TO: ALL HOLDERS OF JT8D THRUST REVERSER TAILPLUG ASSEMBLY OVERHAUL MANUAL, 78-38-71

REVISION NO. 1, DATED JUN 5/91

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D&O	D/Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Changed filler wire number due to the unavailability of existing part number					X								
Changed IPL and illustrations to show clarity and to agree with latest production drawing												X	

JT8D THRUST REVERSER TAILPLUG ASSEMBLY

78-38-71

BOEING P/N 65-27808-2, -6, -7, -10, -13; 65-65919-5

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
78-36		PRR 21986	Oct 15/66
78-50		PRR 21986-1	Feb 15/69
		PRR 22816-7	Feb 15/69
		PRR 31175	Feb 15/69

LIST OF EFFECTIVE PAGES

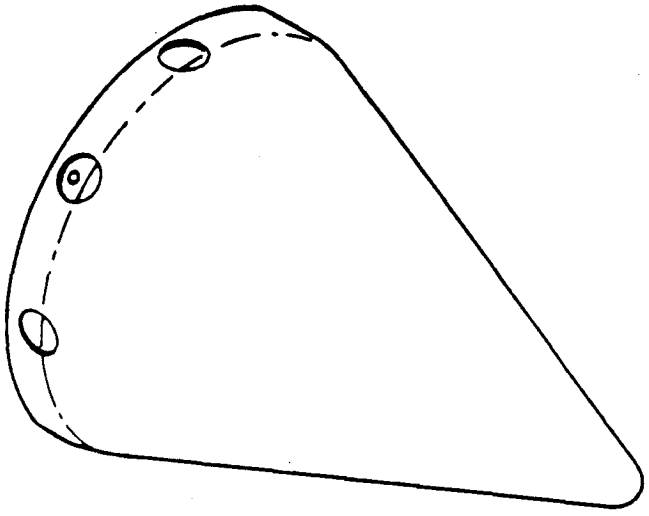
* Indicates pages revised, added or deleted in latest revision
F Indicates foldout pages - print one side only

78-38-71

	PAGE	DATE
*	T-1	Jun 5/91
	T-2	BLANK
*	LEP-1	Jun 5/91
	LEP-2	BLANK
	T/C-1	Feb 15/69
	T/C-2	BLANK
	1	Feb 15/69
	2	Feb 15/69
*	3	Jun 5/91
*	4	Jun 5/91
*	5	Jun 5/91
*	6	Jun 5/91
*	7	Jun 5/91
	8	BLANK

TABLE OF CONTENTS

JT8D THRUST REVERSER TAILPLUG ASSEMBLY
Boeing Part Numbers: 65-27808-7, -10 and -13
65-65919-5



JT8D Thrust Reverser Tailplug Assembly
Figure 1

1. DESCRIPTION AND OPERATION

A. Description

(1) The tailplug assembly is a conical structure with mounting bolt access holes at the forward end. The power plant turbine aft bearing hub has nutplates located to receive the tailplug mounting bolts.

B. Operation

(1) The tailplug allows smooth expansion of the power plant exhaust gas into the thrust reverser tailpipe assembly.

C. Leading Particulars

Length -- 18.00 inches (approximately)
Diameter -- 10.50 inches (approximately)
Weight -- 4.20 pounds

2. DISASSEMBLY (See figure 3.)

A. The tailplug assembly is a welded or formed structure and should not be disassembled unless repair or replacement is necessary.

3. CLEANING

A. Wash all parts in dry cleaning solvent, Specification P-D-680 or equivalent.

B. Use a stiff bristle brush or liquid abrasive blasting (vapor blast) to remove stubborn accumulations of foreign matter.

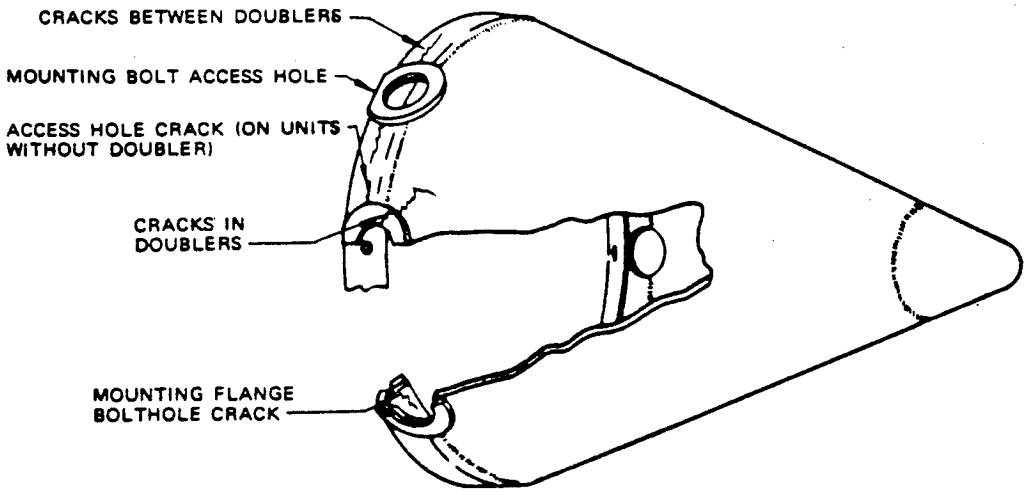
NOTE: Use vapor blast equipment, similar to Pangborn Hydro-Finish Machine, Type EX, Pangborn Corporation, Hagerstown, Maryland. Use a water and grit mixture with 625 or finer mesh grit. Do not concentrate the blast in any one area.

