



ENGINE - INCORPORATE REPLACEMENT VARIABLE INLET GUIDE VANE BRACKET - CATEGORY CODE 4 -  
MOD.ENG-72-0019

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engine, Serial No's.V0014 through V0061, V0063, V0065  
and V0066

B. Reason

(1) Condition

There is some possibility that the current Bracket cannot be installed on  
the Shaft, Assy.

(2) Background

This condition was found at detail interface review.

(3) Objective

To eliminate the above possibility in service.

(4) Substantiation

Substantiation is not necessary.

(5) Effect of Bulletin on the following shop functions:

Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

C. Description

New Bracket is incorporated to improve the installation.

D. Approval

The Part Number change described in Sections 2 and 3 of this Service Bulletin  
has been shown to comply with the applicable Federal Aviation Regulations and  
is FAA-APPROVED for the Engine Module listed.

V2500-ENG-72-0019

**E. Compliance**

Category Code 4

Accomplish at the first visit of an engine or a module to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action or the reason for engine removal.

**F. Manpower**

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue

Estimated Manhours

(1) In service

(a) To gain access

(b) To embody

(c) To return engine to flyable  
status .. .. . 21.75 mins

TOTAL

(2) In shop .. .. . Not applicable

(3) At overhaul .. .. . Not applicable

**G. Material – Price and Availability**

(1) See "Material Information" section for parts required to accomplish this Service Bulletin.

**H. Tooling – Price and Availability**

Special tools are not required.

**I. Weight and Balance**

(1) Weight change None

(2) Moment arm No effect

(3) Datum Engine front mount centerline  
(Power Plant Station (PPS) 100)**J. Electrical Load Data**

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

V2500–ENG–72–0019



K. References

(1) Internal Reference Nos

EC88VJ656

ECM88VJ656-01

(2) Other References

V2500 Illustrated Parts Catalog

V2500 Aircraft Maintenance Manual

V2500 Standard Practices/Procedures Manual

Use Torque Wrenches and Power Tool, IAE Control No.70-41-01

V2500 Overhaul Processes and Consumables Index

L. Other Publications Affected

(1) V2500 Illustrated Parts Catalog, Chapter/Section 72-41-34

(2) V2500 Engine Manual, Chapter/Section 72-41-34, Cleaning and Inspection/Check



## 2. Accomplishment Instructions

### A. Prerequisite Instruction

- (1) Open the Right Thrust Reverser Half (Refer to Aircraft Maintenance Manual, TASK 78-32-00-010-010)

NOTE: For uninstalled engines (without the Thrust Reverser Half), this step is not applicable.

### B. Removal Instructions

- (1) Remove PN 5W8355, Bracket (72-41-34-01-720), Figure 1 and 2
- (a) Remove bolt (11-141), washer (11-142) and spacer (11-146) at the clipping point 5660.
  - (b) Let clip (11-144) stay on tube (11-100).
  - (c) Remove bolt (72-41-34-01-604) from Shaft, Assy.
  - (d) Remove PN 5W8355, Bracket (72-41-34-01-720) from the engine.
  - (e) Remove nut (11-148) from the Bracket (72-41-34-01-720), Figure 2.

### C. Installation Instructions

NOTE: 1. The relationship of the tube clip and securing points shall allow the attachment bolts to be inserted when the bracket is fixed by hand without permanently distorting the assembly.

2. The bolts shall be lubricated with clean engine oil before tightening them. Use Comat 10-039 Engine oil.

- (1) Install PN 5W0088, Bracket (72-41-34-01-720), Figure 1 and 3
- (a) Put nut(11-148) on PN 5W0088, Bracket (72-41-34-01-720), Figure 3.
  - (b) Install PN 5W0088, Bracket (72-41-34-01-720) in position on the engine.
  - (c) Tighten bolt (72-41-34-01-604) to 150 to 170 lbfin (16.94 to 19.21 Nm).
  - (d) Install bolt (11-141), washer (11-142) and spacer (11-146) at the clipping point 5660.
  - (e) Tighten bolt (11-141) to 32 to 36 lbfin (3.61 to 4.07 Nm).

