



ENGINE - LP TURBINE MODULE AND EXHAUST GAS TEMPERATURE (EGT) INDICATING SYSTEM -
PROVIDE RECONTOURED EGT BRACKETS AND DOUBLE HEXAGONAL HEADED NUTS - CATEGORY CODE 5 -
MOD.ENG-72-0050

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines before Serial No.V0107 except V0100, V0102 and V0104.

B. Reason

(1) Condition

The present configuration EGT Brackets on Flange P at hole location 52, 53, 62 and 63 has contact with the Hold-Open Rod Brackets for the C-Ducts.

(2) Background

The condition described occurred and were found during the flight test portion of the Compliance Engine Program.

(3) Objective

To provide a new design for the bracket arrangement on the EGT Brackets to clear the contact with the C-Duct Hold Rod brackets.

(4) Substantiation

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

(6) Supplemental Information

None

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C. Description

- (1) Interference between the EGT Brackets (at Flange P hole locations 52, 53, 62 and 63) and Hold Open Rod Brackets for the C-Ducts is removed as follows:
- (a) Two new brackets are provided to attach the Harness at the locations specified.
 - (b) New Nuts are provided to attach the Loop Clamp Brackets to the Flange P.

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 assemblies.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) In shop	TOTAL 27 minutes
(a) To gain access	14 minutes
TOTAL	14 minutes
(b) To embody	Not applicable (No rework carried out)
(c) To return to modular condition	13 minutes
TOTAL	13 minutes



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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

I. Weight and Balance

- | | |
|-------------------|---|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front mount centerline
(Powerplant Station (PPS) 100) |

J. Electrical Load Data

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

K. References

- (1) Internal Reference No.

89VA089

- (2) Other References

V2500 Service Bulletin Numbers

- (a) V2500-ENG-77-0002 (Engine - LP Turbine Module and Exhaust Gas Temperature (EGT) Indicating System Replacement of EGT Loop Clamp Brackets and Attaching Bolts).

V2500 Standard Practises Manual

L. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-50-00, Figure 01 to add the new parts.
- (2) V2500 Engine Manual Chapter/Section 72-50-00, Cleaning, to add the new parts.
- (3) V2500 Engine Manual Chapter/Section 72-50-00, Inspection/Check, to add the new parts.

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2. Accomplishment Instructions

A. Rework Instructions

- (1) There are no rework instructions necessary for this Service Bulletin.

B. Assembly Instructions

- (1) Remove the Nuts and Bolts which hold the two Loop Clamps to the Loop Clamp Brackets 2A2004 and 2A2005. Keep the Nuts and Bolts.

NOTE: Do a check of the Brackets to make sure that the 2A2050 Loop Clamp Bracket was not installed before.

