



ENGINE – ELECTRICAL POWER – IDG OIL COOLING TUBES – MODIFIED SUPPORT BRACKET FOR CLIP
POINT 1072 – CATEGORY CODE 6 – MOD.ENG-24-0004

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) Airbus A320
(b) Airbus A321
- (2) Engine: (a) V2500-A1 Engines prior to Serial No.V0348
(b) V2500-A5 Engines prior to Serial No.V10015

B. Concurrent Requirements

None.

C. Reason

(1) Condition

It has been found on build that a foul may occur between the support bracket for Clip Point 1072 and the IDG oil cooler oil outlet tube adaptor.

(2) Background

The oil outlet tube can feature an elbow adaptor at the cooler end produced either from a forging or machined bar stock. A small number of tubes with a machined adaptor are fitted to engines.

The support bracket was designed to suit the forged adaptor but a foul may occur with the machined adaptor due to the different profile.

(3) Objective

This Service Bulletin introduces a new bracket to improve clearance with machined adaptors.

(4) Substantiation

A successful trial installation of a modified bracket was undertaken on a mock-up engine.

(5) Effect of Bulletin on Workshop Procedures:

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| | |
|----------------------|--------------|
| Removal/Installation | Not affected |
| Disassembly/Assembly | Not affected |
| Cleaning | Not affected |
| Inspection/Check | Not affected |
| Repair | Not affected |
| Testing | Not affected |

(6) Supplemental Information

None.

D. Description

This Service Bulletin introduces a support bracket which is identical to the existing bracket but for a revised profile between the fixing holes.

Existing brackets can be reworked.

E. Approval

The part number changes and/or part modifications described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

F. Compliance

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Accomplish when the sub-assembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected parts and to all affected spare parts.

G. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

| Venue | Estimated Manhours |
|-----------------|--------------------|
| (1) In Service | Not applicable |
| (2) At Overhaul | TOTAL 45 minutes |

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

- (a) To remove the bracket 4 minutes
- (b) To rework the bracket 35 minutes
- (c) To install the bracket 6 minutes

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TOTAL 45 minutes

H. Material - Price and Availability

- (1) Modification Kit not required.
- (2) See "Material Information" section for prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not required.

J. Weight and Balance

- | | |
|-------------------|---|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front mount centerline (Power Plant Station (PPS)100) |

K. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

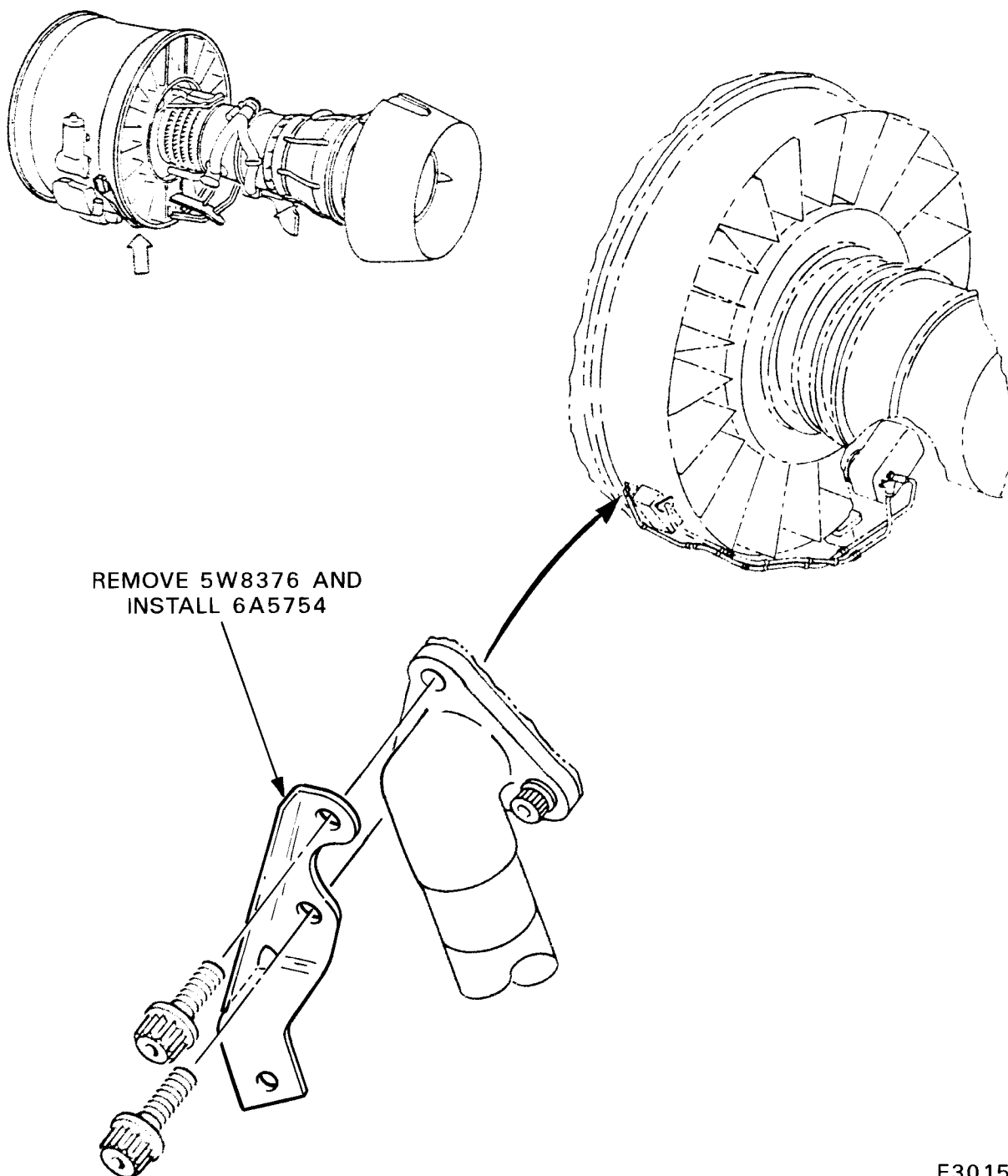
L. References

- (1) Internal Reference No.
EC93VR065

M. Other Publications Affected

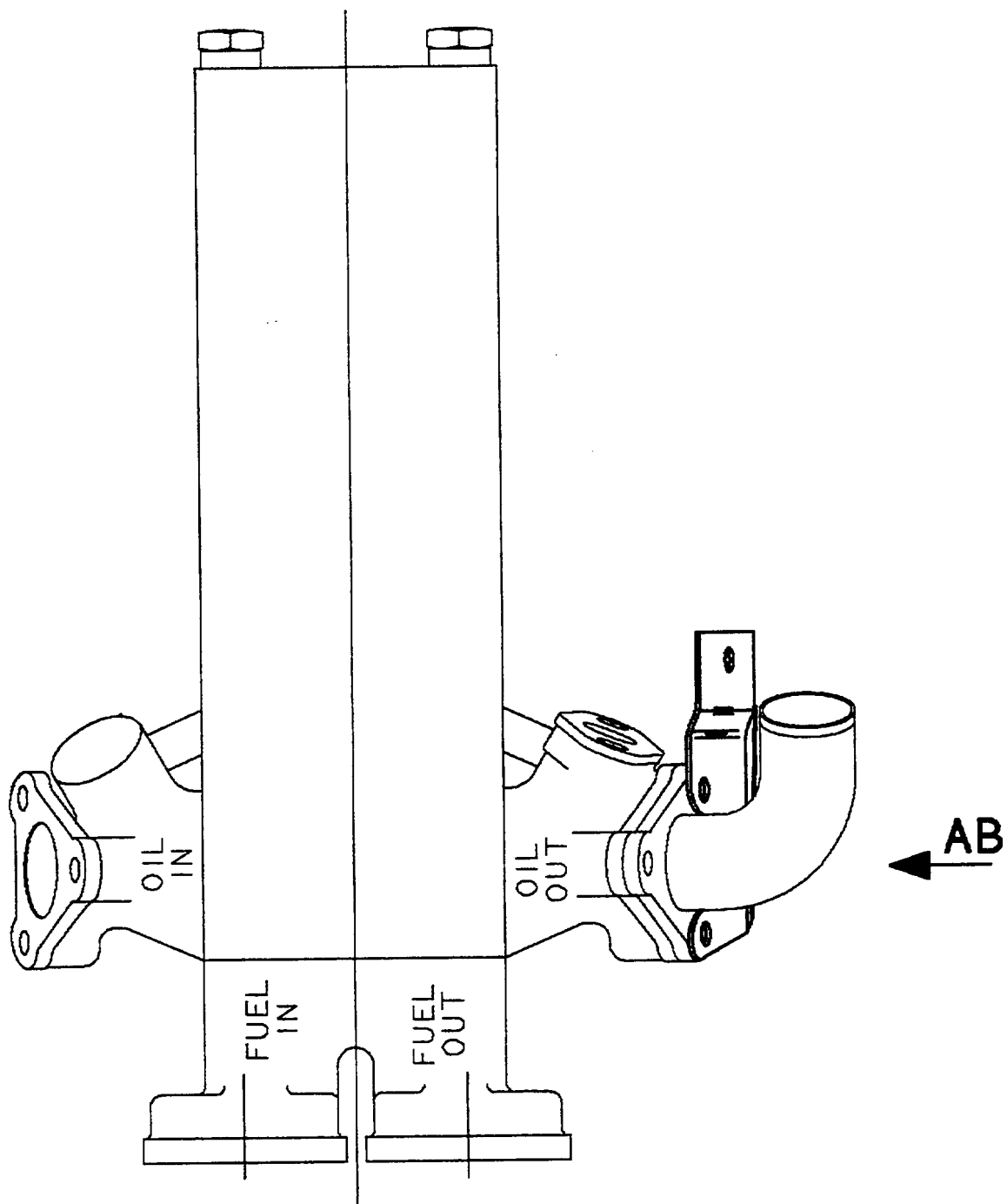
- (1) V2500 Engine Illustrated Parts Catalog (S-V2500-1IA), Chapter/Section 24-21-49.
- (2) V2500 Engine Illustrated Parts Catalog (S-V2500-2IA), Chapter/Section 24-21-49.
- (3) V2500 Component Maintenance Manual (CMM-MECH-V2500-1IA), 24-21-49, Cleaning -00 and -01, Inspection/Check -00 and -01 and Rework.
- (4) V2500 Engine Manual (E-V2500-1IA), 72-00-32, Removal-03, Config-1 and Config-2, Installation-03, Config-1 and Config-2.

