

SERVICE BULLETIN**FUSELAGE - INSTALLATION OF DRAG REDUCING MICROVANES ON C-130J AIRCRAFT AFT FUSELAGE****1. PLANNING INFORMATION****A. EFFECTIVITY**

- (1) This Service Bulletin is applicable to model 382U and 382V series Hercules aircraft only. For these aircraft models all aircraft are affected.
- (2) Aircraft without large fairings (blisters) on the aft fuselage require kits A and B. Aircraft with large fairings (blisters) on the aft fuselage require kits C and D.
- (3) Spares - This Service Bulletin is not applicable to spares.

B. REASON

- (1) Lockheed Martin Aeronautics Company, in an effort to increase aircraft efficiency and reduce operator fuel costs, has designed and tested a set of twenty microvanes to be installed onto the aft fuselage. These microvanes delay separation of aft-body flow resulting in a reduction of base drag which provides for a significant increase in fuel efficiency. This Service Bulletin provides the instructions for installing the two sets of ten microvanes on the left and right hand sides of the C-130J aft fuselage using specially designed tooling.
- (2) Lockheed Martin Aeronautics Company recommends that this modification be accomplished on each affected aircraft at the next convenient maintenance opportunity.

C. DESCRIPTION

This Service Bulletin provides the instructions for installing the two sets of ten microvanes on the left and right hand sides of the C-130J aft fuselage using specially designed tooling.

D. APPROVAL

- (1) The aircraft owner/operator will make an appropriate entry in the aircraft log records upon compliance with this Service Bulletin.
- (2) When the work has been completed on each affected aircraft, please complete and e-mail a Notice of Service Bulletin Compliance to hercules.support@lmco.com.

E. MANPOWER

The manpower estimates provided have not been validated and are estimates only. These estimates are provided only as a convenience for customer planning purposes. It is estimated that approximately 80 man-hours (a crew of 2 qualified technicians) will be required to accomplish the work described herein on each affected aircraft. This will take approximately 40 hours elapsed time while the aircraft is out of service.

EXPORT CONTROLLED INFORMATION

WARNING - This document contains data whose export is restricted by the Arms Export Control Act (Title 22, U.S.C., Sec 2751, et seq.) as amended, or the Export Administration Act (Title 50, U.S.C., App 2401 et seq.) as amended. Violations of these export laws are subject to severe criminal and civil penalties.

THIS DOCUMENT CONTAINS COMMERCIAL PROPRIETARY TECHNICAL DATA OF LOCKHEED MARTIN CORPORATION AND OTHERS. USE, COPYING AND/OR DISCLOSURE OF THE TECHNICAL DATA CONTAINED HEREIN IS GOVERNED BY THE TERMS OF LOCKHEED MARTIN CORPORATION'S C-130J SALES CONTRACT WITH THE CUSTOMER.

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NOTE: This Service Bulletin is based upon the configuration of the aircraft as it was delivered from Lockheed Martin Aeronautics Company. Previous service bulletins issued by Lockheed Martin Aeronautics Company have been considered in the preparation of this Service Bulletin, but no consideration has been given to peculiar changes made to the aircraft by the owner/operator since its delivery.

F. MATERIAL - COST AND AVAILABILITY

Refer to Paragraph 3 for a complete list of kits/parts/materials to modify each aircraft.

Parts/Materials required to accomplish this Service Bulletin for each aircraft, may be obtained from Metro Aerospace, LLC. Direct all inquiries concerning price and availability to the following:

MAIL: Metro Aerospace, LLC
Microvane Support
19031 SE Outrigger Lane
Jupiter, FL 33458 USA

TELEPHONE: (469) 730-6966

G. TOOLING - PRICE AND AVAILABILITY

These fixtures will be furnished to using activities as a separate purchase from Metro Aerospace, LLC.

Part Number	Nomenclature
3368269-1-LF	Locating Fixture
3368269-2-LF	Locating Fixture
3369284-1-LF	Locating Fixture
3369284-2-LF	Locating Fixture

H. WEIGHT AND BALANCE

Make appropriate entries in aircraft Handbook Of Weight And Balance Data, Basic Weight And Balance Record, or Basic Weight And Moment Record upon completion of the work prescribed in this publication.

Total Net Change:	Weight (Pounds)	Arm (Inches)	Moment/1000 (inch-pounds)
382U	7.5	932.2	7.0
382V	7.5	1212.2	9.1

I. REFERENCES

Job Guide S/S/SN 00-10-01, 00-20-02, 52-00-01, 52-00-02

Structural Repair Manual

Corrosion Prevention and Control Manual

J. OTHER PUBLICATIONS AFFECTED

Job Guide
Illustrated Parts Breakdown

SERVICE BULLETIN**2. ACCOMPLISHMENT INSTRUCTIONS**

WARNING: OBSERVE ALL SAFETY PRECAUTIONS WHILE ACCOMPLISHING THIS MODIFICATION. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY TO PERSONNEL.

DO NOT OPERATE AFT CARGO DOOR WITH LOCATING FIXTURE ATTACHED TO AIRCRAFT. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY TO PERSONNEL.

NOTE: Minor deviations to the following instructions may be required and are authorized as long as the intent of the Service Bulletin is accomplished.

- A. Prepare aircraft for maintenance in accordance with Job Guide, S/S/SN 00-10-01.
- B. Open cargo door in accordance with applicable Job Guide, S/S/SN 52-00-01, 52-00-02 (using auxiliary hydraulic system electric pump or hand pump).
- C. Deactivate auxiliary and utility hydraulic systems in accordance with applicable Job Guide, S/S/SN 00-20-02.
- D. For aircraft equipped with no fairings on the aft fuselage, use Steps E and F for installation. For aircraft equipped with large fairings (blisters) on the aft fuselage, proceed to Steps G and H for installation.
- E. Install 3368269-1 Microvanes Installation, Kit on aircraft aft-body LHS as follows:
 - (1) Assemble and locate 3368269-1-LF Locating Fixture on aircraft. For assembly, location and tooling instruction see Figure 1, Sheet 1 and Sheet 2.
 - (2) Temporarily locate 3368268-1/-3/-5/-7/-9/-11/-13/-15/-17/-19 Microvanes using 3368269-1-LF Locating Fixture and 3368270-401-TSUD. See Figure 2 and Figure 3.
 - (3) If required for proper fit, it is permissible to relieve microvanes for rivet heads and steps using best shop practices to a maximum depth of 0.10 inch. Do not penetrate attachment flange. Otherwise proceed to next step.
 - (4) Mark all microvane outlines on aircraft outer mold line (OML).
 - (5) Reduce size of all outlines by 0.10 inch from marked microvane edge of part (EOP).

WARNING: CHEMICAL CONVERSION COATING, SEALANT, AND ALCOHOL ARE FLAMMABLE AND TOXIC TO THE SKIN, EYES, AND RESPIRATORY TRACT. AVOID SKIN AND EYE CONTACT. GOOD GENERAL VENTILATION IS NORMALLY ADEQUATE. SKIN AND EYE PROTECTION IS REQUIRED. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY TO PERSONNEL.

