

# SERVICE BULLETIN REVISION NOTICE

ENGINE — ENGINE BUILD UNIT (EBU) — TERMINAL MODULE ASSEMBLY — REROUTING  
OF THE HARNESS

Turbojet Engine Service Bulletin No. V2500-ENG-71-0275 Revision No. 2 dated June 26, 2015.

## Revision History

Original Issue September 29, 2005

Revision 1 dated October 18, 2013

Revision 2 dated June 26, 2015

## Reason for the Revision

To add Figure 2 to show incorrect and correct views of adhesive tape application.

## Effect of Revision on Prior Compliance

Some operators did not correctly install the adhesive tape when incorporating this service bulletin. Incorrect installation of the adhesive tape may have caused the harness to chafe. The tape must begin at the terminal block and end beyond the clamp. The total length of wrapping is approximately 6.0 inches (152.4 mm). Several graphics have been added in Figure 2 to show correct and incorrect installation of the adhesive tape. Operators that have previously incorporated this service bulletin must perform an inspection to verify that the adhesive tape was installed correctly. This inspection of the adhesive tape must be completed the next time the engine is at a maintenance base that can do this service bulletin.

If the adhesive tape was correctly installed, record incorporation of Revision 2 of this service bulletin as specified in paragraph 4. A. of the Accomplishment Instructions.

If the adhesive tape was not installed correctly, and the harness is chafed on the insulation only, repair the insulation per Aircraft Maintenance Manual, Chapter/Section 70-71-22. Install the adhesive tape as specified in the Accomplishment Instructions.

If the adhesive tape was not installed correctly, and the harness is chafed below the wire insulation, replace the harness per Aircraft Maintenance Manual, Chapter/Section 71-51-42 and 71-51-43. Install the tape as specified in the Accomplishment Instructions.

## This is a Complete Revision (Not Applicable to the SGML version)

The contents are in accordance with the list of effective pages. All pages have the current revision number. Technical changes are marked with black bars.

## MODEL APPLICATION

V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5

## BULLETIN ISSUE SEQUENCE

V2500 Series 71-0275

**V2500-ENG-71-0275**

Page 1 of 2

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Page

Revision No.

Date

1 thru 18

2

June 26/15

**A copy of this Revision Notice and any future revision notices must be filed as a permanent record with your copy of the subject bulletin.**

V2500-ENG-71-0275

Page 2

# SERVICE BULLETIN

ENGINE — ENGINE BUILD UNIT (EBU) — TERMINAL MODULE ASSEMBLY  
— REROUTING OF THE HARNESS

## MODEL APPLICATION

V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5

## BULLETIN ISSUE SEQUENCE

V2500 Series 71-0275

## ATA NUMBER

71-51-43

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## Compliance Category

6

September 29/05

REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 1 of 18

## Summary

The purpose of this Service Bulletin is to provide a rerouting method of the terminal module assembly using the same materials a different way to reduce cable damage and minimize faulty cockpit warnings.

## Planning Information

### Effectivity Data

#### Engine Models Applicable

V2500-A1

Engine Serial Nos. V0001 thru V0361

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5

Engine Serial Nos. V10001 thru V13190

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5

Engine Serial Nos. V15001 thru V16197

### Concurrent Requirements

For V2500-A1 Engines prior to Serial No. V0362

and

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2530-A5 and V2533-A5 Engines prior to Serial No. V10440.

This Service Bulletin must be done before or at the same time as Reference 6, Service Bulletin No. V2500-ENG-73-0137 (Engine — Powerplant — Installation Of New Terminal Block Assembly).

### Reason

1. Condition: Several operators have reported the possibility of part on part contact between the Harness Cables and the Terminal Module Assembly.
2. Background: Part on part contact between the Harness Cables and the Terminal Module Assembly may cause Cable damage resulting in incorrect cockpit warnings.
3. Objective: To minimize the possibility of the Harness Cables from sustaining damage and prevent incorrect cockpit warnings.
4. Substantiation: All hardware changes have been successfully installed and substantiated on the IAE mock-up and has been the subject of satisfactory engineering analysis.

5. Effects of Bulletin on:

Removal/Installation: Affected, See Accomplishment Instructions.

Disassembly/Assembly: Affected, See Accomplishment Instructions.

Cleaning: Not affected.

Inspection/Check: Not affected.

Repair: Not affected.

Testing: Not affected.

September 29/05

REVISION NO. 2 - June 26/15

# V2500-ENG-71-0275

Page 2

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## 6. Supplemental Information

None.

### Description

The existing Harness Cables located inside the Terminal Module Assembly are relocated in a different position and further protected with an additional insulating layer

### 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.

### Approval Data

The technical content of this Service Bulletin has been approved under the authority of the EASA Design Organization Approval No EASA.21J.031. The authorising IAE documents are EC02VN762 and EC12VN300.

The aircraft Type Certificate (TC) holder has been informed of this change.

### Manpower

1. In Service

..... 1.00 M/Hr.

2. At Overhaul

..... 1.00 M/Hr.

### Weight and Balance

1. Weight Change

None.

2. Moment Arm

No Effect.

3. Datum

Nacelle Front Mount Centerline (Power Plant Station (PPS) 100)

### Electrical Load Data

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

### Software Accomplishment Summary

Not Applicable.

### References

**NOTE:** In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

September 29/05

REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 3

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1. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 70-41-00, 70-41-02 and 70-42-05.
2. A320/V2500-A1 A319/A320/A321/V2500-A5 Aircraft Maintenance Manual (M-V2500-1IA) Chapter/Sections 70-00-00, 70-60-00, 71-00-00, 71-13-00 and 78-32-00.
3. A320/V2500-A1 A319/A320/A321/V2500-A5 Component Maintenance Manual (CMM-EHC-V2500-1IA) Chapter/Sections 73-22-34-440-301).
4. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 73-22-34.
5. Overhaul Processes And Consumable Index (IAE PCI-V2500-1IA) Section II.
6. IAE V2500 Service Bulletin V2500-ENG-73-0137 (Engine — Powerplant — Installation Of New Terminal Block Assembly).
7. Bombardier Shorts modifications D1128 and D1296.

