

**MarathonNorco Aerospace, Inc.  
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# **SERVICE BULLETIN**

**SB-SS112-52-1**

**Revision 2**

**Subject: Product Improvement – Escape Slide/Raft – Add Positive Lock  
to Packboard Latch**

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## LIST OF REVISIONS

Rev	Description of Revision
1	<p>PAGE 4 FIGURE 1 .290 WAS .170</p> <p>PAGE 4 SECTION 2.d. .290 WAS 0.170 +/- .020</p> <p>PAGE 4 SECTION 2.e. .290 WAS 0.170 +/- .020</p> <p>PAGE 7 SECTION 3.k. ADDED: HANDLES THAT DO NOT MEET THE 1.5 LBS REQUIREMENT MUST BE RETURNED TO THE MANUFACTURER FOR REWORK.</p>
2	<p>PAGE 3 SECTION 1.f.1.2.a. INSERT {SSM112-11A-48} WAS BLOCK SPRING {SSM112A11-45}</p> <p>PAGE 3 SECTION 1.f.1.2.b. SSM112-11A-46 WAS SSM112A11-46</p> <p>PAGE 5 FIGURE 2 SSM112-11A-46 WAS SSM112A11-46</p> <p>PAGE 6 SECTION 3.g. INSERT WAS BLOCK SPRING</p> <p>PAGE 6 FIGURE 5 INSERT WAS BLOCK SPRING; SSM112-11A-48 WAS SSM112A11-45</p> <p>PAGE 6 SECTIONS 3.h and i. INSERT WAS BLOCK SPRING</p> <p>THIS REVISION ONLY INCLUDES TYPOGRAPHICAL ERROR CORRECTIONS. THERE HAVE BEEN NO ENGINEERING OR FUNCTIONAL CHANGES.</p>

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**1. PLANNING INFORMATION**

a. Effectivity

1. Part numbers

1. SS112A1

a. All Serial Numbers

2. SS112A11

a. All Serial Numbers

2. Manufacture dates: **ALL**

b. Reason

1. Allow SS112A1 or SS112A11 assemblies to be reworked to add a positive locking feature.

c. Description

1. This service bulletin provides detailed instructions for reworking the NORCO Inc. or MarathonNorco Aerospace Inc. - SS112A1 or SS112A11 Latch Assy., Escape Ramp to the SS112A12 specification.

2. The rework requires the addition of a two-piece sliding detent to the handle and base plate.

d. Compliance recommendation

Recommended to be scheduled in accordance with Boeing Service Bulletin 747-25-3428.

e. Manpower

This estimate is for workshop labor and does not include the time required to remove and reinstall the latch assembly on the aircraft.

1. Inspection for critical clearance

0.05 hrs

2. Rework

0.50 hrs

Total 0.55 hrs

f. Material Information

1. Rework Kit and Availability

1. The parts required to accomplish this service bulletin are available from the manufacturer as rework kit part number RW112A12.

2. RW112A12 contains

a. (1) Handle Insert {SSM112-11A-48}

b. (1) Base Plate Block Spring {SSM112-11A-46}

c. (2) Screws {63C0112-20}

2. Operators should submit a purchase order with MarathonNorco Aerospace Inc. for the rework kits or items required. The purchase order should specify this service bulletin number. Delivery schedule will be furnished upon receipt of request. Contact information for MarathonNorco Aerospace Inc. can be found at [WWW.MNAEROSPACE.com](http://WWW.MNAEROSPACE.com) (contact us, Norco Products).

3. Special pricing for RW112A12 is valid for one year after origination date of this service bulletin: \$99.60 each.

g. Tooling and process material

Pull Force Gage 0 – 25 lbs

#43 Drill

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.112-40 UNC-2A Tap

BAC5010 adhesive, suggested use Loctite Hysol 608

h. Weight and Balance

1. Incorporation of this service bulletin will not significantly change the weight of the SS112A1 or SS112A11 when revised to SS112A12 assembly.

**2. ACCOMPLISHMENT OF INSPECTION**

Reference: Component Maintenance Manual, CMM, 52-20-1

- a. Orient the SS112A1 or SS112A11 assembly so that it can be viewed in the locked position.
- b. Ensure that the release arm is in the locked position.
- c. Measure the clearance between the handle and the base attachment plate of the assembly at the edge of the base plate as shown in Figure 1.

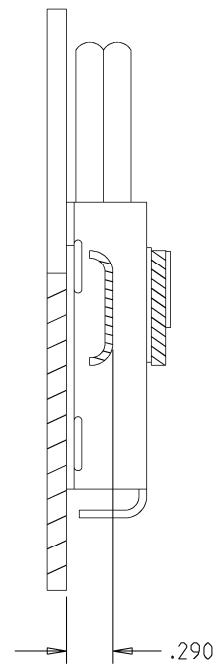


Figure 1. Base Plate to Handle Clearance Measurement Location

- d. If the nominal measurement exceeds 0.290 inches then the part must be returned to the manufacturer for rework.
- e. If the measurement is 0.290 inches or less then rework following the procedure outlined in Part 3 of this section.