- (6) Mask area outside of marked locations to protect adjacent aircraft finishes. Remove aircraft finishes to bare metal in marked areas. Do not penetrate clad.
- (7) Treat bare metal with MIL-DTL-81706, Type I, Class 3, Colored Chemical Conversion Coating in accordance with applicable Corrosion Control and Prevention Manual.
- (8) Mix PR-1829, Class B-1/2, Sealant in accordance with manufacturer instructions. Mix only enough sealant to be used within the 30-minute working life of PR-1829, Class B-1/2, Sealant.

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- (9) Apply PR-1829, Class B-1/2, Sealant to underside of microvanes. Ensure all fastener head channels on underside of microvanes are completely filled.
 - (10) Locate 3368268-1/-3/-5/-7/-9/-11/-13/-15/-17/-19 Microvanes using 3368269-1-LF Locating Fixture. Press microvanes onto aircraft using hand pressure not to exceed 5 lbs. Ensure continuous sealant squeeze-out along the microvane EOP. Clean excess squeeze-out with ASTM D 770 Isopropyl Alcohol. See Figure 2 and Figure 3.
 - (11) Remove 3368269-1-LF Locating Fixture from aircraft after a minimum of 30 minutes from start of installation and mixing.
 - (12) Apply Scapa 572 Flash Tape, HM-426 Teflon Tape, or equivalent tape to secure microvanes in proper location and maintain contact pressure on each microvane during cure.
 - (13) After 12 hours of cure time, remove tape applied in previous step.
 - (14) Aerodynamic fillet seal and smooth around periphery of microvanes using STM40-006, Type 1, Class A2 Sealant, or PR-1829, Class B-1/2, Sealant in accordance with applicable Structural Repair Manual.
 - (15) Allow PR-1829, Class B-1/2, Sealant to fully cure. Full cure at room temperature is achieved in 3 days (minimum). Alternatively, cure can be accelerated by heating the bondline at 140 (±5) degrees Fahrenheit for 30 to 45 minutes following the initial 12 hour setup time at room temperature. Thermocouples or other temperature sensors must be used to continuously monitor part temperature to not exceed 160 degrees Fahrenheit.
 - (16) Finish microvanes and affected areas to match existing aircraft paint scheme in accordance with applicable Corrosion Prevention and Control Manual.
- F. Install 3368269-2 Microvanes Installation, Kit on aircraft aft-body RHS as follows:
- (1) Assemble and locate 3368269-2-LF Locating Fixture tool on aircraft. See Figure 1, Sheet 1 and Sheet 2.
 - (2) Temporarily locate 3368268-2/-4/-6/-8/-10/-12/-14/-16/-18/-20 Microvanes using 3368269-2-LF Locating Fixture and 3368270-401-TSUD See Figure 2 and Figure 3.
 - (3) If required for proper fit, it is permissible to relieve microvanes for rivet heads and steps using best shop practices to a maximum depth of 0.10 inch. Do not penetrate attachment flange. Otherwise, proceed to next step.
 - (4) Mark all microvane outlines on aircraft OML.
 - (5) Reduce size of all outlines by 0.10 inch from marked microvane EOP.
- WARNING:** CHEMICAL CONVERSION COATING, SEALANT, AND ALCOHOL ARE FLAMMABLE AND TOXIC TO THE SKIN, EYES, AND RESPIRATORY TRACT. AVOID SKIN AND EYE CONTACT. GOOD GENERAL VENTILATION IS NORMALLY ADEQUATE. SKIN AND EYE PROTECTION IS REQUIRED. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY TO PERSONNEL.
- (6) Mask area outside of marked locations to protect adjacent aircraft finishes. Remove aircraft finishes to bare metal in marked areas. Do not penetrate clad.

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- (7) Treat bare metal with MIL-DTL-81706, Type I, Class 3, Colored Chemical Conversion Coating in accordance with applicable Corrosion Control and Prevention Manual.
 - (8) Mix PR-1829, Class B-1/2, Sealant in accordance with manufacturer's instructions. Mix only enough sealant to be used within the 30-minute working life of PR-1829, Class B-1/2, Sealant.
 - (9) Apply PR-1829, Class B-1/2, Sealant to underside of microvanes. Ensure all fastener head channels on underside of microvanes are completely filled.
 - (10) Locate 3368268-2/-4/-6/-8/-10/-12/-14/-16/-18/-20 Microvanes using 3368269-2-LF Locating Fixture. Press microvanes onto aircraft using hand pressure not to exceed 5 lbs. Ensure continuous sealant squeeze-out along the microvane EOP. Clean excess squeeze-out with ASTM D 770 Isopropyl Alcohol. See Figure 2 and Figure 3.
 - (11) Remove 3368269-2-LF Locating Fixture from aircraft after a minimum of 30 minutes from start of installation and mixing.
 - (12) Apply Scapa 572 Flash Tape, HM-426 Teflon Tape, or equivalent tape to secure microvanes in proper location, and maintain contact pressure on each microvane for 12 hours during initial cure.
 - (13) After 12 hour initial cure, remove tape applied in previous step.
 - (14) Aerodynamic fillet seal and smooth around periphery of microvanes using STM40-006, Type 1, Class A2 Sealant, or PR-1829, Class B-1/2, Sealant in accordance with applicable Structural Repair Manual.
 - (15) Allow PR-1829, Class B-1/2, Sealant to fully cure. Full cure at room temperature is achieved in 3 days (minimum). Alternatively, cure can be accelerated by heating the bondline at 140 (±5) degrees Fahrenheit for 30 to 45 minutes following the initial 12 hour setup time at room temperature. Thermocouples or other temperature sensors must be used to continuously monitor part temperature to not exceed 160 degrees Fahrenheit.
 - (16) Finish microvanes and affected areas to match existing aircraft paint scheme in accordance with applicable Corrosion Prevention and Control Manual.
- G. Install 3369284-1 Microvanes Installation, Kit on aircraft aft-body LHS as follows:
- (1) Assemble and locate 3369284-1-LF Locating Fixture on aircraft. For assembly, location and tooling instruction see Figure 4, Sheet 1 and Sheet 2.
 - (2) Temporarily locate 3369283-1/-3/-5/-7/-9/-11/-13/-15/-17/-19/-21 Microvanes using 3369284-1-LF Locating Fixture and 3329284-1/-2-TSUD. See Figure 5 and Figure 6.
 - (3) If required for proper fit, it is permissible to increase depth of cuts in microvanes for rivet heads and steps using best shop practices to a maximum depth of 0.10 inch. Do not penetrate attachment flange. Otherwise proceed to next step.
 - (4) Mark all microvane outlines on aircraft outer mold line (OML).
 - (5) Reduce size of all outlines by 0.10 inch from marked microvane edge of part (EOP).

