



8301 Imperial Dr.
Waco, Texas 76712

SERVICE BULLETIN

NO. A2711-78-2

POWER PLANT - COWLING - HOLD OPEN ROD
REPLACE TUBE RIVETS

I PLANNING INFORMATION

A. Effectivity

(1) Component Affected

This Service Bulletin affects hold open rods NORCO Part Nos. A2711-1 through A2711-11 and A2711-15 through A2711-17 that are removed from aircraft for routine maintenance. Not mandatory.

(2) Spares Affected

This Service Bulletin does not affect those Part Nos. A2711-1 through A2711-11 and A2711-15 through A2711-17 units that are in airline spares.

B. Reason

The incorporation of this Service Bulletin will improve maintainability of the hold open rod in the field.

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C. Description

This Service Bulletin provides detailed instructions required for all users to rework Norco part numbers A2711-1 through A2711-11 and A2711-15 through A2711-17. The rework consists of replacing four rivets in the tube with a vibration resistant hex drive bolt and collar. This will allow aircraft operators to replace the end fittings, when required, and quickly assemble the unit with bolts instead of spun rivets.

D. Approval

The repair and modifications herein comply with the applicable Federal Aviation Regulations (FARs) and are approved by Rohr Inc.

E. Manpower

Replace four rivets	.50 hrs.
TOTAL	.50 hrs.

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F. Material Cost and Availability

The parts identified in Section III, A. may be obtained from NORCO, INC. as follows:

<u>Part No.</u>	<u>Description</u>	<u>Availability</u>	<u>Price</u>
RW2711	Rework Kit, Hold Open Rod	7 - 15 Days	\$45.00

The purchase order should specify this Service Bulletin number.

DIRECT PURCHASE ORDER TO:

MarathonNorco Aerospace, Inc.
8301 Imperial Dr.
Waco, Texas 76712
254-776-0650 Main Line
254-776-6558 Fax

G. Tooling - Cost and Availability

Not applicable.

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H. Weight

The effect of this service bulletin on weight and balance is negligible.

I. Other Publications Affected

Component Maintenance Manuals No. 71-10-33, 71-10-34, and 71-10-35 for Hold Open Rod, Part No.'s A2711-1 through A2711-11 and A2711-15 through A2711-17 to be changed accordingly.

II. ACCOMPLISHMENT INSTRUCTIONS

- A. Drill out two (2) of four (4) MS20613-4C14 rivets, item 40, shown in Figure 1. Select one rivet on each end of the tube (50). Drill through the undeformed rivet head using a 0.125 inch (3.175 mm) diameter drill. Remove the remaining part of the rivet with a 0.125 inch (3.175 mm) diameter punch.
- B. Drill out two (2) rivet holes to 0.166 inch (4.216 mm) using a No. 19 drill. Insert two (2) hex drive bolts, 135C0162-01, in the drilled out holes. Thread on two (2) collars, 130A0164-01, and tighten using a 0.3125 inch (7.94 mm) wrench until the end of the collar shears off. Torque to shear off should be 15 - 25 in. lbs.
- C. Repeat Steps A and B for remaining two (2) rivets.

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- D. Clean area immediately following NORCO P/N A2711-1 through A2711-11 and A2711-15 through A2711-17 by rubbing with wiper damped with Aliphatic Naphtha, TT-N-95, or equivalent, until soil is removed. Do not allow solvent to evaporate. Avoid removing pretreatment or finish coating. After soil is removed, wipe the area dry with a clean dry wiper. Using rubber stamp letter size 1/8" to 3/16" and Alcosol or F-100 stamp pad ink, or equivalent, apply the letter "R" immediately following the dash number. Clean stamp with naphtha, or equivalent, as required, for mark legibility and sharpness. Allow ink to dry at least ten minutes and overcoat with Bostik 683-3-2 or 683-3-9 or equivalent.

III MATERIAL INFORMATION

A. Parts Required Per Hold Open Rod

A Rework kit part number RW2711 is available and contains the following parts.

Rework Kit RW2711

<u>Item No.</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
1	135CO162-01	4	Bolt
2	130AO164-01	4	Collar

B. Parts Required to Modify Spares

(If applicable) Same parts as items III A, above.