**3. REWORK PROCEDURE**

- a. Rotate the handle from the locked position to the unlocked position.
- b. Align the base plate Block Spring as shown in Figure 2 insuring that the part fits tightly to the corner of the mating part.

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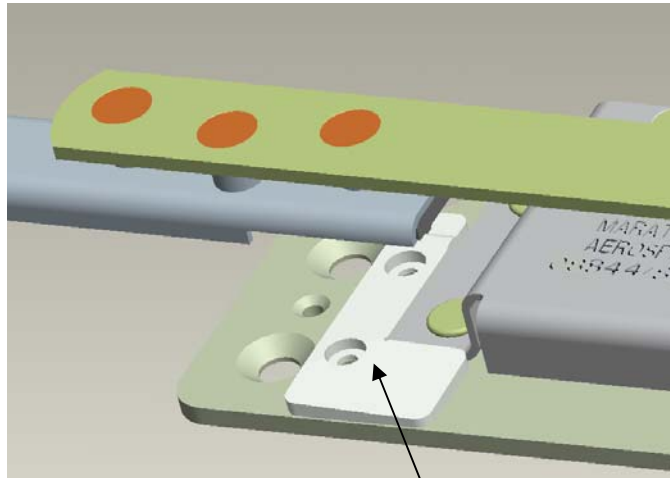


Figure 2: Orientation of the Base Plate Block Spring SSM112-11A-46

- c. Mark the holes while the Block Spring is in place then remove it and drill the .098 diameter interface holes at the locations shown in Figure 3.

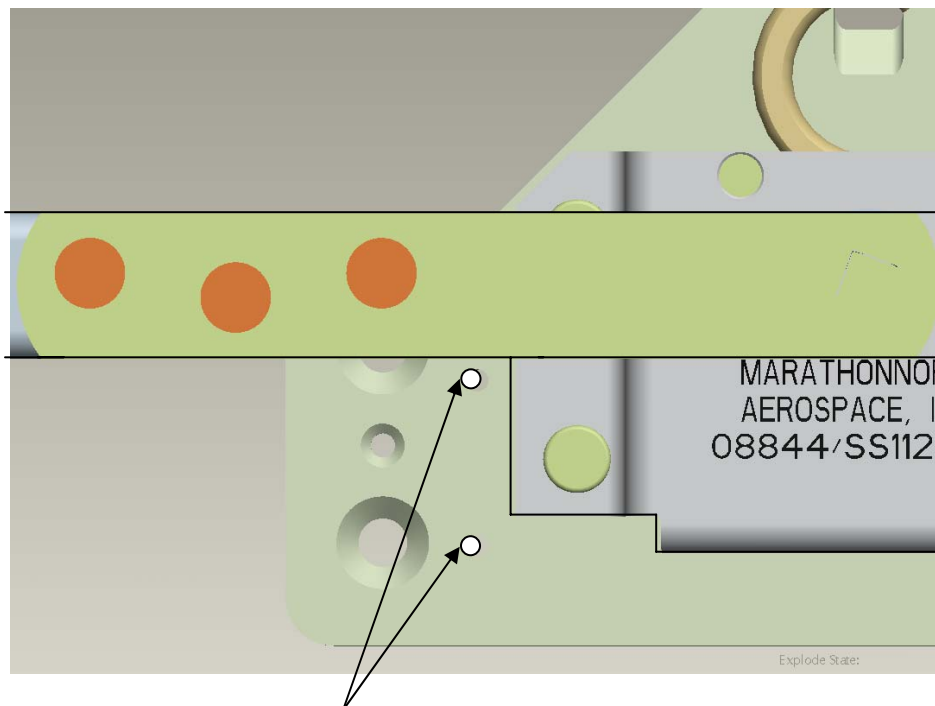


Figure 3: Interface holes in Base Plate

- d. Open pilot holes shown in Figure 3 to .1120, tap using 40 UNC-2A tap and debur.
- e. Apply adhesive to the back of the base plate side of the base plate Block Spring per Standard Overhaul Practices Manual (SOPM) 20-50-12 Type 117 or Type 71. BAC5010 adhesive, suggested use Loctite Hysol 608.

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- f. Install base plate Block Spring in the orientation shown in Figure 4 using the 2 screws 63C0112-20 provided in the rework kit.

