

International Aero Engines
SERVICE BULLETIN

INFORMATION - ANNOUNCEMENT OF REPAIR PARTS TO SUPPORT VARIOUS HP COMPRESSOR
REPAIRS

MODEL APPLICATION

V2500-A1
V2522-A5
V2524-A5
V2527-A5
V2527E-A5
V2530-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

72-41-00

Compliance Category Code

FIO

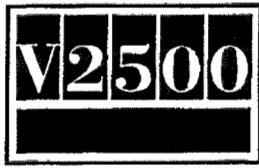
Internal Reference No.

EC87VR772B/74B/75A/75B,
EC89VR814A/20/20A/29A/30A/63A/90/96A
EC90VR702A/03A/13A/16A/30A/34B/43A/55A
EC92VR710A/70A
EC93VR761/64
EC94VR833
EC95VR774

Sep. 25/98

V2500-ENG-70-0353

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**INFORMATION - ANNOUNCEMENT OF REPAIR PARTS TO SUPPORT VARIOUS HP COMPRESSOR
REPAIRS**

1. Planning Information

A. Effectivity

(1) Aircraft

- (a) Airbus A319
- (b) Airbus A320
- (c) Airbus A321
- (d) Boeing Douglas Product Division MD-90

(2) Engines

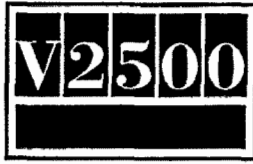
- (a) V2500-A1 Engines
- (b) V2522-A5 Engines
- (c) V2524-A5 Engines
- (d) V2527-A5 Engines
- (e) V2527E-A5 Engines
- (f) V2530-A5 Engines
- (g) V2525-D5 Engines
- (h) V2528-D5 Engines

B. Reason

To announce the availability of new repair parts.

C. Compliance

For information only.



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D. Approval

The part number transactions are given in the Material Information section of this Service Bulletin. They obey the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

E. References

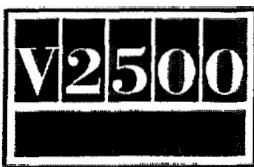
(1) The IAE Engineering Change Numbers that follow:

- (a) EC87VR772B/74B/75A/75B.
- (b) EC89VR814A/20/20A/29A/30A/63A/90/96A.
- (c) EC90VR702A/03A/13A/16A/30A/34B/43A/55A.
- (d) EC92VR710A/70A.
- (e) EC93VR761/64.
- (f) EC94VR833
- (g) EC95VR774.

F. General Information

- (1) The Material Information section of this Service Bulletin gives the latest information about the availability of the affected parts.
- (2) The repair schemes that follow are contained in this Service Bulletin. Special spare parts are necessary for these repair schemes:

<u>ATA Ref No.</u>	<u>Repair Scheme</u>	<u>Title</u>
72-32-23	VRS6113	HP Compressor - Seal ring carrier assy - Replace the seal ring
72-41-11	VRS6220	HP Compressor Stage-3 to 8 discs shaft assy - Replacement of damaged shank nuts.
72-41-21	VRS6266	HP Compressor Stage-7 Case Assembly - Replace spacers



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<u>ATA Ref No.</u>	<u>Repair Scheme</u>	<u>Title</u>
72-41-21	VRS6218	HP Compressor Stage-8 Case Assembly - Replacement of damaged shank nuts
72-41-21	VRS6249	HP Compressor Stage-8 Case Assembly - Replace boroscope access port and/or rivets.
72-41-21	VRS6251	HP Compressor Stage-9 Case Assembly - Replacement of the location dowel.
72-41-21	VRS6162	HP Compressor Stage-9 Case Assembly - Replace intrascope access port and/or rivets.
72-41-21	VRS6308	HP Compressor Rear Heatshield - Stage-7 - Replace loose or damaged rivets and/or a damaged plate.
72-41-21	VRS6253	HP Compressor, Stage-10 Case Assembly - Replace spacers
72-41-21	VRS6336	HP Compressor Front Heatshield - Stage-10 - Replace loose or damaged rivets
72-41-21	VRS6219	HP Compressor Stage-11 Case Assy - Replace shank nuts
72-41-23	VRS6278	HP Compressor, Rear Outer Case Assy - Replace location pins
72-41-31	VRS6514	Repair damaged helicoil inserts in the HP Compressor front case assembly by replacement.
72-41-31	VRS6321	HP Compressor front case assembly - Replace loose or damaged pins

