



ENGINE - INCORPORATE DRY FILM LUBRICANT TO THE NO.2 AND NO.10 STRUTS THRUST MOUNT
BRACKETS - CATEGORY CODE 5 - MOD.ENG-72-0045

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines, Serial Numbers V0014 through V0106.

B. Reason

(1) Condition

Wear may occur on the spigot outer surfaces of the No.2 and No.10 Struts Thrust Mount Brackets which are installed to the Fan Frame Assembly.

(2) Background

This condition has been found on the development engine during the strip inspections after 550 hours endurance test.

It is considered that this condition may also occur on each of the Thrust Mount Brackets of the production engines which are of similar design.

(3) Objective

The changes in configuration recommended in this Service Bulletin are intended to increase the No.2 and No.10 Struts Thrust Mount Brackets durability.

(4) Substantiation

Substantiation test is not required.

(5) Effect of Bulletin on workshop procedures:

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

(6) Supplemental Information

V2500-ENG-72-0045

**SERVICE BULLETIN**

The Inspection/Check of the Post-Service Bulletin configuration requires revision of the Engine Manual under chapter 71-21-11 Inspection/Check to reflect the revised wear limit for the spigot outside diameter of the No.2 and No.10 Thrust Mount Brackets.

C. Description

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

(a) A Dry Film Lubricant with the thickness between 0.0002 and 0.0005in. (0,003 and 0,015 mm.) is coated to the spigot outer surfaces of the No.2 and No.10 Struts Thrust Mount Brackets to prevent the wear during engine operation. (See Figures 1 and 2).

(2) The existing Thrust Mount Brackets can be reworked to the new configurations. (See Figure 2).

(a) If the spigot outside diameter of the Thrust Mount Brackets is between 1.7304 and 1.7313in. (43,950 and 43,975 mm.) at inspection, the Bracket(s) can also be reworked by this Bulletin.

D. Approval

The Part Number changes and/or part modifications described 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 5

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

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) At overhaul	TOTAL 2 hours 24 minutes
(a) To gain access	Not applicable
(b) To embody	

V2500-ENG-72-0045



SERVICE BULLETIN

- (i) To accomplish rework and reidentification of the No.2 and No.10 struts thrust mount brackets 2 hours 24 minutes

TOTAL 2 hours 24 minutes

- (c) Return to modular condition Not applicable

G. Material - Price and Availability

- (1) Modification Kit is not required. Parts supplied as single line items.
- (2) See "Material Information" section for prices and availability of future spares.

H. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

I. Weight and Balance

- (1) Weight change None
- (2) Moment arm No effect
- (3) Datum Engine front mount centreline
(Powerplant Station (P.P.S.) 100)

J. Electrical Load Data

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

K. References

- (1) Internal Reference No.

EC89VJ061

- (2) Other References

V2500 Engine Manual, 71-21-11, Forward Mount Support - Removal, TASK 71-21-11-02-0001, and - Installation, TASK 71-21-11-420-001.

V2500 Standard Practices/Processes Manual, 70-38-03, Surface Treating, TASK 70-380-03-380-501, and 70-09-00, Marking of Parts, TASK 70-09-00-400-501.

V2500-ENG-72-0045



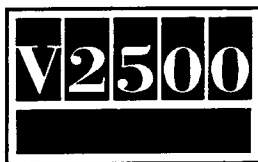
V2500 Overhaul processes and Consumable Index.

L. Other Publications Affected

V2500 Engine Illustrated Parts Catalog, Chapter/Section 71-21-11.

V2500 Engine Manual, 71-21-11, Forward Mount Support - Cleaning, TASK 71-21-11-100-000, TASK 71-21-11-100-003, and - Forward Mount Support - Inspection/Check, TASK 71-21-11-200-003.

V2500-ENG-72-0045



SERVICE BULLETIN

2. Accomplishment Instructions

A. Pre-Requisite Instructions

- (1) Remove 5A8695 and 5A8696, No.2 and No.10 Struts Thrust Mount Brackets by the approved procedures in the Engine Manual, 71-21-11, Removal. (Refer to Figure 1, and 1.K.(1)).
- (2) Examine the each spigot outside diameter on 5A8695 and 5A8696, No.2 and No.10 Struts Thrust Mount Brackets. (Refer to Figure 2).

NOTE: If the spigot outside diameter is between 1.7304 and 1.7313in. (43,950 and 43,975 mm.), send the Bracket(s) also for rework by this Service Bulletin.

If the spigot outside diameter is less than 1.7304in. (43,950 mm.), the Bracket(s) must be rejected.