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- (6) Mask area outside of marked locations to protect adjacent aircraft finishes. Remove aircraft finishes to bare metal in marked areas. Do not penetrate clad.
 - (7) Treat bare metal with MIL-DTL-81706, Type I, Class 3, Colored Chemical Conversion Coating in accordance with applicable Corrosion Control and Prevention Manual.
 - (8) Mix PR-1829, Class B-1/2, Sealant in accordance with manufacturer instructions. Mix only enough sealant to be used within the 30-minute working life of PR-1829, Class B-1/2, Sealant.
 - (9) Apply PR-1829, Class B-1/2, Sealant to underside of microvanes. Ensure all fastener head channels on underside of microvanes are completely filled.
 - (10) Locate 3369283-1/-3/-5/-7/-9/-11/-13/-15/-17/-19/-21 Microvanes using 3369284-1-LF Locating Fixture. Press microvanes onto aircraft using hand pressure not to exceed 5 lbs. Ensure continuous sealant squeeze-out along the microvane EOP. Clean excess squeeze-out with ASTM D 770 Isopropyl Alcohol. See Figure 5 and Figure 6.
 - (11) Remove 3369284-1-LF Locating Fixture from aircraft after a minimum of 30 minutes after installation of the last microvane.
 - (12) Apply Scapa 572 Flash Tape, HM-426 Teflon Tape, or equivalent tape to secure microvanes in proper location and maintain contact pressure on each microvane during cure.
 - (13) After 12 hours of cure time, remove tape applied in previous step.
 - (14) Aerodynamic fillet seal and smooth around periphery of microvanes using STM40-006, Type 1, Class A2 Sealant, or PR-1829, Class B-1/2, Sealant in accordance with applicable Structural Repair Manual.
 - (15) Allow PR-1829, Class B-1/2, Sealant to fully cure. Full cure at room temperature is achieved in 3 days (minimum). Alternatively, cure can be accelerated by heating the bondline at 140 (±5) degrees Fahrenheit for 30 to 45 minutes following the initial 12 hour setup time at room temperature. Thermocouples or other temperature sensors must be used to continuously monitor part temperature to not exceed 160 degrees Fahrenheit.
 - (16) Finish microvanes and affected areas to match existing aircraft paint scheme in accordance with applicable Corrosion Prevention and Control Manual.
- H. Install 3369284-2 Microvanes Installation, Kit on aircraft aft-body RHS as follows:
- (1) Assemble and locate 3369284-2-LF Locating Fixture tool on aircraft. See Figure 4, Sheet 1 and Sheet 2.
 - (2) Temporarily locate 3369283-2/-4/-6/-8/-10/-12/-14/-16/-18/-20/-22 Microvanes using 3369284-2-LF Locating Fixture and 3329284-1/-2-TSUD. See Figure 5 and Figure 6.

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- (3) If required for proper fit, it is permissible to increase depth of cuts in microvanes for rivet heads and steps using best shop practices to a maximum depth of 0.10 inch. Do not penetrate attachment flange. Otherwise, proceed to next step.
- (4) Mark all microvane outlines on aircraft OML.
- (5) Reduce size of all outlines by 0.10 inch from marked microvane EOP.

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 - (8) Mix PR-1829, Class B-1/2, Sealant in accordance with manufacturer's instructions. Mix only enough sealant to be used within the 30-minute working life of PR-1829, Class B-1/2, Sealant.
 - (9) Apply PR-1829, Class B-1/2, Sealant to underside of microvanes. Ensure all fastener head channels on underside of microvanes are completely filled.
 - (10) Locate 3369283-2/-4/-6/-8/-10/-12/-14/-16/-18/-20/-22 Microvanes using 3369284-2-LF Locating Fixture. Press microvanes onto aircraft using hand pressure not to exceed 5 lbs. Ensure continuous sealant squeeze-out along the microvane EOP. Clean excess squeeze-out with ASTM D 770 Isopropyl Alcohol. See Figure 5 and Figure 6.
 - (11) Remove 3369284-2-LF Locating Fixture from aircraft after a minimum of 30 minutes after installation of last microvane.
 - (12) Apply Scapa 572 Flash Tape, HM-426 Teflon Tape, or equivalent tape to secure microvanes in proper location, and maintain contact pressure on each microvane for 12 hours during initial cure.
 - (13) After 12 hour initial cure, remove tape applied in previous step.
 - (14) Aerodynamic fillet seal and smooth around periphery of microvanes using STM40-006, Type 1, Class A2 Sealant, or PR-1829, Class B-1/2, Sealant in accordance with applicable Structural Repair Manual.
 - (15) Allow PR-1829, Class B-1/2, Sealant to fully cure. Full cure at room temperature is achieved in 3 days (minimum). Alternatively, cure can be accelerated by heating the bondline at 140 (±5) degrees Fahrenheit for 30 to 45 minutes following the initial 12 hour setup time at room temperature. Thermocouples or other temperature sensors must be used to continuously monitor part temperature to not exceed 160 degrees Fahrenheit.
 - (16) Finish microvanes and affected areas to match existing aircraft paint scheme in accordance with applicable Corrosion Prevention and Control Manual.
- I. Restore auxiliary and utility hydraulic systems to normal In accordance with applicable Job Guide, S/S/SN 00-20-02.

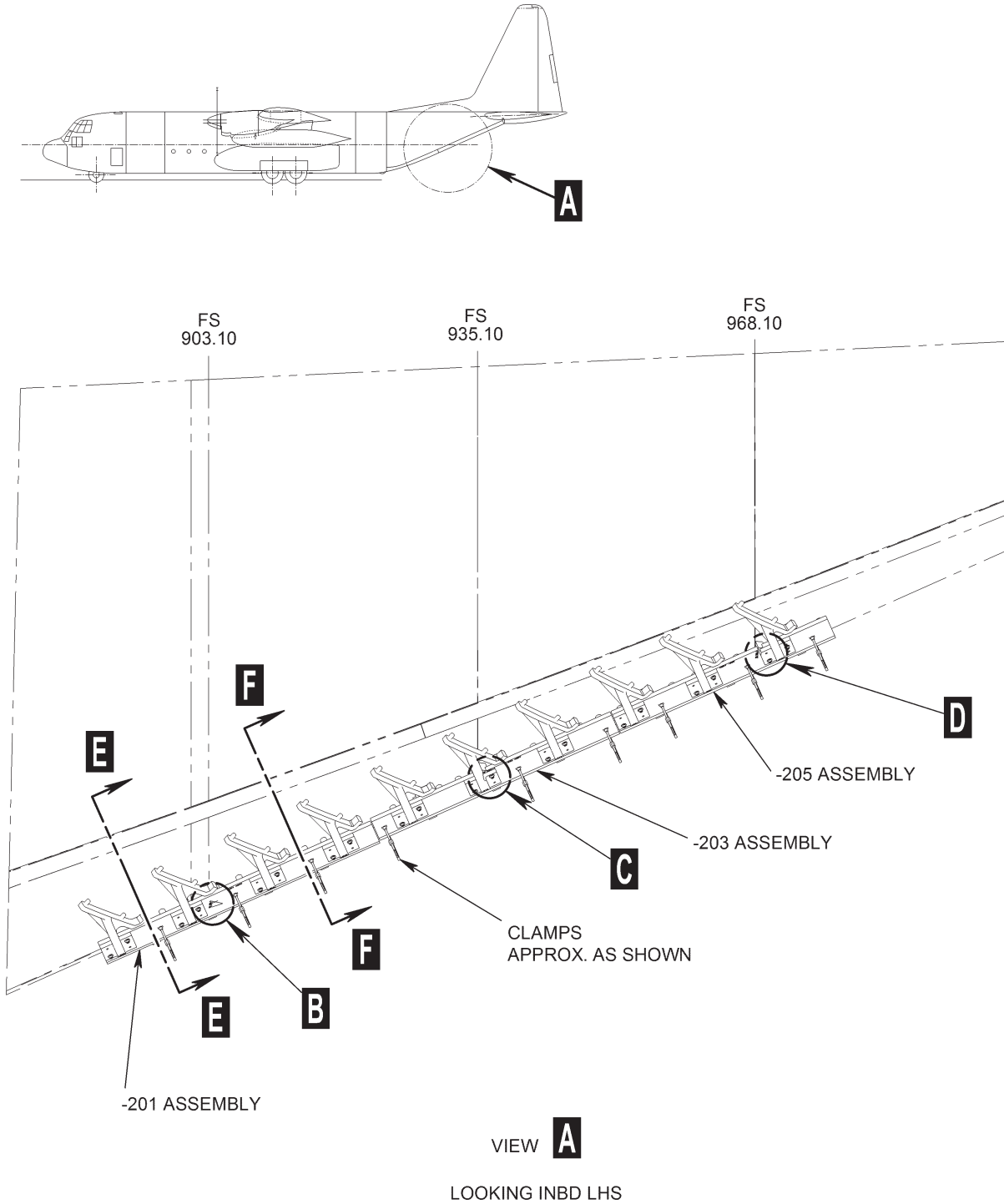
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- J. Close cargo door in accordance with applicable Job Guide, S/S/SN 52-00-01 or S/S/SN 52-00-02 (using auxiliary hydraulic system electric pump or hand pump).

