

NUMBER: SB 500-54-004, Rev A
MODEL: ECLIPSE EA500
SUBJECT: VORE Lower Louver Skin Drainage

Recommended

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1. PLANNING INFORMATION

A. Effectivity

Aircraft Serial Numbers 0001-0300.

B. Reason

This Service Bulletin been prepared to improve drainage in the VORE area.

C. Description

This Service Bulletin provides procedures to add drainage holes to the VORE Lower Louver Skins.

D. Relevant Publications

None

E. Compliance

Eclipse Aerospace Inc. considers this to be a recommended upgrade that can be accomplished at the operator's discretion.

F. Approval

This Service Bulletin is based on engineering data that is FAA-approved, and the modification herein complies with the applicable regulations.

G. Labor Requirements

The following information is for planning purposes only.

(1) Estimated labor hours to perform:

Suggested number of personnel: 1

Prep Aircraft: 1.0 Hour

Remove/Rework (2) Panels: 2.0 Hours

Prime/Paint (2) Panels: 2.0 Hours

Install Panels & Return to Service: 1.0 Hour

Task name: TBD Hours

Total labor hours: 6.0

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 to perform aircraft maintenance under 14 CFR 43 or equivalent approved by the Civil Aviation Authority having jurisdiction.

H. Weight and Balance Change

None

I. References

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

J. Publications Affected

None

2. MATERIAL INFORMATION

A. Materials

Order parts below:

Part Number	Description	Qty	Unit of Issue
AN231-4	Grommet - Drainage, Plastic	2	EA.

B. Consumables

The following consumables are required for this Service Bulletin.

Material	Specification	Use
Adhesive	Scotchweld 2216 or equivalent	Bond grommet to panel
Epoxy Resin	Hysol 9396 or equivalent	To seal hole edge surface

C. Tooling

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

Nomenclature	Specification	Use
Jack, Main	Tronair, 02-0517-0140, (two) or equivalent	To level aircraft
Jack, Tail	Tronair, 02-0522-0140, (one) or equivalent	To level aircraft
Calibrated Inclinator		To level aircraft

D. Interchangeability/Intermixability of Parts

None

E. Part Re-identification

Refer to Accomplishment Instructions.

