

SERVICE BULLETIN

NO. A2898-71-1

POWER PLANT - FAN COWLING - HOLD OPEN ROD REPLACEMENT OF SECONDARY LOCK

I PLANNING INFORMATION

A. Effectivity

(1) Component Affected

This Service Bulletin affects hold open rods NORCO Part No. A2898-1 (Per Boeing Specification Part No. S314T221-1) that are in service installed on Boeing manufactured aircraft.

(2) Spares Affected

This Service Bulletin affects those Part No. A2898-1 units in airline spares stores, if applicable.

B. Reason

The incorporation of this Service Bulletin will replace the secondary lock with a locking pin to prevent inadvertent unlocking of the hold open rod in the extended and locked position.

C. Description

This Service Bulletin is to inform all users of the procedures and the detailed instructions required for reworking Norco part number A2898-1. The rework requires removing the secondary lock and installing a locking pin.

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 The Boeing Company.

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E. Manpower

Required to remove Strut Assembly from Aircraft	.5 hrs.
Remove Secondary Lock and install Locking Pin	2.0 hrs.
Replace Strut Assembly in Aircraft	.5 hrs.
TOTAL	3.0 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>
RW2898-1	Rework Kit, Hold Open Rod	30 days	\$185.00

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. 71-10-43 for Hold Open Rod, Part No. A2898-1 to be changed accordingly.

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II. ACCOMPLISHMENT INSTRUCTIONS

A. Disassembly (See Figure 1)

- (1) Remove secondary lock housing from collar (40) by breaking six spot welds along two sides of rectangular housing. Use a hammer and chisel to break welds. Remove sharp edges on broken welds. Scrap housing, safety latch (44, 43, 42, 41), and spring (45).
- (2) Drill out two rivets (131) using a 0.125 inch (3.175 mm) diameter drill. Remove end fitting (130).
- (3) Drill out two rivets (121) and (101) using a 0.156 inch (3.962 mm) diameter drill. Remove plug (120) spring (110) and damper (100) from end of outer tube (80). Check "O" ring (90) for cuts and wear. Replace if worn or cut.

B. Assembly (See Figures 1 and 2)

- (1) Extend strut to its fully extended and locked position. Locate hole for locking pin at 2.295 inches (58.29 mm) from face of outer tube (80) as shown in figure 3.
- (2) Drill 0.250 inch (6.35 mm) diameter hole through both sides of outer tube (80). Deburr edges of holes and completely remove metal chips from inside of outer tube (80).

CAUTION: METAL CHIPS LEFT INSIDE THE OUTER TUBE (80) WILL CAUSE SEVERE DAMAGE.

- (3) Slide damper (100) with "O" ring (90) into end of outer tube (80) and align the slot in the damper (100) with the innermost hole in the outer tube (80). Insert rivet (101) and form head by spinning against outer tube (80).
- (4) Place spring (110) and plug (120) into end of outer tube (80). Align hole in plug (120) with second innermost hole in outer tube. Insert rivet (121) and form head by spinning against outer tube (80).

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- (5) Insert end fitting (130) into end of outer tube (80) and align two rivet holes. Insert two rivets (131) and form heads by spinning against outer tube (80). Rivet heads should contact outer tube (80) surface except where tube curvature causes a gap.
- (6) To assemble the secondary locking pin (163), place the end of the cable assembly (166) over one large cushioned clamp (168). Slip the cushioned clamp (168) with cable assembly (166) over the rod end of the outer tube (80). Position the edge of the cushioned clamp (168) 0.750 inch (19.05 mm) from the center of the 0.250 inch (6.35 mm) hole in the outer tube. Slip the second cushioned clamp (168) over the end of the outer tube (80) and position the outer edges of the clamps (168) 1.25 inches (31.7 mm) apart. Attached the small cushioned clamps (167) to the large cushioned clamps (168) with bolts (162) and nuts (161). Align holes in small cushioned clamps (167) by inserting pin retainer (164) prior to tightening bolts (162) and nuts (161).
- (7) Secure locking pin (163) to cable assembly (166) with ferrule (165). Check for satisfactory operation of secondary locking pin (163) by extending hold open rod to its locked position and inserting locking pin in 0.250 inch (6.35 mm) hole in outer tube (80).
- (8) Clean area immediately following NORCO P/N A2898 by rubbing with wiper dampened with Aliphatic Naphtha, TT-N-94, 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 dash number "-1M" immediately following P/N 2898. 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.

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III MATERIAL INFORMATION

A. Parts Required Per Hold Open Rod

A rework kit is available, part number RW2898-1 which contains the following parts required to rework each hold open rod, part number A2898-1.

<u>Item No.</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
121	MS20613-5C20	2	Rivet
131	MS20470AD4-20	2	Rivet
161	BACN10JC3CD	2	Nut
162	BACB30NT3K2	2	Bolt
163	CL4BLPB18S	1	Pin
164	AM2724-5-2	1	Retainer
165	BACF22U2	1	Ferrule
166	BACC13Y3B50	1	Cable
167	MS21919WCJ5	2	Clamp
168	MS21919WCJ18	2	Clamp

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.