NOTE: If assistance is needed, contact your local Lockheed Martin Aeronautics Company Representative, or the Enterprise Operations Center - Technical Support in Marietta, Georgia, USA, as follows:

TELEPHONE:	(770) 494-9131
FAX:	(770) 494-9122
E-MAIL:	hercules.support@lmco.com
MAIL:	Lockheed Martin Aeronautics Company 86 South Cobb Drive Dept. 3E1M, Zone 0591 Marietta, GA 30063, USA

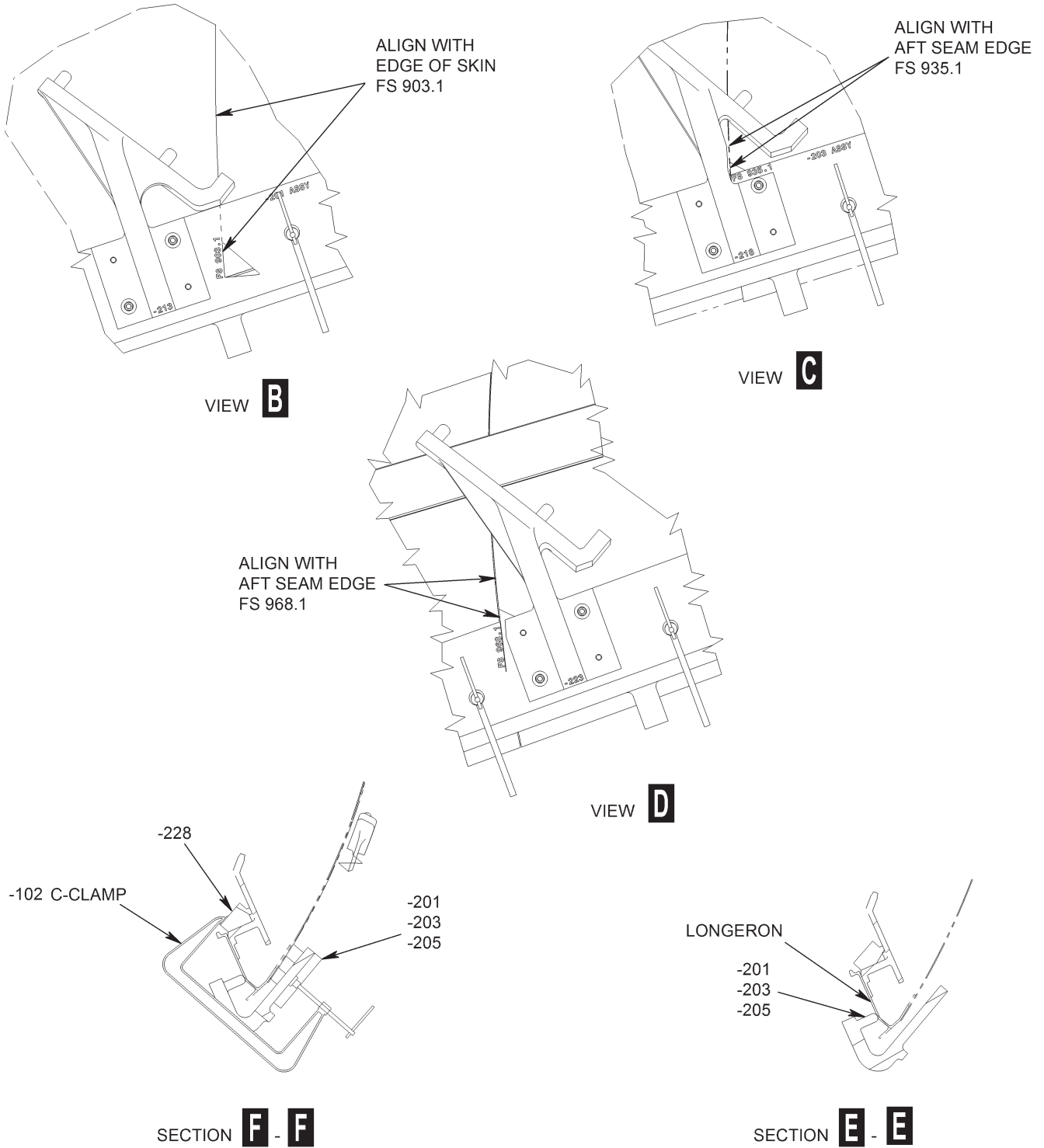
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I-4602-002

3368269-1-LF/3368269-2-LF Locating Fixture Assembly and Location
Figure 1, Sheet 1 of 2

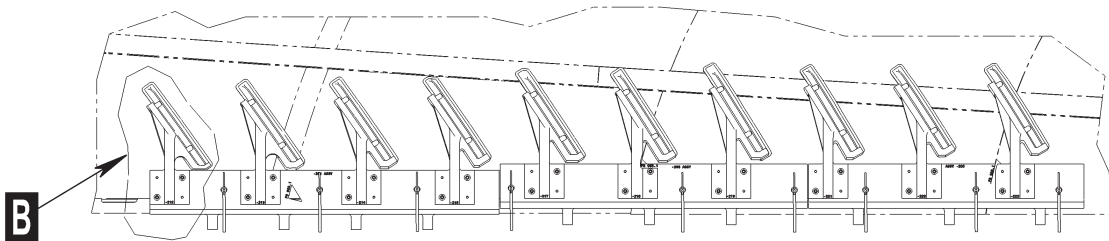
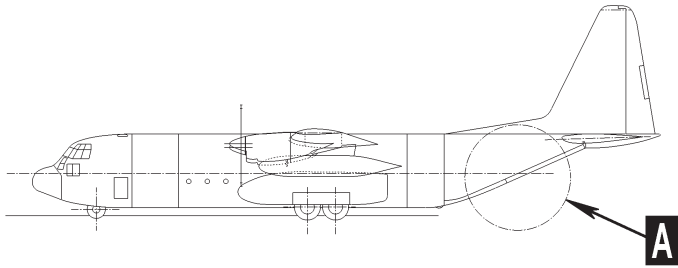
SERVICE BULLETIN