#### Other Publications Affected

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

1. V2500-A1 Series Illustrated Parts Catalog, P&W Ref. PN 2A4427, Chapter/Section 71-51-43 will be revised.
2. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 71-51-43 will be revised.
3. VA320/A321/V2500-A5 Powerplant Build-Up Manual (PPB-V2500-2IA) will be revised.
4. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407 will be revised.

#### Interchangeability of Parts

Old and new parts are interchangeable only in full sets.

#### Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

## Material Information

### Material — Price and Availability

1. There is no new materials or material cost to do this Service Bulletin.
2. There is no kit provided to do this Service Bulletin.

### Industry Support Program

Not Applicable.

### Instructions/Disposition Code Statements

Not Applicable.

### Tooling — Price and Availability

Special tools are not required to accomplish this Service Bulletin.

### Reidentified Parts

Not Applicable.

### Other Material Information Data

#### Materials required to incorporate this Bulletin

Material PN	Material Name
CoMat 01-410	Isopropyl Alcohol
CoMat 02-099	Lint Free Cloth
CoMat 02-148	Tape Adhesive
CoMat 02-159	Tape
CoMat 08-026	Thread Locking Compound
CoMat 10-077	Lubricant

**NOTE:** To identify the consumable materials, refer to Reference 5 Overhaul Processes and Consumables Index PCI-V2500-1IA.

September 29/05

REVISION NO. 2 - June 26/15

# V2500-ENG-71-0275

Page 5

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## Accomplishment Instructions

### 1. Pre-requisite Instructions:

**WARNING:** DO NOT TOUCH THE ENGINE COMPONENTS FOR A SHORT TIME AFTER THE ENGINE IS SHUT DOWN. THE COMPONENTS STAY HOT AND CAN CAUSE INJURY.

- A. Open, safety and tag the applicable Circuit Breakers as instructed in Reference 2, Aircraft Maintenance Manual, Task 71-00-00-401.
- B. Obey the Standard Practices as instructed in Reference 2 Aircraft Maintenance Manual, Task 70-00-00-001.
- C. Obey the Nacelle/Engine Build-up Unit (EBU) Maintenance Practices as instructed in Reference 2 Aircraft Maintenance Manual, Task 70-60-00-201.
- D. Open the Fan Cowl Doors as instructed in Reference 2 Aircraft Maintenance Manual, Task 71-13-00-010-010.
- E. Open the Thrust Reverser Halves as instructed in Reference 2 Aircraft Maintenance Manual, Task 78-32-00-010-010.

### 2. Rework Instructions:

Do the steps that follow on both the left engine and the right engine. See Figures 1 and 2.

**CAUTION:** EXERCISE CAUTION WHEN YOU MANIPULATE CABLES. DO NOT USE EXCESSIVE FORCE OR CREATE TIGHT BEND RADII WHEN YOU DO WORK TO CABLES.

**CAUTION:** MAKE SURE YOU KEEP ALL REMOVED PARTS FOR THE INSTALLATION PROCESS

- A. Find the Terminal Module Assembly, PN 745-5435-501 looking forward on the engine, in the two o'clock position, at the termination of the Harness (ref). Refer to Figure 1.
- B. Remove the four Screws — Pan Head 10-32, PN A218-D14 which attach the Cover, PN 745-5455-501 to the Bracket, PN 745-5453-501 and the Bracket, PN 745-5454-501.
- C. Remove the Screw — Pan Head 6-32, PN A218-B14 and Washer, PN SP154-B which attach the Cover, PN 745-5455- 501 to the Bracket, PN 745-5453-501.

**WARNING:** PUT ON PROTECTIVE GOGGLES WHEN YOU CUT THE LOCKWIRE. PIECES OF THE LOCKWIRE CAN CAUSE DAMAGE TO YOUR EYES.

- D. Where necessary, remove Lockwire (ref) from the two Screws (ref) which attach the two Clamps (ref) to the female end of the Stuffing Tube, PN 638-106-03M.
- E. Remove the two Screws (ref) and the two Clamps (ref) which attach the Harness (ref) to the female end of the Stuffing Tube, PN 638-106-03M.
- F. Fully loosen the female end from the male end of the Stuffing Tube, PN 638-106-03M.
- G. Remove the Adhesive Tape (ref) from the Harness (ref) at the position marked by the two Clamps (ref).
- H. Remove the Lacing Tape (ref) from around the Screen Tails (ref) of the Harness (ref).



- I. Bend the Screen Tails (ref) away from the Harness (ref) and release the Ground Ferrule (ref).
- J. Remove the four Screws — Pan Head 4-40, PN A218-A12 and the four Nuts — Plain 4-40, PN A105-A-P which attach the male end of the Stuffing Tube, PN 638-106-03M to the Bracket, PN 745-5453-501.
- K. Move the Ground Ferrule (ref) and the male and female ends of the Stuffing Tube, PN 638-106-03M as far away from the Bracket, PN 745-5453-501 as is possible without loosening clipping points.

**WARNING:** DO NOT GET THE CLEANING FLUID ON YOUR SKIN OR IN YOUR EYES. PUT ON PROTECTIVE CLOTHING, GLOVES, GOGGLES AND A MASK. USE THE FLUID IN A WELL VENTILATED AREA. DO NOT BREATHE THE GAS.

IF YOU GET THE FLUID ON YOUR SKIN OR IN YOUR EYES FLUSH IT AWAY WITH WATER. GET MEDICAL HELP IF YOUR SKIN OR EYES BECOME IRRITATED.

- L. Use Isopropyl Alcohol (CoMat 01-410) and a Lint Free Cloth (CoMat 02-099) to clean the surfaces of all threaded parts.

