



SERVICE BULLETIN

ENGINE - GENERAL - PROVIDE VARIOUS REPLACEMENT EXTERNAL TUBES WITH RELOCATED TUBE SLEEVES - CATEGORY CODE 7 - MOD.ENG-72-0053

1. Planning InformationA. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines, Prior to Serial Number V0107

B. Reason

(1) Condition

Several tubes on the LPT casing may not have sufficient clearance at some clipping points.

(2) Background

The sleeves of several tubes on the LPT casing have been found misaligned with the lugs at their clipping points. Inadequate clearance may occur among LPT ACC manifold, other tubes, and EGT harness.

(3) Objective

To prevent the tubes LPT ACC manifold and EGT harness from possible interference.

(4) Substantiation

Substantiation has been completed by analysis.

(5) Effect of Bulletin on workshop procedure

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

(6) Supplemental Information

- (a) The removal and installation of the Post-Service Bulletin Configuration parts are different, because several clipping points are deleted, changed and newly introduced. V2500 Engine Manual, 72-00-50, LP Turbine Module Components, External Harnesses and Tubes.

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**SERVICE BULLETIN****C. Description**

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

- (a) 5R8083 tube (71-73-49, 01-500), 5A8749 tube (73-22-49, 01-100) and 5R8225 tube (79-21-49, 16-100) have been re-routed with the relocated sleeves. Refer to section 2: Figures 1, 2 and 3.
- (b) The existing clipping points, CP5524, CP5525, CP5526, CP5547, CP5735, CP5736 and CP5737 have been deleted. Refer to section 2: Figures 5, 9, 11, 12, 13, 16 and 17.
- (c) New clipping points, CP6050, CP6051, CP6052, CP6053, CP6054 and CP6055, have been introduced in place of the deleted clipping points. Refer to section 2: Figures 10, 18, 19, 20, 21 and 22.
- (d) The clipping configurations at CP5201, CP5206, CP5523, CP5549 and CP5734 have been slightly changed. Refer to section 2: Figures 5, 6, 7, 8, 14 and 15.

(c) The existing 5W8393 bracket (72-50-00, 01-370) has been changed to the new bracket to hold the P4.9 pressure rake tube and the oil weep tube at CP5201. The existing 5W8393 bracket holds both tubes at CP5737 and at CP5201. refer to section 2: Figure 4.

(2) The changes must be accomplished as a complete set per engine.

(3) The new parts will be available for future replacement purposes.

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 7

Accomplish when supply of superseded parts has been depleted.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) At Overhaul	Not applicable

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Remarks: No additional time required to maintain the new configuration.

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 Not affected.
- (3) Datum Engine front mount centreline PPS 100

J. Electrical Load Data

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

K. References

- (1) Internal Reference No.

EC88VJ374

EC88VJ374A

EC88VJ374B

EC88VJ631

EC89VR038

EC90VR014

EC90VR014A

- (2) Other References

V2500 Illustrated Parts Catalog, Chapter/Section 71-52-45, 71-73-49, 72-50-00, 73-22-49 and 79-21-49.

V2500 Engine Manual, 72-00-50, LP Turbine Module components, External Harnesses and Tubes - Removal and Installation.

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V2500 Standard Practices/Processes Manual, 70-41-00, Torque Tightening Technique.

V2500 Overhaul Processes and Consumables Index.

L. Other Publications Affected

- (1) V2500 Illustrated Parts Catalog will be revised to add the new parts. Affected Chapter/Sections are as follows:

71-52-45, 71-73-49, 72-50-00, 73-22-49, 79-21-49
- (2) V2500 Powerplant Illustrated Parts Catalog will be revised to add the new parts. Affected Chapter/Sections are as follows:

71-52-45, 71-73-49, 72-50-00, 73-22-49, 79-21-49
- (3) V2500 Component Maintenance Manual will be revised to add the new parts for cleaning, Inspection/Check and Repair. Affected Chapter/Sections are as follows:

71-73-49, 72-50-00, 73-22-49, 79-21-49
- (4) V2500 Engine Manual, Removal and Installation, will be reviewed to show new clippings. Affected Chapter/Section is as follows:

72-00-50



2. Accomplishment Instructions

A. Rework Instructions

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

B. Installation Instructions

- NOTE:
- (a) All joint faces of the tubes shall be checked visually to ensure that they are free from damage or foreign matter.
 - (b) Torque shall be applied to avoid any distortion to connected parts.
 - (c) The relationship of tube clips and securing points shall allow the attachment bolts to be inserted when the tube is fixed by hand without permanently distorting the assembly.
- (1) Install new 5W8392 bracket to the engine. Refer to Figure 4.
 - (2) Put new 5R8143 tube in position on the engine. Refer to Figure 1.
 - (a) Connect new 5R8143 tube to 5R8226 tube and the LP turbine case connector.
 - (b) Torque the tube nuts to 159 to 177 lbfin (18 to 20 Nm) and safety with CoMat 02-126 lockwire.
 - (3) Put new 5A8793 tube in position on the engine. Refer to Figure 2.
 - (a) Connect new 5A8793 tube to the pipe adaptor and 5A9060 tube.
 - (b) Torque the two tube nuts to 159 to 177 lbfin (18 to 20 Nm) and safety with CoMat 02-126 lockwire.
 - (4) Put new 5R8142 tube in position on the engine. Refer to Figure 3.
 - (a) Connect new 5R8142 tube to the outer oil feed tube. Put AS42704 gasket in the correct position.
 - (b) Install 4W0168 bolts (3 off) and 4W0002 nuts (3 off).
 - (c) Torque the nuts to 85 to 105 lbfin (10 to 12 Nm).
 - (d) Torque the tube nut to 230 to 248 lbfin (26 to 28 Nm) and safety with CoMat 02-126 lockwire.
 - (5) Install the clips, bolts, washers, spacers, nuts and clip nuts at the clipping points as follows:



- (a) At CP5201, install 4W0043 clip nuts, 5W1109 clips (2 off), 5W1086 washer and 4W0104 bolt, to the new 5W8392 bracket, the oil weep tube and the P4.9 pressure rake tube. Refer to Figure 6.
- (b) At CP5734, install 4W0001 nut, ST1455-07 or TA0210046FT07 clip, 5W1086 washer and new 4W0102 bolt, to the lug on P4.9 pressure rake tube and the EGT harness. Refer to Figure 15.
- (c) At new CP6055, install new 4W0001 nut, new ST1455-05 or TA0210046FT05 clip, new 5W1086 washer and new 4W0102 bolt, to the lug on P4.9 pressure rake tube. Refer to Figure 22.
- (d) At CP5523, install 4W0043 clip nut, 3A0813 clips (2 off), 5W1109 clips (2 off), new 5W1030 spacer, new ST1455-05 or TA0210046FT05 clip, 5W1086 washer and new 4W0116 bolt, to the LPT ACC tubes, the oil weep tube, the P4.9 pressure rake tube and the EGT harness. Refer to Figure 8.
- (e) At new CP6053, install new 4W0001 nut, new ST1455-05 or TA0210046FT05 clip, new 5W1086 washer and new 4W0102 bolt, to the lug on P4.9 pressure rake tube and the EGT harness. Refer to Figure 21.
- (f) At new CP6051, install new 4W0001 nut, new 5W1109 clip, 5W1030 spacer, new ST1455-05 or TA0210046FT05 clip, new 5W1086 washer and new 4W0110 bolt, to the lug on oil weep tube, the P4.9 pressure rake tube and the EGT harness. Refer to Figure 20.
- (g) At new CP6052, install new 4W0001 nut, new 5W1031 spacer, new ST1455-05 or TA0210046FT05 clip, new 5W1086 washer and new 4W0112 bolt, to the lug on P4.9 pressure rake tube and the EGT harness. Refer to Figure 20.
- (h) At CP5549, install 4W0001 nut, new 5W1030 spacer, ST1455-05 or TA0210046FT05 clip, 5W1086 washer and new 4W0109 bolt to the lug on P4.9 pressure rake tube and the EGT harness. Refer to Figure 14.
- (i) At CP5206, install 5W1110 clip, 4W0043 nut, 5W1086 washer and new 4W0102 bolt to the bracket and the No.5 oil feed tube. Refer to Figure 7.
- (j) At new CP6050, install new 5W1109 clip, new 4W0001 nut, new 5W1086 washer and new 4W0103 bolt to the lug on the No.5 oil feed tube and the No.4 oil weep tube. Refer to Figure 10.
- (k) At new CP6054, install new 5W1086 washer, new TA0210046FT05 or new ST1455-05 clip, new 4W0001 nut and new 4W0102 bolt to the lug on the No.4 oil weep tube and the harness. Refer to Figure 21.