### D. Post-requisite Instructions

# V2500-ENG-72-0019

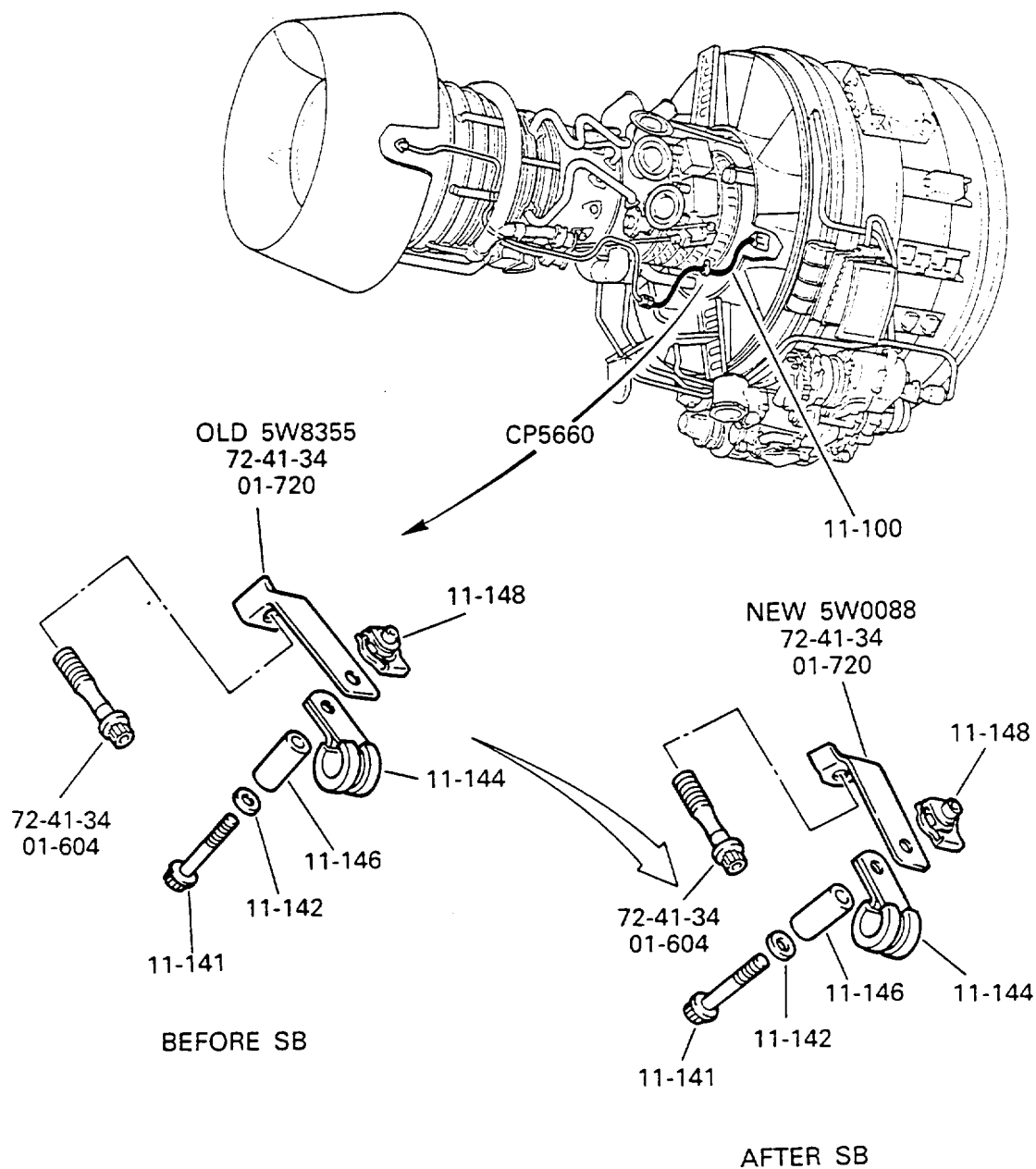


- (1) Close the Right Thrust Reverser Half (Refer to Aircraft Maintenance Manual, TASK 78-32-00-410-010).

