

SERVICE BULLETIN SUMMARY

This Service Bulletin is available at:

www.cic.bombardier.com

MODEL BD-100-1A10 (CL-300)

ATA 78-30

EXHAUST

**MODIFICATION – THRUST REVERSER –
DOOR AND BEAM ASSEMBLY CORROSION REMOVAL**

The information below is provided for your reference. For full details, please see corresponding paragraph contained within this bulletin.

RECOMMENDED SPECIFIED TIME COMPLIANCE	COMPLIANCE TIME Within 48 months from this Service Bulletin release date (Basic Issue)	
EFFECTIVITY: 20003 to 20302 and 20316		
MANPOWER: 114 man-hours		
TLMC, CH 5, PART 4 REQUIREMENT	YES <input type="checkbox"/>	NO <input checked="" type="checkbox"/>
KITS and/or PARTS	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
TOOLING/GSE	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
PLANNING INFORMATION: See important information at the start of Paragraph 1.	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
DEDICATED SCHEDULE	YES <input type="checkbox"/>	NO <input checked="" type="checkbox"/>
PREREQUISITE SERVICE BULLETINS: N/A		

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1. PLANNING INFORMATION

- NOTES:** 1. Bombardier Aerospace recommends that you perform this Service Bulletin at the next maintenance opportunity when the aircraft will be out of service for sufficient time to accomplish the modification
2. This Service Bulletin is applicable to the following thrust reversers, on the BD-100 aircraft:

Description	Part Number	Serial Number	APS Number
Thrust Reverser	13A010-00-0G	TR-001 to TR-020	APS 0003-0005 (L/R)
LH Thrust Reverser	13A012-00-0G	TR-021 to TR-627	APS 0006-0302 (LH) and 0316 (LH)
RH Thrust Reverser	13A013-00-0G	TR-022 to TR-628	APS 0006-0302 (RH) and 0316(RH)

A. Effectivity

BD-100-1A10 aircraft, Serial No. **20003** to **20302** and **20316**.

Refer to applicable governmental agency regulations and requirements and make sure that the work described in this Service Bulletin is performed in compliance with manufacturer's recommendations and/or acceptable industry standards.

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The intent of this Service Bulletin was met on the aircrafts that follow with the Service Requests for Product Support Action (SRPSA) listed in the table that follows:

AIRCRAFT SERIAL NO.	SRPSA NO.
20122	96396
20162	46965
20207	46918
20245	48291
20262	47650

NOTE: The instructions given in this Service Bulletin are only applicable to the systems and parts installed at the time of delivery of the aircraft or as changed by Bombardier Aerospace Service Bulletin(s).

Before you do this bulletin, examine all STC, STA or equivalent action changes to make sure that this bulletin can be completed.

B. Reason

Corrosion was found on the thrust reversers pivot doors and beam inner air-washed surfaces. This Service Bulletin gives instructions to remove the corrosion from the thrust reverser's inner air-washed surfaces and to apply an improved protective coating.

C. Description

This Service Bulletin gives instructions to:

- Remove the LH and RH thrust reversers from the aircraft,
- Remove the upper and lower pivot door assemblies from each thrust reverser,
- Repair the assemblies as instructed in Honeywell Service Bulletin 78-30-007,
- Install the upper and lower pivot door assemblies on each thrust reverser,
- Install both the LH and RH thrust reversers on the aircraft, and
- Do the necessary tests to make sure that the system operates correctly.

D. Compliance

Recommended within 48 months from this Service Bulletin release date (Basic Issue).

E. Approval

This Service Bulletin does not contain modification information that revises the approved configuration and therefore does not require governmental or other regulatory approval.

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F. Manpower

NOTES: 1. The man-hours given are estimates to help you schedule the tasks given in this bulletin. The estimates are for direct labor performed by an experienced crew and do not include the time for familiarization, planning, aircraft preparation in hangar such as towing and positioning of scaffolds, removal of interior furnishings, repainting, supervision and inspection.

For more information related to the manpower estimates, refer to SB 100-00-02.