B. Rework Instructions

Procedure	Supplementary Information
(1) Abrasive blast 5A8695, and 5A8696, No.2 and No.10 Struts Thrust Mount Brackets	Refer to Figure 2, Sheets 1 and 2, and 1.K.(2), 70-38-03, Surface Treating, and 1.K.(3)
(a) Apply CoMat 02-001, Masking Tape or CoMat 02-005, Masking Tape, to the area which is not to be given a layer of the Dry Film Lubricant	
(b) Abrasive blast 5A8695, and 5A8696, No.2 and No.10 Struts Thrust Mount Brackets, with CoMat 05-022, Abrasive Medium, and 40 psi (275 kPa) of the air pressure	
(c) Remove the Masking Tape	
(d) Remove the abrasive grits with a dry blast or a soft brush. Use a vacuum assisted brush to make sure all the grits are removed	

V2500-ENG-72-0045



SERVICE BULLETIN

- (e) Remove the grease with CoMat 01-124, Isopropyl Alcohol, and a clean cloth to clean the coating area
- (2) Apply the Dry Film Lubricant to 5A8695, and 5A8696, No.2 and No.10 Struts Thrust Mount Brackets
- Refer to Figure 2, Sheets 1 and 2, and 1.K.(2), 70-38-03, Surface Treating, and 1.K.(3)
- (a) Apply CoMat 02-019, Heat resistant paper Masking Tape, to the area which is not to be given a layer of the Dry Film Lubricant
- (b) Apply CoMat 10-004, Dry Film Lubricant, and CoMat 07-009, Thinners, to each spigot outside diameter of the Brackets

NOTE: The coating thickness must be between 0.0002 and 0.0005in. (0,003 and 0,015 mm.) all rounds.

- (c) Remove the Masking Tape.
- (d) Stove the No.2 and No.10 Struts Thrust Mount Brackets for two hours between 365 and 383 deg.F. (185 and 195 deg.C.)
- (3) Renumber by the Electrolytic etch adjacent to the existing Part Numbers on each of No.2 and No.10 Struts Thrust Mount Brackets
- Refer to Figure 2, Sheet ? and 1.K.(2), 70-09-00, Marking of Parts
- | | No.2 St. | No.10 St. |
|----------|----------|-----------|
| Existing | 5A8695 | 5A8696 |
| Renumber | 5A0390 | 5A0391 |

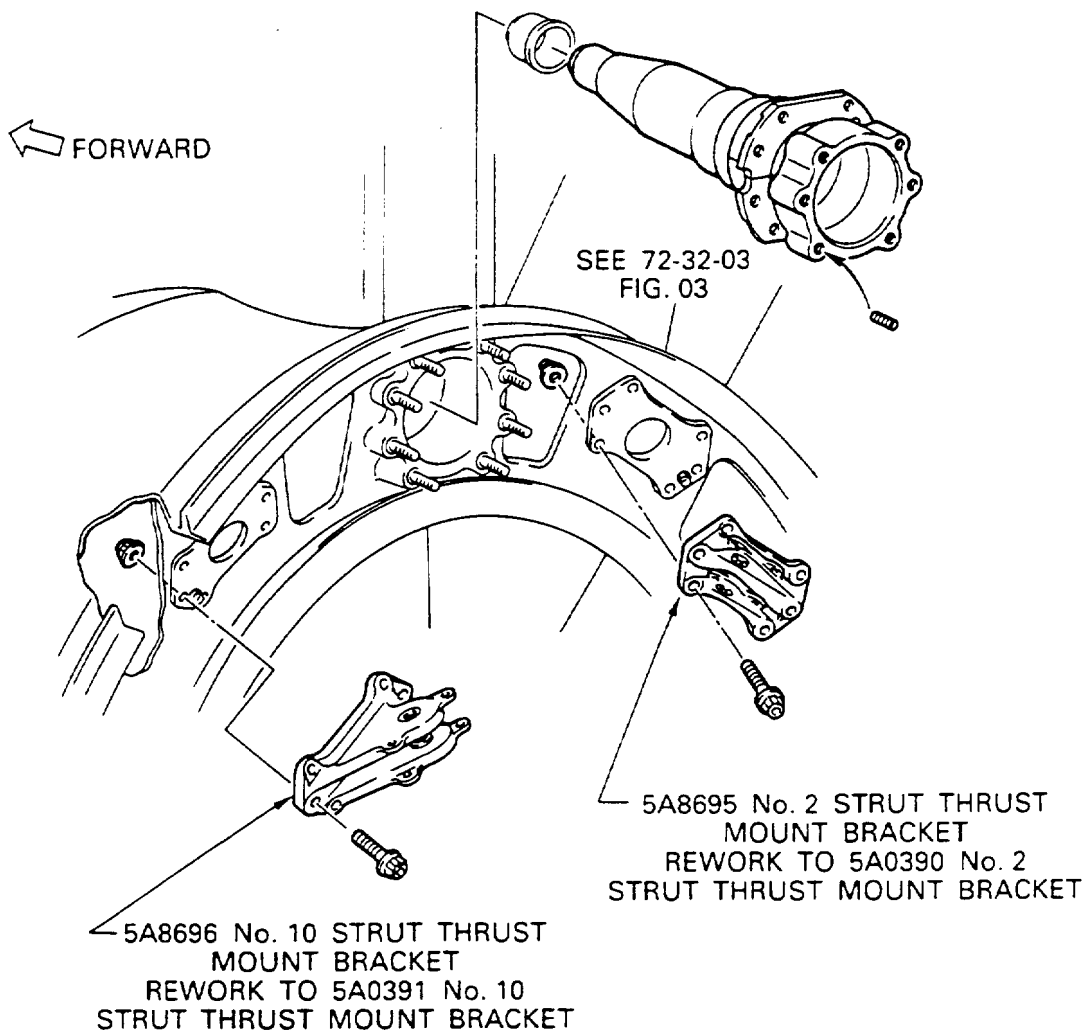
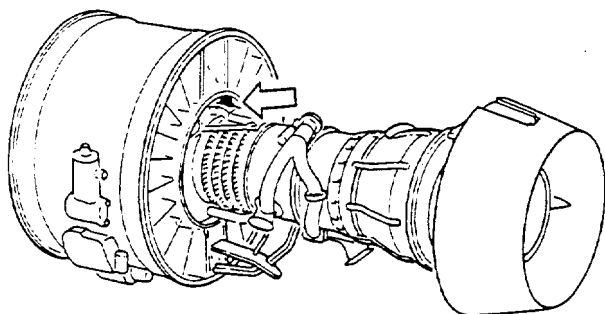
C. Post-Requisite Instructions