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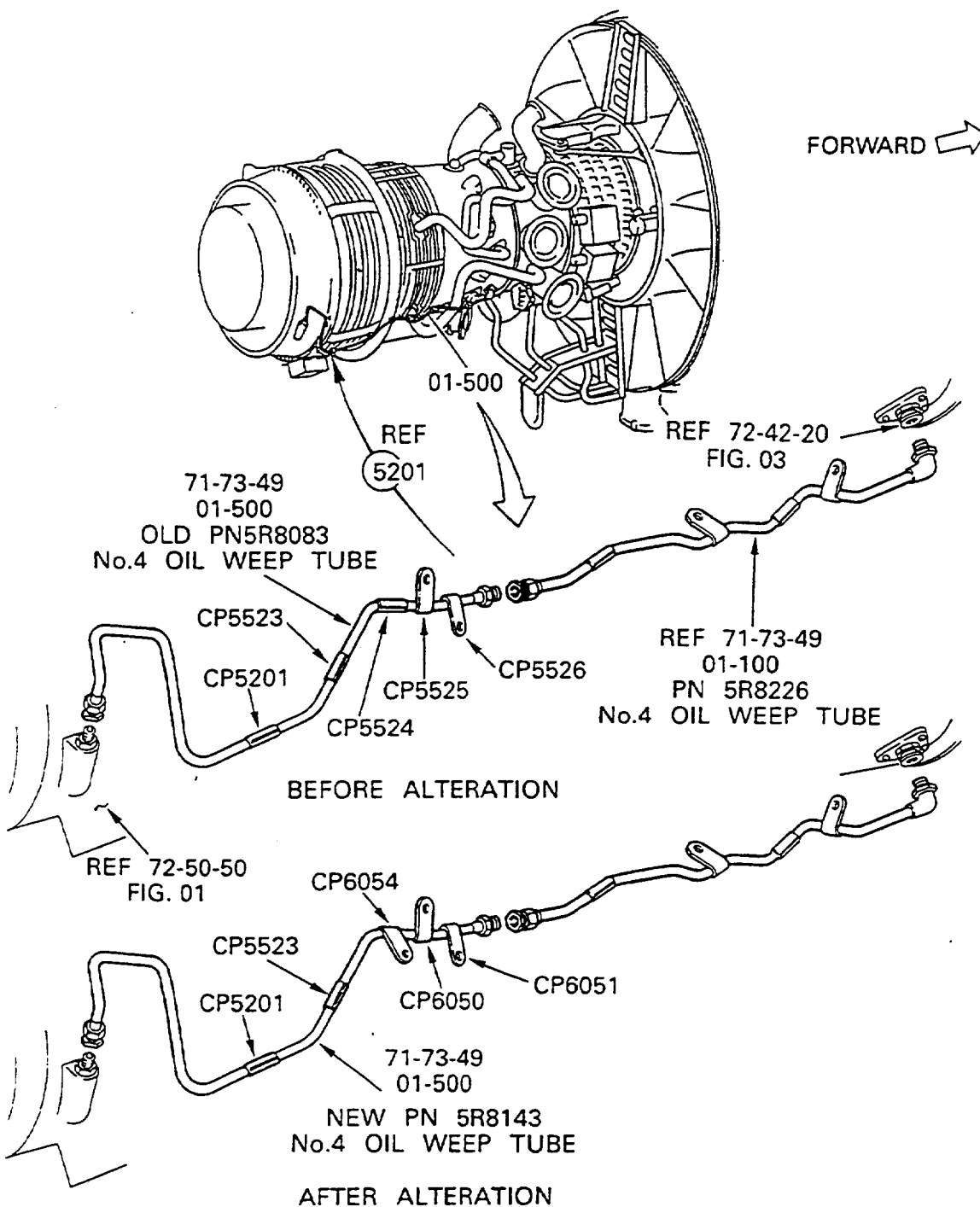
- (l) Torque each bolt or nut to 36 to 40 lbfin (4.07 to 4.52 Nm) at the clipping points CP5201, CP5734, CP6055, CP5523, CP6053, CP6051, CP6052, CP5549, CP5206, CP6050 and CP6054. Refer to 1.K.(3).