2. This Service Bulletin may require consumable materials that have specific curing times (refer to Paragraph 3). The accumulated curing time is not included in the labor estimates and should be considered for planning purposes before you schedule this Service Bulletin.
3. Labor hours are based on the fact that the modification will be done at the next scheduled maintenance task or inspection. Therefore no man-hours are allotted to prepare the aircraft for maintenance or to prepare for this Service Bulletin.

114 man-hours may be necessary to do this modification and are broken down as follows:

- 16 man-hours are necessary to deploy, deactivate and remove the thrust reversers and the pivot doors.
- 38 man-hours may be necessary to remove the corrosion (depending on the level of corrosion) and measure the material that is left.
- 44 man-hours are necessary to treat the surface and apply the new improved paint scheme.
- 16 man-hours are necessary to install the thrust reversers and pivot doors and to perform the functional test.

For aircraft in and out of warranty, the labor required to do this Service Bulletin is at no cost and covered by Honeywell if:

- (i) The work is done at Bombardier Business Aviation Services (BBAS) or Authorized Service Facilities (ASF), and
- (ii) This Service Bulletin is scheduled in less than 48 months from its release date (Basic Issue).

For information on labor coverage and how to file warranty claims with Honeywell, please refer to HTF7000 Special Program Number 4 which can be found on the Honeywell Aerospace Portal at: <https://portal.honeywell.com/wps/portal/aero>.

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G. Material - Cost and Availability

No kit required.

For parts that may be necessary to do this Service Bulletin, refer to Honeywell Service Bulletin, 78-30-007, Paragraph 2.G.

For aircraft in and out of warranty, the parts necessary to do this Service Bulletin are at not cost if:

- (i) A no-charge purchase order is sent to Aircelle Customer Support Centre in less than 48 months from this Service Bulletin release date (Basic Issue). Refer to Honeywell Service Bulletin, 78-30-007, Paragraph 2.G., for ordering details.

During or after the above free period, Smart Parts Plus does not pay for the parts.

H. Tooling

GSE REFERENCE NO.	PART NO.	DESCRIPTION
24-00-24	S4933959-501	Tag, Circuit Breaker
71C-00-11	5837823	Common Lifting Sling
See Note: 1	LE6923	Pivot Door Template
Commercially available	-	Acoustic Thickness Measurement Instrument with 'A' Scan capability (minimum resolution accuracy 0.001")
Commercially available	-	Acoustic Probe (10 MHz minimum, range 0.6-ca)
See Note: 2	-	Electronic Paint Thickness Measurement Instrument
Note 1: This template is reusable, only one per repair facility is required.		
Note 2: This tool is available from: Fischer Technologies		

- NOTES:** 1. Refer to the BD-100 Illustrated Tool and Equipment Manual to make sure that you use the correct equipment configuration.
2. Refer to the Liability Statement for acceptable GSE equivalents.

I. Weight and Balance

No change.

J. Electrical Load Data

No change.

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K. References

- BD-100 Aircraft Maintenance Manual (AMM), Chapters 6, 24, 29, 71 and 78.
- BD-100 Structural Repair Manual (SRM), Chapter 51.
- BD-100 Standard Practices Manual (SPM), Chapter 51.
- BD-100 Non-Destructive Testing Manual (NDTM), Part 1, Section 4, Ultrasonic Inspection.
- Honeywell Service Bulletin, 78-30-007 (attached).

L. Other Publications Affected

BD-100 Aircelle Component Maintenance Manual (CMM), 78-30-01.

M. Equivalent Service Bulletin

None.

2. ACCOMPLISHMENT INSTRUCTIONS

- NOTES:
1. All TASKs given in the procedures that follow are from the BD-100 Aircraft Maintenance Manual unless otherwise specified.
 2. All references made to zones, access panels and/or doors, are from the BD-100 Aircraft Maintenance Manual, Chapter 6.