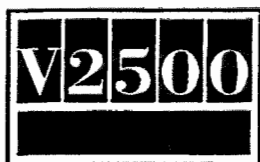


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<u>ATA Ref No.</u>	<u>Repair Scheme</u>	<u>Title</u>
72-41-32	VRS6259	HP Compressor, variable inlet guide vane assembly - Replace stud.
72-41-34	VRS6258	HP Compressor adaptable crank shaft assembly - Replace damaged inserts.
72-42-50	VRS6203	HP Compressor - Rear static seal - Replace inner seal carrier
72-42-50	VRS6204	HP Compressor - Rear static seal - Replace outer seal carrier
75-00-49	VRS6234	HP Compressor Stage-7 BV & Cabin air duct assy replacement of insert
75-32-52	VRS6046	Repair of HP Compressor Stage-7 right bleed seal carrier
75-32-52	VRS6285	Air seal assembly HP7 left lower Replace the captive nuts.
75-32-52	VRS6043	HP Compressor Stage-7 off-take seal carrier - Replace the seal.
75-32-52	VRS6360	HP Compressor Stage-7 Right upper air seal assy - Replace the seal
75-32-54	VRS6045	HP Compressor Stage-10 right bleed seal carrier - Replace loose or damaged rivet(s) and/or a damaged seal duct

For the necessary special repair parts, refer to 2. Material Information.



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2. Material Information

FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
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A. All models

(1) The special repair parts that follow are necessary to do repair VRS6308:

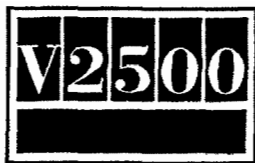
AS16246 (72-41-21)	A/R	Rivet, solid universal head	- (03-888)	(A)
AS16287 (72-41-21)	A/R	Rivet, solid universal head (.126 dia x .276)	- (03-889)	(A)
6A5664 (72-41-21)	A/R	Plate	- (03-891)	(A)

(2) The special repair parts that follow are necessary to do repair VRS6336:

AS16246 (72-41-21)	A/R	Rivet, solid universal head	- (04-508)	(A)
AS16287 (72-41-21)	A/R	Rivet, solid universal head (.126 dia x .276)	- (04-509)	(A)

(3) The special repair parts that follow are necessary to do repair VRS6321:

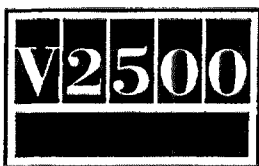
AS20762 (72-41-31)	A/R	Ring, retaining	- (01-455)	(A)
AS20742 (72-41-31)	A/R	Pin, grooved headless	- (01-456)	(A)
6A5954 (72-41-31)	A/R	Pin, grooved, headless (.005 o/size)	- (01-457)	(A)
6A5955 (72-41-31)	A/R	Pin, grooved, headless (.010 o/size)	- (01-458)	(A)
AS20763 (72-41-31)	A/R	Ring, retaining	- (01-459)	(A)



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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
AS20745 (72-41-31)		A/R	Pin, grooved headless	- (01-460)	(A)
6A5956 (72-41-31)		A/R	Pin, grooved, headless (.005 o/size)	- (01-461)	(A)
6A5957 (72-41-31)		A/R	Pin, grooved, headless (.010 o/size)	- (01-462)	(A)
AS20744 (72-41-31)		A/R	Pin, grooved headless	- (01-465)	(A)
6A5958 (72-41-31)		A/R	Pin, grooved, headless (.005 o/size)	- (01-466)	(A)
6A5959 (72-41-31)		A/R	Pin, grooved, headless (.010 o/size)	- (01-467)	(A)
(4) The special repair parts that follow are necessary to do repair VRS6360:					
AS16490 (75-32-52)		A/R	Rivet	- (01-280)	(A)
AS16532 (75-32-52)		A/R	Rivet, solid csk head	- (01-281)	(A)
ARM944 (75-32-52)		A/R	Duct, seal	- (01-286)	(A)
B. A5 and D5 Models Only					
(1) The special repair parts that follow are necessary to do repair VRS6113:					
6A1450 (72-32-23)		A/R	Retainer	- (01-724)	(A)
UP10892 (72-32-23)		A/R	Ring, seal	- (01-726)	(A)



