

SERVICE BULLETIN SUMMARY

This Service Bulletin is available at:

www.cic.bombardier.com

MODEL BD-700-1A10 (BD-700)

ATA 52-31

DOORS

**MODIFICATION – BAGGAGE DOOR –
 REPLACE BAGGAGE DOOR TRACK ROLLERS TO IMPROVE OPERATION**

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

RECOMMENDED RELIABILITY/DISPATCHABILITY/COST AVOIDANCE	COMPLIANCE TIME Not applicable		
EFFECTIVITY: A/C Serial No. 9002 to 9314			
MANPOWER: 10 man-hours			
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 type="checkbox"/>	NO <input checked="" type="checkbox"/>
DEDICATED SCHEDULE	YES	<input type="checkbox"/>	NO <input checked="" type="checkbox"/>
PREREQUISITE SERVICE BULLETINS: N/A			

To place an order for parts or kits, please call Bombardier Parts Logistics at:

514-855-2999 or 1-866-538-1247

SERVICE BULLETIN

This Service Bulletin is available at:

www.cic.bombardier.com

MODEL BD-700-1A10 (BD-700)

ATA 52-31

DOORS

**MODIFICATION – BAGGAGE DOOR –
REPLACE BAGGAGE DOOR TRACK ROLLERS TO IMPROVE OPERATION**

1. PLANNING INFORMATION

A. Effectivity

BD-700-1A10 aircraft, Serial No. **9002** to **9314**

All other subsequent BD-700-1A10 aircraft are scheduled for the modification in production (Ref.: Modification Summary 700T02330).

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

Because of a build-up of tolerances, excessive gaps between the baggage door tracks and cam rollers were found on some aircraft. On several occasions, this condition caused the baggage door to come off its tracks during open/close operations.

This Service Bulletin gives instructions to replace the cam rollers with new parts that have larger diameter and width, which will reduce the gap between the rollers and the tracks.

This modification will prevent repetitive operational problems with the baggage door and reduce maintenance time and costs.

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.

This document is proprietary to Bombardier Inc. and/or its affiliates and may not be reproduced or copied in any form or by any means without the prior written consent of Bombardier Inc. and/or its affiliates.

© 2008 Bombardier Inc. All rights reserved
Challenger*, Global Express*, Global Express^{XRS}*, Global 5000*, Learjet* are Trademarks of Bombardier Inc.

C. Description

This Service Bulletin gives instructions to:

- Remove the floor panels 251DLF and 251FLF,
- Remove the baggage door,
- Replace the cam rollers,
- Install the baggage door,
- Check the rigging of the baggage door,
- Do the functional and operational tests of the baggage door, and
- Install the floor panels 251DLF and 251FLF.

D. Compliance

Recommended – Reliability/Dispatchability/Cost Avoidance

E. Approval

The technical content of this Service Bulletin has been approved under the authority of Transport Canada Civil Aviation (TCCA) Design Approval Organization (DAO) No. DAO #93-Q-02.

- NOTES:
1. The technical content of this Service Bulletin is accepted by the FAA under the Canada/USA bilateral Aviation Safety Agreement.
 2. The technical content of this Service Bulletin is accepted by the JAA and by EASA in accordance with established procedures.

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 700-00-002.

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.

10 man-hours are necessary to do this modification.

MODEL BD-700-1A10 (BD-700)

The labor required to do this Service Bulletin is available at no cost if:

- (i) the work is done during new aircraft warranty period, and
- (ii) the work is done at Bombardier Business Aviation Services (BBAS) or Authorized Service Facilities (ASF), and
- (iii) this Service Bulletin is scheduled in less than 12 months from its release date.

G. Material – Cost and Availability

Kit 700K52-033 is necessary to do this modification. Only the U.S. domestic price is shown:

KIT NO.	PRICE
700K52-033	\$496.80

The above price can change. For the price outside of the U.S., refer to the last applicable Spare Parts Price Catalog. This data is also available from Bombardier Business Aviation Services (BBAS) at the addresses shown in the catalog.

