



SERVICE BULLETIN

ENGINE - HP COMPRESSOR - STAGE 8 AND 11 REAR INNER CASING HEATSHIELDS WITH CORROSION PROTECTION - CATEGORY CODE 6 - MOD.ENG-72-0034

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500 A1 Engine prior to Serial No.V0127 except Serial No.V0124 and V0125

B. Reason

(1) Condition

Corrosion of the HP compressor stage 8 and 11 inner casing heatshields.

(2) Background

Strip inspection of numerous compressors to the current production standard, following 150 hour mod. approval tests, revealed corrosion of the stage 8 and 11 casing heatshields.

(3) Objective

Incorporation of this Service Bulletin (Modification) is designed to maintain engine reliability.

(4) Substantiation

It is concluded that the changes introduced by this modification will be beneficial.

(5) Effects of Service Bulletin on workshop procedures

Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Affected (see 1.L.)
Inspection/Check	Affected (see 1.L.)
Repair	Affected (see 1.L.)
Testing	Not affected

(6) Supplemental Information

None

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**C. Description**

(1) The changes introduced by this Service Bulletin are as follows:

- (a) The stage 8 and 11 rear inner heatshields are coated all over except for abutment areas, with heat resisting enamel.

D. Approval

The part number changes and/or part modification 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 6

Accomplish when the sub-assembly (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 man-hours to incorporate the full intent of this Bulletin

Venue	Estimated Manhours
(1) In Service	Not applicable
(2) At Overhaul	TOTAL 1 hour, 3 minutes

(Note: The parts affected by this Service Bulletin are accessible at overhaul.)

(a) To rework the stage 8 and 11 rear inner casing heatshields ..	1 hour, 3 minutes
TOTAL	1 hour, 3 minutes

G. Material - Price and Availability

- (1) Modification kit not required.
- (2) See Material Information section for Prices and Availability of future spares.

H. Tooling - Price and Availability

Special tools are not required

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I. Weight and Balance

- | | |
|-------------------|--|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front mount centreline
(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.
88VR166
- (2) Other References
V2500 Engine Manual, 72-41-20, Assembly

L. Other Publications Affected

- (1) V2500 Illustrated Parts Catalogue, 72-41-21.
- (2) V2500 Engine Manual, 72-41-21, Inspection/Check, Cleaning and Repair.



2. Accomplishment Instructions

A. Rework Instructions

- (1) Rework 6A3020, stage 8, heatshield and 6A3021, stage 11, heatshield.
(Refer to 72-41-21, Fig./Item 03-900 and 04-520).

Standard Equipment

Overhaul process facility
Vibro-engraving equipment

Consumable Materials

CoMat 02-001 Masking tape
CoMat 07-036 Aluminium high heat resistant paint.

Procedure	Supplementary Information
(a) Clean component	Use overhaul process facility. Refer to S.P.M. TASK 70-38-21-380-501, SUBTASK 70-38-21-380-006
(b) Cover the areas with tape which have not to be painted	See Fig.2. Use CoMat 02-001 masking tape
(c) Apply type 'A' layer of high heat resistant paint and stove as required	See Fig.2. Refer to S.P.M. TASK 70-38-21-380-501, SUBTASK 70-38-21-380-008. Use CoMat 07-036 aluminium high heat resistant paint. Use overhaul process facility
(d) Remove tape	
(e) Inspect the layer of high heat resistant paint	Refer to S.P.M. TASK 70-38-21-380-501, SUBTASK 70-38-21-220-001
(f) Cancel the old part number and identify with the new part number	Old Part No. New Part No. 6A3020 6A3978 6A3021 6A3979 Refer to S.P.M. TASK 70-09-00-400-501, SUBTASK 70-09-00-400-001. Use vibro-engraving equipment