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Location of support bracket for clip point 1072
Fig.1

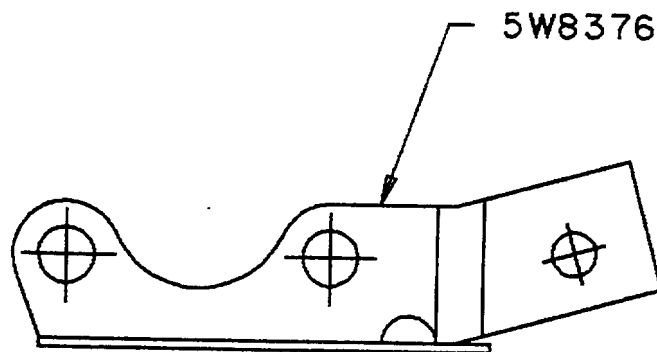
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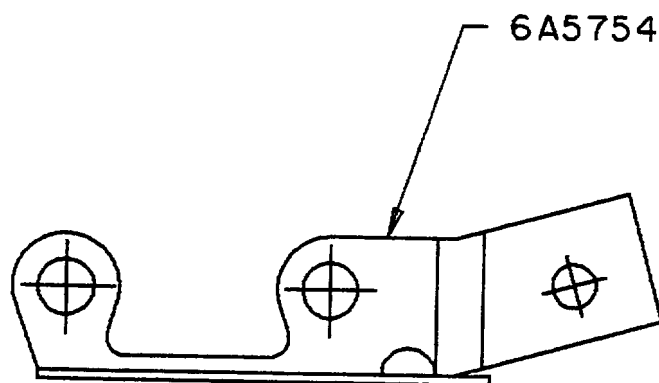
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View on fuel cooled IDG oil cooler - Before and after alteration
Fig.2

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VIEW ON ARROW **AB** SHOWING BRACKET
BEFORE ALTERATION
SHOWN THUS FOR CONVENIENCE



VIEW ON ARROW **AB** SHOWING BRACKET
AFTER ALTERATION
SHOWN THUS FOR CONVENIENCE

View on arrow AB showing bracket - Before and after alteration
Fig.3

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2. Accomplishment Instructions

A. Rework Instructions

- (1) Rework the following parts.

5W8376, bracket, support-clip point 1072 (Refer to 24-21-49, Fig./Item 01-070).

Consumable Materials

CoMat 02-124

Marking ink

Standard Equipment

Chemical cleaning equipment
Standard workshop equipment
Vibro-engraving equipment

Procedure

Supplementary Information

- | | |
|---|--|
| (a) Chemically clean the support bracket | Refer to SPM TASK 70-11-01-300-503. Use chemical cleaning equipment. |
| (b) Apply marking ink to the area(s) for rework | See Figure 4. Use CoMat 02-124 marking ink. Use standard workshop equipment |
| (c) Mark the rework area(s) | See Figure 4. Use locally manufactured template with a scribing tool. |
| (d) Remove the unwanted material | See Figure 4. Use standard workshop equipment |
| (e) Visually examine and measure the dimensions of the support bracket | See Figure 4. Use standard workshop equipment |
| (f) Cancel the exiting part number and re-identify with the new part number | Refer to SPM TASK 70-09-00-400-501, SUBTASK 70-09-00-400-001. Use vibro-engraving equipment |