50 kits were available when this Service Bulletin was released. Sufficient kits will be kept for the estimated amount of orders.

This kit is available at no cost if:

- (i) ordered during new aircraft warranty period, and
- (ii) a no-charge purchase order is sent to Bombardier Aerospace in less than 12 months from this Service Bulletin release date.

For those aircraft in new aircraft warranty at the time of Service Bulletin distribution, Smart Parts Plus does not pay for the kit(s) at any time.

For those aircraft out of new aircraft warranty at the time of Service Bulletin distribution, Smart Parts Plus pays for the kit(s) for up to one year from the Service Bulletin distribution date.

H. Tooling – Price and Availability

GSE REFERENCE NO.	PART NO.	DESCRIPTION
52X-31-01 or acceptable equivalent (See NOTE 2)	-	Torque Wrench Adaptor, Baggage Door Handle
-	Commercially Available	Force Gauge, 0 to 50 lbf (0 to 222.4 N)
-	Commercially Available	Torque Wrench, 0 to 50 lbf-ft (0 to 67.8 Nm)
-	M81969/14-02	Insertion/Extraction Tool, Splice

- NOTES:**
1. Refer to the Global Express or the Global Express XRS BD-700 Illustrated Tool and Equipment Manual to make sure you use the correct equipment configuration.
 2. Refer to the Liability Statement of the publication listed in NOTE 1 for acceptable GSE equivalents.

I. Weight and Balance

No change.

J. Electrical Load Data

No change.

K. References

- Bombardier Aerospace, Modification Summary, 700T02330, Rev. A1.
- Global Express BD-700 Aircraft Maintenance Manual, Chapters 6, 24, 52 and 53.
- Global Express BD-700 Aircraft Illustrated Parts Catalog (AIPC), Chapter 52.
- Global Express BD-700 Illustrated Tool and Equipment Manual (ITEM), Chapter 52.
- Global Express BD-700 Wiring Manual, Chapters 20 and 52.
- Global Express XRS BD-700 Aircraft Maintenance Manual, Chapters 6, 24, 52 and 53.
- Global Express XRS BD-700 Aircraft Illustrated Parts Catalog (AIPC), Chapter 52.
- Global Express XRS BD-700 Illustrated Tool and Equipment Manual (ITEM), Chapter 52.
- Global Express XRS BD-700 Wiring Manual, Chapters 20 and 52.

BOMBARDIER
GLOBAL EXPRESS
BOMBARDIER
GLOBAL EXPRESS^{XRS}

MODEL BD-700-1A10 (BD-700)

L. Other Publications Affected

- Global Express BD-700 Aircraft Illustrated Parts Catalog (AIPC), Chapter 52.
- Global Express XRS BD-700 Aircraft Illustrated Parts Catalog (AIPC), Chapter 52.

M. Equivalent Service Bulletin

For the Global 5000 BD-700-1A11 aircraft, use SB 700-1A11-52-010.

2. ACCOMPLISHMENT INSTRUCTIONS

- NOTES:**
1. All TASKs given in the procedures that follow are from the Global Express or Global Express XRS BD-700 Aircraft Maintenance Manual unless otherwise specified.
 2. All references made to zones, access panels and/or doors, are from the Global Express or Global Express XRS BD-700 Aircraft Maintenance Manual, Chapter 6.

A. Aircraft Setup

- (1) Obey all electrical/electronic safety precautions. Refer to TASK 24-00-00-910-801.
- (2) Set the circuit breakers that follow OUT (on aircraft pre SB 700-24-045) or LOCKED (on aircraft, Serial No. 9123 and subsequent or aircraft post SB 700-24-045) (refer to TASK 24-00-00-863-801):

SYSTEM NAME	CIRCUIT BREAKER NAME	BUS NAME
LDG GEAR	GEAR CTL A PWR 1	DC 1
LDG GEAR	GEAR CTL A PWR 2	BATT
LDG GEAR	GEAR CTL B PWR 1	DC 2
LDG GEAR	GEAR CTL B PWR 2	BATT

- (3) Remove the floor panel 251DLF and 251FLF. Refer to TASK 53-41-01-000-801.