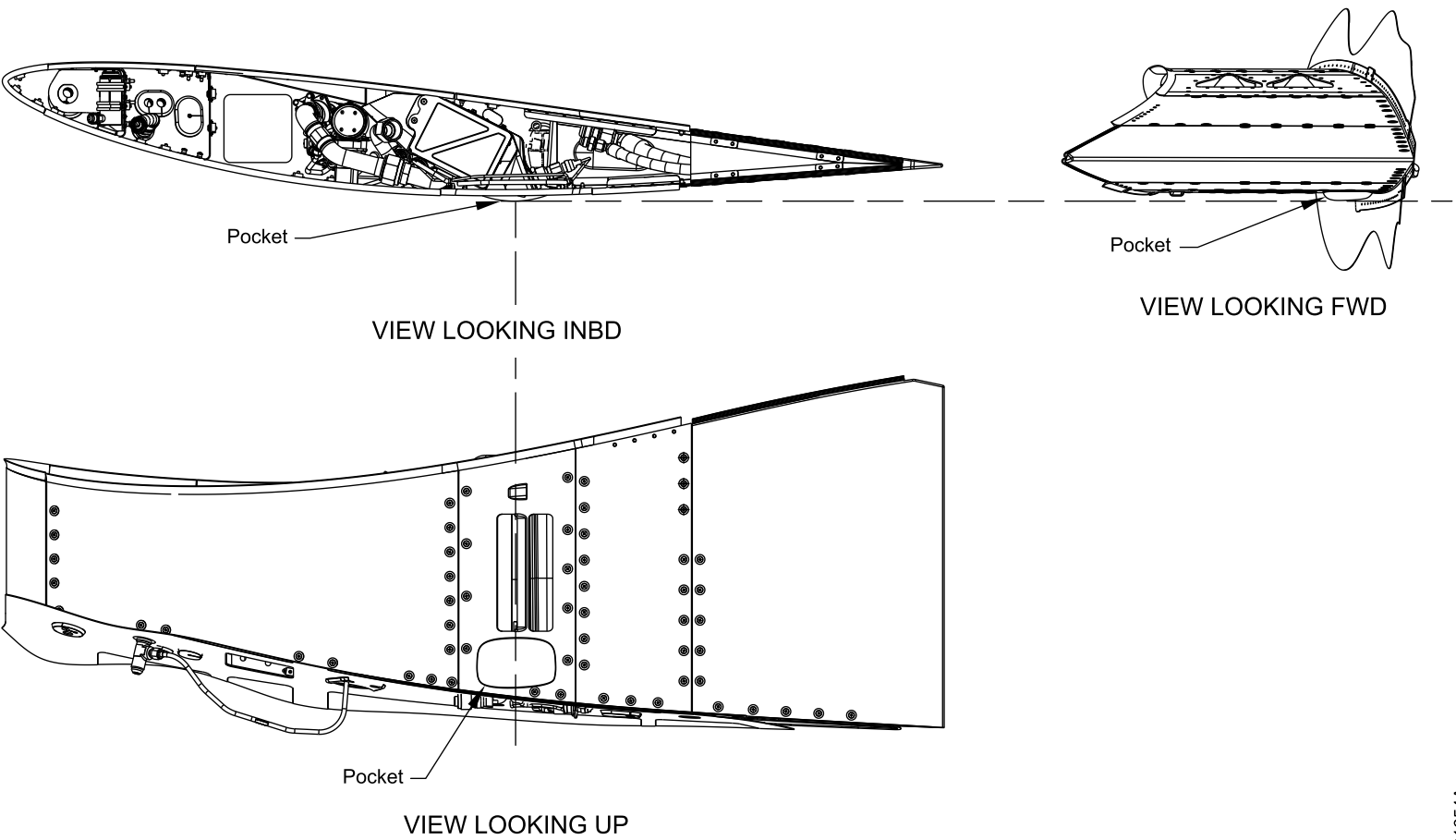
3. ACCOMPLISHMENT INSTRUCTIONS

A. Procedure

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- (1) Make the aircraft safe for maintenance. Refer to AMM 20-00-01 MAKE SAFE FOR MAINTENANCE. _____
 - (2) Level aircraft. Refer to AMM-07-10-00 - JACKING - MAINTENANCE PRACTICES and AMM-08-20-00 - LEVELING. _____
- NOTE: Jacking the aircraft may be required to level the aircraft.
- (3) Locate and mark position for center of hole at the lowest point at the pocket located on Left Lower Pylon Louver Assembly - 311 KL and Right Lower Pylon Louver Assembly - 312 GR. Refer to [Figure 1](#). _____

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**Left Louver (Right Side Opposite)
Figure 1**