C. Dry parts with a clean lint-free cloth or moisture-free compressed air.

4. INSPECTION/CHECK (See figure 2.)

A. Check tailplug assembly for dents, and other damage.

B. Perform a penetrant inspection on tailplug assembly paying particular attention to the mounting flange bolthole area.



Inspection and Repair
Figure 2

5. REPAIR (Fig. 2 and 3)

A. Repair

(1) Remove minor scratches, nicks, pitting and corrosion by polishing with abrasive cloth. Fill defects that penetrate deeper than 20 percent of base metal thickness with AWS A5.9, class ER347 or ER349 filler metal. Use inert gas tungsten arc welding with copper backup plates to prevent burn-through and warping.

(2) Handwork all deformed structure to original contours.

(3) Repair minor cracking as indicated in Fig. 2 as follows:

(a) Penetrant inspect and stop-drill cracks.

(b) Weld cracks using the Inert Gas Tungsten Arc process. Use AWS A5.9, class ER347 or ER349 filler metal, and copper backup plates to prevent burn-through.

(c) Penetrant-inspect weld repair areas prior to grinding or machining.

(d) Stress-relieve after all welding, forming or sizing, and before final machining. Heat to 1650° ±25°F and maintain for 30 minutes in air atmosphere. Air cool. For optional bright stress relief, heat to 1650° ±25°F in argon or hydrogen atmosphere. Retort cool in protective atmosphere to 250°F or lower.

NOTE: Tailplug material is Corrosion Resistant Steel, Type AISI 321 or 347, Specification MIL-S-6721, Condition Annealed.

B. Refinish

(1) Passivate tailplug per BAC5751, Method 2.

C. Replacement

(1) Replace all parts found unserviceable or damaged beyond prescribed repair.

6. ASSEMBLY

A None

7. FITS AND CLEARANCES

A. None

8. TESTING

A. None

9. TROUBLE SHOOTING

A. None

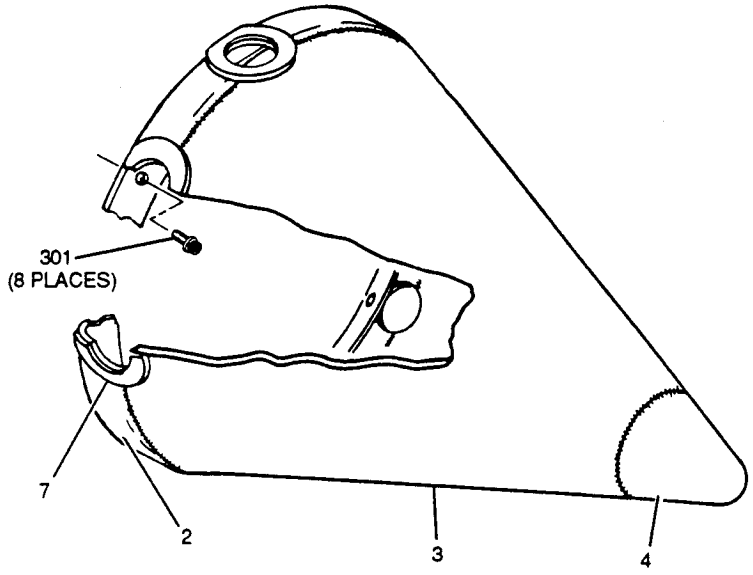
10. STORAGE INSTRUCTIONS

A. If storage rather than installation of the tailplug assembly on the engine is planned, wrap the unit in vapor barrier material. Enclose the unit in an economical structure to prevent handling damage.

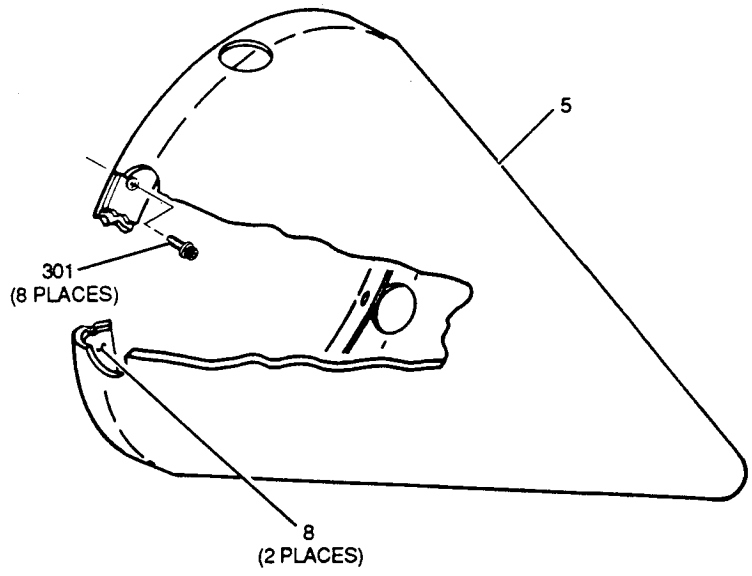
11. SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