NOTE: If the floor panel 251DLF is in two parts, only the forward part needs to be removed.

B. Modification

- (1) Remove the baggage door. Refer to TASK 52-31-00-000-801.

- NOTES:**
1. To disconnect the wires from the splice located under the floor panel 251FLF, move it under adjacent floor panel 251DLF for better access.
 2. Safety the balance spring cables with a clamp or retainer to prevent retraction into the spring box.
 3. Refer to the Global Express or the Global Express XRS BD-700 Wiring Manual, Chapter 52-70-00 for the wiring diagram of the door warning system and to Chapter 20-16-00 for crimp wire splicing instructions. Replace wire contacts if necessary.

BOMBARDIER
GLOBAL EXPRESS
BOMBARDIER
GLOBAL EXPRESS^{XRS}

MODEL BD-700-1A10 (BD-700)

- (2) For each cam roller, do as follows before removal (refer to Figure 1 for cam roller location):

NOTE: This procedure will show the position of the old rollers in relation to the door structure for reference during the installation of the new rollers.

- (a) Identify the cam roller position on the door with a tag.
- (b) Identify, with a mark on the roller shank, the junction point of the roller and the door structure.
- (c) Measure the length from the roller head to the mark on the roller shank and record it on the tag.

- (3) Remove and keep for reference the four cam rollers, Part No. NAS562-5R25. Refer to Figure 1 item 390 in the BD-700 AIPC, Chapter 52-31-01.

NOTE: Remove and keep the nuts (item 395), the jam nuts (item 415), the washers (item 420), the threaded sleeves (item 410) and the bumpers (item 405). Discard the cotter pins (item 400 not illustrated).

- (4) Install the four new cam rollers, Part No. GD322-3175-1 with kept hardware.

NOTES: 1. Use the recorded measurement from the kept cam rollers as reference to install and adjust the new cam rollers at each position on the door.

2. Torque the cam roller nuts 100 to 140 lbf-in (11.30 to 15.82 Nm) and safety with new cotter pins. Refer to TASK 20-50-00-400-801.

- (5) Install the baggage door as given in TASK 52-31-00-400-801 but do not connect the door warning wire at this time.

- (6) Move the door up and down in the tracks to check for smooth travel and make sure that the baggage door is centered.

NOTE: If necessary, adjust the cam rollers with the jam nut(s) on the threaded sleeve(s) of the cam roller(s) and make sure that the distance between the cam rollers and the track flange with the door closed is between 0.020 and 0.025 inch (0.508 and 0.635 mm).

- (7) If the door is not centered, do the rigging as given in TASK 52-31-00-820-801.

- (8) Connect the door warning wire and complete the installation of the baggage door as given in TASK 52-31-00-400-801.

C. Testing

- (1) Set the circuit breakers that follow to IN (refer to TASK 24-00-00-863-802):

SYSTEM NAME	CIRCUIT BREAKER NAME	BUS NAME
LDG GEAR	GEAR CTL A PWR 1	DC 1
LDG GEAR	GEAR CTL A PWR 2	BATT
LDG GEAR	GEAR CTL B PWR 1	DC 2
LDG GEAR	GEAR CTL B PWR 2	BATT

- (2) Connect and energize the external ac power. Refer to TASK 24-41-00-861-801.
(3) Do the functional test of the baggage door. Refer to TASK 52-31-00-720-801.
(4) Do the operational test of the baggage door. Refer to TASK 52-31-00-710-801.
(5) Remove the external ac power. Refer to TASK 24-41-00-861-802.

D. Close-out

- (1) Remove all tools, equipment and unwanted materials from the aircraft.
(2) Install the floor panel 251DLF and 251FLF. Refer to TASK 53-41-01-400-801.

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).