- (1) Install new or reidentified 5A0390 and 5A0391, No.2 and No.10 Struts Thrust Mount Brackets by the approved procedures in the Engine Manual, 71-21-11, Installation. (Refer to Figure 1, and 1.K.(1)).

D. Recording Instructions

- (1) A record of accomplishment is necessary.

V2500-ENG-72-0045

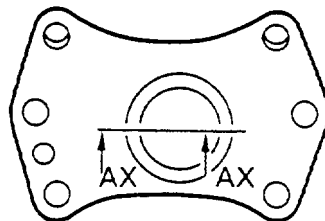
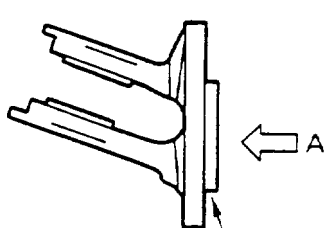


Location of the No.2 and No.10 Struts Thrust Mount Brackets
Fig.1

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SERVICE BULLETIN



VIEW ON A

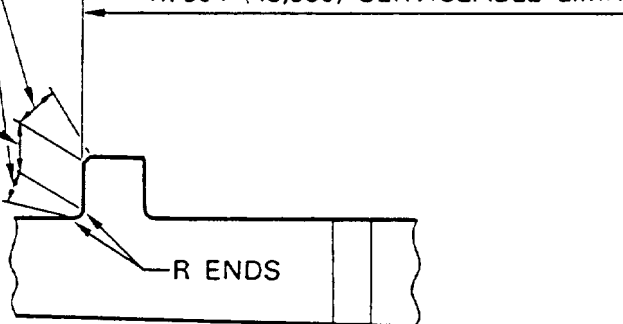
5A8695 No. 2 STRUT THRUST MOUNT BRACKET
APPLY THE DRY FILM LUBRICANT

OVERCOATING OF THE DRY
FILM LUBRICANT IS
PERMITTED ALL ROUNDS.

APPLY THE DRY FILM
LUBRICANT ALL ROUNDS
WITH 0.0002 - 0.0005
in. (0,003 - 0,015 mm)
OF THE COATING
THICKNESS.