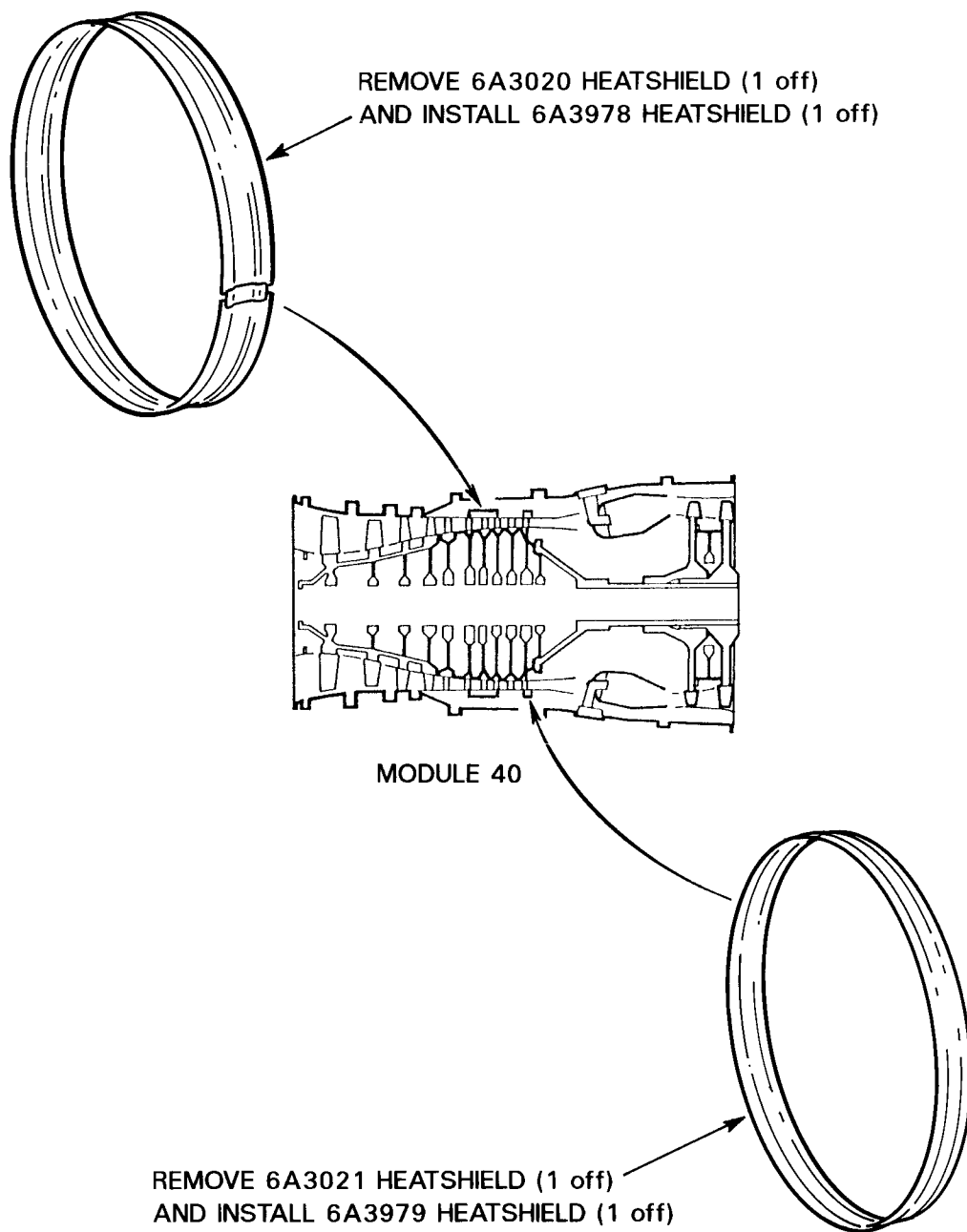


B. Assembly Instructions

- (1) New 6A3978 and 6A3979 Stage 8 and 11 H.P. compressor rear inner heatshields introduced by this Service Bulletin are interchangeable with in use Stage 8 and 11 rear inner heatshields.
- (2) Assemble new or re-identified 6A3978 and 6A3979 stage 8 and 11 H.P. compressor rear inner casing heatshields by use of approved procedures, Engine Manual, 72-41-20 Assembly.