3. MATERIAL INFORMATION

A. Kit

Kit 700K52-033 is necessary to do this Service Bulletin and contains the parts that follow:

NEW PART NO.	QTY	KEY WORD	USED PART NO.	INSTRUCTIONS - DISPOSITION
GD322-3175-1	4	Cam Roller	NAS562-5R25	Discard
MS24665-82	2	Cotter Pin	MS24665-82	Discard
MS24665-159	4	Cotter Pin	MS24665-159	Discard
M39029/1-101	2	Contact #20-24, Splice	M39029/1-101	Discard

- NOTES:**
1. In case of discrepancy between this list and the "Service Bulletin Kit Parts List" contained in the respective kit, then the latter list prevails.
 2. The actual quantity for some of the hardware contained in the kit can be greater than the amount shown in the table as these items are supplied in pre-packaged quantities.

B. Parts

No parts required.

C. Material

The materials that follow, or equivalents, 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)
Compound, Corrosion Preventive CT: 1 to 2 hrs	LPS-3 or Aeroshell Compound 02 or Braycote 137	MIL-C-16173, Grade 2	As Necessary	Code: A or Code: B or Code: C
Tape, Polyurethane Protective	3M Part No. 8671	CMS 535-07, Type IV	As Necessary	Code: D

**BOMBARDIER
GLOBAL EXPRESS
BOMBARDIER
GLOBAL EXPRESS^{XRS}**

MODEL BD-700-1A10 (BD-700)

DESCRIPTION	PART No./NAME	SPECIFICATION	QUANTITY	SUPPLIER (See Note)
Solvent	Diestone DLS or Diestone HFP or HFE-71DA	-	As Necessary	Code: E
Tape, PTFE Sealant	Skyflex GSC-21-95261-011 (0.06 x 1.1 inch) or GSC-21-98006-021 (0.125 x 1.1 inch)	BAMS 533-02, Type II (AMS 3255)	As Necessary	Code: F
Liquid Barrier, Protection Tape, Interlined Vinyl	P-306L	-	As Necessary	Code: G

- NOTES:**
1. Refer to the next table 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.

SUPPLIERS ADDRESSES BY CODES	
<p>Code: A</p> <p>LPS Laboratories 4647 Hugh Howell Road Tucker, GA, 30085-5052 U.S.A. Tel.: 1-800-241-8334 Web Site: www.lpslabs.com</p>	<p>Code: B</p> <p>Shell UK Products Ltd. Stanlow Manufacturing Complex P.O. Box 3 Ellesmere Port U.K. CH65 4HB Tel.: 0151-350-4000 Web Site: www.shell.com</p>