I-4602-003

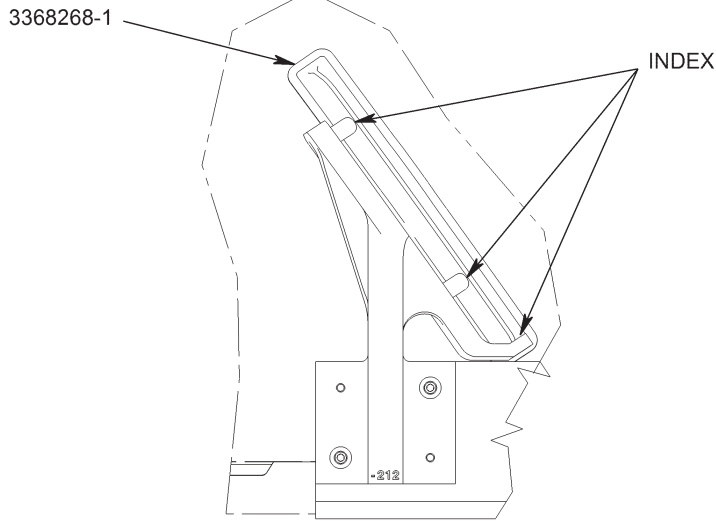
3368269-1-LF/3368269-2-LF Locating Fixture Assembly and Location
Figure 1, Sheet 2

SERVICE BULLETIN



VIEW **A**

LOOKING NORMAL TO OML



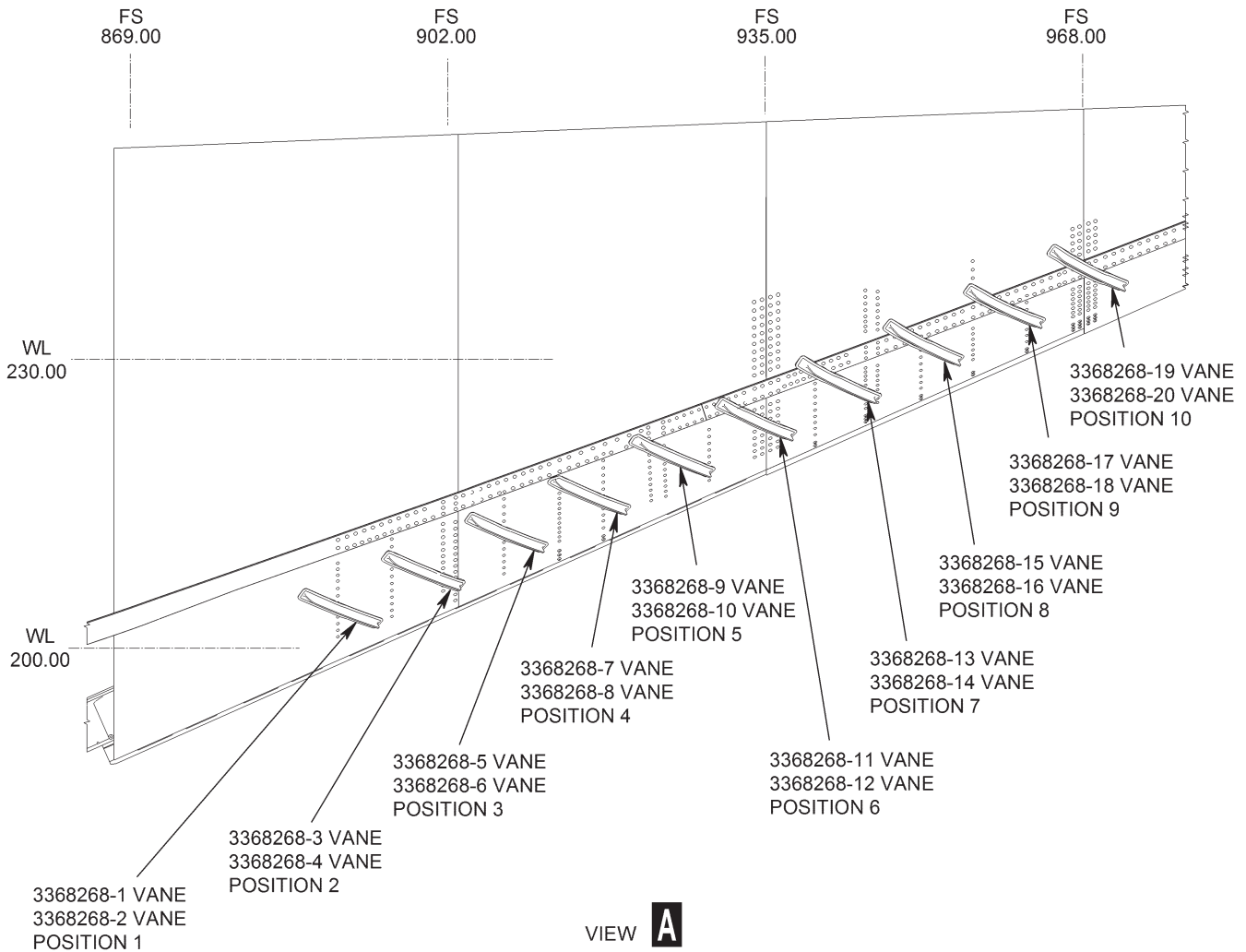
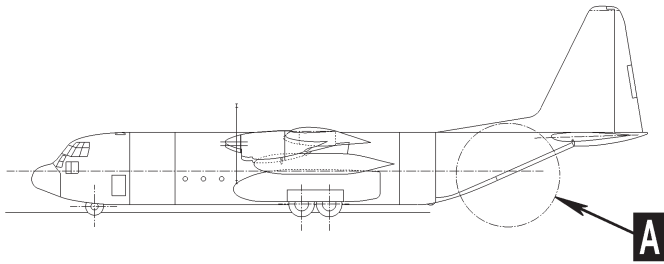
VIEW **B**

