



8301 Imperial Dr  
Waco, Texas 76712

# SERVICE BULLETIN

## NO. A3312-71-1

POWER PLANT-FAN COWL-HOLD OPEN ROD  
REPLACE OUTER TUBE RIVETS

### I. PLANNING INFORMATION

#### A. Effectivity

##### (1) Component Affected

This Service Bulletin affects hold open rods Norco P/N A3312-1, Rohr P/N 277D1250-501, with the following serial numbers:

S/N 0005-0016  
S/N 0100-0122  
S/N 0200-0208

These rods are installed in CF6-80EI engine nacelles on Airbus A330 aircraft.

#### B. Reason

The incorporation of this service bulletin will prevent rivet shear failure due to vibration.

#### C. Description

This service bulletin provides detailed instructions required for all users to rework Norco P/N A3312-1, Rohr P/N 277D1250-501. The rework consists of removing the four (4) rivets in the rear end of the outer tube and replacing them with four (4) higher strength rivets.

#### D. Approval

The repair and modifications herein comply with applicable Federal Aviation Regulations (FAR).

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E. Manpower

Required to remove rod from aircraft	.25 hours
Replace outer tube rivets	.5 hours
Replace strut in aircraft	.25 hours
<b>TOTAL</b>	<b>1.0 hours</b>

Rods may be returned to Norco for replacement of the rivets at no charge to the user. If the user prefers to replace the rivets with the available rework kit, RW3312-1, labor costs will be reimbursed at the rate of \$15.00/hour up to a maximum of \$15.00.

F. Material Cost and Availability

The parts identified in Section IIIA. may be obtained from Norco, Inc. as follows:

<i>PART NO.</i>	<i>DESCRIPTION</i>	<i>AVAILABILITY</i>	<i>PRICE</i>
RW3312-1	Rework Kit, Hold Open Rod	7-15 days	No Charge

The purchase order should specify this Service Bulletin number.

Direct Purchase Orders 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

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

I. Other Publications Affected

Component Maintenance Manual No. 71-10-49 to be changed accordingly.

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## II. ACCOMPLISHMENT INSTRUCTIONS

- A. Drill out four (4) rivets in outer tube, shown in Figure 1, using a No. 19 drill (.166 inch diameter).
- B. Place a mark on the outer tube and end cap to indicate alignment of the four holes. Remove end cap assembly from the outer tube.
- C. Remove all metal chips from the end cap assembly and inside of the outer tube.
- D. Place end cap assembly back into end of outer tube and align rivet holes using marks placed on outer tube and end cap before disassembly.
- E. Install four (4) MS21141-0503 rivets using a double action tool as indicated on sheet 1 of the attached Military Standard MS21141.
- F. Clean area immediately following NORCO P/N A3312-1 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 "M" immediately following the dash number "-1". 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 is available, part number RW3312-1 which contains the following parts required to rework each hold open rod, part number A3312-1.

<u>Item No.</u>	<u>P/N's Provided</u>	<u>Quantity</u>	<u>Keyword</u>
1	MS21141-0503	4	Rivet

### B. Parts Required to Modify Spares

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

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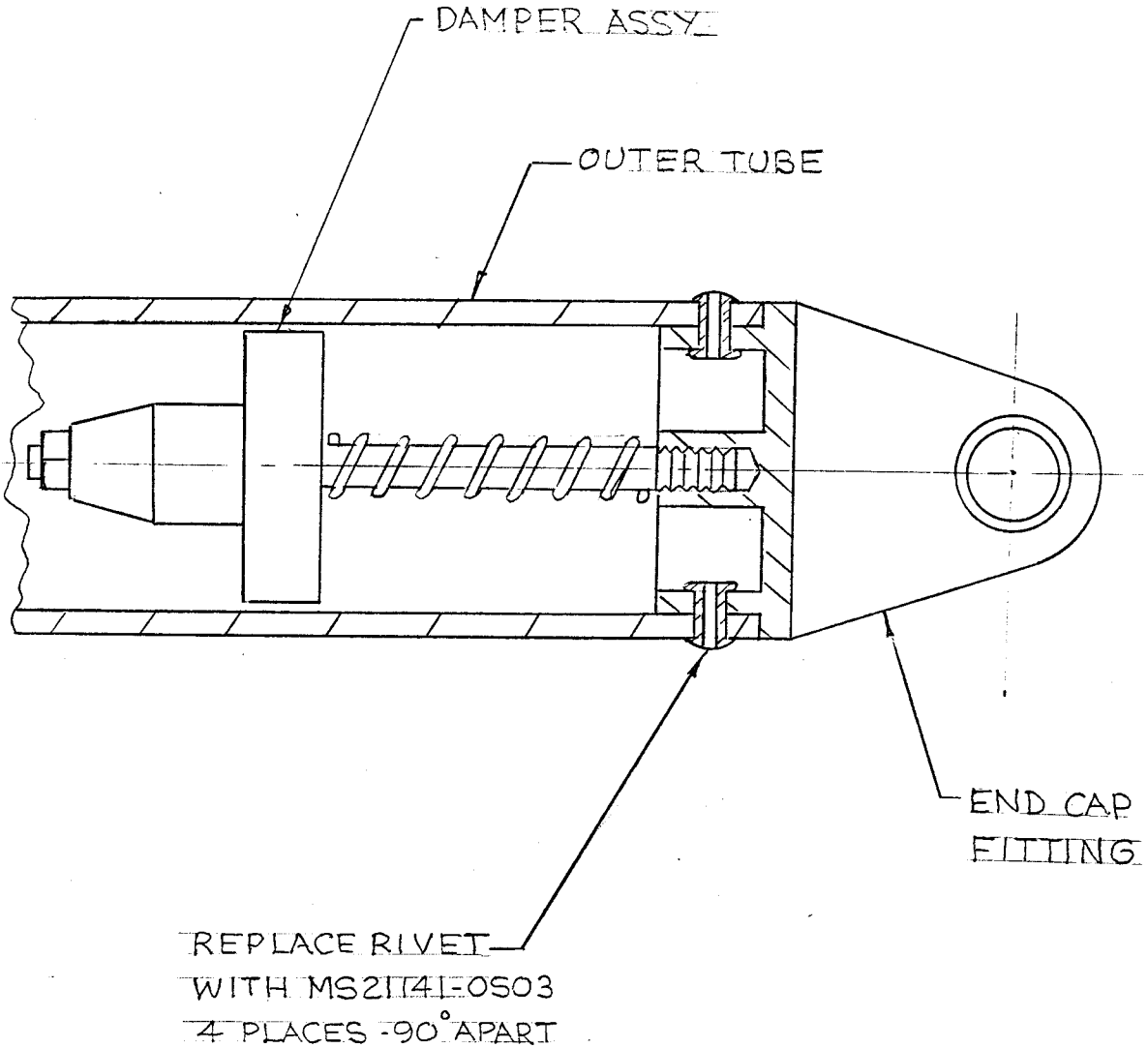


FIGURE 1 — OUTER TUBE AND END CAP

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