



SERVICE BULLETIN

SUBJECT: Norco, Inc. Strut Assembly A2711-3 rework to
A2711-15 by installation of Sleeve AM2711-15-2.

1. PLANNING INFORMATION

A. Effectivity

First unit and on, not mandatory, accomplish at user option.

B. Reason

Prevent potential chafing of adjacent electrical harness.

C. Description

This service bulletin provides a detailed description for incorporating this design improvement.

D. Manpower

Required to install Sleeve 0.6 hrs.

E. Material Availability

The parts required to accomplish this service bulletin are available from the manufacturer as rework kit part number RW2711-15.

Operators should submit a purchase order for the rework kits required. The purchase order should specify this service bulletin number. Delivery schedule will be furnished upon receipt of request.

Direct purchase order to: MarathonNorco Aerospace, Inc.
8301 Imperial Dr.
Waco, Texas 76712
254-776-0650 Main Line
254-776-6558 Fax

A2711-78-1

PAGE 1 OF 4

SERVICE BULLETIN

F. Weight

Incorporation of this service bulletin will increase the weight of the A2711-3 assembly by 0.067 lbs.

2. ACCOMPLISHMENT INSTRUCTIONS

A. Rework Instructions

1. Position sleeve (AM2711-15-2) as shown in Figure 1 and clamp in place.
2. Using sleeve (AM2711-15-2) as a drill template, drill through one wall with #29 drill (.136) in three places.
3. Remove sleeve (AM2711-15-2), deburr holes, and remove any loose metal chips.
4. Reposition sleeve (AM2711-15-2) and align with previously drilled holes.
5. Install one (1) NAS1398C-4-3 rivet and set rivet with installation tool.
6. Verify hole alignment on the remaining two (2) holes by inserting rivets and setting with installation tool.
7. Check that sleeve (AM2711-15-2) is tightly held at all three attachment points.

A2711-78-1



SERVICE BULLETIN

D. Reidentify

1. After incorporation of this service bulletin, the -3 part number should be removed by "X"ing it out with a vibroscribed tool.

2. Reidentify by vibroscribing -15.

a. Example: Part Number After Reidentification

A2711-3-15

Material Information

A rework kit is available under part number RW2711-15 which contains all parts required to accomplish this service bulletin.

<u>Item #</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
1	AM2711-15-2	1	Sleeve
2	NAS1398C-4-3	3	Rivet

A2711-78-1

PAGE 3 OF 4

NORCO, INC.

SERVICE BULLETIN

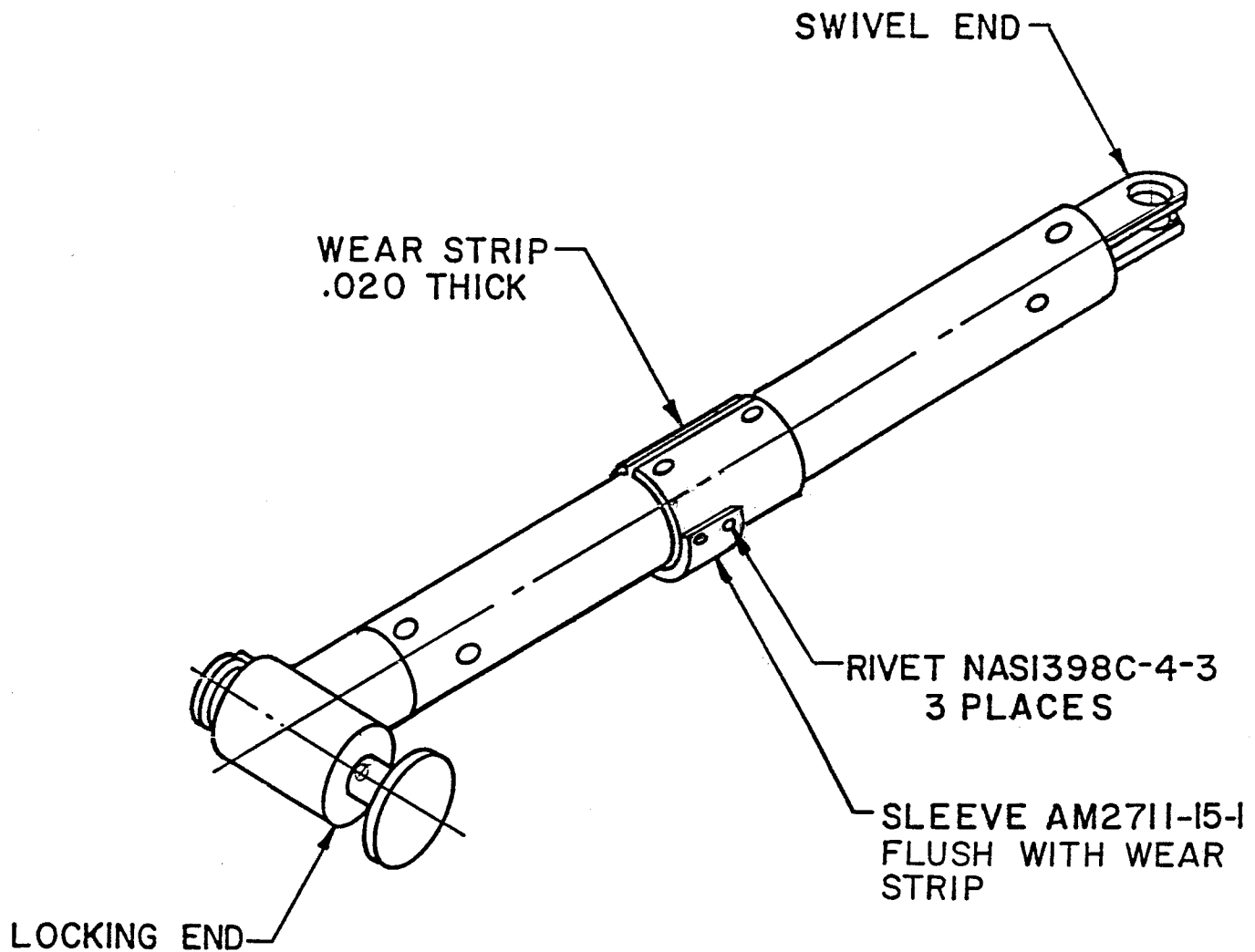


FIGURE 1 - STRUT ASSEMBLY A2711-15

A2711-78-1