



SERVICE BULLETIN

NUMBER: SB 500-54-002, REV B
MODEL: ECLIPSE EA500
SUBJECT: ENGINE TAIL CONE PRIMER

1. PLANNING INFORMATION

A. Effectivity

Aircraft Serial Numbers 000001-000189.

B. Reason

Engine exhaust tail cone requires primer on mounting flange.

Revision B corrects Labor Hours.

C. Description

This service bulletin provides instructions to remove engine tail cone, prime mounting flange, and reinstall tail cone.

D. Compliance

Eclipse Aerospace Inc. considers this to be an recommended modification that should be accomplished. May accomplish at operators discretion within one year from the release of the service bulletin or next 300 hour inspection or next access.

E. Approval

This Service Bulletin is based on engineering data and the modification herein complies with the applicable regulations.

F. Labor Requirements

The following information is for planning purposes only.

(1) Estimated labor hours to perform - per engine:

Suggested number of personnel: 1

Set up: 6 Hours

Rework : 2 Hours (does not include drying time)

Close up: 8 Hours

Total labor hours: 32 Hours

The above is an estimate based on properly equipped and experienced personnel complying with this Service Bulletin. Actual labor hours may vary depending on workforce experience, concurrent maintenance, discovery of other discrepancies, etc.

(2) Qualification of personnel:

- A person properly authorized under 14 CFR 43 to perform aircraft maintenance.



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G. Weight and Balance Change

None.

H. Electrical Load Data Change

None.

I. Software Accomplishment Summary

None.

J. References

Aircraft Maintenance Manual (AMM), P/N 06-117751, latest revision.

K. Publications Affected

None.

2. MATERIAL INFORMATION

A. Consumables

The following consumables are required for this Service Bulletin.

Material	Specification	Use
Isopropyl Alcohol	ASTM D770 or JIS K 1522	Surface cleaning
Methyl Ethyl Ketone (MEK)	ASTM D740 Type I or JIS K1524	Surface cleaning
PPG Aerospace (PRC-DeSoto) HS/CA7700 series of primers.	MIL-PRF-23377	Exhaust tail cone flange

B. Tooling

The following special tooling/support equipment is required to accomplish this Service Bulletin.

Nomenclature	Specification	Use
High Volume Low Pressure Spray Gun (HVLP) or Conventional Air Spray Gun	HVLP Tip Size 1.0 to 1.4 mm (or equivalent), Pot Pressure 10 to 20 psi (0.69 to 1.4 bar), Atomization Pressure at the Cap 10 psi maximum (0.69 bar). Conventional Air Spray Gun Tip Size 1.2 to 1.8 mm (or equivalent), Pot Pressure 10 to 20 psi (0.69 to 1.4 bar), Atomization Pressure at the Cap 45 to 60 psi (3.1 to 4.1 bar)	Application of primer.

C. Interchangeability/Intermixability of Parts

None

D. Part Re-identification

None.



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3. ACCOMPLISHMENT INSTRUCTIONS

A. Set Up

- (1) Make aircraft safe for maintenance. Refer to AMM 20-00-01 MAKE SAFE FOR MAINTENANCE.
- (2) Remove left and right engine exhaust tail cones. Refer to AMM 54-20-24 TAIL CONE-REMOVAL.

B. Procedure

- (1) Clean exhaust tail cone by wiping with a clean cloth moistened with Methyl Ethyl Ketone (MEK) or Isopropyl Alcohol, changing cloths as necessary when they become discolored or otherwise contaminated. Refer to AMM 20-09-00 SURFACE PREPARATION.
- (2) Mask off tail cone to prevent overspray. Do not coat inside of tail cone. Refer to [Figure 1](#).
- (3) Clean a second time prior to coating by wiping with a clean cloth moistened with Methyl Ethyl Ketone (MEK) or Isopropyl Alcohol, changing cloths as necessary when they become discolored or otherwise contaminated. Wipe dry immediately after the solvent moistened cloth with a clean, dry cloth before the solvent has a chance to completely evaporate. Refer to AMM 20-09-00 SURFACE PREPARATION.
- (4) Apply two coats of MIL-PRF-23377 epoxy primer. Apply primer to the following dry film thickness of 0.0010 – 0.0018 in. (25-46 microns). Refer to AMM 20-09-00 APPLICATION (epoxy primer).

NOTE: Spray coating is recommended, however brush or roller is permissible.

C. Close Up

- (1) Install left and right engine exhaust tail cone. Refer to AMM 54-20-24 TAIL CONE-INSTALLATION.
NOTE: Allow primer to dry before installing tail cone.
- (2) If all other maintenance is complete, return aircraft to service. Refer to AMM 20-00-02 RETURN TO SERVICE (AFTER MAINTENANCE).



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**Tail cone flange
Figure 1**



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D. Limitations and Procedures

None.

E. Cost

Contact Eclipse Aerospace Customer Care for cost information.

4. RECORD OF COMPLIANCE

Upon completion of this Service Bulletin, make an appropriate maintenance-record entry specifying the Service Bulletin number.

5. NOTIFYING ECLIPSE AEROSPACE

On completing this service bulletin, the operator/maintainer shall complete the attached Compliance Record and send it to Eclipse Aerospace via regular mail, fax, or e-mail.

MAILING ADDRESS	Eclipse Aerospace Incorporated ATTN: Customer Care 2503 Clark Carr Loop SE Albuquerque, NM 87106
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