A. Aircraft Setup

- (1) Obey all electrical/electronic safety precautions. Refer to TASK 24-00-00-910-801.
- (2) Obey all hydraulic safety precautions. Refer to TASK 29-00-00-910-801.
- (3) Obey all the engine safety precautions. Refer to TASK 71-00-00910-801.
- (4) Do the operational test of the Thrust Reversers to deploy the Pivot Doors and leave the Pivot Doors in the unlocked (deployed) position. Refer to TASK 78-30-00-710-801.
- (5) Do the Deactivation of the Thrust reversers. Refer to TASK 78-30-00-040-801.
- (6) Remove the Thrust Reversers. Refer to TASK 78-30-00-000-801.
- (7) Remove the LH and RH Upper pivot door. Refer to TASK 78-31-01-000-801.
- (8) Remove the LH and RH Lower pivot door. Refer to TASK 78-31-05-000-801.

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B. Modification

Remove the corrosion and apply the improved coating as instructed in Honeywell Service Bulletin, 78-30-007.

NOTE: Any components that are determined to be below the minimum thickness when performing the ultrasound thickness check will need to be replaced unless otherwise instructed in the Honeywell Service Bulletin, 78-30-007.

C. Testing

- (1) Install the LH and RH Upper pivot door. Refer to TASK 78-31-01-400-801.
- (2) Install the LH and RH Lower pivot door. Refer to TASK 78-31-05-400-801.
- (3) Install the Thrust Reversers. Refer to TASK 78-30-00-400-801.
- (4) Do the Activation of the Thrust Reversers. Refer to TASK 78-30-00-440-801.
- (5) Do the Operational test of the Thrust Reversers. Refer to TASK 78-30-00-710-801.

D. Close-out

Remove all tools, equipment and unwanted materials from the aircraft.

E. Recording

When this Service Bulletin is completed, make an entry in the aircraft log and send the attached Incorporation Notice to Bombardier Business Aircraft Customer Services (BBACS).

In an effort to improve the quality of our technical communications, we are requesting your feedback. Please take a moment to fill out our easy on-line Service Bulletin survey:

<http://csefeedback.aero.bombardier.com>

3. MATERIAL INFORMATION

A. Kit

No kits required.

B. Parts

For parts that may be necessary to do this Service Bulletin, refer to Honeywell Service Bulletin, 78-30-007, Paragraph 2.G.

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C. Material

The materials that follow, or equivalent, are necessary to do this Service Bulletin. These can be purchased from a local supplier. Bombardier Aerospace does not pay for these consumables.

DESCRIPTION	PART No./NAME	SPECIFICATION	QUANTITY	SUPPLIER (See Note)
Epoxy Primer	10P4-2	BAMS 565-001	As Necessary	Code: A
Alodine	1200S	MIL-C-81706	As Necessary	Code: B
Corrosion Removing Compound	Turco Metal Glo #6	MIL-C-38334A	As Necessary	Code: B
Paint Stripper	Turco 6776 LO or approved equivalent	-	As Necessary	Code: B
	Ardrox 2865 or approved equivalent	-		Code: G
Desothane Black Topcoat	HS CA8000	BAMS 565-002	As Necessary	Code: C
High Temp Jointing Compound	Hylomar PL32	-	As Necessary	Code: D
Adhesive Sealant	RTV 106	MIL-A-46106	As Necessary	Code: E
Aluminum Tape	-	-	As Necessary	Code: F
Masking Tape	-	-	As Necessary	Code: F
Paint Adhesion Test Tape	3M250	-	As Necessary	Code: F
Abrasive Pad	Scotch Brite 3M	-	As Necessary	Code: H
Aluminum Abrasive Paper	120 Grit and 180 Grit	-	As Necessary	Code: H
Bristle Brush	-	-	As Necessary	Code: H

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DESCRIPTION	PART No./NAME	SPECIFICATION	QUANTITY	SUPPLIER (See Note)
Distilled Water	-	-	As Necessary	Code: H
Lint Free Cloth	-	-	As Necessary	Code: H
Marker (Water Soluble)	-	-	As Necessary	Code: H
Masking Paper	-	-	As Necessary	Code: H
Solvent	Dope and Lacquer Thinner	A-A-857	As Necessary	Code: H
Solvent	Methyl Ethyl Ketone (MEK)	ASTM D740	As Necessary	Code: H

- NOTES:**
1. Refer to the table that follows for each supplier's address listed by codes.
 2. The Curing Time (CT), if applicable, for each consumable material is indicated with the description of each product.
 3. At time of release of this Service Bulletin, the information on the supplier was valid and accurate. In the event that this information has changed, the operator is encouraged to use the World Wide Web to find a local supplier.