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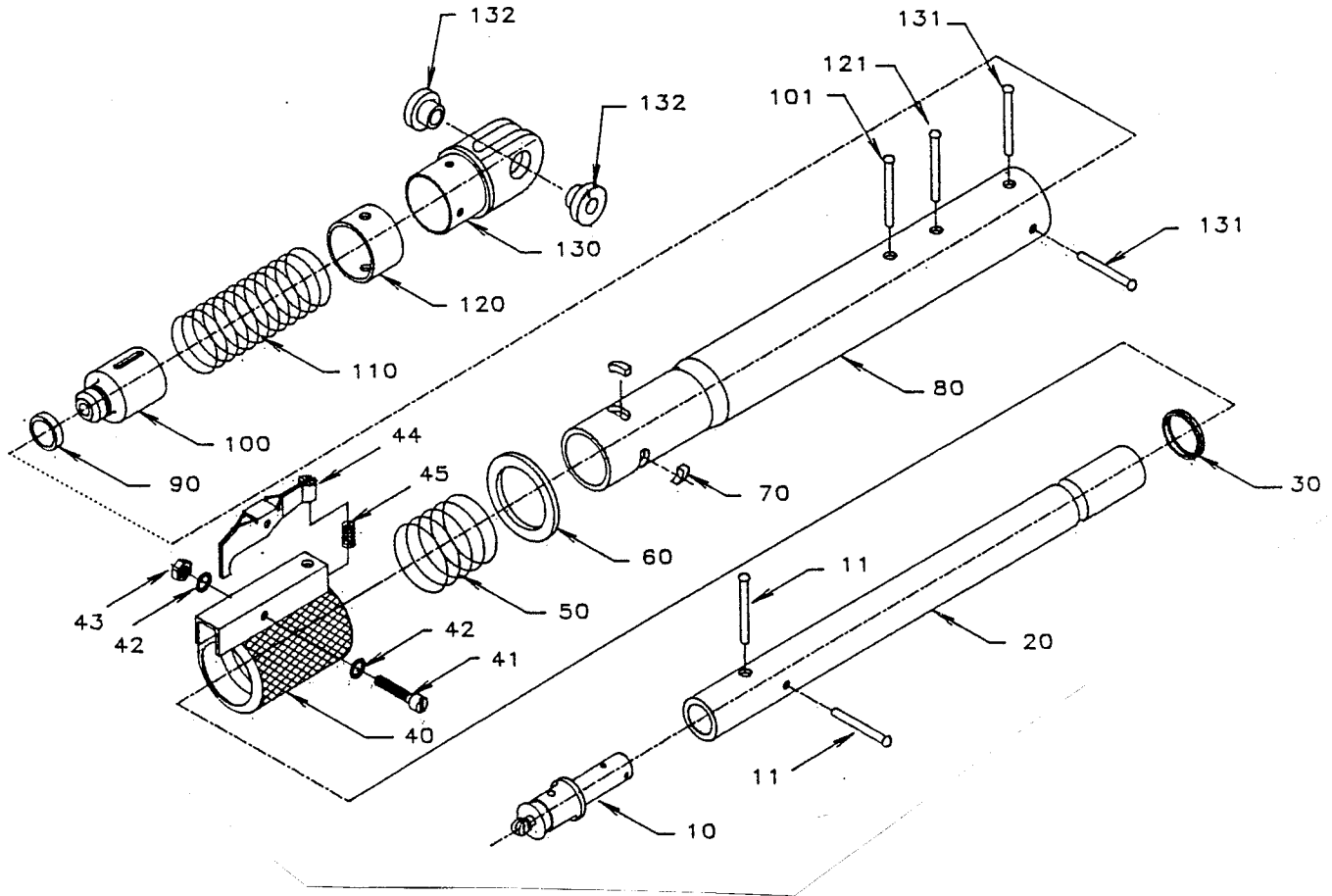