BOMBARDIER
GLOBAL EXPRESS
BOMBARDIER
GLOBAL EXPRESS^{XRS}

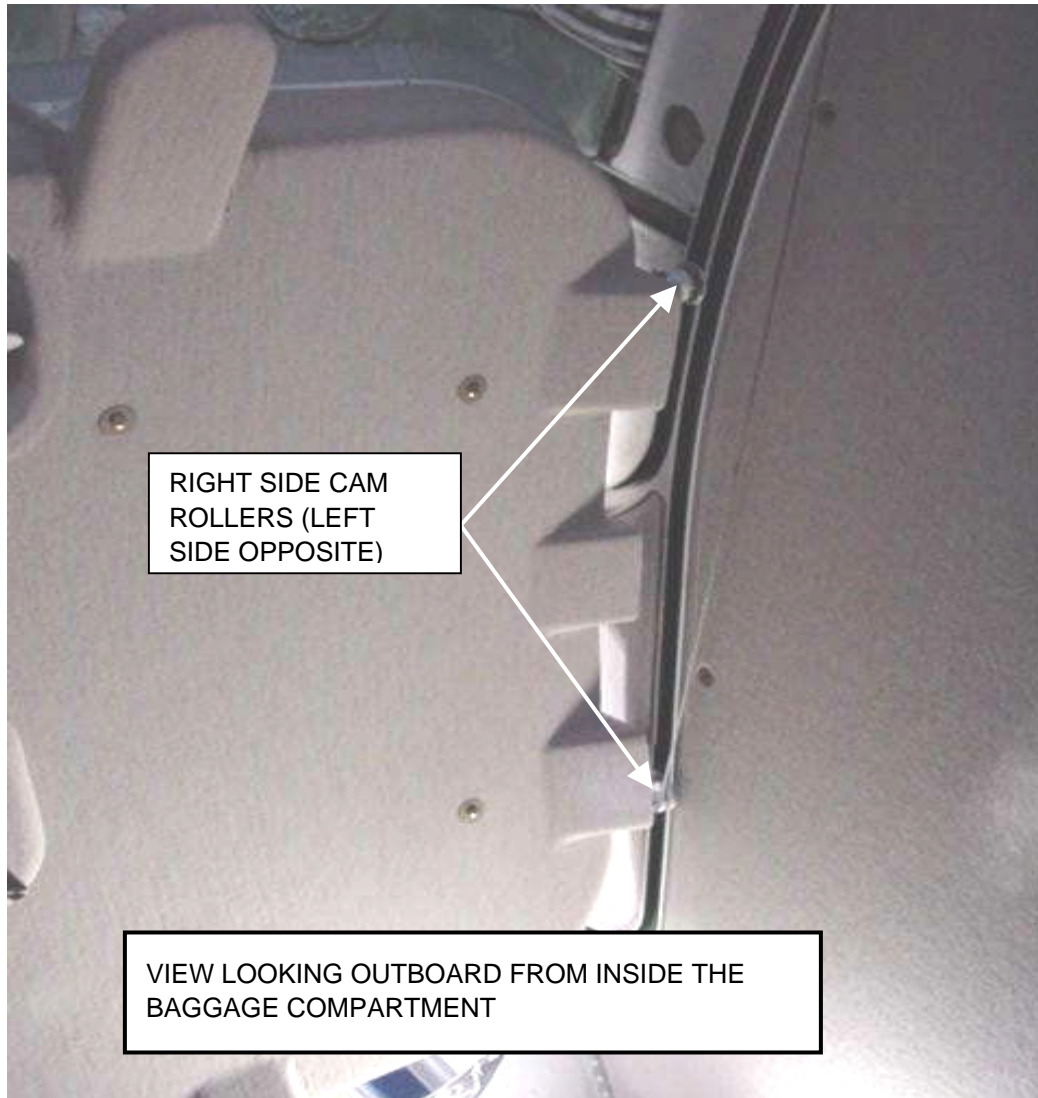
MODEL BD-700-1A10 (BD-700)

SUPPLIERS ADDRESSES BY CODES	
<p>Code: C</p> <p>Castrol Industrial North America 1001 West 31ST Street Downers Grove, IL, 60515-1280 U.S.A. Tel.: (708) 241-4000 Web Site: www.castrol.com</p>	<p>Code: D</p> <p>3M Aerospace and Aircraft Maintenance Division 3M Center Building 223-1N-14 St Paul, MN, 55144-1000 U.S.A. Tel: 1-800-235-2376 Web Site: http://www.3M.com/aerospace</p>
<p>Code: E</p> <p>MagChem Inc 1271 Ampere Boucherville, Que Canada, J4B 5Z5 Tel.: (450) 655-1344 or 3M Product Information Center 3M Center, Building 0304-01-01 St. Paul, MN 55144-1000 U.S.A. Tel.: 1-888-364-3577 Fax: 1-800-713-6329</p>	<p>Code: F</p> <p>A. L. Gore and Associates GoreTM Skyflex[®] Sealant Contact Information 402 Vieve's Way Elkton, MD, 21921 U.S.A. Tel.: 1-800-311-3060 Web Site: www.gore.com</p>
<p>Code: G</p> <p>Permacel, a Nitto Denko Company One Tower Center, 14th Floor East Brunswick, NJ, 08816 Tel.: 1-800-755-8273 Web Site: www.permacel.com</p>	

D. Publications

No publications required.

