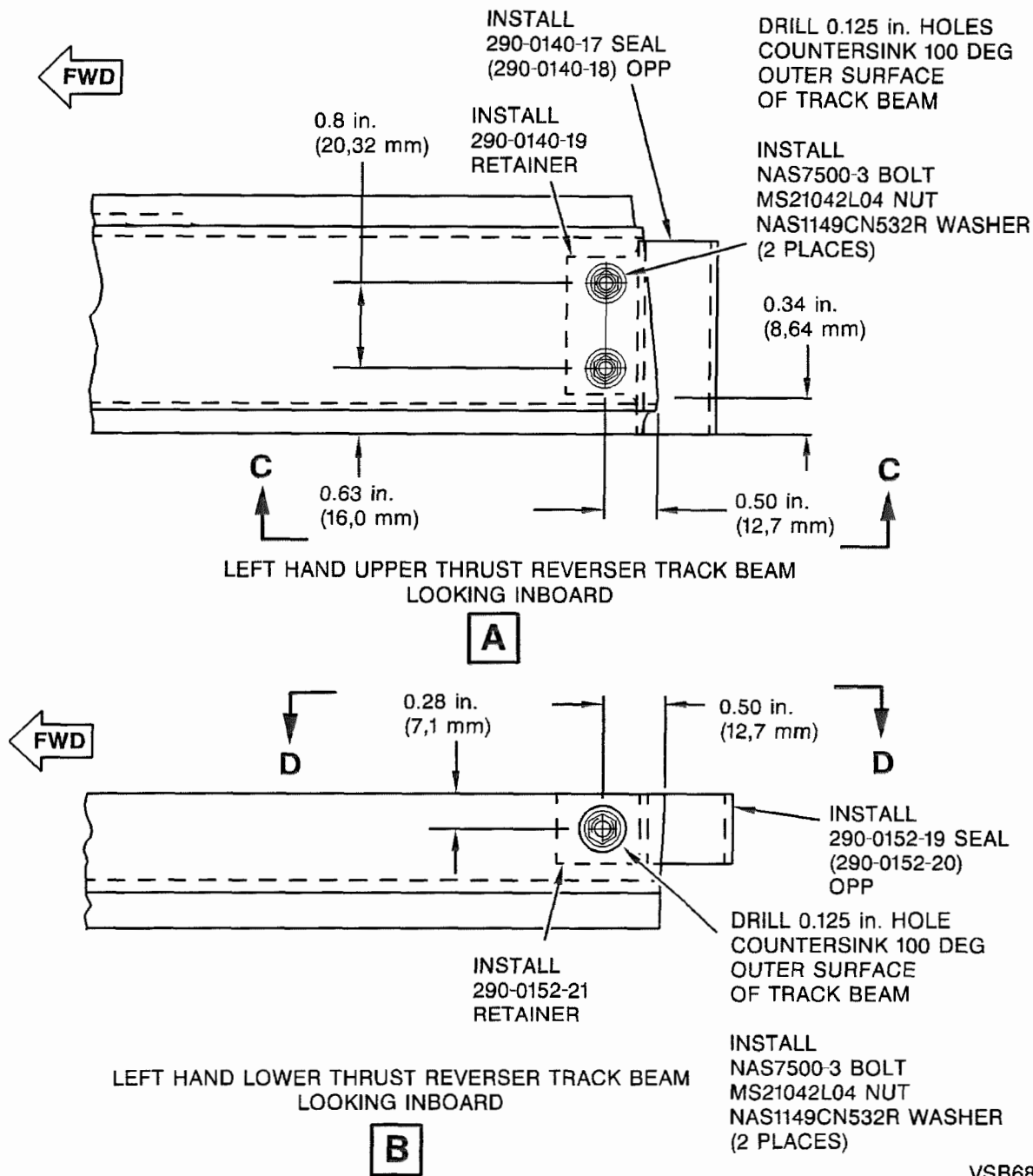
January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 19 of 24