C. Recording Instructions

- (1) A record of accomplishment is necessary.



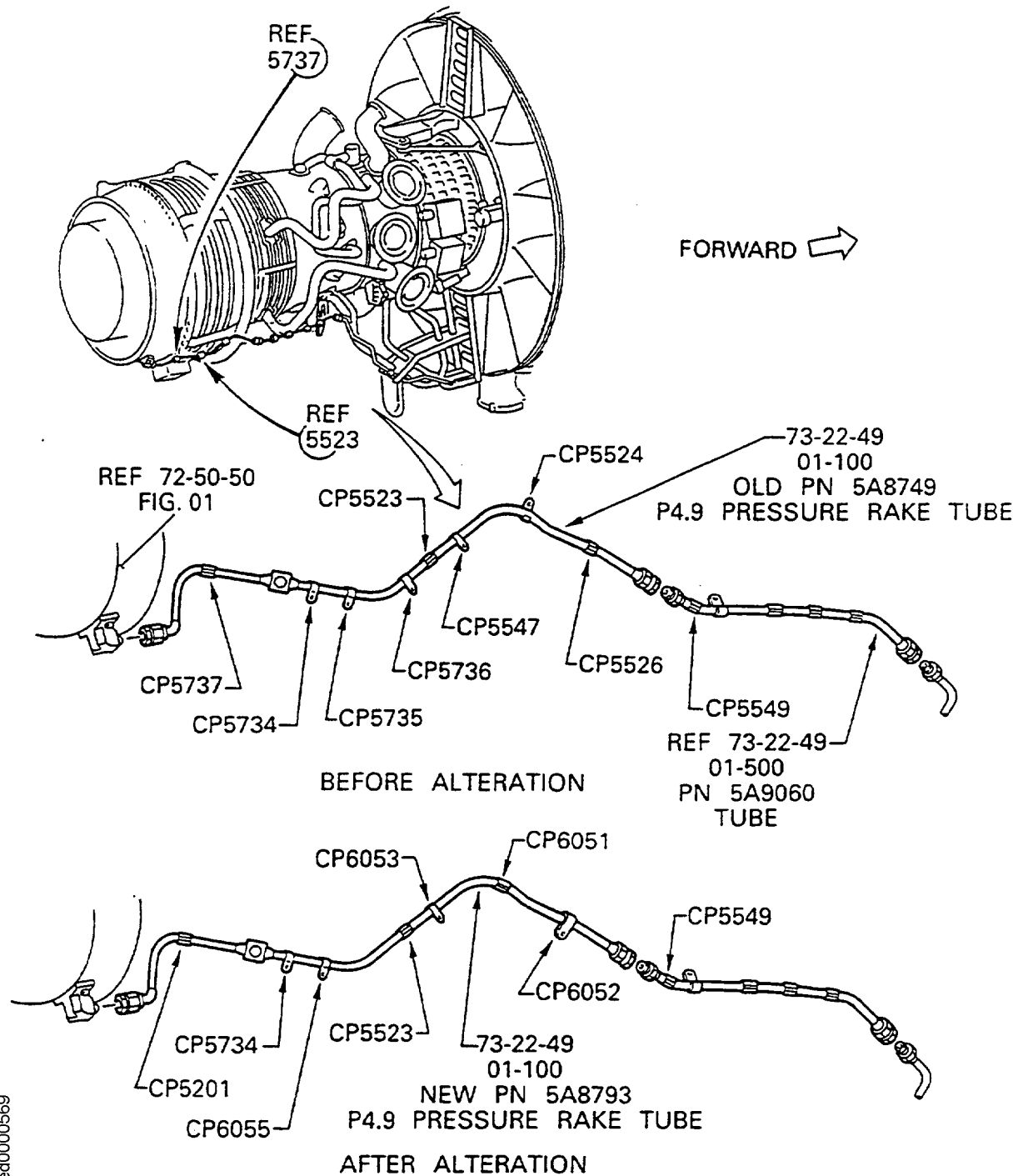
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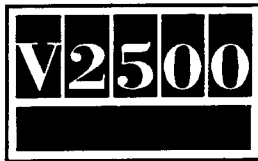
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No.4 oil weep tube (oil hydraulic and water drain tube) Before and after alteration
Fig.1