**NOTE:** Make sure you wipe the parts before the Isopropyl Alcohol evaporates.

**CAUTION:** DO NOT INSTALL ADHESIVE TAPE IF CABLES HAVE BEEN DAMAGED. IF CABLES HAVE SUSTAINED DAMAGE THEY MUST BE REPLACED BEFORE YOU INSTALL ADHESIVE TAPE (REFER TO REFERENCE 3 COMPONENT MAINTENANCE MANUAL (CMM-EHC), TASK 73-22-34-440-301).

- M. Starting from the Terminal Junction Module, PN M81714/3-D-A1 and the Terminal Junction Module, PN M81714/3-D-B1, install three layers of Adhesive Tape (CoMat 02-148) along the length of the Harness (ref) for a distance of approximately 6.0 in. (152.4 mm).

**NOTE:** For ease of installation you may manipulate the Cables in the forward and aft direction to ensure easy installation of the adhesive tape to the cables at the through-hole in the Bracket, PN 745-5453-501. The adhesive tape may be split at this point to ease installation but there must not be any gaps in the three protective layers.

- N. Locate the Harness (ref) in the new position making sure that it will not make contact with the Cover, PN 745-5455-501, the Anchor Nut (ref) or the through-hole in the Bracket, PN 745-5453-501.

**NOTE:** Make sure that the Cables have a sufficient bend radii to avoid a sharp angle at the attachment to the Terminal Junction Module, PN M81714/3-D-A1 and the Terminal Junction Module, PN M81714/3-D-B1.

**CAUTION:** TO PREVENT THE HARNESS FROM BEING CHAFED, MAKE SURE THAT THE ADHESIVE TAPE IS APPLIED TO THE HARNESS AT THE BRACKET OPENING. IF THE TAPE IS NOT INSTALLED CORRECTLY, REMOVE THE TAPE AND APPLY AGAIN.

- O. Move the male end of the Stuffing Tube, PN 638-106-03M into position against the through-hole in the Bracket, PN 745-5453-501.

- P. Install the four Screw — Pan Head 4-40, PN A218-A12 and the four Nuts — Plain 4-40, PN A105-A-P which attach the male end of the Stuffing Tube, PN 638-106-03M to the Bracket, PN 745-5453-501. Torque the fasteners as instructed in Reference 1 Standard Practices/Processes Manual, Task 70-41-00-400-501 and Task 70-41-02-400-501.

NOTE: Make sure you lubricate all threads and abutment faces of Nuts, Bolts and Screws with Engine Oil (CoMat 10-077) prior to installation.

NOTE: Make sure the heads of the Screws — Pan Head 4-40, PN A218-A12 are installed on the outside surface of the Bracket, PN 745-5453-501.

- Q. Move the Ground Ferrule (ref) along the Harness (ref) to secure the contact between the Screen Tails (ref) and the male end of the Stuffing Tube, PN 638-106-03M.
- R. Put the Screen Tails (ref) over the Ground Ferrule (ref) at equal distance spacing and orient along the length of the cables. Use Lacing Tape (CoMat 02-159) to secure the Screen Tails (ref) immediately behind the Ground Ferrule (ref).

NOTE: You may have to expose and then trim additional lengths of Screen Tails (ref) to allow the correct seating of the Ground Ferrule (ref) in the male end of the Stuffing Tube, PN 638-106-03M.

WARNING: IT IS THE RESPONSIBILITY OF THE OPERATOR TO OBTAIN AND OBSERVE THE MANUFACTURERS MATERIAL SAFETY DATA SHEETS FOR CONSUMABLE MATERIALS. INFORMATION SUCH AS HAZARDOUS INGREDIENTS, PHYSICAL/CHEMICAL CHARACTERISTICS, FIRE, EXPLOSION, REACTIVITY, HEALTH HAZARD DATA, PRECAUTIONS AND SAFE HANDLING, USE AND CONTROL MEASURES AND LOCAL REGULATIONS MUST BE TAKEN INTO CONSIDERATION.

CAUTION: MAKE SURE THE LOCKING COMPOUND IS CONFINED TO THE THREADS OF THE PARTS.

- S. Apply two drops of Loctite 222 Thread Locking Compound (CoMat 08-026), opposite to each other, to the threads of the male end of the Stuffing Tube, PN 638-106-03M.
- T. Install the female end to the male end of the Stuffing Tube, PN 638-106-03M. Hand tighten the female end of the Stuffing Tube, PN 638-106-03M.
- U. Mark the female end of the Stuffing Tube, PN 638-106-03M with an indelible red stripe to signify that Loctite 222 Thread Locking Compound (CoMat 08-026) has been applied to the threads of this part.
- V. Apply one drop of Loctite 222 Thread Locking Compound (CoMat 08-026) to the threads of the two Screws (ref) which hold the two Clamps (ref) which attach the Harness (ref) to the female end of the Stuffing Tube, PN 638-106-03M.
- W. Install the two Screws (ref) and the two Clamps (ref) to attach the Harness (ref) to the female end of the Stuffing Tube, PN 638-106-03M. Torque the fasteners sufficiently to prevent the Harness (ref) from vibrating against the Clamps (ref) on the female end of the Stuffing Tube, PN 638-106-03M. Make sure you do not make any indentations in the Harness (ref) when you tighten the Clamps (ref).

NOTE: Confirm that the end of adhesive tape application is aft of the clamps (ref) .

- X. Where necessary, install Lockwire (ref) to the two Screws (ref) which attach the two Clamps (ref) to the female end of the Stuffing Tube, PN 638-106-03M. Install the

Lockwire (ref) as instructed in Reference 1 Standard Practices/Processes Manual, Task 70-42-05-400-501.