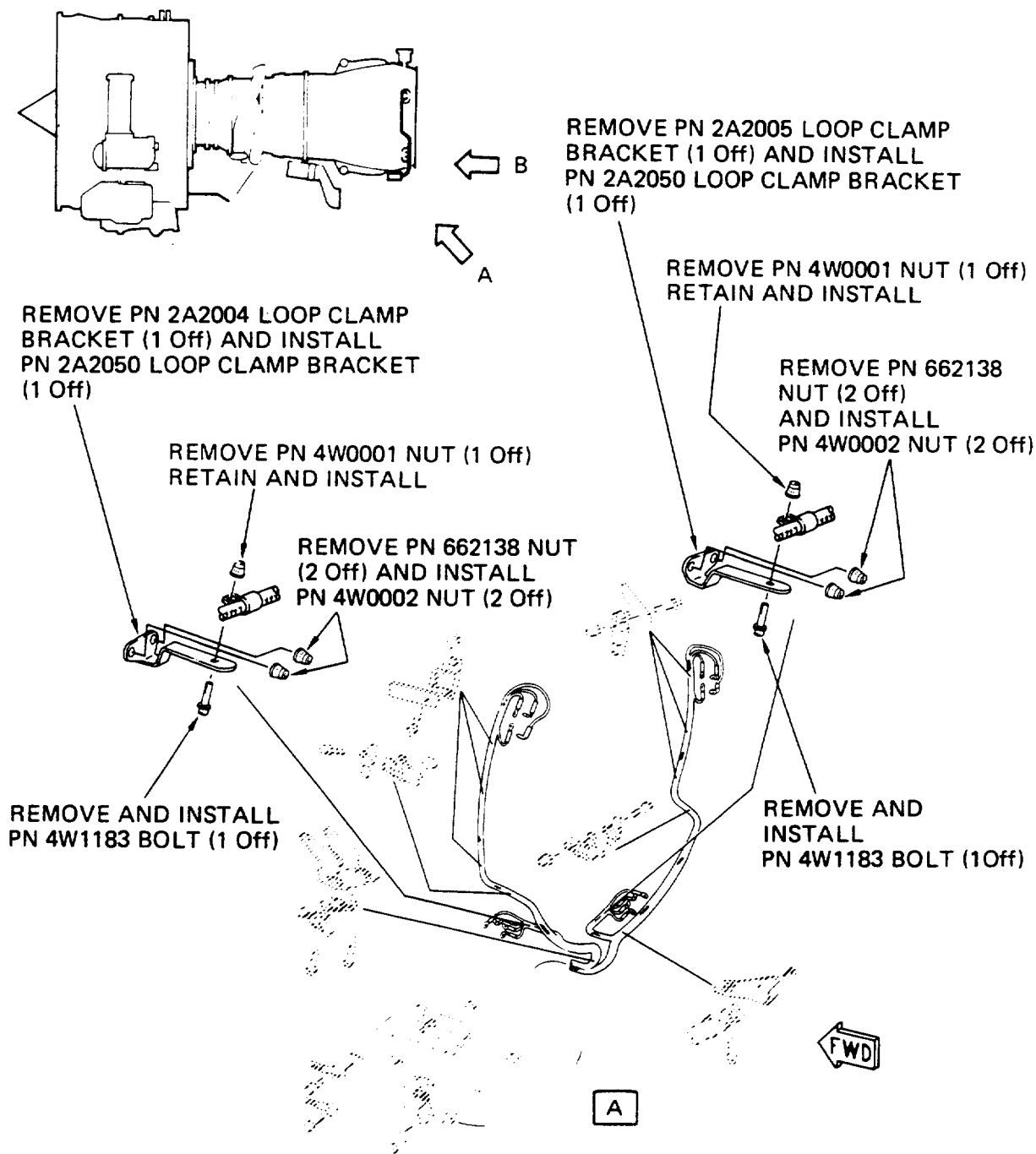
- (2) Remove the Nuts and Bolts which hold the 2A2004 and 2A2005 Loop Clamp Brackets to the Turbine Exhaust Case (Hole Locations 52, 53, 62 and 63). See Reference (1).
- (3) Remove the Loop Clamp Brackets.
- (4) Lubricate the threads of the 4W0002 Nuts (4 off) and Bolts (which will hold the Brackets to the flange) with CoMat 10-039 Engine Oil.
- (5) Put the 2A2050 Loop Clamp Bracket (1 off) at the location of holes 62 and 63. Refer to Figure 1.
 - (a) Make sure that the bracket mount flange is forward of Flange P.
- (6) Install the Nuts and Bolts and tighten them with your hand.
- (7) Put the 2A2050 Loop Clamp Bracket (1 off) at the location of holes 52 and 53. Refer to Figure 1.
 - (a) Make sure that the bracket mount flange is forward of flange P.
- (8) Install the Nuts and Bolts and tighten them with your hand.
- (9) Torque the Bolts to between 85 to 105 lbfin (9,60 to 11,86 Nm). See Reference (2) Chapter/Section 70-41-00, Torque Tightening Technique.
- (10) Move the Loop Clamps so the bolt holes in the Clamps align with the bolt holes in the Loop Clamp Brackets.
- (11) Lubricate the threads of the two Bolts and the two Nuts removed in step (1), with CoMat 10-039 Engine Oil.
- (12) Install the Bolts and the Nuts and tighten them with your hand.
- (13) Torque the Bolts to between 36 to 45 lbfin (4,07 to 5,08 Nm). See Reference (2), Chapter/Section 70-41-00, Torque Tightening Technique.