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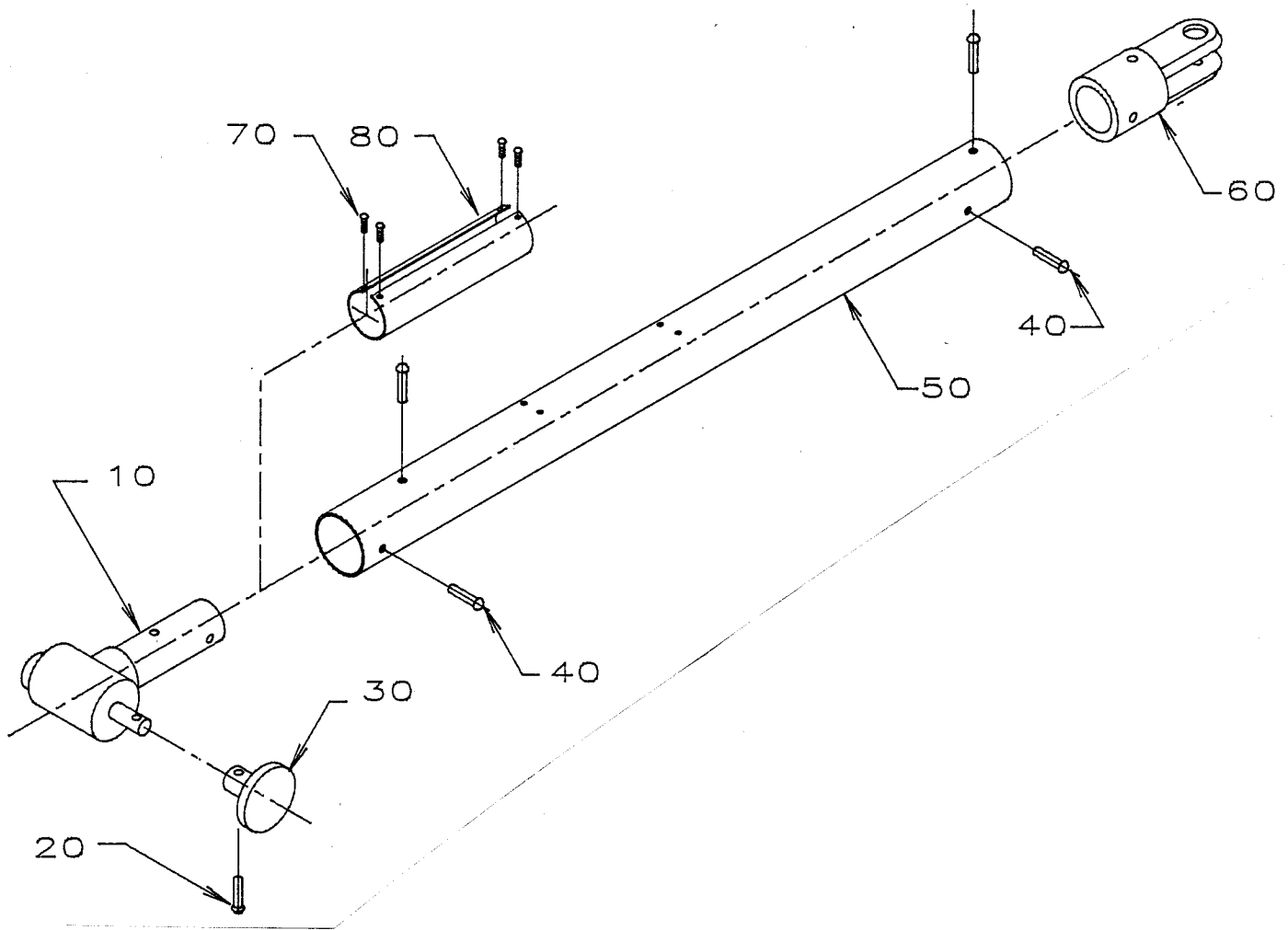


FIGURE 1 - TYPICAL A2711 STRUT ASSEMBLY

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