



# 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

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## 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.

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## 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.

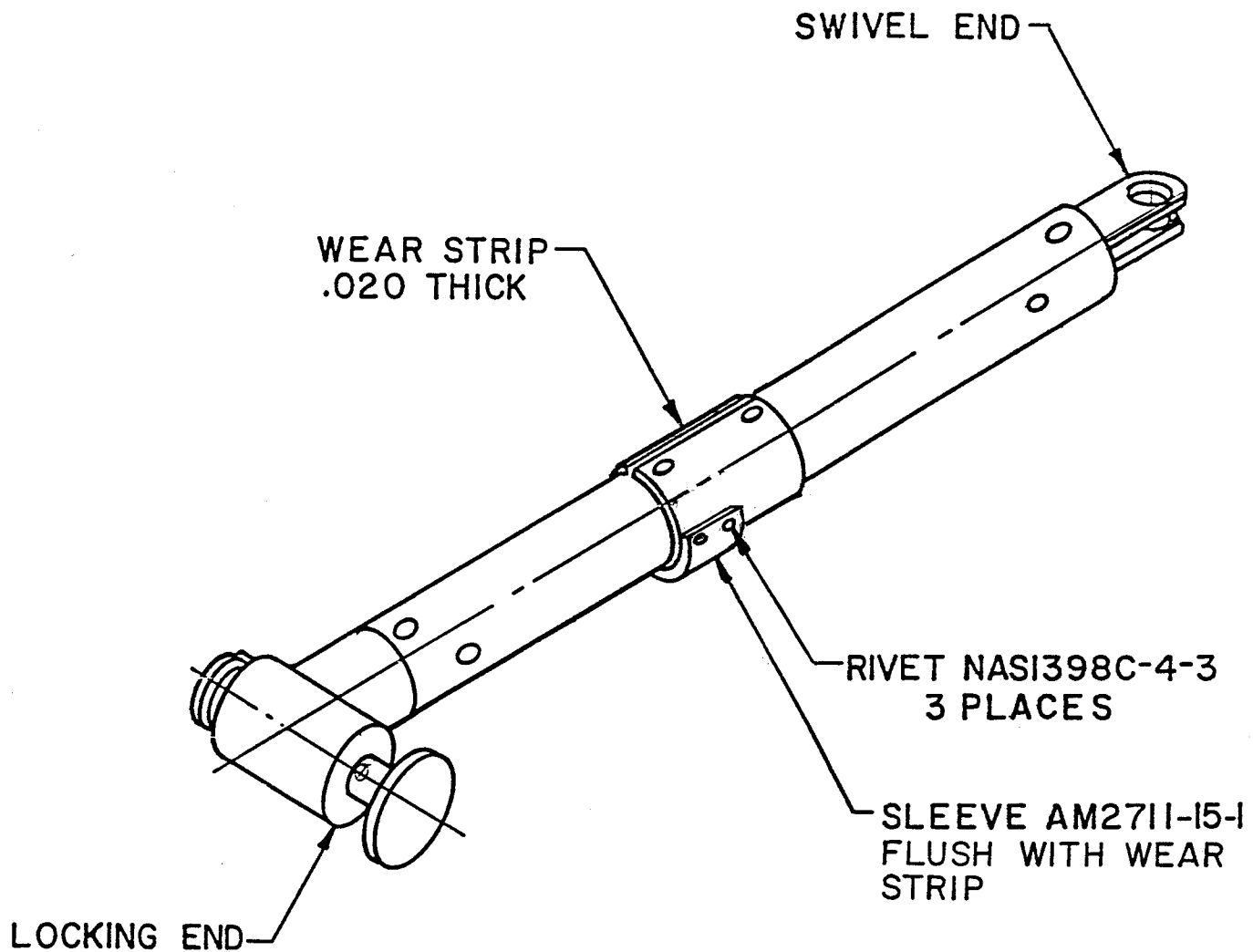
<u>Item #</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
1	AM2711-15-2	1	Sleeve
2	NAS1398C-4-3	3	Rivet

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**FIGURE 1 - STRUT ASSEMBLY A2711-15**

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