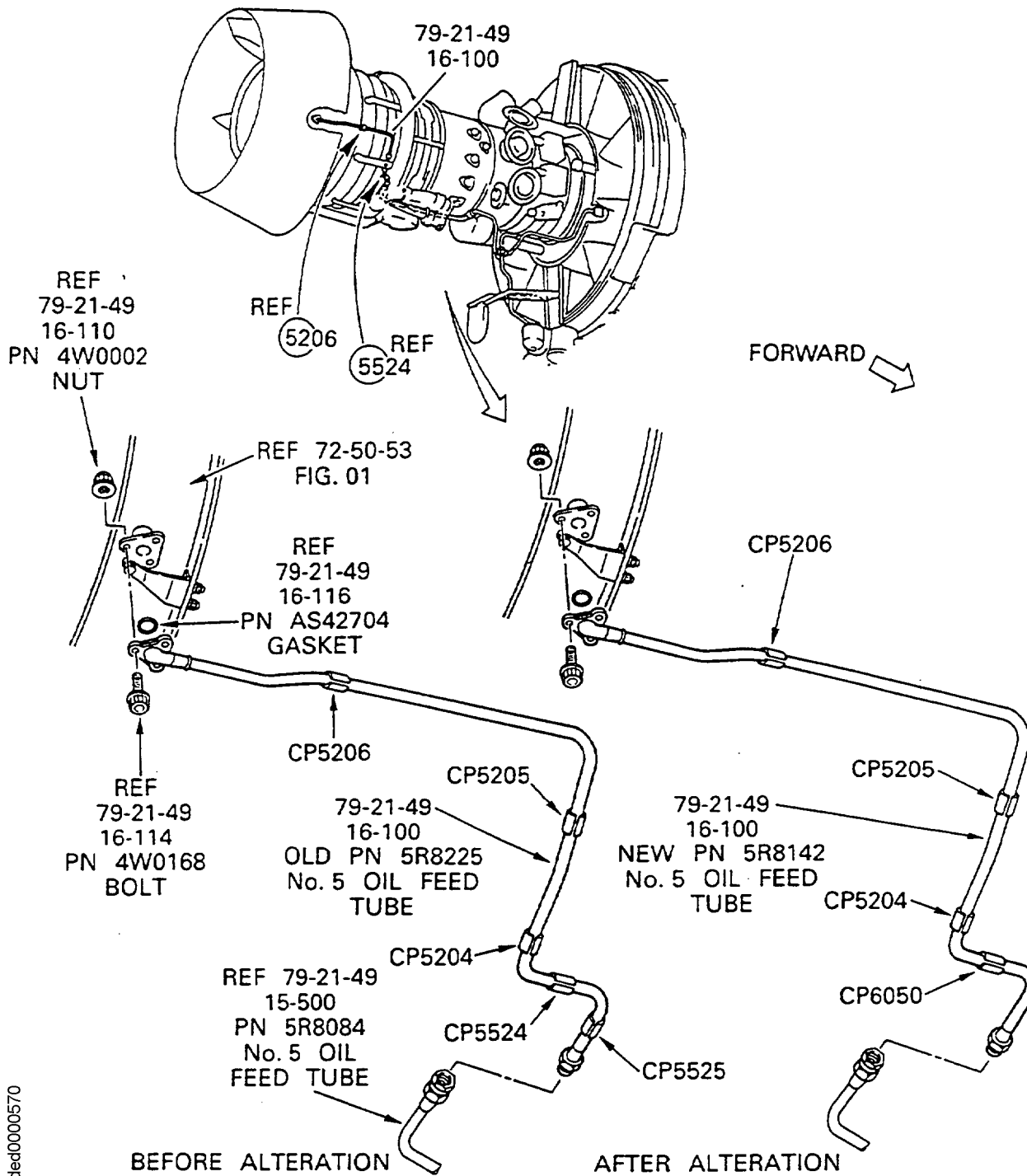
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P4.9 pressure rake tube (fuel system air tubes) Before and after alteration
Fig.2

