



8301 Imperial Dr.
Waco, Texas 76712

SERVICE BULLETIN

NO. A2866-71-1

POWER PLANT - FAN COWLING - HOLD OPEN ROD
BOND WEAR STRIP

I PLANNING INFORMATION

A. Effectivity

(1) Component Affected

This Service Bulletin affects hold open rods NORCO Part No.'s A2866-3 and A2866-4, Rohr Part No.'s 285-21103 and 285-21104 respectively.

(2) Spares Affected

This Service Bulletin affects those Part No.'s A2866-3 and A2866-4 units that are in airline spares.

B. Reason

The incorporation of this Service Bulletin will replace the attachment rivets of the wear strip with a bonded joint to prevent interference with the stowage clip.

C. Description

This Service Bulletin is to inform all users of the procedures and the detailed instructions required for reworking Norco strut assemblies A2866-3 and A2866-4. The rework requires removing the riveted wear strip and reattaching by bonding.

D. Approval

This Service Bulletin has been reviewed by Federal Aviation Administration (FAA). The repair and modifications herein comply with the applicable Federal Aviation Regulations (FARs) and are approved by FAA and Rohr Industries.

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E. Manpower

Required to remove Strut Assembly from Aircraft	.5 hrs.
Remove Wear Strip and Bond	1.0 hrs.
Replace Strut Assembly in Aircraft (24 Hrs. Required Before Reinstallation)	.5 hrs.
TOTAL	2.0 hrs.

F. Material Cost and Availability

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

<u>Part No.</u>	<u>Description</u>	<u>Availability</u>	<u>Price</u>
RW2866-1	Rework Kit, Hold Open Rod	30 days	\$12.00

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.

H. Weight and Balance

Incorporation of this Service Bulletin will not increase the weight of the Strut Assembly. The effect on balance is negligible.

I. Other Publications Affected

Component Maintenance Manual No. 71-10-18 for Hold Open Rod, Part No. A2866-3 and A2866-4 to be changed accordingly.

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II. ACCOMPLISHMENT INSTRUCTIONS

A. Disassembly (See Figure 1)

- (1) Drill out two rivets (27) using a 0.125 inch (3.175 mm) diameter drill. Remove end plug (26) and lock assembly (14).
- (2) Drill out four rivets (9) using a 0.125 inch (3.175 mm) diameter drill. Remove clamp assembly (8) from tube (28).

B. Assembly (See Figures 1 and 2)

- (1) Remove any burrs around drilled out rivet holes.
- (2) Clean inside surface of wear sleeve (12) and outside surface of tube (28) in area to be bonded. Clean parts with lint-free cloth moist with dry cleaning solvent, 1-1-1 trichloroethane or equivalent.

WARNING: SOLVENT IS TOXIC AND FLAMMABLE. USE ONLY IN A WELL VENTILATED AREA. KEEP AWAY FROM OPEN FLAME. AVOID BREATHING FUMES OR PROLONGED CONTACT WITH SKIN.

- (3) Apply a thin layer of Masterbond Supreme 11 HT Epoxy Adhesive uniformly over area to be bonded. Slide clamp over end of tube (28) and position end of wear sleeve (12) 3.41 inches from the face of lock body (19) as shown in Figure 2. Rotate wear sleeve (12) so rivet holes are not aligned with holes in tube (28). Wipe off excess adhesive. Do not move for 12 hours. Allow 36 hours cure time at room temperature (70°F min.) before reinstalling in aircraft.
- (4) Insert end plug (26) and lock assembly (14) into end of tube (28) and align rivet holes. Insert two new rivets (27) and set heads by spinning.

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- (5) Clean area immediately following NORCO P/N A2866-3 or -4 by rubbing with wiper dampened with Aliphatic Naphtha, TT-N-94, or equivalent. Do not allow solvent to evaporate. Avoid removing pretreatment or finish coating. 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 dash number "M" immediately following P/N 2866-3 or -4. Clean stamp with naphtha, or equivalent, as required, for marking legibility and sharpness. Allow ink to dry at least 10 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 is available, part number RW2866-1 which contains the following parts required to rework each hold open rod, part numbers A2866-3 and A2866-4.

<u>Item No.</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
27	MS20613-4C22	2	Rivet

Item numbers correspond to those shown in Figures 1 and 2.

B. Parts Required to Modify Spares

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

C. Adhesive Required

Masterbond Supreme 11 HT is a two-part room temperature curing epoxy adhesive. Direct purchase order to:

Master Bond Inc.
154 Hobart Street
Hackensack, New Jersey 07601
201-343-8983

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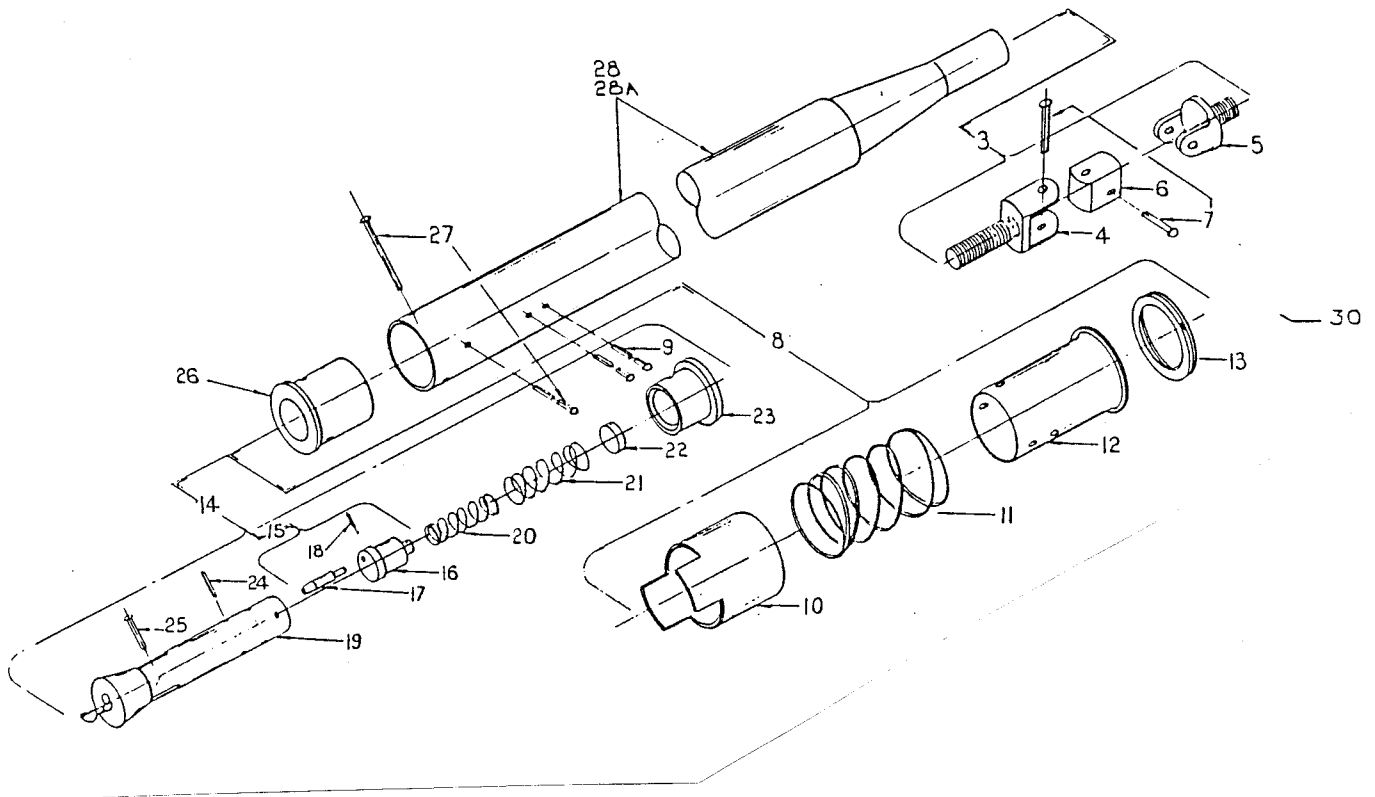


FIGURE 1 - A2866-3 AND -4 STRUT ASSEMBLY
EXPLODED VIEW

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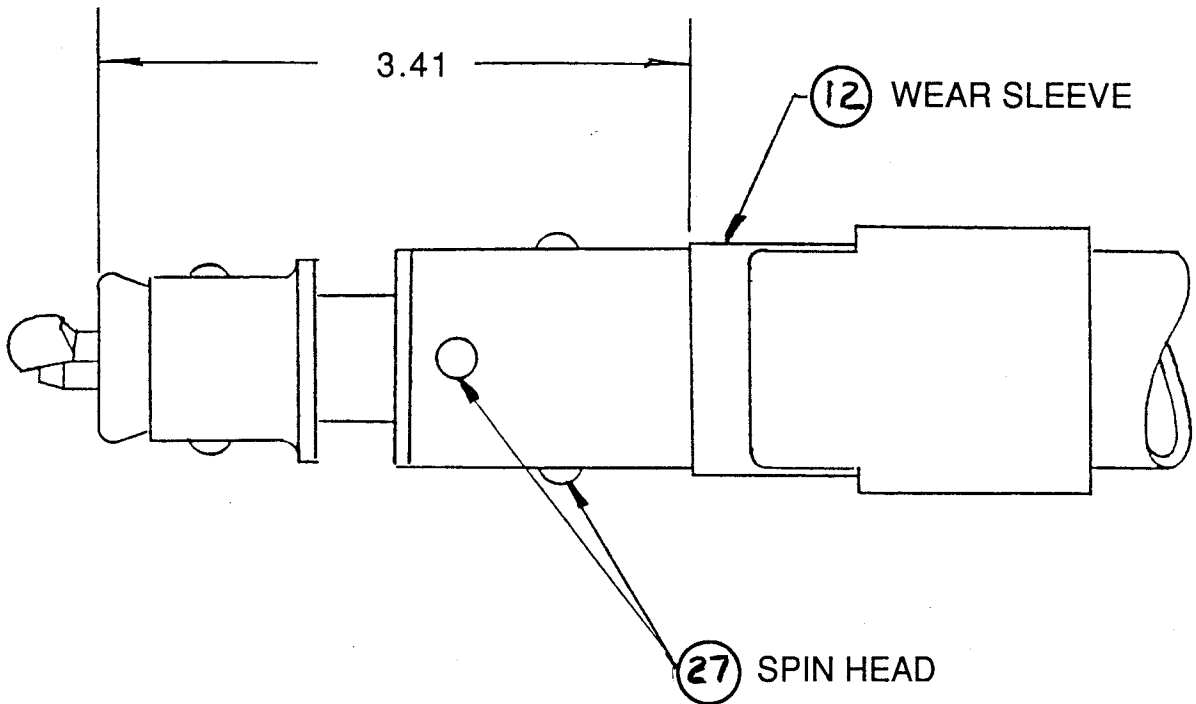


FIGURE 2 - WEAR SLEEVE LOCATION

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