FIGURE 1 - A2898-1 STRUT ASSEMBLY
EXPLODED VIEW

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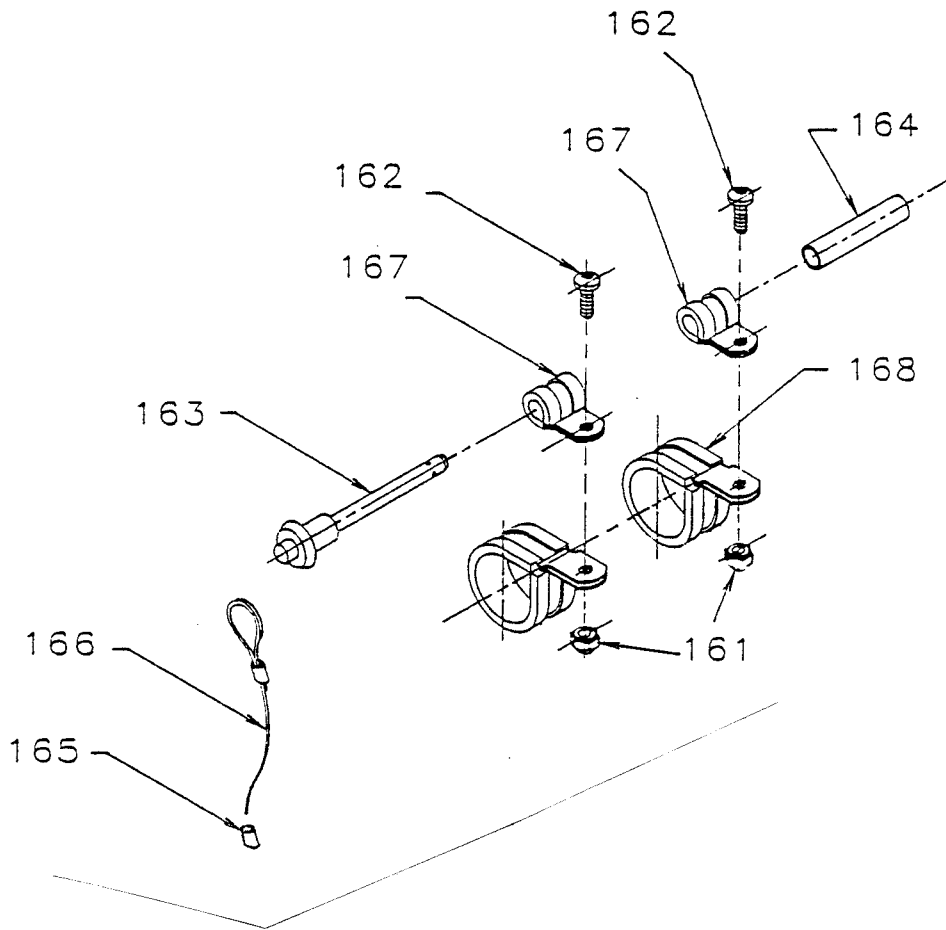


FIGURE 2 - LOCKING PIN ASSEMBLY
EXPLODED VIEW

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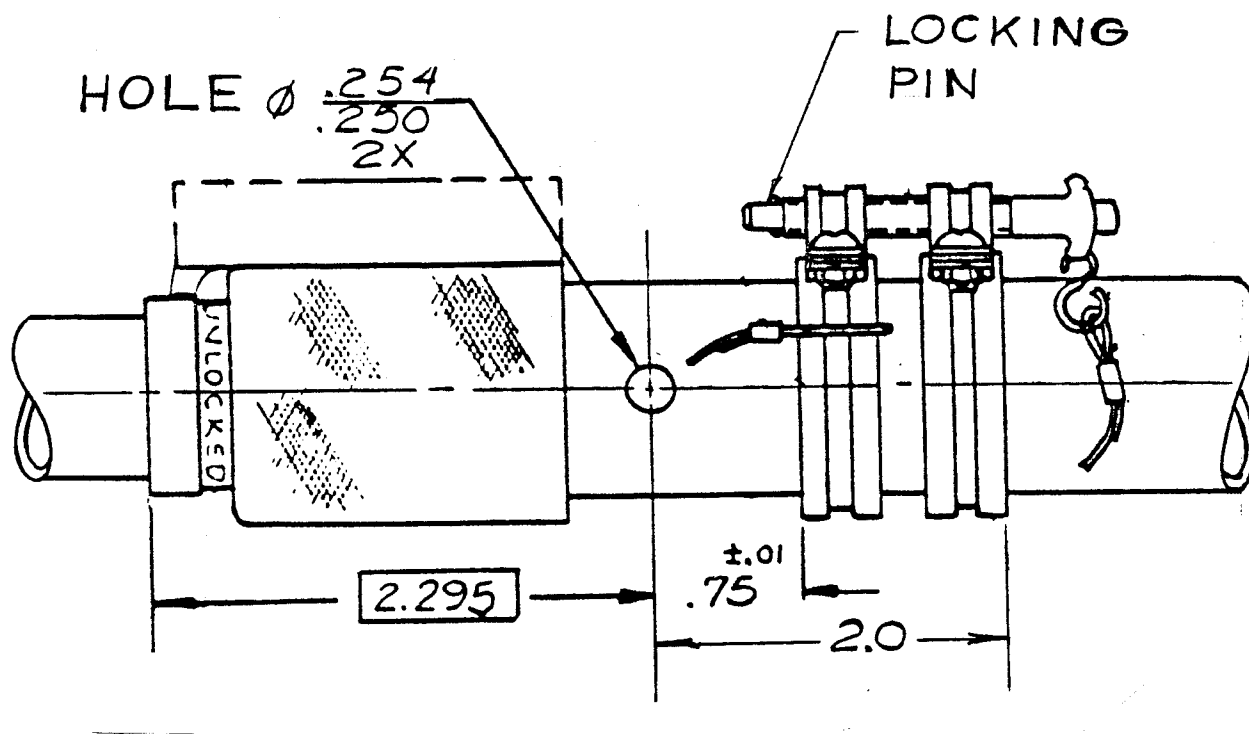


FIGURE 3 - LOCKING PIN ASSEMBLY

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