



## SERVICE BULLETIN

ENGINE - HP COMPRESSOR - INTRODUCTION OF WEIGHT REDUCED BOROSCOPE BLANKS - CATEGORY  
CODE 7 - MOD.ENG-72-0005

1. Planning InformationA. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: (a) V2500 A1 Engine prior to Serial No.V0063\* as delivered

\* The serial number data shown is of a preliminary nature and is provided for advanced planning only. A future revision to this Service Bulletin will confirm final serial number effectivity.

B. Reason

## (1) Condition

The existing borescope blanks contribute unnecessary weight to the V2500 engine.

## (2) Background

Design review has shown the need for the introduction of weight reduction changes.

## (3) Objective

The changes in configuration in this Service Bulletin are designed to contribute towards an overall reduction in engine weight.

## (4) Substantiation

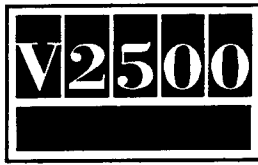
Analysis of the changes introduced by this Service Bulletin has concluded that the new parts will be satisfactory.

## (5) Effect of Bulletin on:

Removal/Installation	Not affected
Disassembly/Assembly	Affected (See Supplemental Information)
Cleaning	Not affected
Inspection/Check	Affected (See Supplemental Information)
Repair	Not affected
Testing	Not affected

## (6) Supplemental Information

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(a) The assembly of the Post-Service Bulletin configuration requires instructions for installing six new boroscope blank covers.

(b) The new configuration has revised fitment instructions.

C. Description

The changes introduced by this Service Bulletin are as follows:

(a) Stage 7, 8, 9 and 11 boroscope blanks have had the captive bolt removed to permit the three large bosses on each cover to be deleted.

(b) The Stage 7 boroscope blank featured a central boss. This boss has now been deleted.

(c) because of the captive bolt being deleted on Stages 7, 8, 9, and 11 boroscope blanks, the captive bolts are no longer necessary.

(2) Existing boroscope blanks cannot be reworked.

D. Approval

The part number changes and/or part modifications in Sections 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.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts have been deleted.

F. Manpower

Estimated Manhours to include the full intent of this Bulletin

Venue	Estimated Manhours
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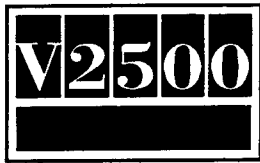
(1) In Service .. .. .	Not applicable
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(2) At overhaul .. .. .	None
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(Note the parts affected by this Service Bulletin are accessible at overhaul).

G. Material - Price and Availability

(1) Modification kit not required.



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- (2) See Material Information section for prices and availability of future spares.

### H. Tooling - Price and Availability

Special tools are not required.

### J. Weight and Balance

- |     |               |    |    |    |  |
|-----|---------------|----|----|----|--|
| (1) | Weight Change | .. | .. | .. | Minus 0.7 lb (0,32 kg)   |
| (2) | Moment Arm    | .. | .. | .. | 22.5 in. (571,5 mm)  |
| (3) | Datum         | .. | .. | .. | Engine front mount centerline<br>(Power Plant Station (PPS) 100) |

### J. Electrical Load Data

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

### K. References

- (1) Internal Reference No.  
EC87VR244
- (2) Other References  
V2500 Engine Manual, 72-41-00 Assembly.