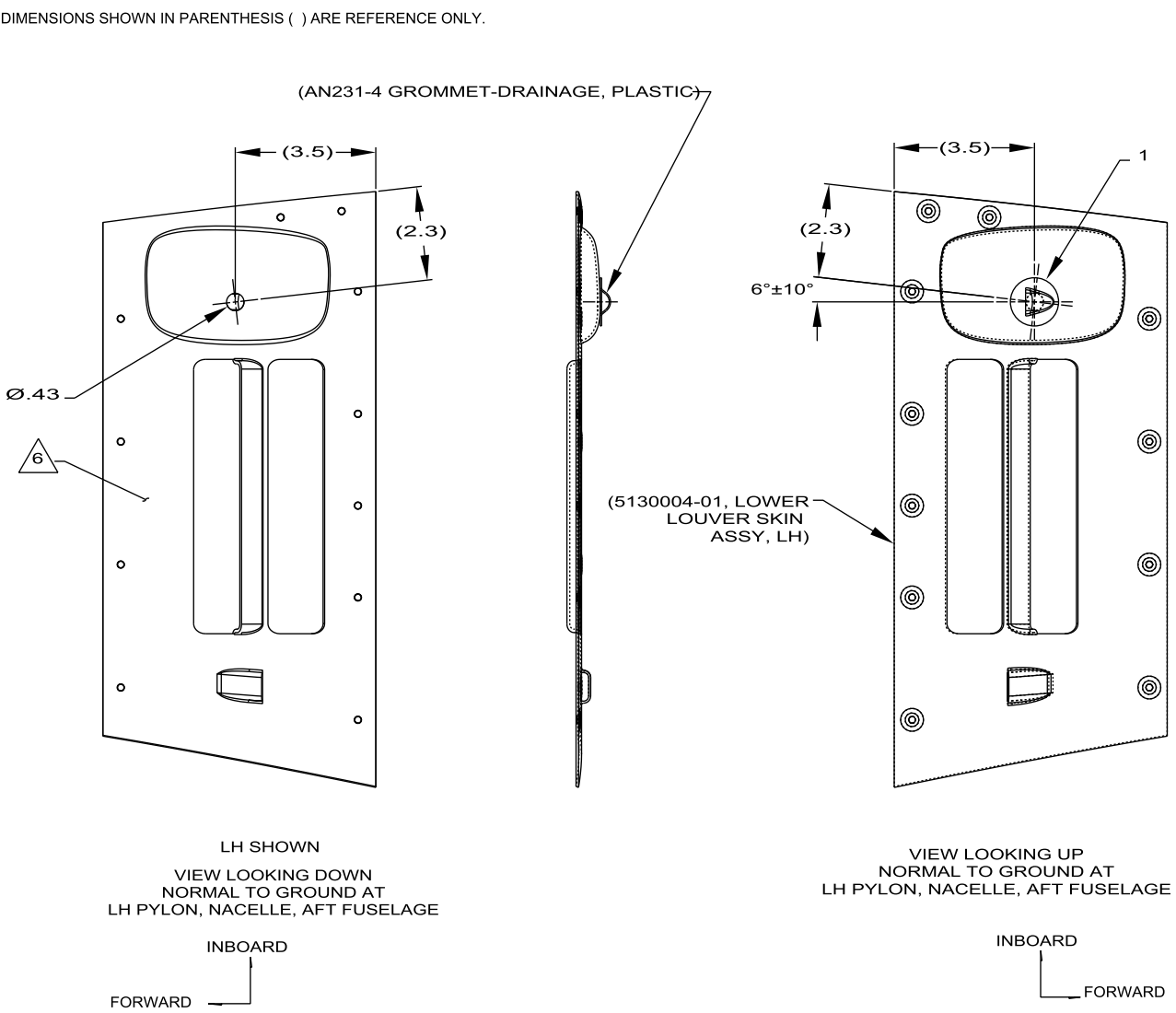
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- (4) Remove Left Lower Pylon Louver Assembly - 311 KL and Right Lower Pylon Louver Assembly - 312 GR. Refer to AMM - 54-30-16-B - LOWER LOUVER PYLON SKIN - REMOVAL. _____
- (5) Inspect area behind Left Lower Pylon Louver Assembly - 311 KL for corrosion. Treat area as required. Refer to AMM - 20-10-00 - CORROSION. _____
- (6) Inspect area behind Right Lower Pylon Louver Assembly - 312 GR for corrosion. Treat area as required. Refer to AMM - 20-10-00 - CORROSION. _____
- (7) Rework Left Lower Pylon Louver Assembly - 311 KL as follows:

NOTE: Dimensions () on figure are for reference only.

- (a) Locate using mark from step (3) and drill Ø 0.43 hole on Left Lower Pylon Louver Assembly - 311 KL. Refer to [Figure 2](#). _____
- (b) Surface prep the area to be bonded. _____
- (c) Seal exposed edge of hole with Hysol 9396 or equivalent. _____
- (d) Bond Drainage Grommet, P/N AN231-4 (1, [Figure 2](#)) with Scotchweld 2216 or equivalent over new Ø 0.43 hole on outer surface of Left Lower Pylon Louver Assembly - 311 KL. Note direction of opening of Drainage Grommet, P/N AN231-4 in relation to the aft facing edge. Refer to [Figure 2](#). _____
- (e) Fill and blend any areas where the base of the Drainage Grommet, P/N AN231-4 rises above the loft of the convex surface with Scotchweld 2216. _____
- (f) After adhesive has cured, primer and paint reworked area. _____
- (g) Part mark "Modified by SB 500-54-004" with indelible ink in area shown. Refer to [Flag Note 6, Figure 2](#). _____