- Y. Install the four Screws — Pan Head 10-32, PN A218-D14 which attach the Cover, PN 745-5455-501 to the Bracket, PN 745-5453-501 and the Bracket, PN 745-5454-501. Install the Screw — Pan Head 6-32, PN A218-B14 and Washer, PN SP154-B which attach the Cover, PN 745-5455-501 to the Bracket, PN 745-5453-501. Torque the fasteners as instructed in Reference 1 Standard Practices/Processes Manual, Task 70-41-00-400-501 and Task 70-41-02-400-501.

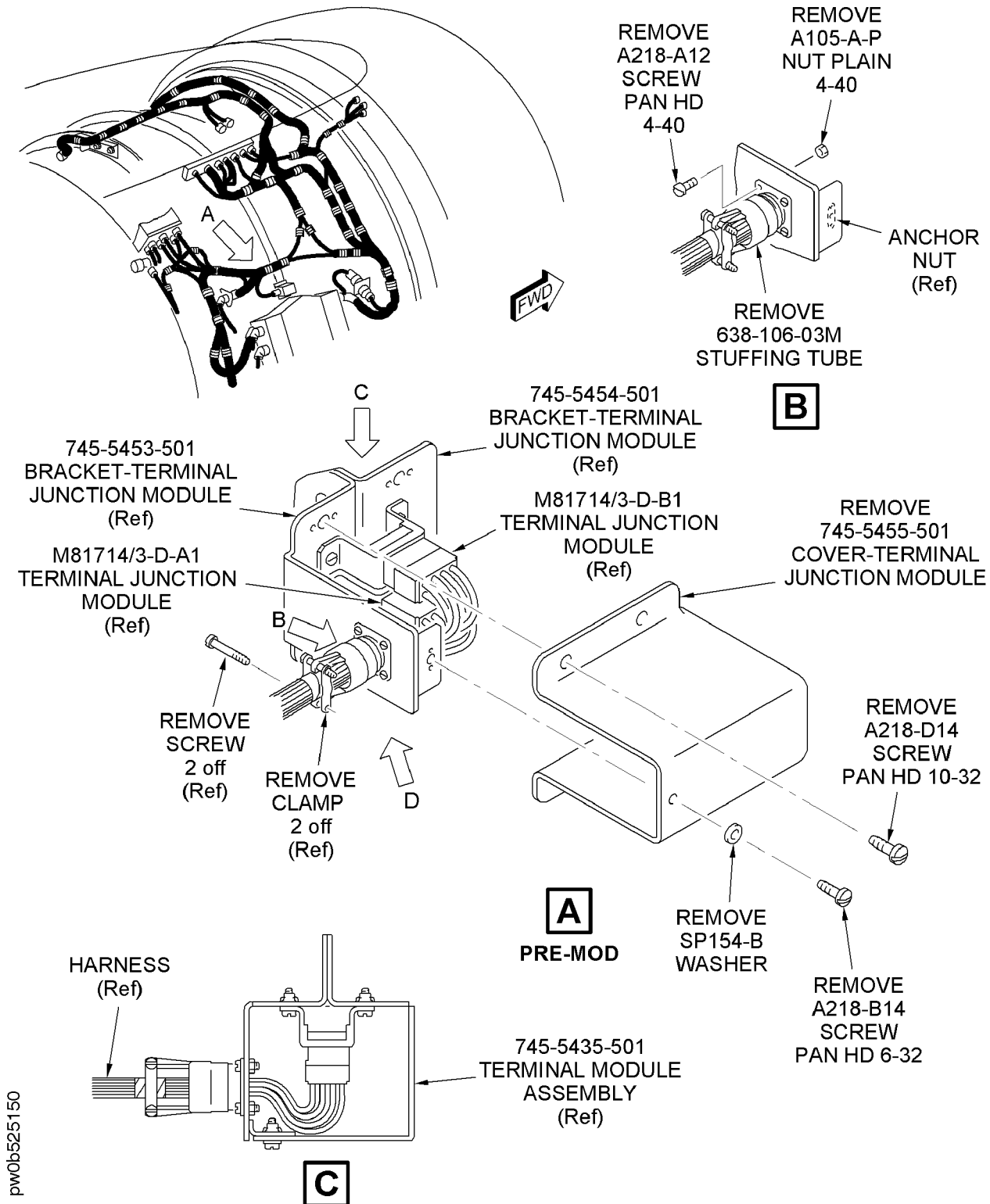
NOTE: Make sure you lubricate all threads and abutment faces of Nuts, Bolts and Screws with Engine Oil (CoMat 10-077) prior to installation.

3. Post-requisite Instructions:

- A. Close the Thrust Reverser Halves as instructed in Reference 2 Aircraft Maintenance Manual, Task 78-32-00-410-010.
- B. Close the Fan Cowl Doors as instructed in Reference 2 Aircraft Maintenance Manual, Task 71-13-00-410-010.
- C. Remove the tags and close the applicable Circuit Breakers as instructed in Reference 2 Aircraft Maintenance Manual, Task 71-00-00-401.
- D. Do a test of the Powerplant as instructed in Reference 2 Aircraft Maintenance Manual, Task 71-00-00-501.

4. Recording Instructions

- A. A record of accomplishment is required. Write in the Aircraft Log Book that Service Bulletin V2500-ENG-71-0275, Rev 2 has been incorporated.



