



V2500 Propulsion System - Nacelle  
**SERVICE BULLETIN**

NACELLE - EXHAUST – C.N.A. BIFURCATION FAIRING – MODIFICATION OF

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

78-00-00

Compliance Category Code

6

Internal Reference No.

JG 97VN804A

June 7, 1999

**V2500-NAC-78-0168**

Page 1 of 8



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

### NACELLE - EXHAUST – C.N.A. BIFURCATION FAIRINGS – MODIFICATION OF

#### 1. Planning Information

##### A. Effectivity

###### (1) Aircraft

(a) Boeing DPD MD90

###### (2) Nacelle

(a) V2500-D5 common nozzle assembly (C.N.A.) serial numbers prior to 0158001.

##### B. Reason

###### (1) Condition

Operators have found C.N.A.s with cracks in the bifurcation fairings.

###### (2) Background

The C.N.A. bifurcation fairings can crack in service.

###### (3) Objective

To modify the existing fairings and install new end fairings which are more resistant to cracking.

###### (4) Substantiation

Not applicable.



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

(5) Effect of Bulletin on:

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

C. Description

The existing one-piece bifurcation fairings are modified and four new fairings are installed.

D. Approval

Incorporation of this Service Bulletin must be accomplished only in conjunction with Douglas Aircraft Company Service Bulletin MD90 78-036 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

<u>VENUE</u>		<u>ESTIMATED MANHOURS</u>
(1)	In Service	N/A
(2)	In Shop	
(a)	To rework	<u>8.0 M/Hrs.</u>
Total		8.0 M/Hrs.

NOTE: Manhours provided for planning purposes only.



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

### G. Material Cost and Availability

The parts to accomplish this service bulletin are available from the supplier as kit V2578168-551 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 kit part number listed herein. Operators will have one year from the issue date of the service bulletin to place an order. Upon receipt of purchase order Rohr shall provide a delivery schedule for kits ordered. After one year, kits may no longer be available and operators may have to order parts individually at catalog prices, if they desire to incorporate the change:

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-78-0168)

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

### 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 Centreline<br>(Powerplant Station PPS 100.0) |

### J. Electrical Load Data

Not affected.



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

### K References

<u>Manual</u>	<u>Chapter/Section</u>
Common Nozzle Component Maintenance Manual (CMM-CN-V2500-3IA)	78-11-11
IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)	70-09-00
Overhaul Processes and Consumable Index (PCI-V2500-1IA)	

### L. Other Publications Affected

Manual	Chapter/Section
MD90/V2500D5 Common Nozzle Component Maintenance Manual (CMM-CN-V2500-3IA)	78-11-11



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

### 2. Accomplishment Instructions

- A. Modify the C.N.A. bifurcation fairings and install the four new fairing pieces (290-1264-509, 290-1264-510, 290-1264-511, and 290-1264-512). Refer to the Common Nozzle CMM 78-11-11, Repair 007 (VRS2641). Use the parts in kit V2578168-551.

NOTE: If repair VRS2641 has been done, it is not necessary to do this service bulletin.

### B. Recording Instructions

A record of accomplishment is necessary. Write in the applicable records and metal stamp, vibroetch, or electro etch on the C.N.A. data plate that Service Bulletin V2500-NAC-78-0168 has been done. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.



# V2500 Propulsion System - Nacelle SERVICE BULLETIN

## 3. Material Information

Applicability: For each V2500-D5 common nozzle 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>
V2578168-551	1	\$18,714.00	Kit		(A)
Consisting of:					
290-1201-17	4		Shim, laminated		
290-1264-509	1		Fairing, aft upper left		
290-1264-510	1		Fairing, aft upper right		
290-1264-511	1		Fairing, aft lower left		
290-1264-512	1		Fairing, aft lower right		
CR3522-5-02	24		Rivet		
NAS9308M5-02	24		Rivet (oversize alternate for CR3522-5-02)		
2ASPFF-EU06-15	24		Pin		
2ASPFF-DT06-14	24		Pin (oversize alternate for 2ASPFF-EU06- 15)		
ASPF-S-EU06	24		Sleeve		
ASPF-S-DT06	24		Sleeve (oversize alternate for ASPF-S-EU06)		
ASP-LC-2AC06	24		Collar		

### B. Parts affected by this Bulletin:

None

### C. Instruction/Disposition Code Statements

(A) Kit is available.



## V2500 Propulsion System - Nacelle **SERVICE BULLETIN**

D. Materials Required to Incorporate this Service Bulletin:

CoMat 01-438	Solvent
CoMat 02-099	Lint free cloth
CoMat 02-158	Release agent
CoMat 02-178	Masking tape
CoMat 05-074	Aluminum oxide abrasive paper
CoMat 05-126	Scotchbrite pad
CoMat 07-106	Conversion coating for aluminum
CoMat 07-149	Primer Base
CoMat 07-150	Primer converter
CoMat 07-151	Thinner
CoMat 08-021	Adhesive
CoMat 08-032	Primer
CoMat 08-033	Sealant

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