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C. Recording Instructions

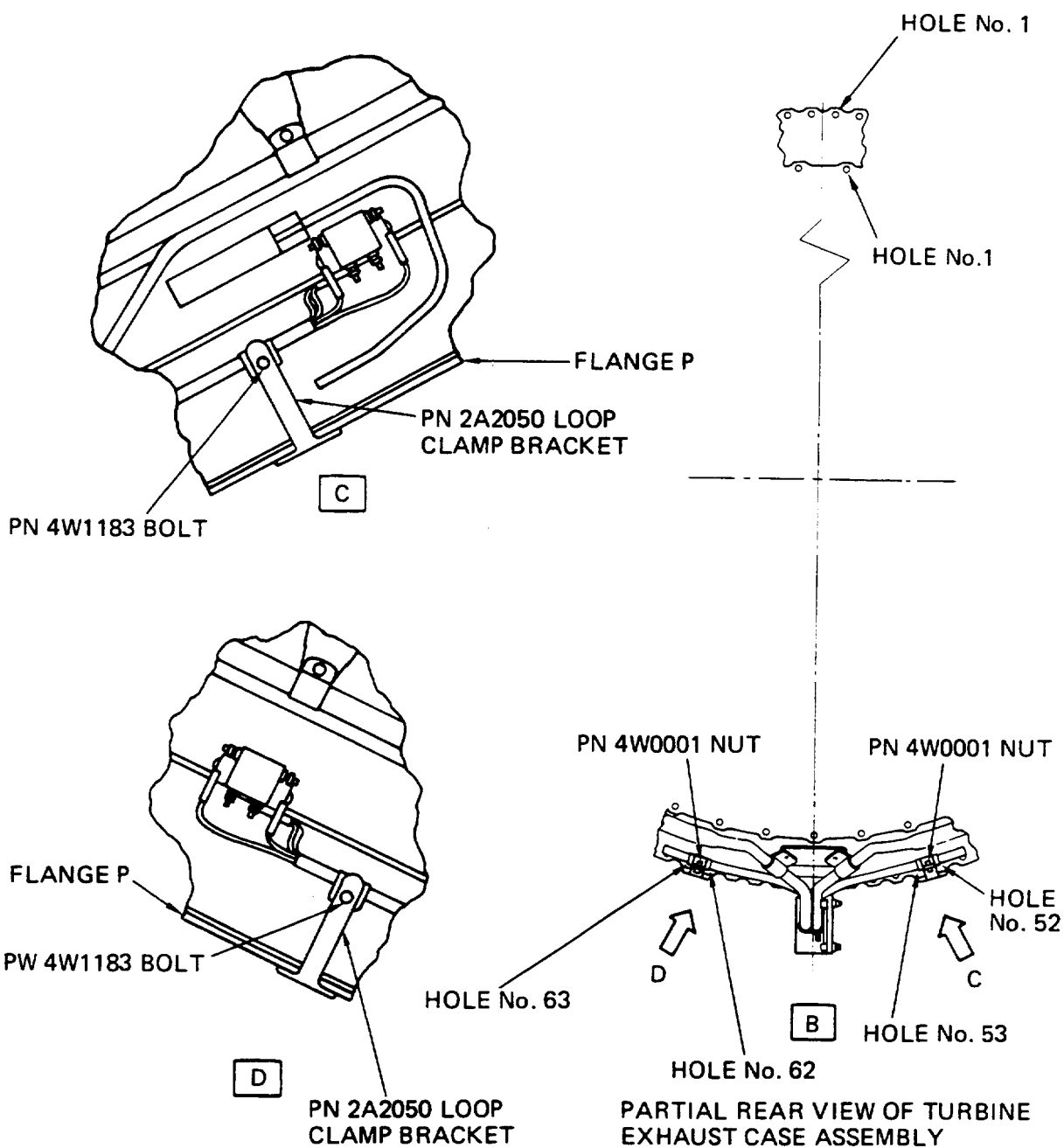
- (1) A record of accomplishment is necessary.



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Replacement of loop clamp brackets and attaching nuts
Fig.1 (Sheet 1 of 2)

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Replacement of loop clamp brackets
Fig.1 (Sheet 2 of 2)

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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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Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

- (72-50-00)	1		Bracket - Loop Clamp	2A2004 (01-410)	(A)
- (72-50-00)	1		Bracket - Loop Clamp	2A2005 (01-400)	(A)
2A2050 (72-50-00)	1	38.90	Bracket - Loop Clamp	- (01-400) (01-410)	(B)
- (72-50-00)	4		Nut Option Consisting of Nut Nut Nut Nut	662138 (01-055) 662139 662140 662141 662142	(A)
4W0002 (72-50-00)	4	6.11	Nut Option Consisting of:	- (01-050)	(B)
AS20625			Nut		
AS3066-10			Nut		
AS3067-10			Nut		
AS3068-10			Nut		
AS3069-10			Nut		
AS3070-10			Nut		

C. Instruction/Disposition Code Statements:

- (A) Old part will no longer be available.
(B) New part is currently available.

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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