REROUTING OF THE TERMINAL MODULE ASSEMBLY — HARNESS CABLES  
FIGURE 1, SHEET 1 OF 3

September 29/05

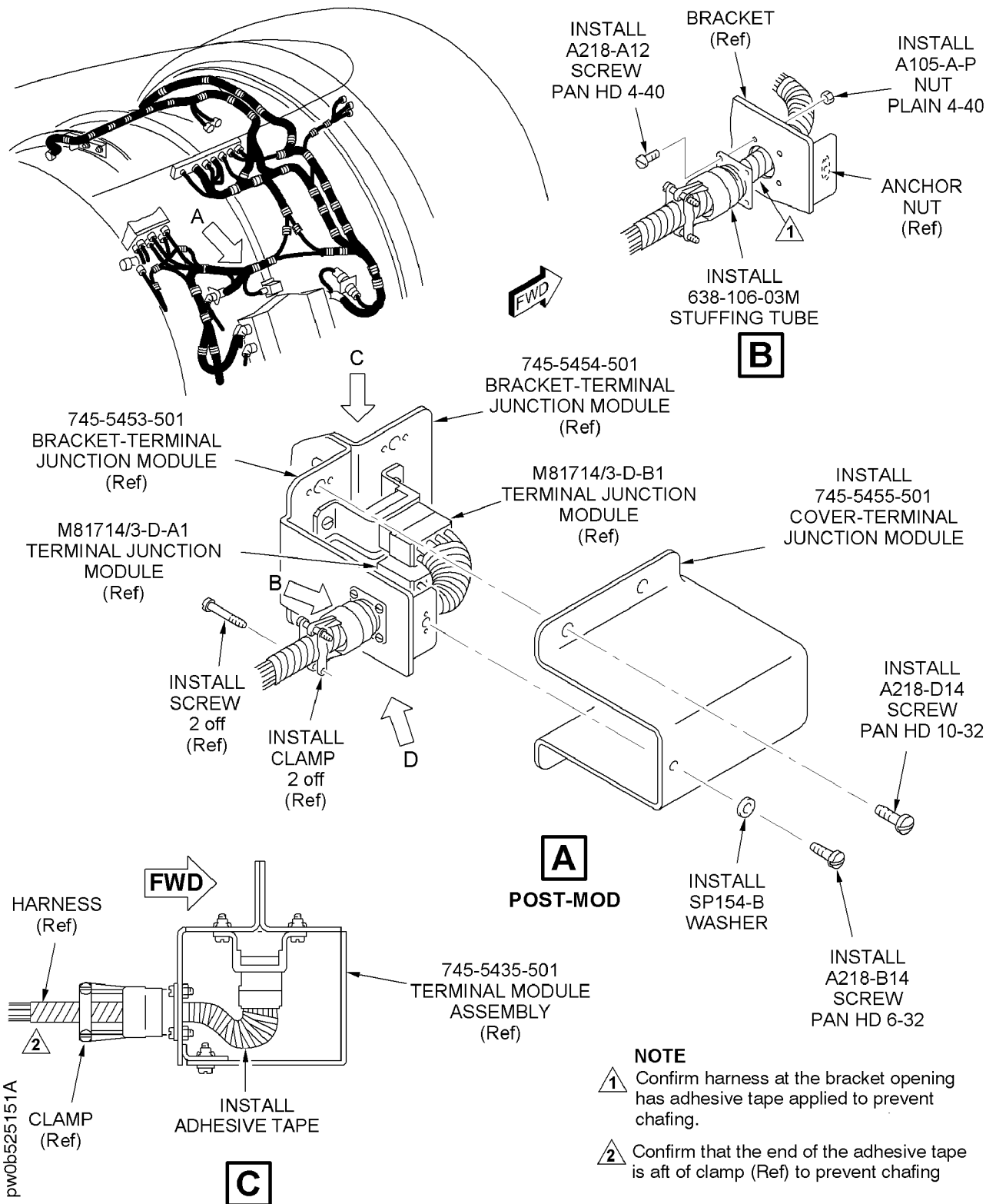
REVISION NO. 2 - June 26/15

V2500-ENG-71-0275

Page 10

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**REROUTING OF THE TERMINAL MODULE ASSEMBLY — HARNESS CABLES**  
FIGURE 1, SHEET 2 OF 3

September 29/05

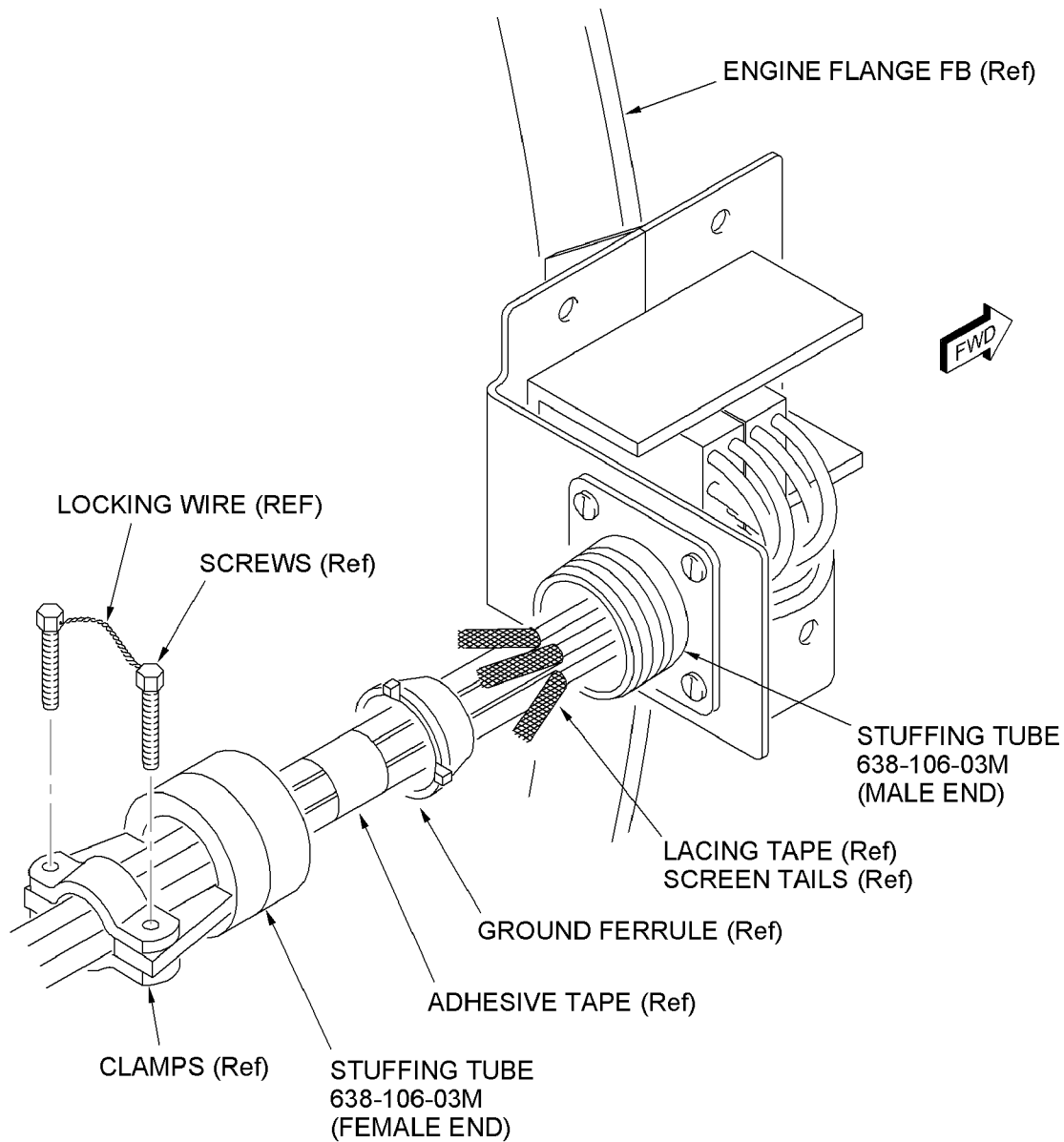
REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 11