BOMBARDIER
GLOBAL EXPRESS
BOMBARDIER
GLOBAL EXPRESS^{XRS}
MODEL BD-700-1A10



Baggage Door – Cam Roller Location
Figure 1

SERVICE BULLETIN EVALUATION FORM

(Your ideas will help us provide better bulletins)

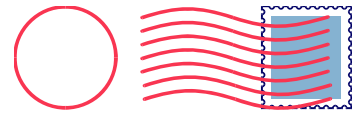
SERVICE BULLETIN: 700-52-033 **ISSUE:** Basic **DATED:** Sep 15/2008

TITLE: Modification – Baggage Door – Replace Baggage Door Track Rollers to Improve Operation

	STRONGLY DISAGREE	DISAGREE	NEUTRAL	AGREE	STRONGLY AGREE
<ul style="list-style-type: none"> Instructions to do the Service Bulletin were accurate. Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<ul style="list-style-type: none"> Illustration(s), figure(s), and/or kit drawing(s) were helpful to carry out instructions. Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<ul style="list-style-type: none"> If a kit was required, did the kit contents received agree with the contents listed in the bulletin? Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<ul style="list-style-type: none"> The loose parts listed under Paragraph 3 were easily procured. Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<ul style="list-style-type: none"> Work was accomplished in the prescribed time. Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<ul style="list-style-type: none"> Overall, I was satisfied with this Service Bulletin. Comments: 	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

<i>For administrative use only</i>	PLEASE SUPPLY US WITH THE FOLLOWING DATA AND FAX TO: (514) 855-7634 or E-MAIL TO: MTL_BBAD_SB_Evaluation@aero.bombardier.com	
522AT	OPERATOR:	
	AIRCRAFT SERIAL NO.:	
	TELEPHONE:	
	FACSIMILE:	
	NAME: (Please print)	

THANK YOU FOR YOUR RESPONSE!
 PLEASE RETURN THIS COMPLETED EVALUATION FORM BY MAIL, E-MAIL OR FAX



Bombardier Business Aircraft Customer Services (BBACS)

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

Attention: Customer Support Department

SERVICE BULLETIN INCORPORATION SHEET – “700-52-033”

Upon completion of the Service Bulletin, please fill in this form and either fold and mail in the envelope provided, or fax to:(514) 855-7634, or e-mail to Fracas at fracas.montreal@aero.bombardier.com

NOTE: For configuration control purposes, please fill out one form for each Service Bulletin.

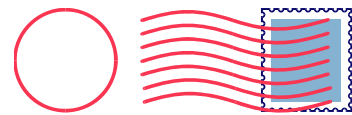
Service Bulletin Number	Rev.	* Parts Completed	Further Action Required	
			YES	NO
700-52-033	Basic	-	<input type="checkbox"/>	<input type="checkbox"/>
-	-	-	<input type="checkbox"/>	<input type="checkbox"/>
-	-	-	<input type="checkbox"/>	<input type="checkbox"/>

Actual hours to accomplish Service Bulletin:
 Access: _____ Modification: _____ Tests: _____ Restore: _____

* **NOTES:** 1. 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.
 2. For repetitive checks (usually PART A), only the initial check should be reported unless otherwise stated in the Service Bulletin.
 3. When more than one part is carried out at the same time, each part should be reported.

Is the aircraft enrolled on the CAMP computerized maintenance program?	Yes	No
	<input type="checkbox"/>	<input type="checkbox"/>

Aircraft Serial No.	_____	Aircraft Reg. No.	_____
Airframe Landings	_____	Airframe Hours	_____
Date of Incorporation	_____	Service Order No.	_____
Facility & Location Incorporation Bulletin	_____		
PRINT NAME	_____	DATE:	_____
SIGNATURE:	_____		



Bombardier Business Aircraft Customer Services (BBACS)

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

Attention: Customer Support Department, Maintenance Engineering