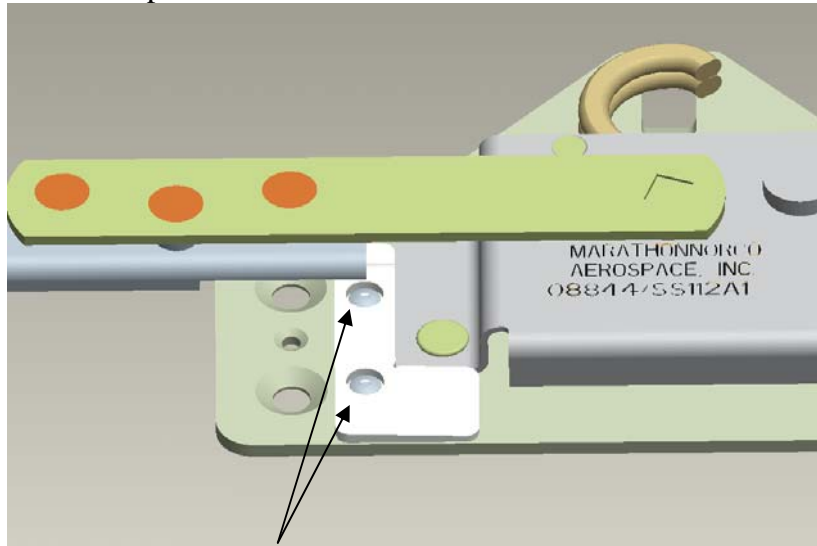


Figure 4: Installation of Screws

- g. Locate the handle Insert as shown in Figure 5.

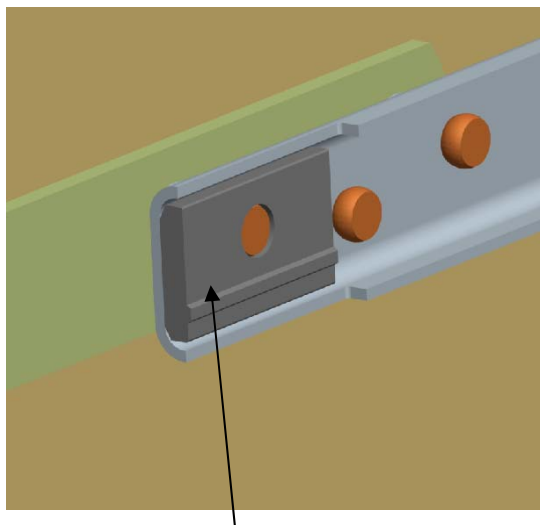


Figure 5: Location of Insert Under Handle, P/N SSM112-11A-48

- h. Apply adhesive to the Insert per SOPM 20-50-12 Type 117 or Type 71. Use sufficient adhesive to obtain squeeze-out between Insert, handle flanges and rivet head.
- i. Press the Insert with adhesive into the handle as shown in Figure 5 and clamp securely until adhesive is set up and dry.
1. Insert will only fit as shown in Figure 5.
- j. Allow the adhesive to dry then remove the clamp from the assembly.
1. Cure / Dry time is specified by the adhesive manufacturer

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- k. Operate the handle to ensure that all of the components are securely in place and that the handle will not operate unless pulled open with a force of 1.5 lbs or greater (force applied at the webbed loop at the end of the handle – as shown in Figure 6). Handles that do not meet the 1.5 lbs requirement must be returned to the manufacturer for rework.
- l. Reference Figure 6 for exploded view of installation.

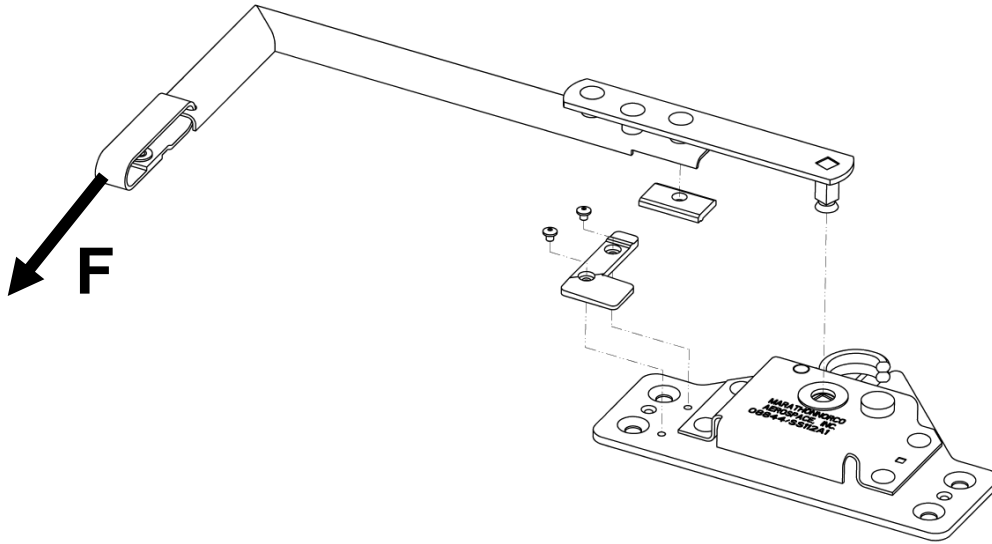


Figure 6: Exploded View of the Updated Assembly

- m. Following rework of component part-mark the assembly to update the part number to the following
  1. “Reworked to SS112A12”
  2. Mark below original part number



Figure 6: Part-Marking, Update to “Reworked to SS112A12”