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DETAILS OF STUFFING TUBE ASSEMBLY, PN 638-106-03M  
FIGURE 1, SHEET 3 OF 3

September 29/05

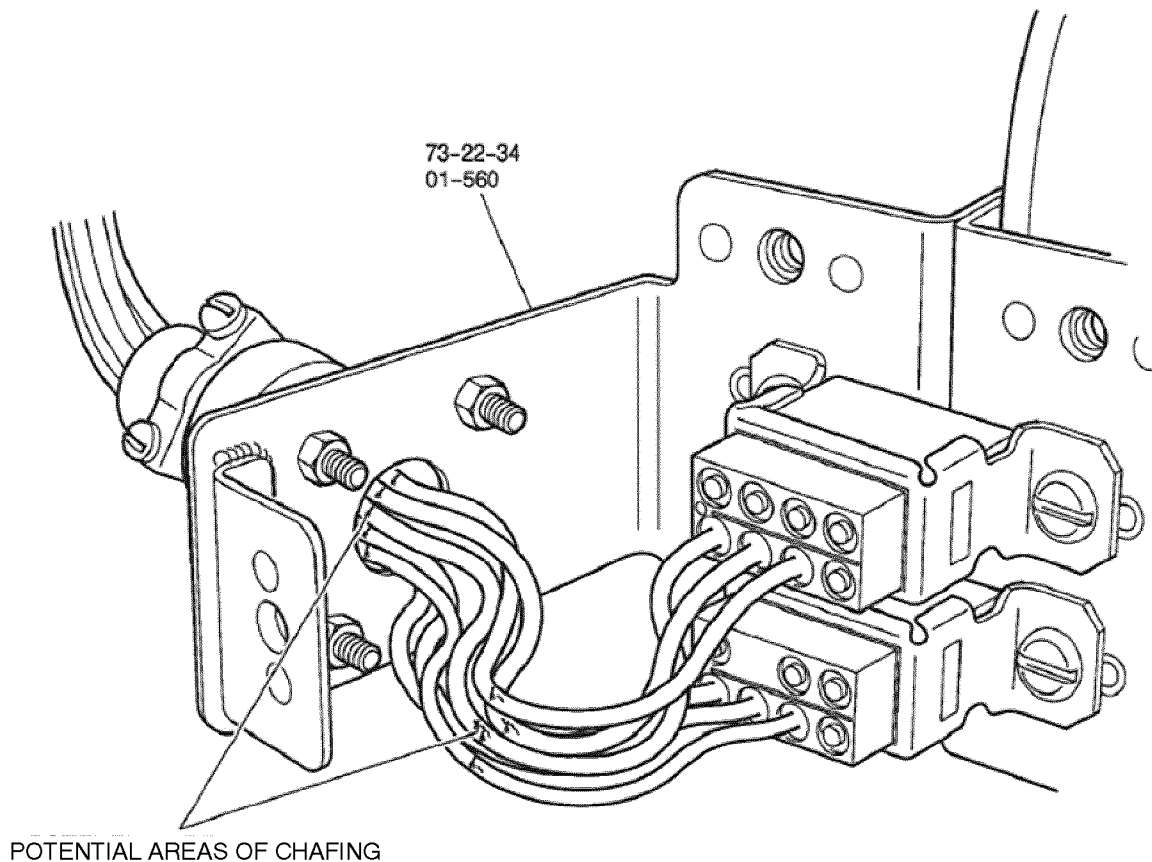
REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 12

