

## International Aero Engines INFORMATION BULLETIN

INFORMATION – ENGINE - ANNOUNCEMENT OF PARTS FOR REPAIR OF HP COMPRESSOR  
INNER SHROUD RING ASSEMBLIES, REPAIR OF STAGE 6 VARIABLE STATOR VANE BUSH  
LOCATION AND VANE REPLACEMENT OF STAGE 12 VANE(S)

### MODEL APPLICATION

V2500-A1  
V2522-A5  
V2524-A5  
V2527-A5  
V2527E-A5  
V2527M-A5  
V2530-A5  
V2533-A5  
V2525-D5  
V2528-D5

### BULLETIN INDEX LOCATOR

72-41-00  
72-42-00

#### Compliance Category Code

Not Applicable

#### Internal Reference No.

97VR755, 98VR803 and  
99VR800

Sept.10/99

**V2500-ENG-70-0722**



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### A. Effectivity

#### (1) Aircraft

- (a) Airbus A319
- (b) Airbus A319CJ
- (c) Airbus A320
- (d) Airbus A321
- (e) 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) V2527M-A5 Engines
- (g) V2530-A5 Engines
- (h) V2533-A5 Engines
- (i) V2525-D5 Engines
- (j) V2528-D5 Engines

### B. Reason

To announce the availability of newly released repair parts.

### C. Compliance

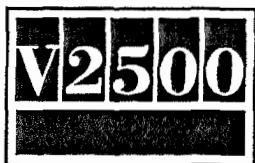
For information only.

### D. Approval

The part number transactions shown under the "Material Information" portion of this Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model Listed.

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### E. References

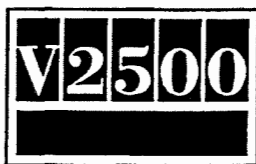
IAE Engineering Change Numbers 97VR755, 98VR803 and 99VR800.

### F. General Information

- (1) The material information portion of this bulletin provides the latest information concerning the availability of the affected parts.
- (2) New repair schemes being introduced into the V2500 Engine Manual which require special spare parts for their accomplishment.

<u>ATA Ref No.</u>	<u>Repair Scheme</u>	<u>Title</u>
72-41-31	VRS6618	HP Comp Front Case assembly- repair worn or damaged stage 6 variable stator vane bush locations by installation of steel liners.
72-41-33	VRS6631	HP Comp VIGV, Stage 3, 4 & 5 inner shroud ring assemblies- repair worn/damaged bush location hole(s) by the installation of O/S bush(es).
72-42-40	VRS6619	HP Compressor OGV assembly - Stage 12 - Repair damaged vane(s) by replacement

(For special repair parts required, refer to "Material Information").



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### G. Material Information

#### A. Parts affected by this Service Bulletin:

NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
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#### A1 Model

(1) The following special repair parts are required to accomplish repair VR6618:-

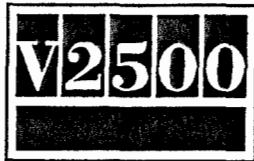
6A6576 (72-41-31)	A/R	..Liner	(01.480)	(G)
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(2) The following special repair parts are required to accomplish repair VR6631:-

6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot VIGV- HPC (0.010 in (0,254 mm))	(01.191)	(B)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot VIGV- HPC (0.020 in (0,0508 mm))	(01.192)	(B)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.3- HPC (0.010 in (0,254 mm))	(02.191)	(C)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.3- HPC (0.020 in (0,0508 mm))	(02.192)	(C)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.4- HPC (0.010 in (0,254 mm))	(03.191)	(E)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.4- HPC (0.020 in (0,0508 mm))	(03.192)	(E)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.5- HPC (0.010 in (0,254 mm))	(04.191)	(F)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.5- HPC (0.020 in (0,0508 mm))	(04.192)	(F)

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NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
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(2) The following special repair parts are required to accomplish repair VR6619:-

6A7390 (72-42-40)	A/R	.. Vane Outlet Guide - HP Compressor, Stage 12 front	(01.220)	(A)
6A7391 (72-42-40)	A/R	.. Vane, Outlet Guide - HP Compressor, Stage 12 rear	(01.221)	(A)

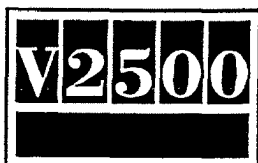
### A5 and D5 Models

(1) The following special repair parts are required to accomplish repair VR6631:-

6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot VIGV- HPC (0.010 in (0,254 mm))	(01.191)	(B)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot VIGV- HPC (0.020 in (0,0508 mm))	(01.192)	(B)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.3- HPC (0.010 in (0,254 mm))	(02.191)	(C)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.3- HPC (0.020 in (0,0508 mm))	(02.192)	(C)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.4- HPC (0.010 in (0,254 mm))	(03.191)	(E)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.4- HPC (0.020 in (0,0508 mm))	(03.192)	(E)
6A7541 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.5- HPC (0.010 in (0,254 mm))	(04.191)	(F)
6A7542 (72-41-33)	A/R	.Bush,half-O/S inner pivot Stg.5- HPC (0.020 in (0,0508 mm))	(04.192)	(F)

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### H. Instruction/Disposition Code Statement

- (A) New part currently available for repair of HP Compressor Stage 12 vane(s).
- (B) New part currently available for repair of HP Compressor VIGV inner shroud ring assembly.
- (C) New part currently available for repair of HP Compressor Stage 3 inner shroud ring assembly.
- (E) New part currently available for repair of HP Compressor Stage 4 inner shroud ring assembly.
- (F) New part currently available for repair of HP Compressor Stage 5 inner shroud ring assembly.
- (G) New part currently available for repair of HP Compressor Stage 6 Bush locations.

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only.  
For actual prices, refer to IAE Price Catalog or contact IAE's spare parts sales department.