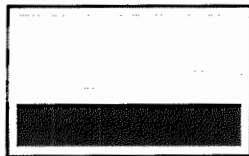


V2500 Propulsion System - Nacelle SERVICE BULLETIN

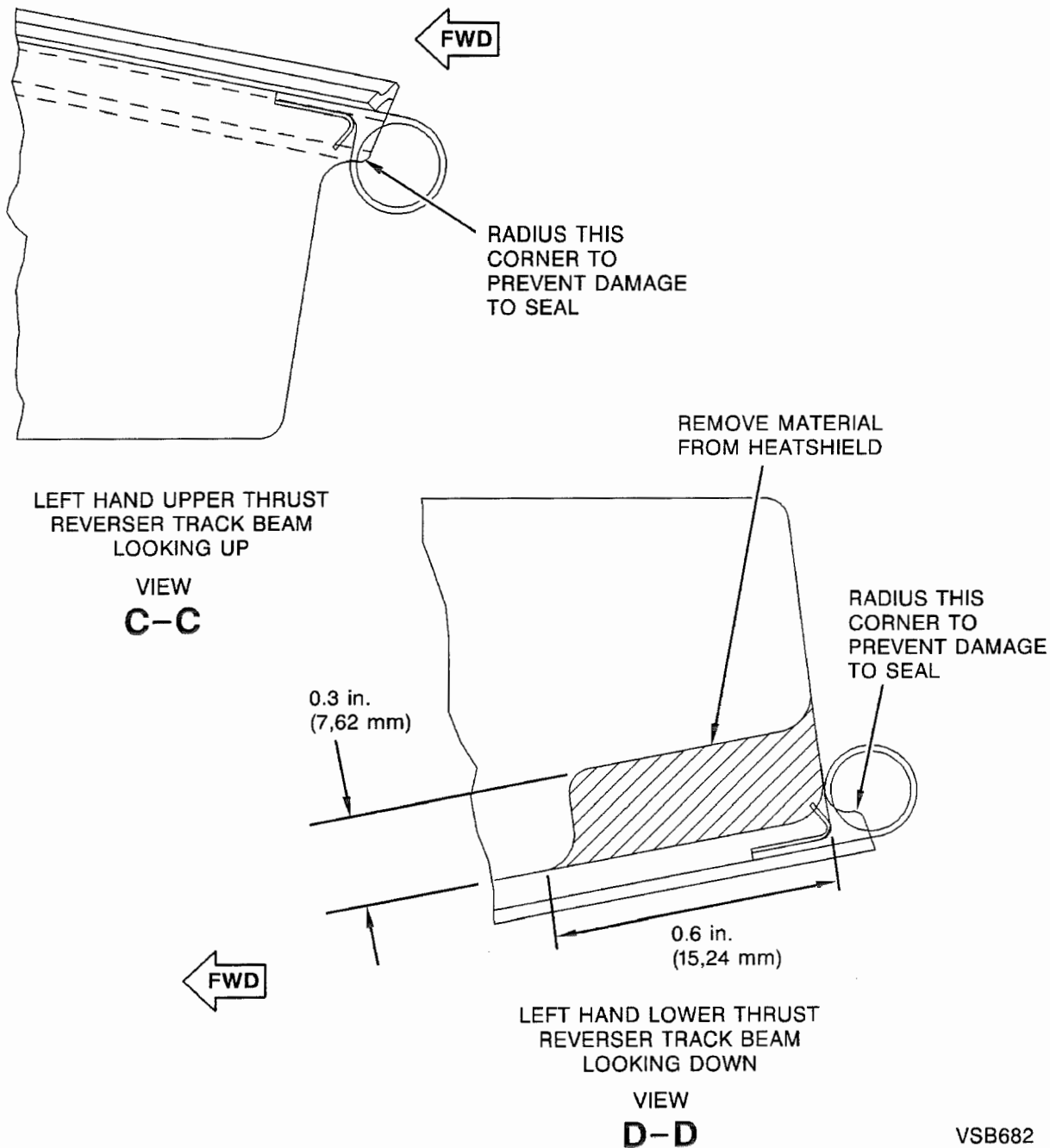


VSB681

Track Beam Seal Installation
Figure 4 (sheet 2)



V2500 Propulsion System - Nacelle SERVICE BULLETIN



VSB682

Track Beam Seal Installation
Figure 4 (sheet 3)

January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 21 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN

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 UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
V2578167-553 Consisting of:	1	\$2,348.00	Kit, LH Nacelle		
290-0003-1S	1		Seal		
290-0038-17	1		Retainer		
290-0038-19	1		Seal		
290-0038-21	1		Retainer		
290-0038-23	1		Seal		
290-0038-25	1		Seal		
290-0140-17	1		Seal		
290-0140-19	1		Retainer		
290-0152-19	1		Seal		
290-0152-21	1		Retainer		
HL41-5-2	6		Pin		
HL41-5-5	6		Pin		
MS21042L04	3		Nut		
MS21042L08	6		Nut		
MS20426AD3-5	10		Rivet		
MS20426AD3-8	10		Rivet		
NAS1149CN532R	3		Washer		
NAS1149C0332R	6		Washer		
NAS7500-3	3		Bolt		
NAS77A7-010	3		Bushing		
S700B0455-A4B010	10		Bushing		
S700S1552-1	1		Seal		

<u>NEW PART NO.</u> <u>(ATA NO.)</u>	<u>QTY</u>	<u>EST'D UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
V2578167-554 Consisting of:	1	\$2,348.00	Kit, RH Nacelle		
290-0003-1S	1		Seal		
290-0038-17	1		Retainer		
290-0038-19	1		Seal		
290-0038-21	1		Retainer		
290-0038-24	1		Seal		

January 22, 1999
Revision 2 – July 20, 1999

V2500-NAC-78-0167

Page 22 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN

290-0038-25	1	Seal
290-0140-18	1	Seal
290-0140-19	1	Retainer
290-0152-20	1	Seal
290-0152-21	1	Retainer
HL41-5-2	6	Pin
HL41-5-5	6	Pin
MS21042L04	3	Nut
MS21042L08	6	Nut
MS20426AD3-5	10	Rivet
MS20426AD3-8	10	Rivet
NAS1149CN532R	3	Washer
NAS1149CO332R	6	Washer
NAS7500-3	3	Bolt
NAS77A7-010	3	Bushing
S700B0455-A4B010	1	Bushing
S700S1552-1	1	Seal

<u>NEW PART NO.</u> <u>(ATA NO.)</u>	<u>QTY</u>	<u>EST'D UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
V2578167-555			Kit		(C)
Consisting of:					
290-0003-1S	1		Seal		
HL41-5-5	6		Pin		
MS20426AD3-8	10		Rivet		

NOTE: The V2578167-553 and V2578167-554 service bulletin kits have been assembled so that they may be used to modify the "skin-and-stringer" or "machined" latch access doors. For this reason, there will be parts remaining after you install the kits.

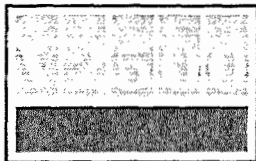
B. Parts affected by this Bulletin:

<u>NEW PART NO.</u> <u>(ATA NO.)</u>	<u>QTY</u>	<u>EST'D UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO.</u> <u>(IPC NO.)</u>	<u>INSTR/</u> <u>DISPOS</u>
290-0003-3S	1		Door, Latch	290-0038-509	(1D)
(78-32-10)			Access	(01-010)	
290-0003-4S	1		Door, Latch	290-0038-510	(1D)
(78-32-10)			Access	(01-012)	
290-0038-515	1		Door, Latch	290-0038-513	(A)(B)(1D)
(78-32-10)			Access	(01-010)	
290-0038-516	1		Door, Latch	290-0038-514	(A)(B)(1D)
(78-32-10)			Access	(01-012)	

January 22, 1999
Revision 2 - July 20, 1999

V2500-NAC-78-0167

Page 23 of 24



V2500 Propulsion System - Nacelle SERVICE BULLETIN

C. Instruction/Disposition Code Statements

- (A) New part is available.
- (B) Old part will no longer be available.
- (C) If you have "skin-and-stringer" latch access doors and you have received V2578167-551 and V2578167-552 kits, you need to order one V2578167-555 kit for each "skin-and-stringer" configuration latch access door.
- (ID) Old part can be re-worked to the new part configuration.

D. Materials Required to Incorporate this Service Bulletin:

CoMat 01-438	Solvent
CoMat 02-099	Lint free cloth
CoMat 07-106	Chromate conversion coating for aluminum
CoMat 07-139	Catalyst
CoMat 07-140	Epoxy primer
CoMat 07-144	Thinner
CoMat 08-030	Adhesive
CoMat 08-032	Primer
CoMat 08-119	Adhesive

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