



POWER PLANT - ENGINE - CLIPPING POINT SUPPORT BRACKET - MODIFICATION OF - CATEGORY
CODE 6 - MOD.ENG-71-0006

1. Planning Information

A. Effectivity

- (1) Airplane: Airbus A320
- (2) Engine: V2500-A1 Engines V0022, V0058, V0065 and V0067.

B. Reason

(1) Condition

The mounting bolt for the air starter duct support link may touch the support bracket for the fan case clipping point CP0812.

(2) Background

The support brackets for the air starter duct were moved. Their new position compromised the clearance between the duct support link mounting bolt and an adjacent clipping point support bracket. In some instances the bolt and bracket touch.

(3) Objective

To provide the necessary clearance between the link mounting bolt and the adjacent bracket.

(4) Substantiation

Mock-up fit check showed the new configuration gave adequate clearance.

(5) Effect of Bulletin on:

- | | |
|--------------------------|---------------|
| (a) Removal/Installation | -Not affected |
| (b) Disassembly/Assembly | -Not affected |
| (c) Cleaning | -Not affected |
| (d) Inspection/Check | -Not affected |
| (e) Repair | -Not affected |
| (f) Testing | -Not affected |

(6) Supplemental Information

None

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**C. Description**

(1) The change introduced by this Service Bulletin is as follows:-

- (a) The support bracket for clipping point CP0812 is temporarily removed. The bracket is modified and the part number is changed (Refer to Illustration 2). The bracket is then re-installed back onto the engine and the clipping point reassembled.

D. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification No. which is under DGAC (Direction Generale de L'Aviation Civile - France) approval.

E. Compliance

Category 6

Accomplish when the subassembly (i.e. Modules, Accessories,, Components, Build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

F. Manpower

Estimated manhours to incorporate the full intent of this Service Bulletin:

VENUE	ESTIMATED MANHOURS
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(1) In Service.....

(a) To gain access.....	0.20 M/Hrs
(b) To embody.....	0.45 M/Hrs
(c) To return engine to service.....	0.20 M/Hrs
Total.....	0.85 M/Hrs

(2) In Shop.....

(a) To gain access.....	M/Hrs
(b) To embody.....	0.45 M/Hrs
(c) To return engine to service.....	M/Hrs
Total.....	0.45 M/Hrs

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G. Material Cost and Availability

Modification Kit not required.

H. Tooling - Cost and Availability

None required.

I. Weight and Balance

- | | | |
|-----|--------------------|--|
| (1) | Weight change..... | None |
| (2) | Moment arm..... | No effect |
| (3) | Datum..... | Engine Front Mount Centerline
(Powerplant Station PPS 100.00) |

J. Electrical Load Data

Not affected.

K. References

- (1) Internal Reference No.

88VN150

- (2) Other References

A320 Aircraft Maintenance Manual, Section 70-23-11

L. Other Publications Affected

Publication

A320/V2500 Illustrated Parts Catalog 71-51-42



2. Accomplishment instructions

A. Pre-requisite Instructions

- (1) Find clipping point CP0812 on the right side of the engine fancase (Refer to Figure 1).
- (2) Remove the AS21409 bolt, AS20624 nut and the SP154-D washer to release the JM44LC39H109RG and JM44LC39H106RG 'P' clips (at CP0812).
- (3) Remove the AS23017 bolt, AS20625 nut and an ST1698-E37 spacer as shown.
- (4) Remove the AS23023 bolt and AS20625 nut to release the 740-5432-503 support bracket.

B. Rework or Modification Instructions

- (1) Modify the 740-5432-503 support bracket as follows:

Procedure	Supplementary Information
(a) Cut off that part of the support bracket that is shown hatched.	Refer to Figure 2
(b) Remove any sharp corners or burrs.	
(c) Identify the bracket to the new part number with No. 127 1/2 Master Marker (or any alternative marking ink).	740-5432-505

C. Post-Requisite Instructions

- (1) Install the 740-5432-505 support bracket on the FA1 engine flange with:

- two AS20625 nuts
- AS23017 bolt
- AS23023 bolt
- ST1698-E37 spacer.