A. Inert Tungsten Arc welding equipment with 1/16-inch AWS A5.9, class ER347 or ER349 bare filler wire.

B. Copper chill blocks to prevent weld burn-through or warpage.



65-27808-2, -7



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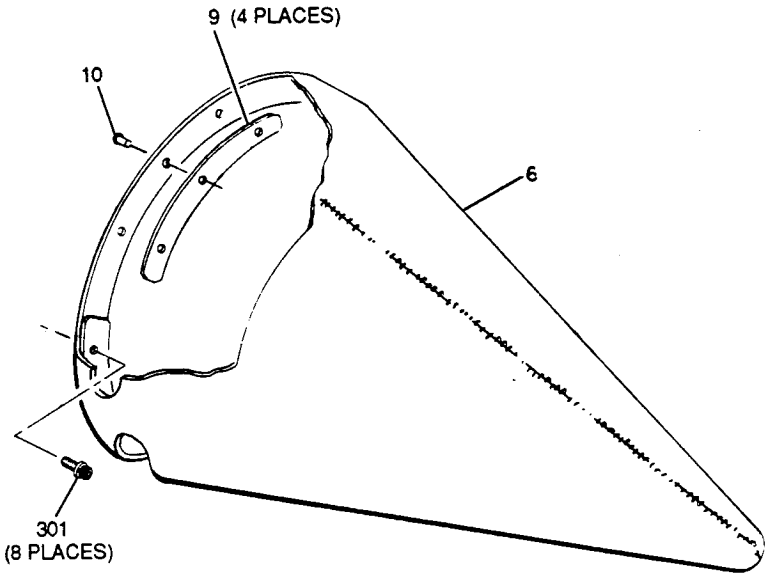
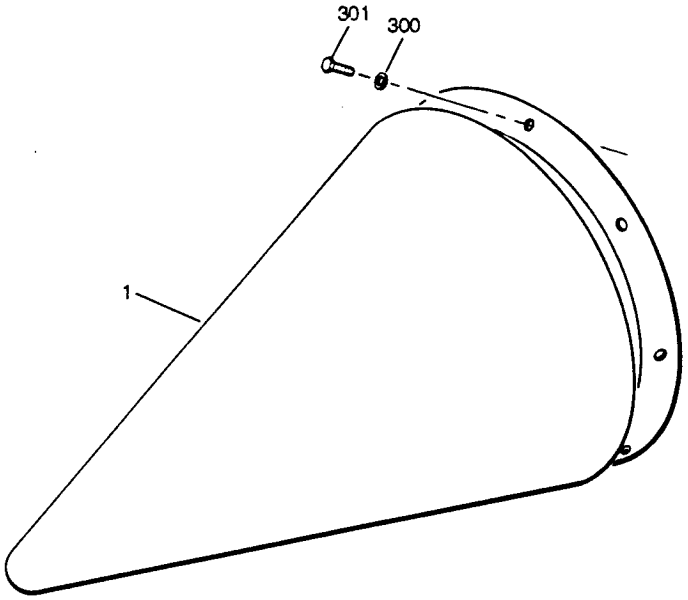


65-27808-13



65-65919-5

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
1	65-27808-2		TAIL PLUG ASSY (LIMITED) (OPT 65-27808-7,-6)	A	RF
1	65-27808-6		TAIL PLUG (LIMITED) *[1] (PREF)	B	RF
1	65-27808-7		TAIL PLUG ASSY (LIMITED) (OPT 65-27808-6)	C	RF
1	65-27808-10		TAIL PLUG ASSY (SB 78-50)	D	RF
1	65-27808-13		TAIL PLUG ASSY (SB 78-50)	E	RF
1	65-65919-5		TAIL PLUG *[1]	F	RF
2	65-27808-3		. ANGLE MOUNTING	A	1
3	65-27808-4		. CONE (USED ON 65-27808-2)	A	1
4	65-27808-5		. END (USED ON 65-27808-3)	A	1
5	65-27808-6		. TAIL PLUG (LIMITED)	D	1
6	65-27808-14		. TAIL PLUG (LIMITED)	E	1
6	65-27808-800		. TAIL PLUG (LIMITED) (OPT 65-27808-14)	E	1
7	65-27808-8		. DOUBLER	C	8
8	65-27808-9		. DOUBLER (SB 78-50)	D	2
9	65-27808-15		. DOUBLER (SB 78-50)	E	4
			ATTACHING PARTS		
10	MS20427F4-6		. RIVET (USED ON 65-27808-15) (SB 78-50)		4
			---------*---------		
			INSTALLATION PARTS		
300	AN960C416		WASHER	F	8
301	MS9054-10		BOLT	F	8
301	MS9034-8		BOLT	AC	8
301	MS9034-10		BOLT	BDE	8

*[1] NO COMPONENT PARTS REQUIRED