TYPICAL
FOR ALL VANE LOCATIONS

I-4414-004

Vane Installation on 3368269-1-LF/3368269-2-LF Locating Fixture
Figure 2

SERVICE BULLETIN



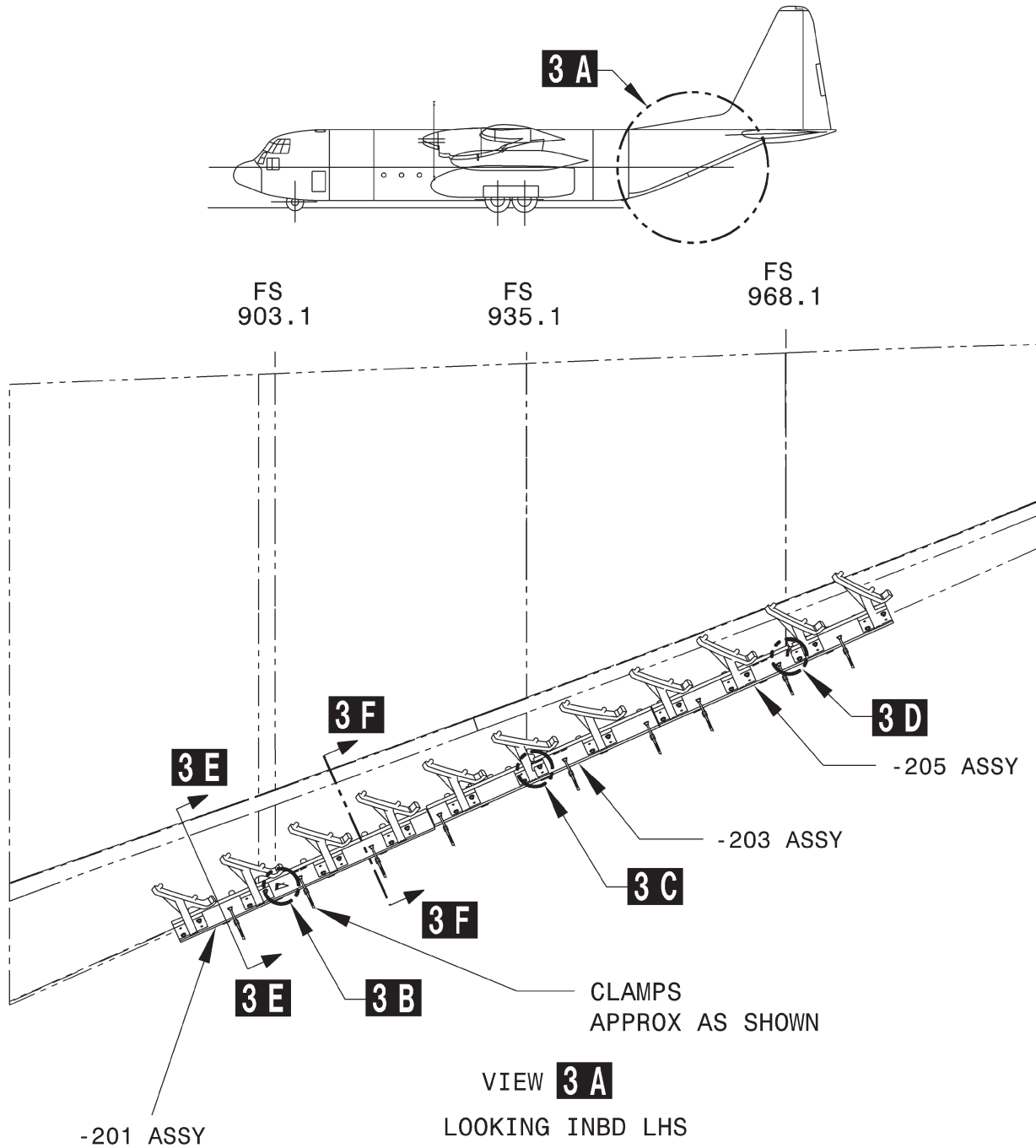
VIEW **A**

3368269-1 MICROVANES INSTALLATION - LHS (SHOWN)
3368269-2 MICROVANES INSTALLATION - RHS (OPPOSITE)
LOOKING INBD LHS

I-4414-001

3868269-1/-2 Vane Positions on Aircraft
Figure 3

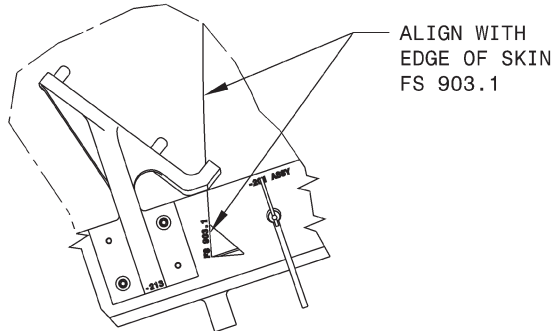
SERVICE BULLETIN



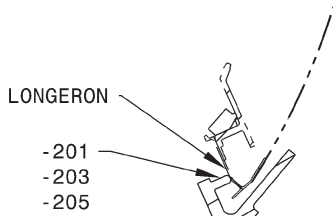
I-4643-004

3369284-1-LF/3369284-2-LF Locating Fixture Assembly and Location
Figure 4, Sheet 1 of 2