Torque the nuts to 100lbf in (1.13 Nm). Refer to the A320 Aircraft Maintenance Manual Section 70-23-11 on torque tightening technique.

- (2) Assemble the clipping point CP0812 to the 740-5432-505 support bracket with:

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- AS21409 bolt
- AS20624 nut
- SP154-D washer
- JM44LC39H109RG 'P' clip
- JM44LC39H106RG 'P' clip

Torque the nuts to 40lb in (4.52 Nm).

D. Recording Instructions

- (1) A record of accomplishment is necessary.

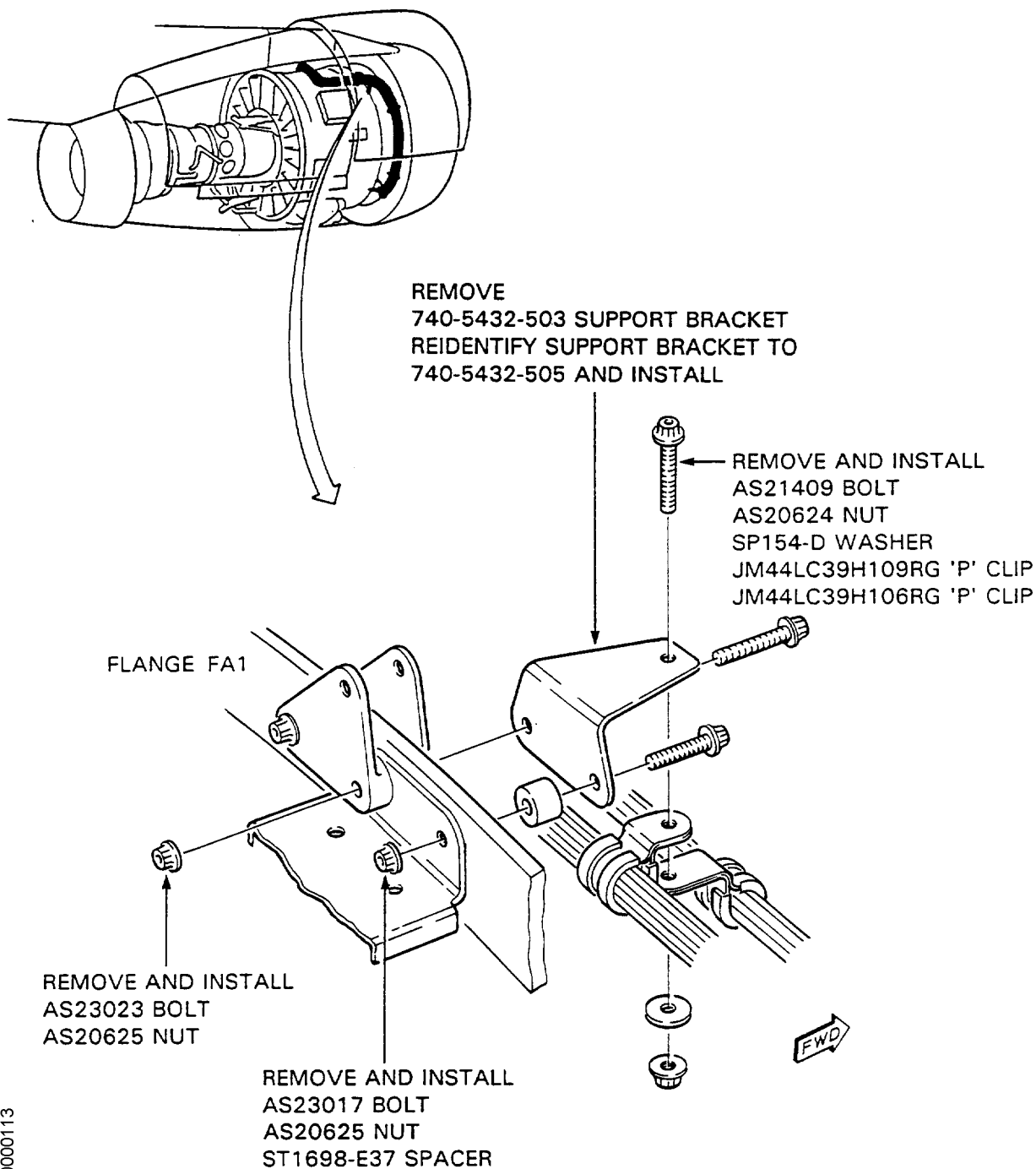


Fig. REMOVAL AND REPLACEMENT OF SUPPORT BRACKET



NOTE: Remove the hatched part on the support bracket and identify to new part number (740-5432-505)

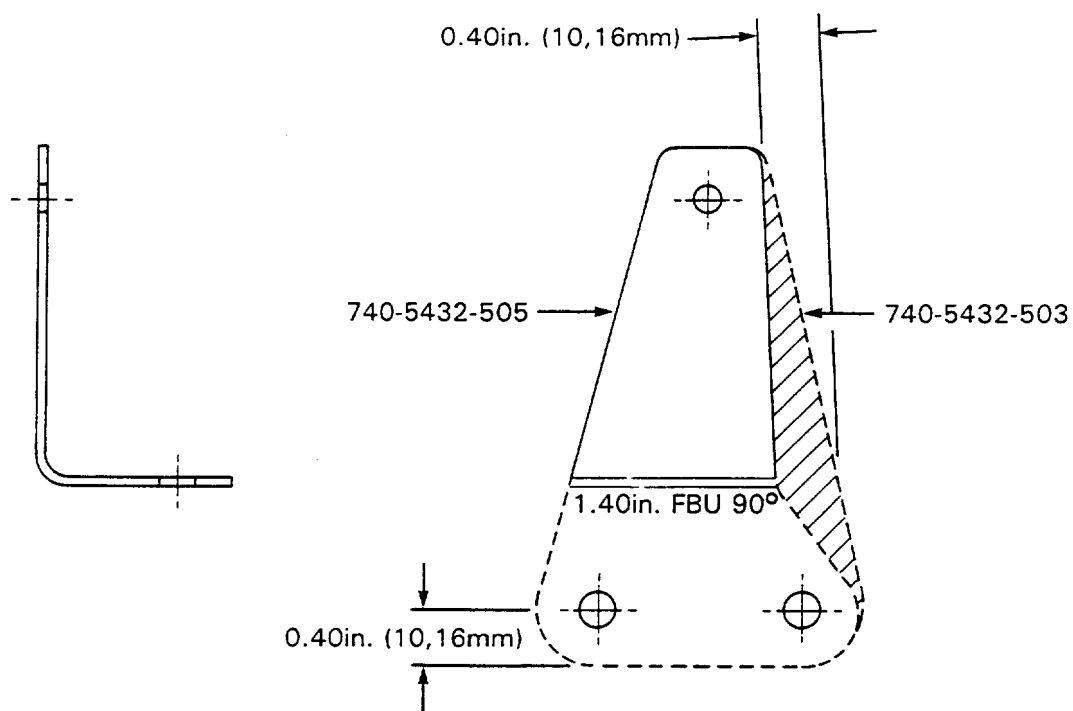


Fig. MODIFICATION OF THE SUPPORT BRACKET



SERVICE BULLETIN

3. Material Information

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	INSTR DISPOS
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Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin

None.

B. Parts affected by this Bulletin:

740-5432-505 1 (71-51-42)	Bracket	740-5432-503 (05-770)	(B)(A) (S1)(1D)
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C. Instructions/Dispositions Code Statements

- (A) New part is currently available for sale.
- (B) Old part will no longer be available for sale.
- (S1) Old and new parts are fully and freely interchangeable both physically and functionally.
- (1D) Rework old part and reidentify with new part number.

The following material is to be procured by the Operator or obtained from his stock:

PART No	KEYWORD	QTY	SOURCE	VENDOR CODE
	Master Marker NO. 127 1/2	1	Pannier Ink Corp. John Fitch Industrial Park Warminster, PA18974 USA	N/A

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