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SUPPLIERS ADDRESSES BY CODES	
Code: A Akzo Nobel Aerospace Coatings 1 East Water Street Waukegan, IL USA, 60085-5652 Tel.: (847) 623-4200 Web site: www.akzonobelaerospace.com	Code: B Henkel Corp. 23343 Sherwood Ave. Warren, MI USA, 48091-5362 Tel.: (586)-759-5555 Fax: (586) 759-3518 Web site: henkelna.com
Code: C PRC-Desoto / PPG 11601 United Street Mojave, CA USA, 93501 Tel.: (661) 824-4532 Web site: www.prc-desoto.com	Code: D Hylomar USA Inc. 4840 N. Adams Rd Rochester, MI, 48306 U.S.A. Tel.: (248) 433-2194 Fax: (206) 202-6334 E-mail: Info@hylomarus.com
Code: E Momentive Performance Materials 260 Hudson River Road Waterford, NY, 12188-1910 U.S.A. Tel: 1-866-443-9466 Fax: 1-877-443-9466 Web site: www.momentive.com	Code: F 3M Adhesive Division 3M Center Building 21-1W-10 900 Bush Ave. St Paul, MN, 55144-1000 U.S.A. Tel: 1-800-362-3550 Web Site: www.3M.com/industrial
Code: G Chemetall US Inc. 675 Central Avenue New Providence NJ 07974 USA Tel: 1-908-508-2182 Fax: 1-908-464-2377 Web Site: www.chemetall.aero	Code: H Commercially Available

D. Publications

No publications required.

SERVICE BULLETIN EVALUATION FORM

(Your ideas will help us provide better bulletins)

SERVICE BULLETIN: 100-78-02 **ISSUE:** Basic **DATED:** Dec 15/2011

TITLE: Modification – Thrust Reverser – Door and Beam Assembly Corrosion Removal

In an effort to improve the quality of our technical communications, we are replacing the standard **Service Bulletin Evaluation Form** with an on-line **Service Bulletin Survey** and we are requesting your feedback. Please take a moment to fill out our easy on-line Service Bulletin survey:

<http://csefeedback.aero.bombardier.com>

SERVICE BULLETIN INCORPORATION SHEET – “100-78-02”

**BOMBARDIER
SUBMISSION**

Upon completion of the Service Bulletin, please fill-in, fax to (514) 855-8798 or e-mail to Fracas at fracas.montreal@aero.bombardier.com

If your aircraft is registered on CAMP and you are reporting to them, please do not send the incorporation sheet to Bombardier. If your aircraft is on another tracking system, please contact Bombardier to make arrangements for automated data submission.

Service Bulletin Number	Rev.	* Parts Completed	COMPLIED WITH			Remarks/Reason
			YES	NO	N/A	
100-78-02	Basic	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
-	-	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
-	-	-	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

Actual hours to accomplish Service Bulletin: _____

- * **NOTES:**
- Where the Service Bulletin is divided into a number of parts (e.g., PARTS A, B, C, D, etc.) which can be carried out separately, indicate only those parts completed at this time.
 - For repetitive checks (usually PART A) only the initial check should be reported unless otherwise stated in the Service Bulletin.
 - When more than one part is carried out at the same time, each part should be reported.

Aircraft Serial No. _____ Aircraft Reg. No. _____

Airframe Hours: _____ Airframe Landings _____

S.B. Incorporation date _____ Service Order No. _____

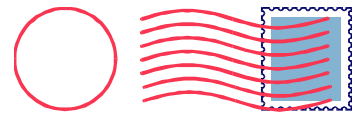
(dd/mm/yy)

Facility Incorporating S.B. _____

Name _____ Signature _____ Date _____

Signature not required if sent by E-Mail

(dd/mm/yy)



Bombardier Business Aircraft Customer Services (BBACS)

P.O. Box 6087, Station Centre-ville
Montreal, Québec, Canada H3C 3G9

Attention: Customer Support Department, Maintenance Engineering