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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
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(2) The special repair tools that follow are necessary to do repair VRS6220:

AS27862 (72-41-11)	A/R	Nut, self locking shank (.250 dia)	AS27862 (01-238)	(A)
6A1130 (72-41-11)	A/R	Plate, anti frettage	6A1130 (01-240)	(A)

(3) The special repair parts that follow are necessary to do repair VRS6266:

UP60548 (72-41-21)	A/R	Spacer	- (03-513)	(A)
UP60477 (72-41-21)	A/R	Spacer	- (03-514)	(A)

(4) The special repair part that follows is necessary to do repair VRS6218:

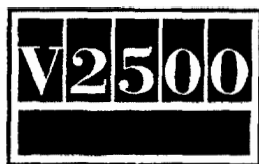
AS44750 (72-41-21)	A/R	Nut, self locking shank (.190 dia)	- (03-666)	(A)
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(5) The special repair parts that follow are necessary to do repair VRS6249:

AS16688 (72-41-21)	A/R	Rivet, solid csk head	- (03-692)	(A)
6A5870 (72-41-21)	A/R	Adaptor - Boroscope access port	- (03-695)	(A)

(6) The special repair parts that follow are necessary to do repair VRS6162:

AS16688 (72-41-21)	A/R	Rivet, solid csk head	- (03-842)	(A)
AS16729 (72-41-21)	A/R	Rivet, solid csk head	AS16729 (03-843)	(A)
6A5948 (72-41-21)	A/R	Adaptor - Intrascop access port	- (03-844)	(A)



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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
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(7) The special repair part that follows is necessary to do repair VRS6253:

UP60477 (72-41-21)	A/R	Spacer	- (04-364)	(A)
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(8) The special repair part that follows is necessary to do repair VRS6336:

6A5672 (72-41-21)	A/R	Plate	- (04-512)	(A)
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(9) The special repair part that follows is necessary to do repair VRS6219:

AS44750 (72-41-21)	A/R	Nut, self locking shank (.190 dia)	- (04-616)	(A)
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(10) The special repair parts that follow are necessary to do repair VRS6278:

AS20763 (72-41-23)	A/R	Ring, retaining	- (02-455)	(A)
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LK54570 (72-41-23)	A/R	Pin	- (02-456)	(A)
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(11) The special repair parts that follow are necessary to do repair VRS6259:

UP11066 (72-41-32)	A/R	Stud	- (01-515)	(A)
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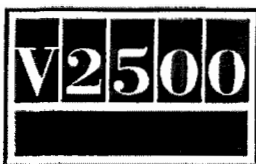
UP11066 (72-41-32)	A/R	Stud	- (01-615)	(A)
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(12) The special repair part that follows necessary to do repair VRS6258:

AGS3733 (72-41-34)	A/R	Insert, screw thread	AGS3733 (01-613)	(A)
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(13) The special repair parts that follow are necessary to do repair VRS6203:

AS16289 (72-42-50)	A/R	Rivet, solid universal head	- (01-123)	(A)
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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
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AS16330 (72-42-50)		A/R	Rivet, solid universal head	AS16330 (01-124)	(A)
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6A5943 (72-42-50)		A/R	Seal - assy of, inner carrier	- (01-160)	(A)
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(14) The special repair parts that follow are required to do repair VRS6285:

AS16446 (75-32-52)		A/R	Rivet, solid countersunk head (.094 dia)	- (01-076)	(A)
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AS16487 (75-32-52)		A/R	Rivet, solid countersunk head	AS16487 (01-077)	(A)
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4W0039 (75-32-52)		A/R	Nut, self locking plate (.250 dia)	- (01-078)	(A)
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(15) The special repair parts that follow are necessary to do repair VRS6045:

AS16490 (75-32-54)		A/R	Rivet	- (01-380)	(A)
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AS16532 (75-32-54)		A/R	Rivet, solid countersunk head	- (01-381)	(A)
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ARM944 (75-32-54)		A/R	Duct, seal	- (01-386)	(A)
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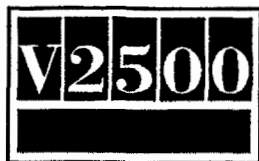
C. A1 Model

(1) The special repair part that follows is necessary to do repair VRS6266:

UP60487 (72-41-21)		A/R	Spacer	UP60487 (03-514)	(A)
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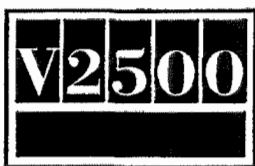
(2) The special repair parts that follow are necessary to do repair VRS6251:

AS16295 (72-41-21)		A/R	Rivet, solid universal head	- (03-822)	(A)
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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE		OLD PART NUMBER	INSTR DISP
EY29248 (72-41-21)		A/R	Washer	-	(03-824)	(A)
UP10743 (72-41-21)		A/R	Dowel	-	(03-825)	(A)
(3) The special repair part that follows is necessary to do repair VRS6253:						
UP60487 (72-41-21)		A/R	Spacer		UP60487 (04-364)	(A)
(4) The special repair part that follows is necessary to do repair VRS6336:						
6A5667 (72-41-21)		A/R	Plate	-	(04-511)	(A)
(5) The special repair part that follows is necessary to do repair VRS6514:						
AGS3732 (72-41-31)		A/R	Insert, screw thread (.250 dia x 1.5D)	-	(01-432)	(A)
(6) The special repair part that follows is necessary to do repair VRS6204:						
6A5944 (72-42-50)		1	Seal - assembly of, outer carrier	-	(01-145)	(A)
(7) The special repair parts that follow is necessary to do VRS6043:						
AS16490 (75-32-52)		A/R	Rivet	-	(01-080)	(A)
ARM944 (75-32-52)		A/R	Duct, seal		ARM944 (01-086)	(A)
(8) The special repair parts that follow are necessary to do repair VRS6046:						
AS16492 (75-32-52)		A/R	Rivet, solid countersunk head	-	(01-480)	(A)



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FIG ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	OLD PART NUMBER	INSTR DISP
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AS16532 (75-32-52)		A/R	Rivet, solid countersunk head	AS16532 (01-481)	(A)
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ARM944 (75-32-52)		A/R	Duct, seal	- (01-486)	(A)
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D A5 Models Only

(1) The special repair part that follows is necessary to do repair VRS6234:

AGS3732 (75-00-49)		A/R	Insert, screw thread (.250 dia x 1.5D)	AGS3732 (01-262)	(A)
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(2) The special repair part that follows is necessary to do repair VRS6046:

AS16492 (75-32-52)		A/R	Rivet, solid countersunk head	AS16492 (01-480)	(A)
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AS16532 (75-32-52)		A/R	Rivet, solid countersunk head	AS16532 (01-481)	(A)
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ARM944 (75-32-52)		A/R	Duct, seal	- (01-486)	(A)
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E D5 Models Only

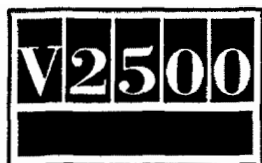
(1) The special repair part that follows is necessary to do repair VRS6285:

4W0039 (75-32-52)		A/R	Nut, self locking plate (.250 dia)	4W0039 (01-545)	(A)
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AS16446 (75-32-52)		A/R	Rivet, solid countersunk head (.094 dia)	- (01-550)	(A)
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AS16487 (75-32-52)		A/R	Rivet, solid countersunk head	- (01-551)	(A)
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NOTE: The units prices, if shown, are an estimate and they are given for the purpose of planning only. For information about actual prices, refer to the IAE price catalogue or contact IAE's spare part Sales Department.



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F. Instruction Disposition Codes

(1) New part is available for repair of the HP Compressor.