NOTE: For uninstalled engines (without the Thrust Reverser Half), this step is not applicable.

**E. Recording Instructions**

- (1) A record of accomplishment is necessary.

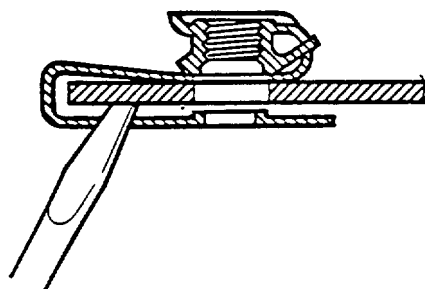


Change of the bracket  
Fig.1

V2500-ENG-72-0019



## SERVICE BULLETIN



Put the tapered thin end of a suitable lever into the engaging bracket and the spigot side of the clip. Turn the lever to lift the spigot clear of its socket. The clip and nut assembly can then be removed from the engaging bracket.

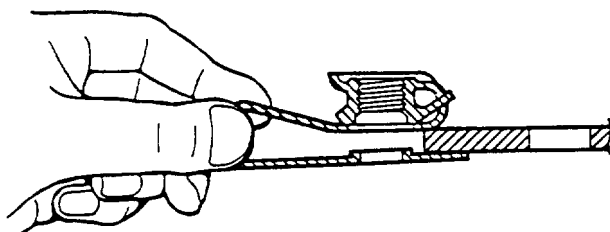
ded0000483

Removal of clip and nut assembly  
Fig.2

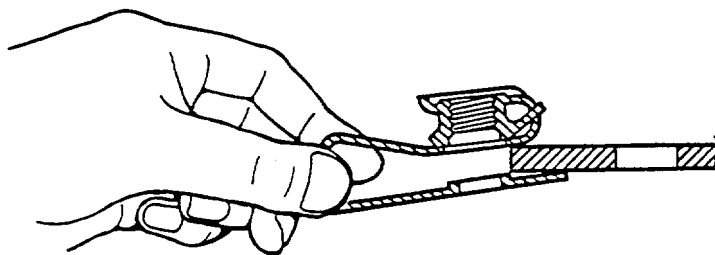
V2500-ENG-72-0019

Jul.6/90

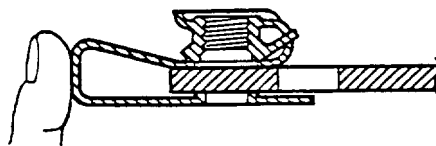
Page 7



(1) Push the mouth of the clip against the engaging bracket as shown.



(2) Push in the rear of the clip sufficiently to ensure that the locating spigot will clear the edge of the engaging bracket.



(3) Push the clip forward so that grip is moved to the spigot face.



(4) Move the clip along the engaging bracket until the locating spigot correctly engages in its socket.

(5) When the locking torque of the nut and bolt installation falls below the value of 2 lbf in. (0,226 Nm) the entire clip and nut assembly is to be discarded and a new one used for replacement.

Installation of clip and nut assembly  
Fig.3

V2500-ENG-72-0019





## SERVICE BULLETIN

3. Material Information

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
------------------------------	-----	-----------------------------	---------	------------------------------	-----------------------------

---

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

5W0088	1	93.30	Bracket	5W8355	(S1)(A)(B)
(72-41-34)				(01-720)	

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 Sales Department for information concerning firm prices.

C. Instruction/Disposition Code Statements:

- (A) New part is currently available.
- (B) Old part is no longer available for sale.
- (S1) New part must be used in place of old part.

D. Consumable Material:

The following consumable material is required.

CoMat 10-039 Engine oil

V2500-ENG-72-0019