DIAMETER BEFORE COATING

1.7319 (43,991)
 \varnothing 1.7313 (43,975)
 \varnothing 1.7304 (43,950) SERVICEABLE LIMIT



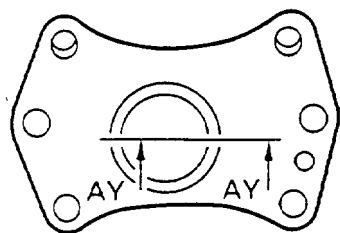
SECTION AX-AX

Rework of the No.2 and No.10 Struts Thrust Mount Brackets
Fig.2 Sheet 1 of 3

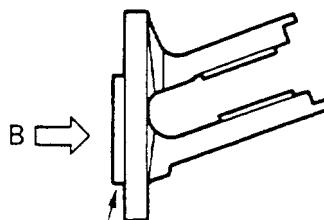
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SERVICE BULLETIN



VIEW ON B



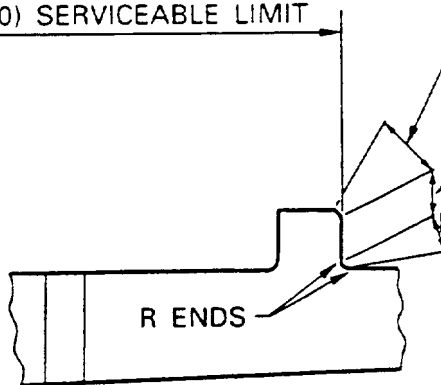
5A8696 No. 10 STRUT THRUST MOUNT BRACKET
APPLY THE DRY FILM LUBRICANT

DIAMETER BEFORE COATING

1.7319 (43,991)

Ø1.7313 (43,975)

Ø1.7304 (43,950) SERVICEABLE LIMIT

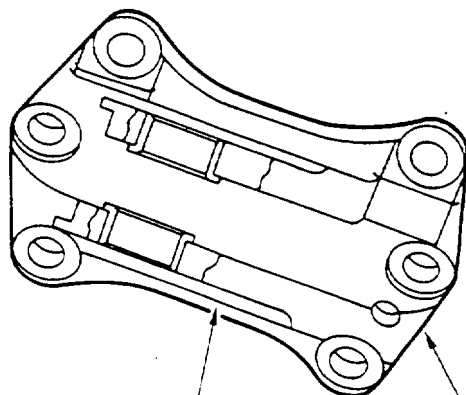


SECTION AY-AY

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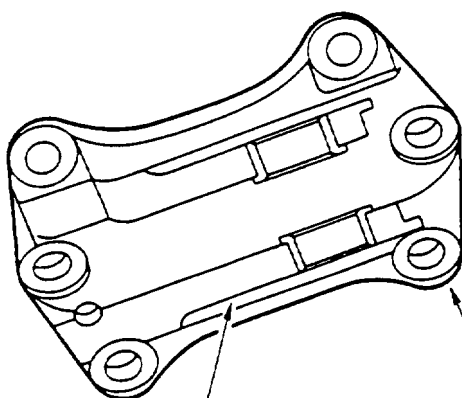
Rework of the No.2 and No.10 Struts Thrust Mount Brackets
Fig.2 Sheet 2 of 3

V2500-ENG-72-0045



5A0390 No.2 STRUT THRUST
MOUNT BRACKET

MARK NEW PN 5A0390 BY ELECTROLYTIC
ETCH ADJACENT TO OLD PN 5A8695
IDENTIFIED HERE.
MARK TWO LINES (==) ON THE OLD PN
WITH ELECTROLYTIC ETCH TO ERASE IT.

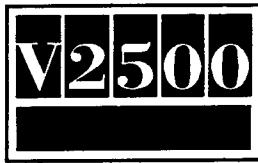


5A0391 No.10 STRUT THRUST
MOUNT BRACKET

MARK NEW PN 5A0391 BY ELECTROLYTIC
ETCH ADJACENT TO OLD PN 5A8696
IDENTIFIED HERE.
MARK TWO LINES (==) ON THE OLD PN
WITH ELECTROLYTIC ETCH TO ERASE IT.

Rework of the No.2 and No.10 Struts Thrust Mount Brackets
Fig.2 Sheet 3 of 3

V2500-ENG-72-0045



SERVICE BULLETIN

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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Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

5A0390 (71-21-11)	1	2,259.00	.Bracket, A/O T/Mount No.2 Strut	5A8695 (01-500)	(A)(B)(S1) (1D)
5A0391 (71-21-11)	1	2,259.00	.Bracket, A/O T/Mount No.10 Strut	5A8696 (01-700)	(A)(B)(S1) (1D)

C. Instruction/Disposition Code Statements:

- (A) New part is currently available for sale.
- (B) Old part is no longer available for sale.
- (S1) Old and new parts are freely and fully interchangeable, both physically and functionally.
- (1D) Old part can be reworked and reidentified to the New Part Number.

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.

V2500-ENG-72-0045