SERVICE BULLETIN

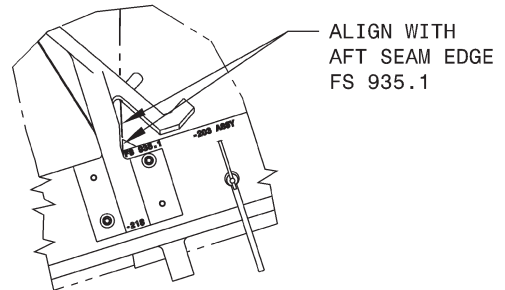


VIEW **3 B**

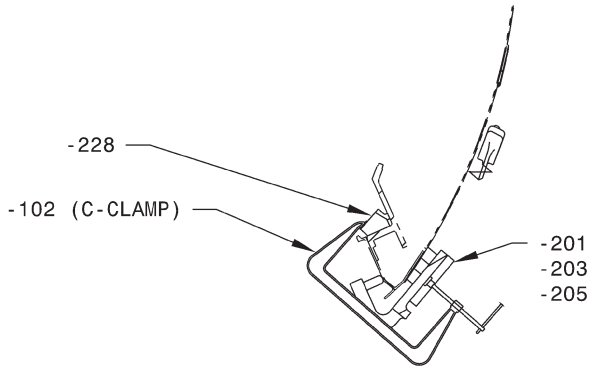


SECTION **3 E - 3 E**

TYPICAL FOR -201,203 & 205

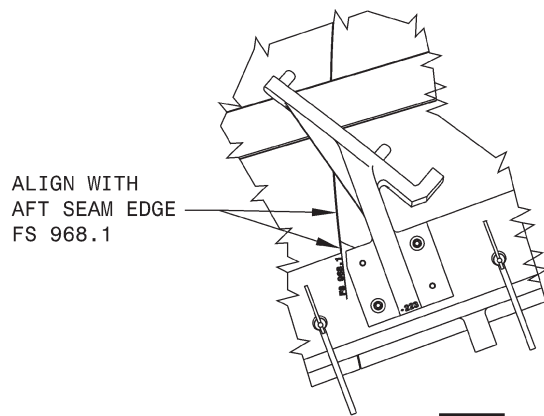


VIEW **3 C**



SECTION **3 F - 3 F**

TYPICAL FOR -201,203 & 205

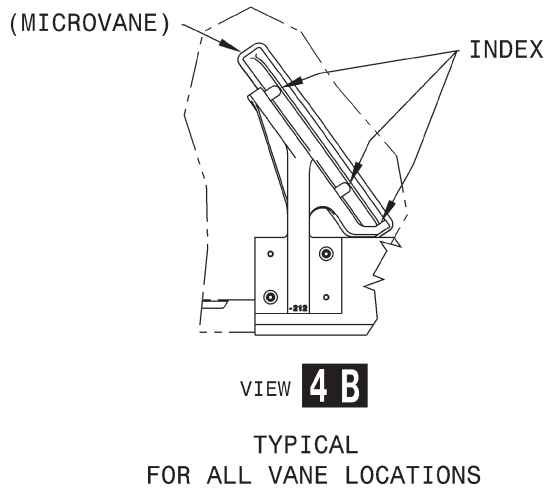
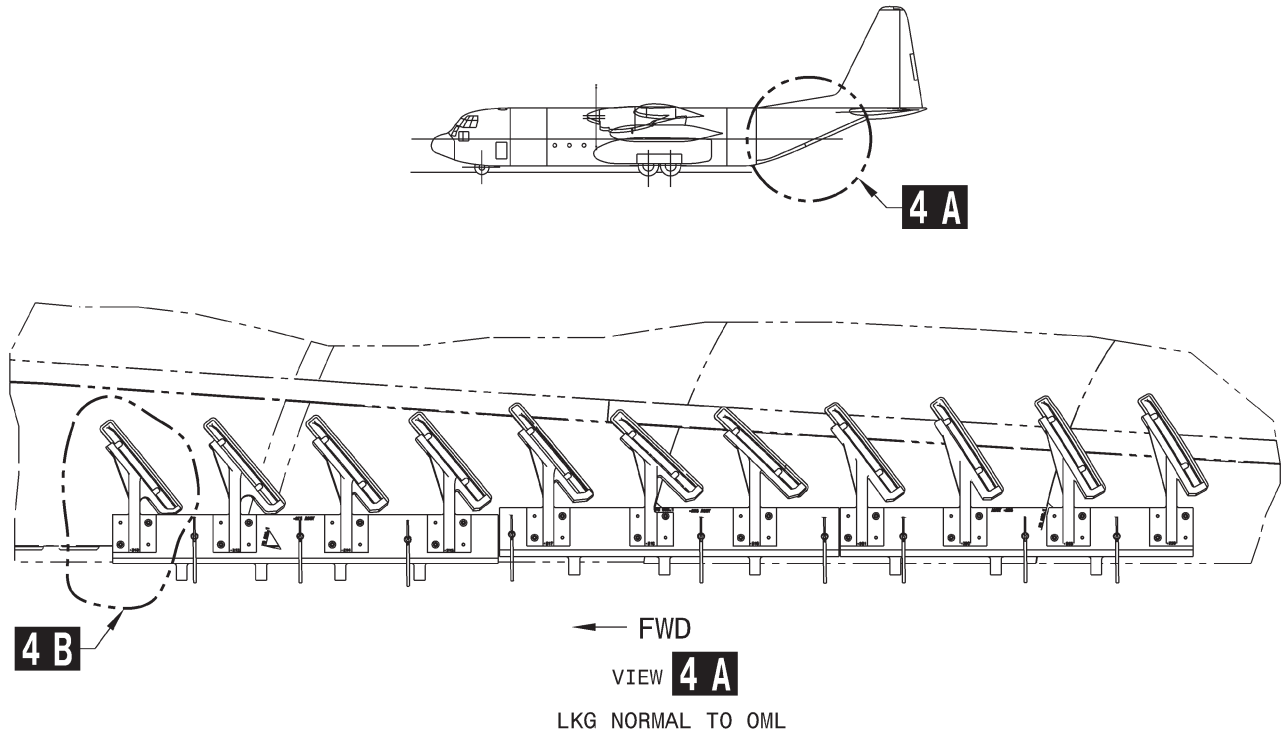


VIEW **3 D**

I-4643-005

3369284-1-LF/3369284-2-LF Locating Fixture Assembly and Location
Figure 4, Sheet 2

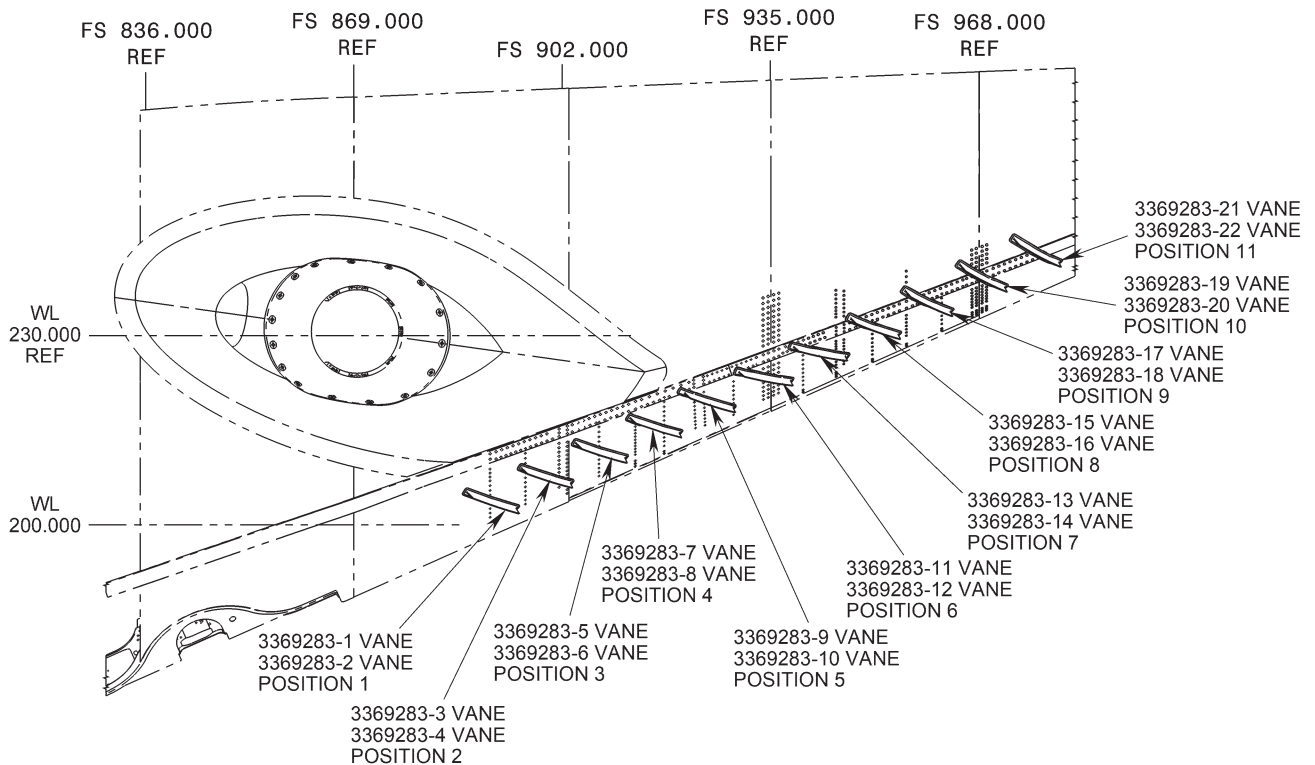
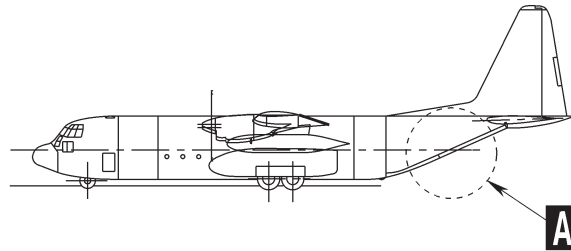
SERVICE BULLETIN