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VIEW OF THE HARNESS PRIOR TO INCORPORATION OF THIS SERVICE BULLETIN

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ADHESIVE TAPE APPLICATION VIEWS  
FIGURE 2, SHEET 1

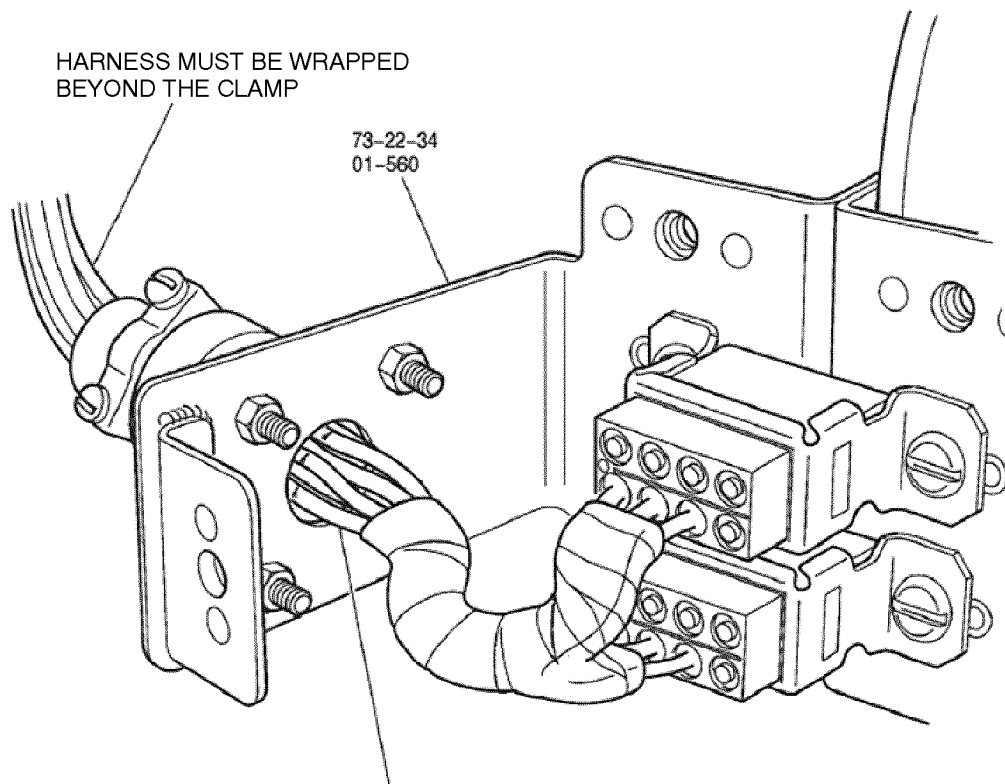
September 29/05

REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 13





INCORRECT APPLICATION OF ADHESIVE TAPE

B525792

ADHESIVE TAPE APPLICATION VIEWS  
FIGURE 2, SHEET 2

September 29/05

REVISION NO. 2 - June 26/15

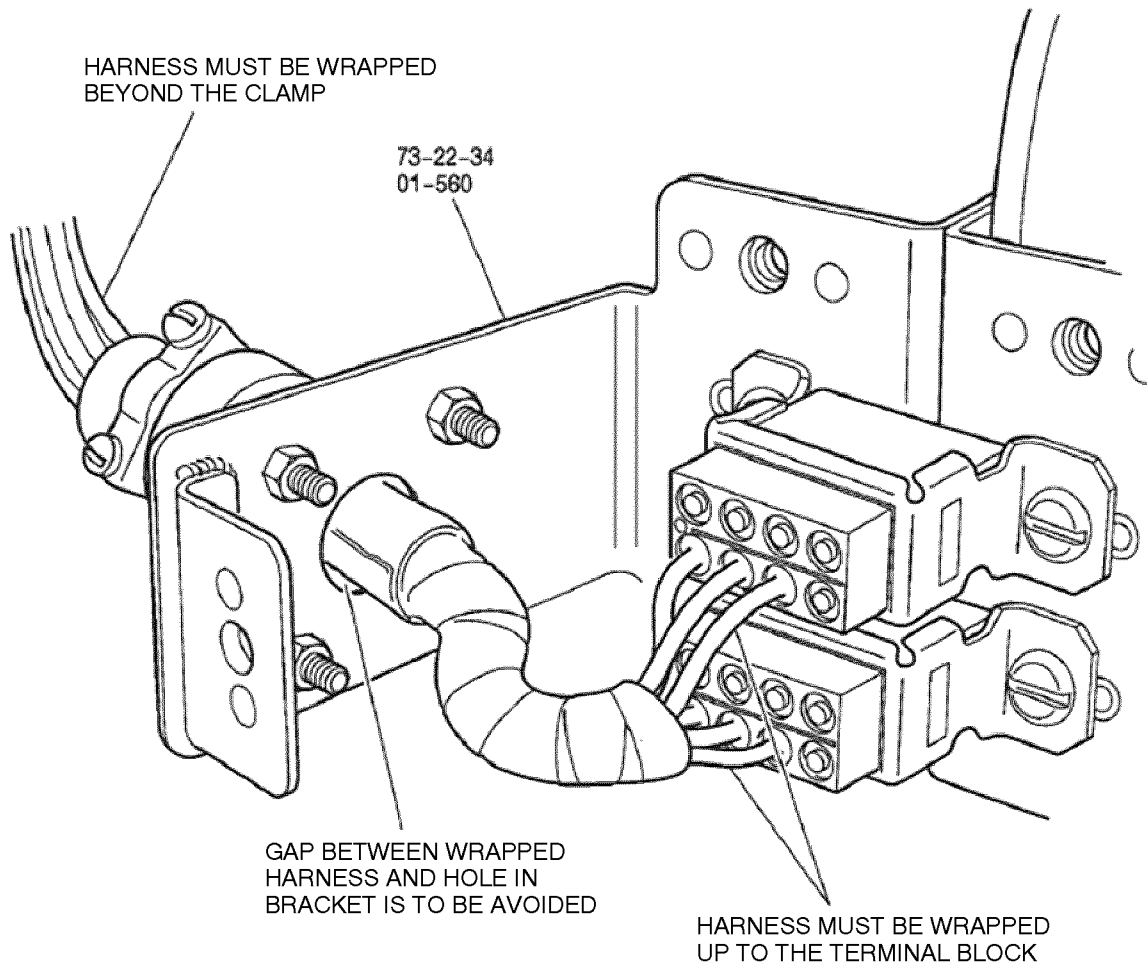
**V2500-ENG-71-0275**

Page 14

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B525794

ADHESIVE TAPE APPLICATION VIEWS  
FIGURE 2, SHEET 3

September 29/05

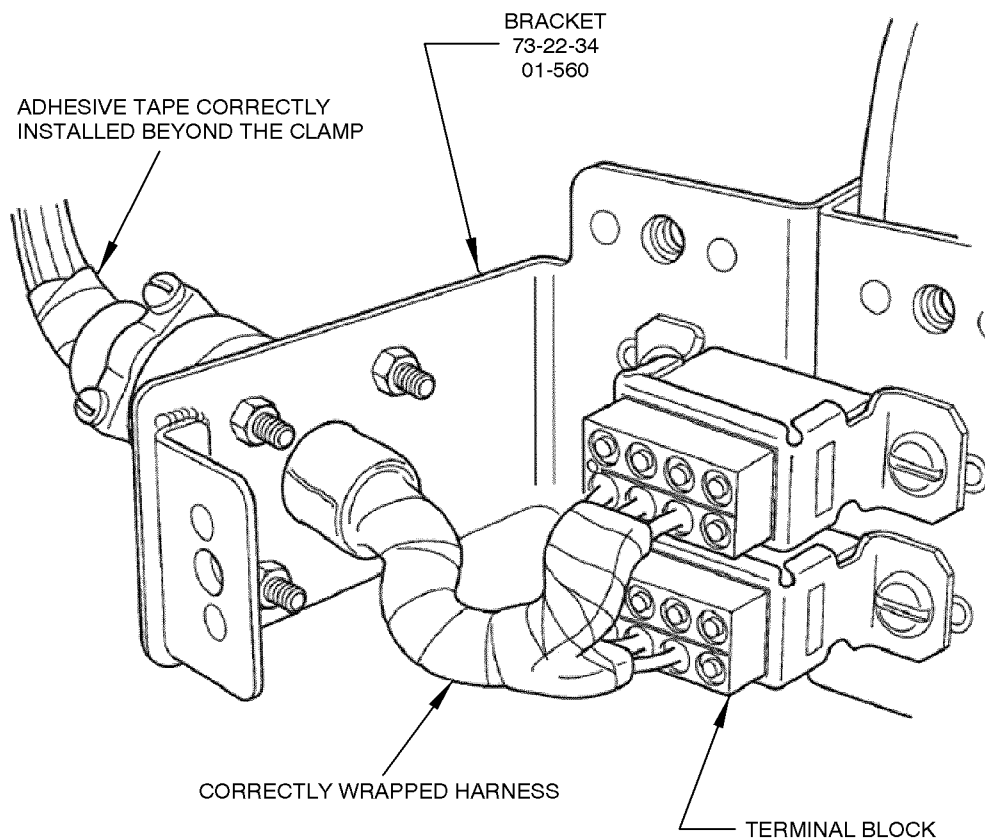
REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 15

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VIEW OF CORRECT ADHESIVE TAPE INSTALLED ON THE HARNESS

B525794

ADHESIVE TAPE APPLICATION VIEWS  
FIGURE 2, SHEET 4

September 29/05

REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 16

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## Appendix

### Added Data

#### Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC02VN762	GR
1	EC12VN300	MA/CMS
2	EA14VC331	UTAS

Number values shown in parentheses adjacent to U.S. values are International System of units (SI) equivalents.

**NOTE:** In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, the following Technical Publications cross reference table is provided.

#### Technical Publications Cross Reference Table

Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