Existing

Re-number

5W8376

6A5754

B. Assembly Instructions

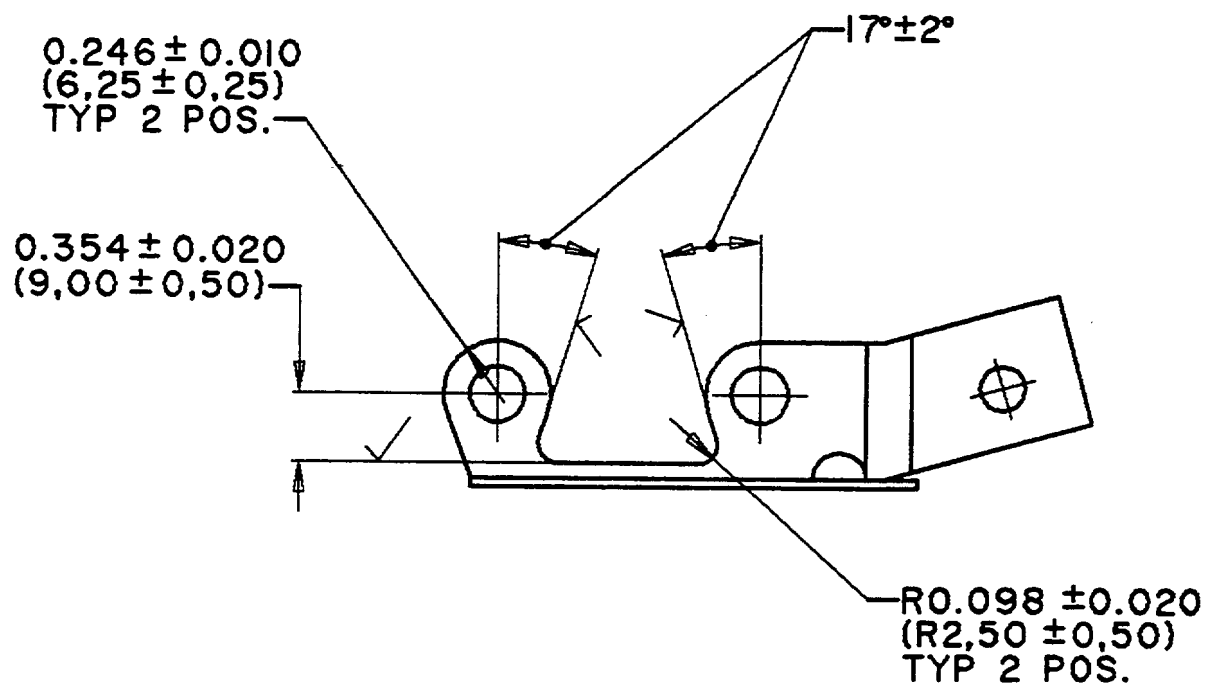
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- (1) Install the 6A5754 bracket on to the IDG oil cooler outlet tube by use of approved procedures, Engine Manual 72-00-32, Installation-03, Config-1 and Config-2.

C. Recording Instructions

- (1) A record of accomplishment is necessary.



ALL DIMENSIONS ARE IN INCHES(MILLIMETRES).
ANGULAR DIMENSIONS ARE IN DEGREES AND DECIMAL PARTS
OF A DEGREE.
MACHINE WHERE MARKED ✓.
REMOVE BURRS AND SHARP EDGES.

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Reworking of existing bracket
Fig.4

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3. Material Information

Applicability: For each V2500 engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

| New Part No. (ATA No.) | Qty | Est'd Unit Price (\$) | Keyword | Old Part No. (IPC No.) | Instructions Disposition |
|------------------------------|-----|-----------------------------|---------------------------------------|------------------------------|-----------------------------|
| 6A5754 (24-21-49) | 1 | | Bracket, support - Clip Point 1072 | 5W8376 (01-070) | (A) (B) (1D) (S1) |

C. Instructions/Disposition Code Statements:

- (A) New part is currently available.
- (B) Old part is no longer available.
- (1D) Old part may be reworked and re-identified to the new part number.
- (S1) New part may be used in place of old part but not vice versa.

NOTE: The estimated 1994 Unit Price shown is provided for planning purposes only and does not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE'S Spare Parts Sales Department for information concerning firm prices.

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