I-4643-003

Vane Installation on 3369284-1-LF/3369284-2-LF Locating Fixture Assembly
Figure 5

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VIEW **A**

3329284-1 MICROVANES INSTALLATION - LHS (SHOWN)
3329284-2 MICROVANES INSTALLATION - RHS (OPPOSITE)
LOOKING INBD - LHS

I-4363-001

3329285-1/-2 Vane Positions on Aircraft
Figure 6

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3. MATERIAL INFORMATION

NOTE: A quantity in (parentheses) is a part included in a sub-kit.

A. The following parts are required to modify each aircraft:

<u>PART NUMBER</u>	<u>QUANTITY</u>				<u>NOMENCLATURE</u>	<u>NOTE</u>
	<u>KIT A</u>	<u>KIT B</u>	<u>KIT C</u>	<u>KIT D</u>		
3368270-1	1	-	-	-	Top Kit, Microvanes, consisting of:	2
3368270 Rev. A	(Ref)	-	-	-	Top Kit - Microvanes Drawing	-
3368269-1	1	-	-	-	Microvanes Installation, Kit, consisting of	2
3368269 Rev. NC., PS-1	(Ref)	-	-	-	Microvanes Installation, Kit Drawing	-
3368268-1	(1)	-	-	-	Vane	2
3368268-3	(1)	-	-	-	Vane	2
3368268-5	(1)	-	-	-	Vane	2
3368268-7	(1)	-	-	-	Vane	2
3368268-9	(1)	-	-	-	Vane	2
3368268-11	(1)	-	-	-	Vane	2
3368268-13	(1)	-	-	-	Vane	2
3368268-15	(1)	-	-	-	Vane	2
3368268-17	(1)	-	-	-	Vane	2
3368268-19	(1)	-	-	-	Vane	2
3368269-2	1	-	-	-	Microvanes Installation, Kit, consisting of	2
3368269 Rev. NC., PS-1	(Ref)	-	-	-	Microvanes Installation, Kit Drawing	-
3368268-2	(1)	-	-	-	Vane	2
3368268-4	(1)	-	-	-	Vane	2
3368268-6	(1)	-	-	-	Vane	2
3368268-8	(1)	-	-	-	Vane	2
3368268-10	(1)	-	-	-	Vane	2

SERVICE BULLETIN

<u>PART NUMBER</u>	<u>QUANTITY</u>				<u>NOMENCLATURE</u>	<u>NOTE</u>
	<u>KIT A</u>	<u>KIT B</u>	<u>KIT C</u>	<u>KIT D</u>		
3368268-12	(1)	-	-	-	Vane	2
3368268-14	(1)	-	-	-	Vane	2
3368268-16	(1)	-	-	-	Vane	2
3368268-18	(1)	-	-	-	Vane	2
3368268-20	(1)	-	-	-	Vane	2
3368270-401	-	1	-	-	Tool Kit, Microvanes, consisting of:	2
3368270 Rev. A	-	(Ref)	-	-	Top Kit - Microvanes Drawing	-
3368269-1-LF	-	(1)	-	-	Locating Fixture	2
3368269-2-LF	-	(1)	-	-	Locating Fixture	2
3368270-401-TSUD	-	(1)	-	-	Tooling Set Up Drawing	-
3369285-1	-	-	1	-	Top Kit - Microvanes, consisting of:	2
3369285	-	-	(Ref)	-	Top Kit - Microvanes Drawing	-
3368284-1	-	-	1	-	Microvanes Installation, Kit, consisting of	2
3368284	-	-	(Ref)	-	Microvanes Installation, Kit Drawing	-
3369283-1	-	-	(1)	-	Vane	2
3369283-3	-	-	(1)	-	Vane	2
3369283-5	-	-	(1)	-	Vane	2
3369283-7	-	-	(1)	-	Vane	2
3369283-9	-	-	(1)	-	Vane	2
3369283-11	-	-	(1)	-	Vane	2
3369283-13	-	-	(1)	-	Vane	2
3369283-15	-	-	(1)	-	Vane	2
3369283-17	-	-	(1)	-	Vane	2
3369283-19	-	-	(1)	-	Vane	2

SERVICE BULLETIN

<u>PART NUMBER</u>	<u>QUANTITY</u>				<u>NOMENCLATURE</u>	<u>NOTE</u>
	<u>KIT A</u>	<u>KIT B</u>	<u>KIT C</u>	<u>KIT D</u>		
3369283-21	-	-	(1)	-	Vane	2
3369284-2	-	-	1	-	Microvanes Installation, Kit, consisting of	2
3369284	-	-	(Ref)	-	Microvanes Installation, Kit Drawing	-
3369283-2	-	-	(1)	-	Vane	2
3369283-4	-	-	(1)	-	Vane	2
3369283-6	-	-	(1)	-	Vane	2
3369283-8	-	-	(1)	-	Vane	2
3369283-10	-	-	(1)	-	Vane	2
3369283-12	-	-	(1)	-	Vane	2
3369283-14	-	-	(1)	-	Vane	2
3369283-16	-	-	(1)	-	Vane	2
3369283-18	-	-	(1)	-	Vane	2
3369283-20	-	-	(1)	-	Vane	2
3369283-22	-	-	(1)	-	Vane	2
3369285-401	-	-	-	1	Tool Kit, Microvanes, consisting of:	2
3369285	-	-	-	(Ref)	Top Kit - Microvanes Drawing	-
3369284-1-LF	-	-	-	(1)	Locating Fixture	2
3369284-2-LF	-	-	-	(1)	Locating Fixture	2
3329284-1/-2-TSUD	-	-	-	(1)	Tooling Set Up Drawing	-

B. The following consumable materials are required to modify each aircraft:

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>NOMENCLATURE</u>	<u>NOTE</u>
A/R	ASTM D 770	Isopropyl Alcohol	1
A/R	HM-426	Teflon Tape	1, 2
A/R	MIL-DTL-81706, Type I, Class 3	Colored Chemical Conversion Coating	1
A/R	PR-1829, Class B-1/2	Sealant	1

SERVICE BULLETIN

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>NOMENCLATURE</u>	<u>NOTE</u>
A/R	Scapa 572	Flash Tape	1, 2
A/R	STM40-006, Type 1, Class A2	Sealant	1

NOTE:

1. Local purchase/local supply item.
2. Part may be obtained in accordance with Paragraph 1.F.

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