ENGINE MANUAL — A1, A5	All	E-V2500-1IA	2A4407
CMM-EHC — A1, A5	All	EHC-V2500-1IA	2A4409
CMM-FN — A1, A5	All	FN-V2500-1IA	2A4410
CMM-MMC — A1, A5	All	MECH-V2500-1IA	2A4411
CMM-THD — A1, A5	All	THD-V2500-1IA	2A4412
TLM — A1, A5	All	T-V2500-1IA	2A4408
SPPM (SPM) — A1, A5, D5	All	SPP-V2500-1IA	2A4414
EIPC — A1	V2500-A1102Q00	S-V2500-1IA	2A4427

September 29/05

REVISION NO. 2 - June 26/15

# V2500-ENG-71-0275

Page 17

IAE PROPRIETARY INFORMATION

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Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
EIPC — A5	V2522/V2524/V2527M-AQ02	S-V2500-6IA	2A4428
	V2522/V2524/V2527M-AQ03	S-V2500-6IB	
	V2522/V2524/V2527M-SQ02	S-V2500-6SA	
	V2522/V2524/V2527M-SQ03	S-V2500-6SB	
	V2522/V2524/V2527M-SQ04	S-V2500-6NA	
	V2522/V2524/V2527M-SQ05	S-V2500-6NB	
	V2527/V2527E-AQ02	S-V2500-7IA	
	V2527/V2527E-AQ03	S-V2500-7IB	
	V2527/V2527E-SQ02	S-V2500-7SA	
	V2527/V2527E-SQ03	S-V2500-7SB	
	V2527/V2527E-SQ04	S-V2500-7NA	
	V2527/V2527E-SQ05	S-V2500-7NB	
	V2530-AQ02	S-V2500-2IA	
	V2530-AQ03	S-V2500-2IB	
	V2530-SQ02	S-V2500-2SA	
	V2530-SQ03	S-V2500-2SB	
	V2530-SQ04	S-V2500-2NA	
	V2530-SQ05	S-V2500-2NB	
	V2533-AQ02	S-V2500-5IA	
	V2533-AQ03	S-V2500-5IB	
	V2533-SQ02	S-V2500-5SA	
	V2533-SQ03	S-V2500-5SB	
	V2533-SQ04	S-V2500-5NA	
	V2533-SQ05	S-V2500-5NB	

September 29/05

REVISION NO. 2 - June 26/15

**V2500-ENG-71-0275**

Page 18

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