### L. Other Publications Affected

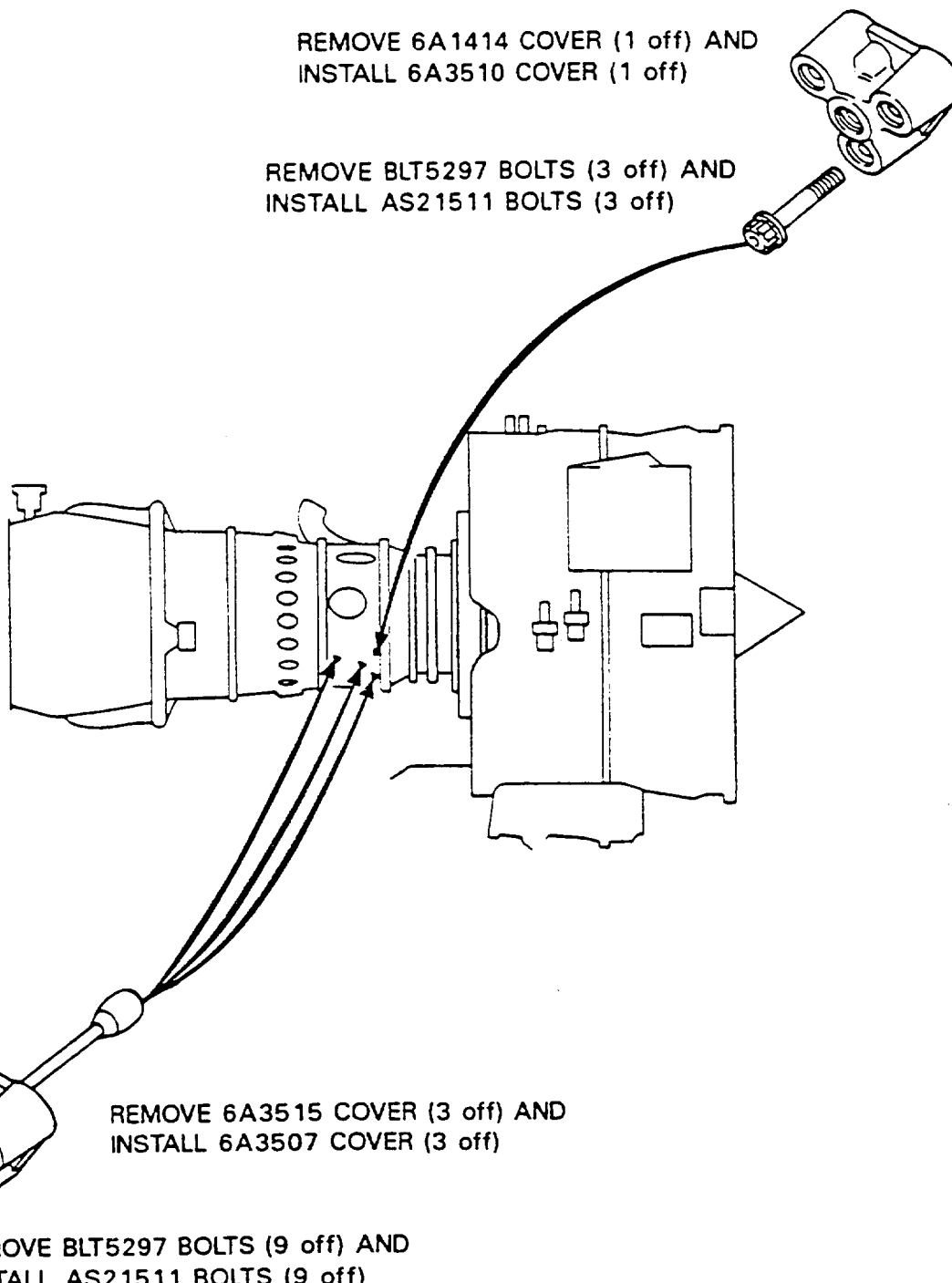
- (1) V2500 Illustrated Parts Catalog , 72-41-00, 72-41-23
- (2) V2500 Engine Manual, 72-41-00 Assembly, Inspection/Check, and Cleaning, 72-41-23 Inspection/Check and Cleaning and 72-00-00 Inspection/Check-02.
- (3) Aircraft Maintenance Manual, 72-00-00, Inspection/Check.

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REMOVE 6A1414 COVER (1 off) AND  
INSTALL 6A3510 COVER (1 off)

REMOVE BLT5297 BOLTS (3 off) AND  
INSTALL AS21511 BOLTS (3 off)

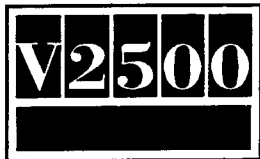


REMOVE 6A3515 COVER (3 off) AND  
INSTALL 6A3507 COVER (3 off)

REMOVE BLT5297 BOLTS (9 off) AND  
INSTALL AS21511 BOLTS (9 off)

Location of boroscope blanks  
Fig.1

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2. Accomplishment Instructions

A. Rework Instructions

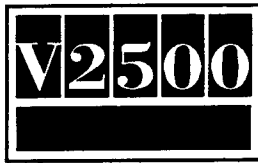
- (1) None

B. Assembly Instructions

- (1) Assemble new 6A3507 and 6A3510 boroscope blank covers and AS21511 bolts by use of approved procedures, Engine Manual, 72-41-00 Assembly.

C. Record Instructions

- (1) A record of accomplishment is necessary.



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3. Material Information

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No)	Instructions Disposition
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A. Kits Associated with this Bulletin:

None

B. Parts Affected by this Bulletin:

6A3507 (72-41-00)	3	293.00	Cover assy blank, boroscope	6A3515 (02-100)	(A)(B)(S1)
AS21511 (72-41-00)	9	3.53	Bolt, machine double hex	BLT5297 (02-102)	(A)(B)(S1)
6A3510 (72-41-23)	1	32.40	Cover assy, blank, boroscope	6A1414 (02-100)	(A)(B)(S1)
AS21511 (72-41-23)	3	3.53	Bolt, machine double hex	BLT5297 (02-102)	(A)(B)(S1)

C. Instruction/Disposition Code Statements:

- (A) New part currently available for sale.
- (B) Old part no longer available for sale.
- (S1) New parts coded (S1) replace old parts coded (S1) as a complete set per location. Each set can be incorporated separately but to obtain the full benefit of this Service Bulletin all new parts should be incorporated.
- (S2) New parts coded (S2) replace old parts coded (S2) as a complete set. Parts coded (S1) and parts coded (S2) can be incorporated separately, but to obtain the full benefit of this Service Bulletin all parts coded (S1) and (S2) should be incorporated.

NOTE: The estimated 1990 Unit Prices shown are provided for planning purposes only and do 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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