

SERVICE BULLETIN

MD-80/90 SERIES

PASSENGER ADDRESS SERVICE INTERPHONE CALL SYSTEM (PASICS), ATTENDANT CRADLE ASSEMBLY P/N 686-2000-001, MAGNET ASSEMBLY, PRODUCT IMPROVEMENT.

1 PLANNING INFORMATION:

- A. Effectivity: Attendant Cradles P/N 686-2000-001, S/N's 0001 through 2700, used in the PASICS system on board the MD-80/90 series aircraft are affected. This product improvement will be incorporated during manufacturing of units after S/N 2700.
- B. Reason: To improve the magnetic strength of the magnet assembly P/N 686-2026-001, which is used to provide the physical cradled indication of an attendant handset to the PASICS system.
- C. Description: Performance of this bulletin is determined by a series of on-aircraft tests, as outlined below. Upon the determination of a weak or faulty magnet assembly, replacement is per instructions provided in the Accomplishment section.
- D. Performance Determination: The following defines the on-aircraft test to be performed to determine if the magnet assembly is a candidate for replacement;
1. Initiate an Attendant call from the station being tested, then re-cradle.
 2. If Call light extinguishes, handset and cradle are in proper working order. But if Call light does not extinguish, using a spare magnet assembly, place it within ¼" of handset ID plate window. If Call light extinguishes, cradle magnet assembly must be replaced. If Call light still does not extinguish, handset must be troubleshot for other problems.
 3. Additionally, if intermittent resetting is occurring, apply some additional hand pressure on handset backshell when cradling. If this produces reliable resetting of Call light, magnet assembly is weak or misaligned. Corrective action is replacement or alignment, respectively.
- E. Compliance: The incorporation of this bulletin is recommended to be upon the determination of a performance discrepancy as defined in paragraph D. above. or at the earliest convenience of the operator.
- F. Approval: This modification is in accordance with the currently manufactured configuration of the unit and does not require FAA approval.
- G. Manpower: It is estimated that 0.5 man-hours will be required per unit for the performance of this bulletin.

686-2000-23-1



H. Material - Cost and Availability:

- (1) Telephonics Performance: Telephonics will incorporate this bulletin at current Service Center labor rate, in units meeting the Performance Determination criteria as defined paragraph D., when returned for modification or for repair.
- (2) Kits: Kits, P/N SBK686-2000-1, which will consist of the improved magnet assembly, will be supplied at the current price listed in Telephonics Spare Parts Catalog. For kit information, refer to MATERIAL INFORMATION section of this bulletin.

I. Tooling: None

J. Weight and Balance: None

K. References:

- (1) Component Maintenance Manual with IPL, Handset Assembly P/N 686-1000 and Cradle Assembly P/N 686-2000 (ATA 23-44-30).

L. Publication Affected: Reference (1) at next scheduled revision will include changes affected by this bulletin.



2. ACCOMPLISHMENT INSTRUCTIONS:

A. Disassembly: Item references are per IPL Figure 5 & 6 of Reference 1, unless otherwise noted.

- (1) Using a 3/32" ballpoint hex screwdriver, loosen hex head cradle housing captive screw (115). Access to this screw is through front of cradle, by pushing ejection lever (55) to rear of housing. (Item references are per IPL Figure 6)
- (2) Separate cradle chassis assembly (40) from cradle housing assembly (35) by applying finger pressure on lower trigger levers (90, Fig. 6) until retainer releases. Set cradle chassis assembly (40) aside

B. Magnet Assembly Replacement: Item references are per IPL Figure 5.

- (1) Locate magnet assembly (10) at rear of cradle housing. Remove magnet assembly using pliers, apply a quick but short rocking motion to break the adhesive grip.
- (2) Clean mounting surface on cradle plastic with a razor knife or abrasive to ensure a clean and smooth surface, making sure not to disturb the two alignment nubs in the plastic.
- (3) Apply a moderate amount of LOCTITE® 414 Liquid Bonder adhesive to the bottom plastic surface of the magnet assembly. Position magnet assembly on cradle housing, aligning holes in magnet assembly with the two nubs on cradle housing for proper positioning. If, during removal of old magnet assembly, the nubs were sheared off, align the magnet assembly using Figure 601 in Reference 1. (Note: new improved magnet assembly is marked with a REV. B)
- (4) Once aligned into proper position, hold magnet assembly in place for approximately 10 seconds to allow adhesive to set.

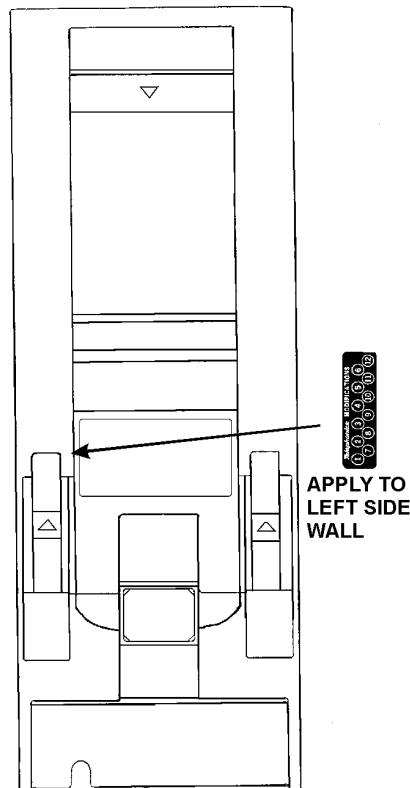
C. Assembly: Item references are per IPL Figure 5 & 6.

- (1) Re-engage the cradle chassis assembly (40) with the cradle housing assembly (35) by snapping the two together, while the ejector lever (55) is being held in its upward position.
- (2) Using a 3/32" ball type hex screwdriver, tighten the hex head cradle housing screw (115) to secure the assemblies together.



D. Identification:

- (1) Install a Modification Record Plate as follows;
 - (a) Using a clean, soft cloth moistened with isopropyl alcohol, clean left side wall of cradle housing assembly where modification record plate will be installed, as shown in sketch below.
 - (b) Strip protective paper from adhesive backing of modification record plate P/N 255B012 and install on left side wall, adjacent to ID plate, as shown below. Press with fingers to ensure maximum adhesion.
- (2) Obliterate the circled numeral ① of the modification record plate, using black epoxy ink.



- E. Testing: Test unit in accordance with instructions contained in Reference 1.



3. MATERIAL INFORMATION:

Material information is furnished on a unit basis.

A. Kits: Each kit, P/N SBK686-2000-1, contains all parts listed in the NEW PART NUMBER column.

QTY	NEW PART NUMBER	KEY WORD	OLD PART NUMBER	DISPOSITION
1	686-2026-001 Rev. B	Magnet Assembly	686-2026-001	N/A
1	255B012	Plate, Mod Record	None	N/A

Note: New improved magnet assembly has same part number but is identified by the following white lettered marking on the side surface of the magnet assembly; **REV. B.**

B. Material – Not kitted: Small quantities of black epoxy ink and LOCTITE® 414 Liquid Bonder.

C. Identification: Units incorporating this product improvement are identified by obliteration of the numeral ① of the modification record plate.

D. Interchangeability: Modified and unmodified units are interchangeable.