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Left Louver Panel Rework
Figure 2

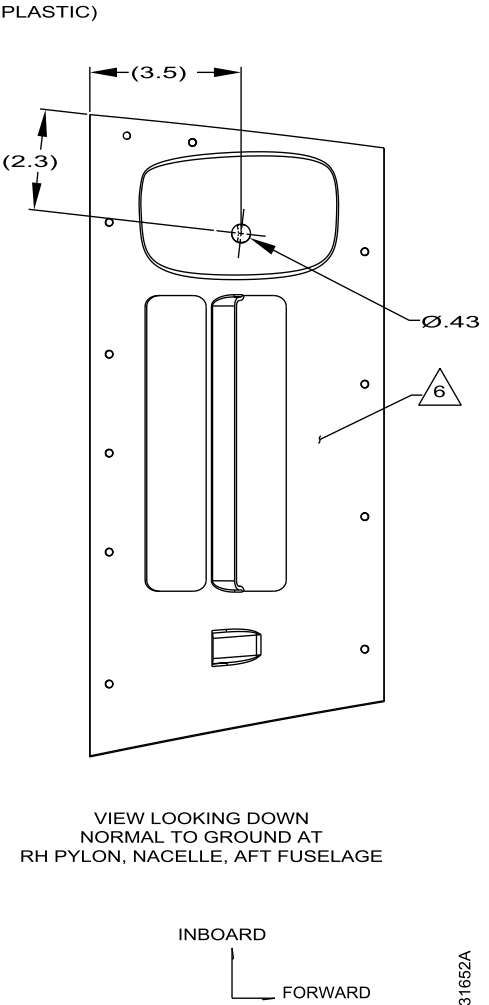
- (8) Rework Right Lower Pylon Louver Assembly - 312 GR as follows:

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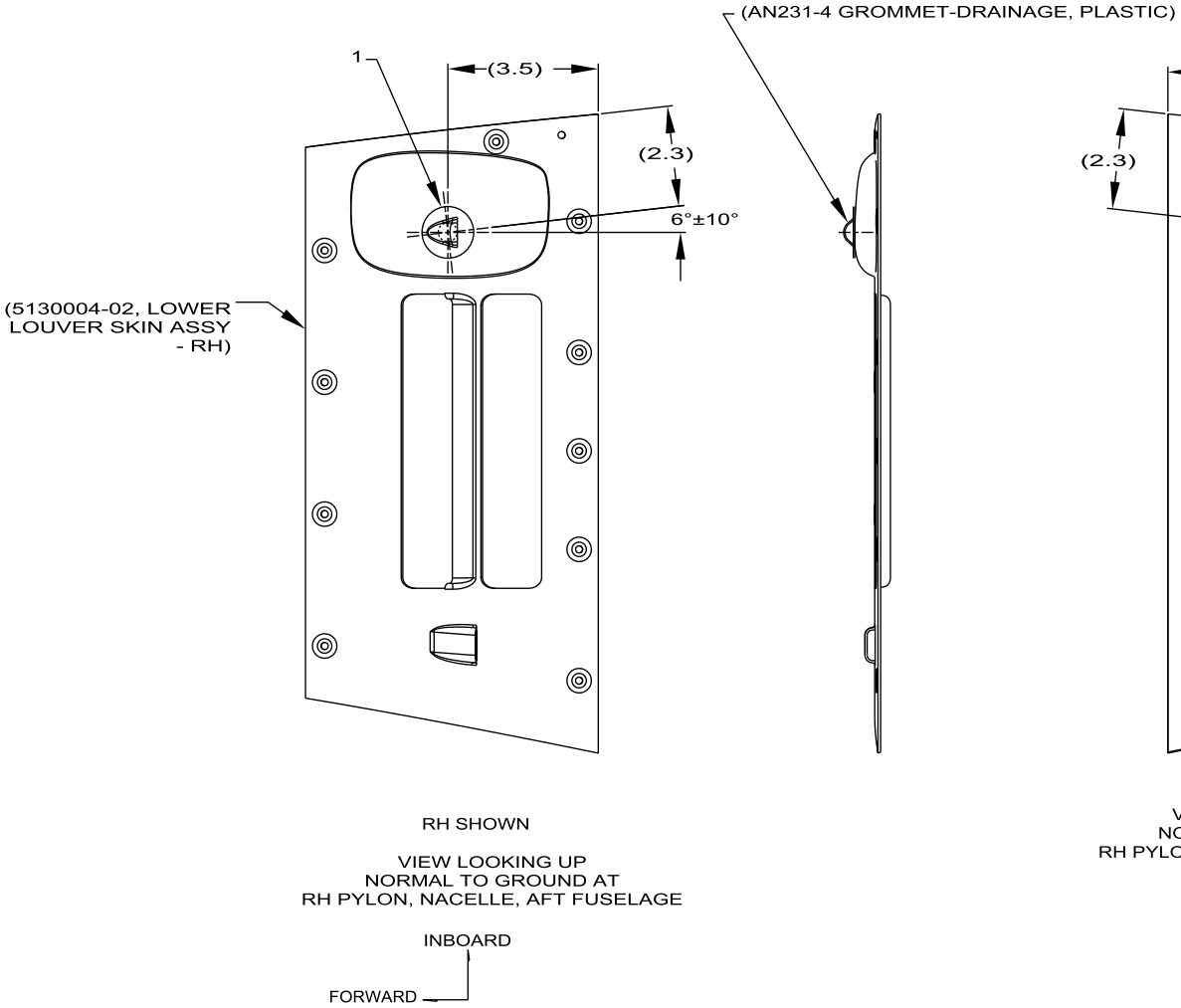
NOTE: Dimensions () on figure are for reference only.

- (a) Locate using mark from step (3) and drill \varnothing 0.43 hole on Right Lower Pylon Louver Assembly - 312 GR. Refer to [Figure 3](#). _____
- (b) Surface prep the area to be bonded. _____
- (c) Seal exposed edge of hole with Hysol 9396 or equivalent. _____
- (d) Bond Drainage Grommet, P/N AN231-4 ([1, Figure 3](#)) with Scotchweld 2216 or equivalent over new \varnothing 0.43 hole on outer surface of Left Lower Pylon Louver Assembly - 311 KL. Note direction of opening of Drainage Grommet, P/N AN231-4 ([1, Figure 3](#)) in relation to the aft facing edge. Refer to [Figure 3](#). _____
- (e) Fill and blend any areas where the base of the Drainage Grommet, P/N AN231-4 rises above the loft of the convex surface with Scotchweld 2216. _____
- (f) After adhesive has cured, primer and paint reworked area. _____
- (g) Part mark "Modified by SB 500-54-004" with indelible ink in area shown. Refer to [Flag Note 6, Figure 3](#). _____

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NOTE: DIMENSIONS SHOWN IN PARENTHESIS () ARE REFERENCE ONLY.



Right Louver Panel Rework
Figure 3

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- (9) If jacks were used to level aircraft, lower aircraft and remove jacks. _____
- (10) Install Left Lower Pylon Louver Assembly - 311 KL and Right Lower Pylon Louver Assembly - 312 GR. Refer to AMM - 54-30-16-B - LOWER LOUVER PYLON SKIN - INSTALLATION. _____
- (11) If all other maintenance is complete, return the aircraft to service. Refer to the AMM 20-00-02 RETURN TO SERVICE (AFTER MAINTENANCE). _____

B. Limitations and Procedures

None

C. Cost

Contact Eclipse Aerospace Inc. for cost and availability.

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: Service Engineering 2503 Clark Carr Loop SE Albuquerque, NM 87106
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