C. Recording Instructions

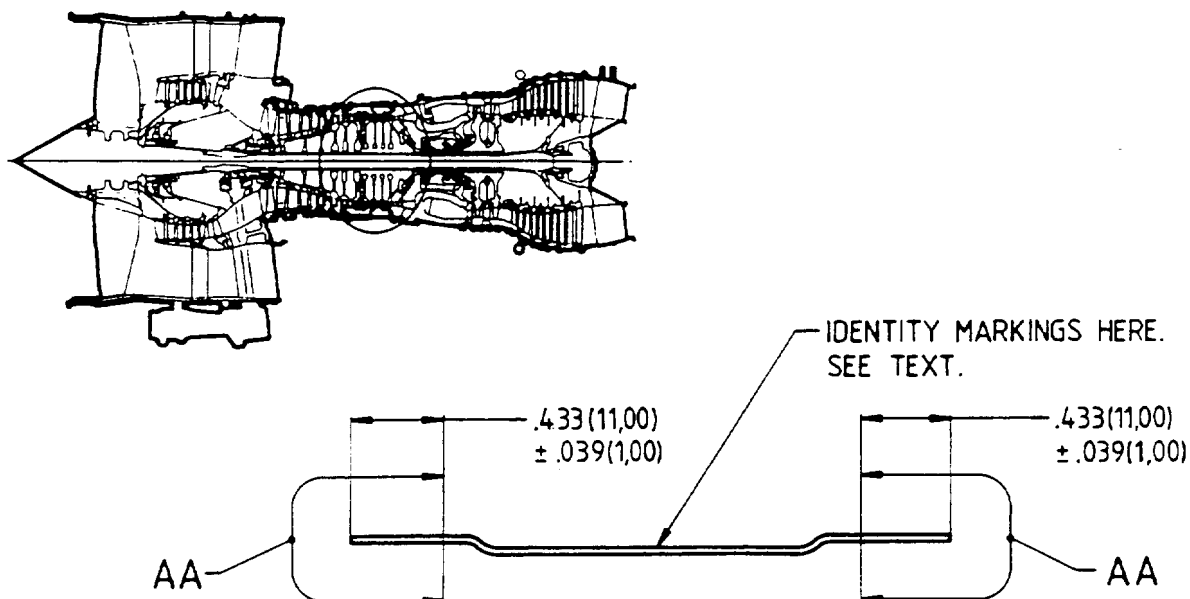
- (1) A record of accomplishment is required.



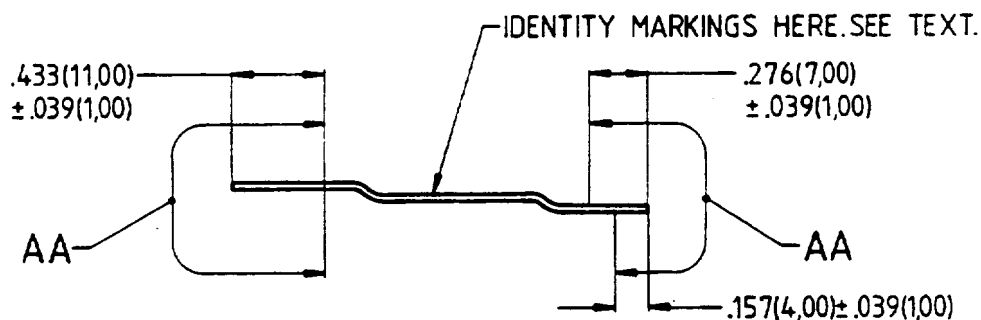
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Location of heatshields
Fig.1

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TYPICAL SECTION THRU HEATSHIELD ASSY.—STAGE 8



TYPICAL SECTION THRU HEATSHIELD ASSY.—STAGE 11.

DIMENSIONS IN INCHES(MILLIMETRES).

APPLY THE HIGH HEAT RESISTING ENAMEL AS GIVEN IN TEXT.

DO NOT LET THE ENAMEL TOUCH THE AREAS SPECIFIED AA.

REWORKING OF EXISTING HEATSHIELD ASSEMBLIES—STAGES 8 & 11.

Typical section thru heatshield assembly - Stage 11
Fig.2



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3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this bulletin:

None

B. Parts affected by this bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
6A3978 (72-41-21)	1	488.00	Heatshield, assy of stage 8	6A3020 (03900)	(A)(B)(1D) (S1)
6A3979 (72-41-21)	1	473.00	Heatshield, assy of stage 11	6A3021 (04520)	(A)(B)(1D) (S1)

C. Instruction/Disposition Code Statements:

- (A) New part currently available.
- (B) Old part is no longer available.
- (1D) Old part can be reworked and re-identified to the new part number.
- (S1) Old and new parts are completely interchangeable.

NOTE: The estimated 1991 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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