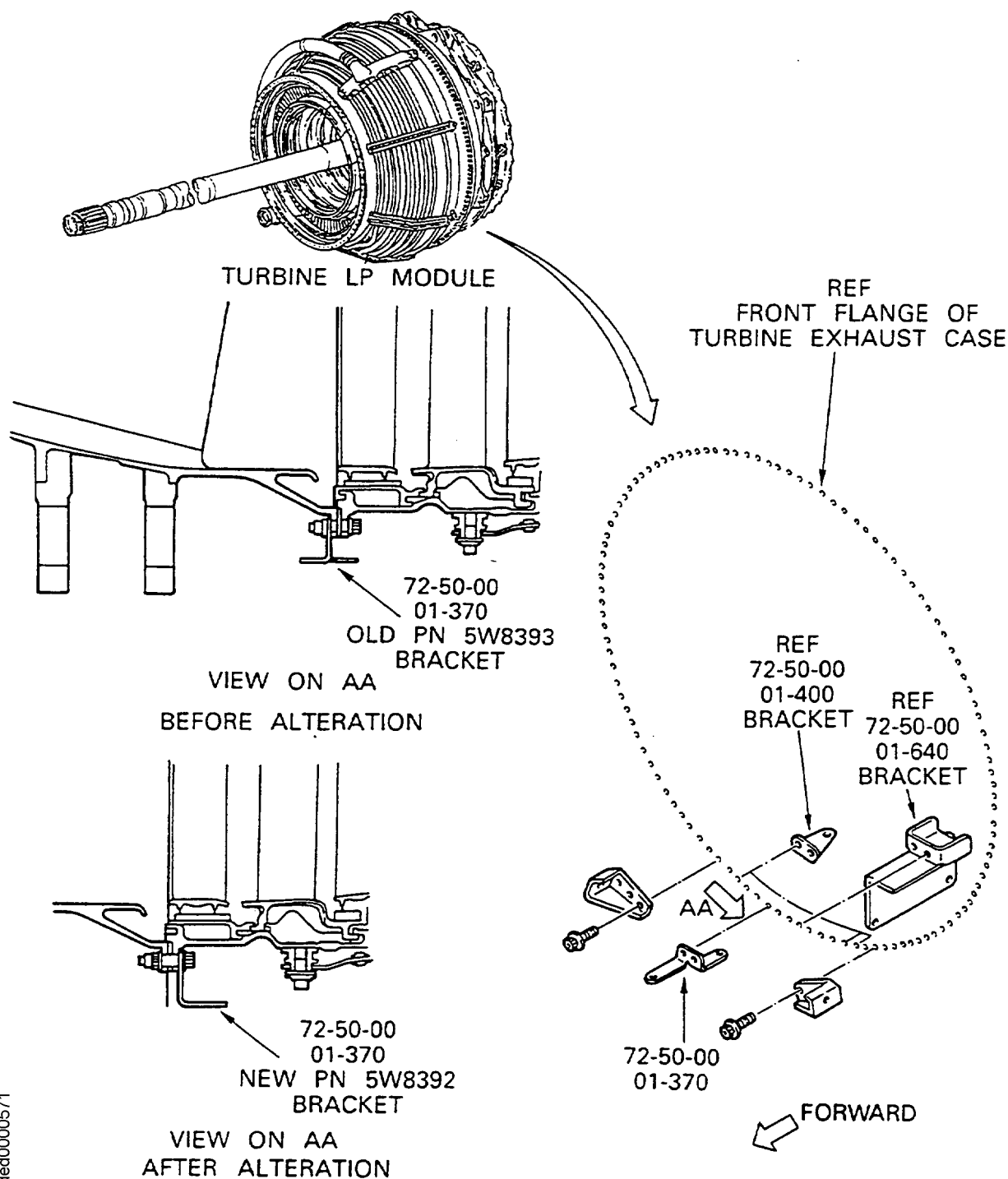


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No.5 oil feed tube (pressure oil tubes - engine) Before and after alteration
Fig.3

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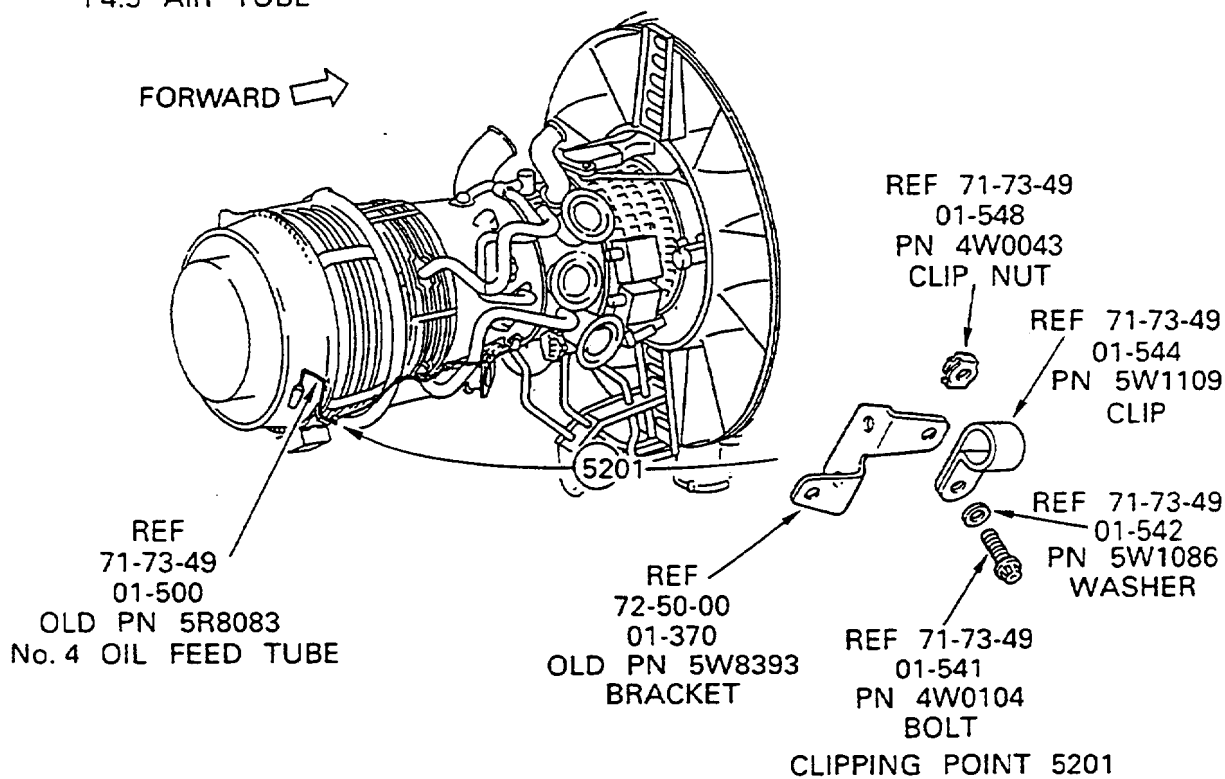
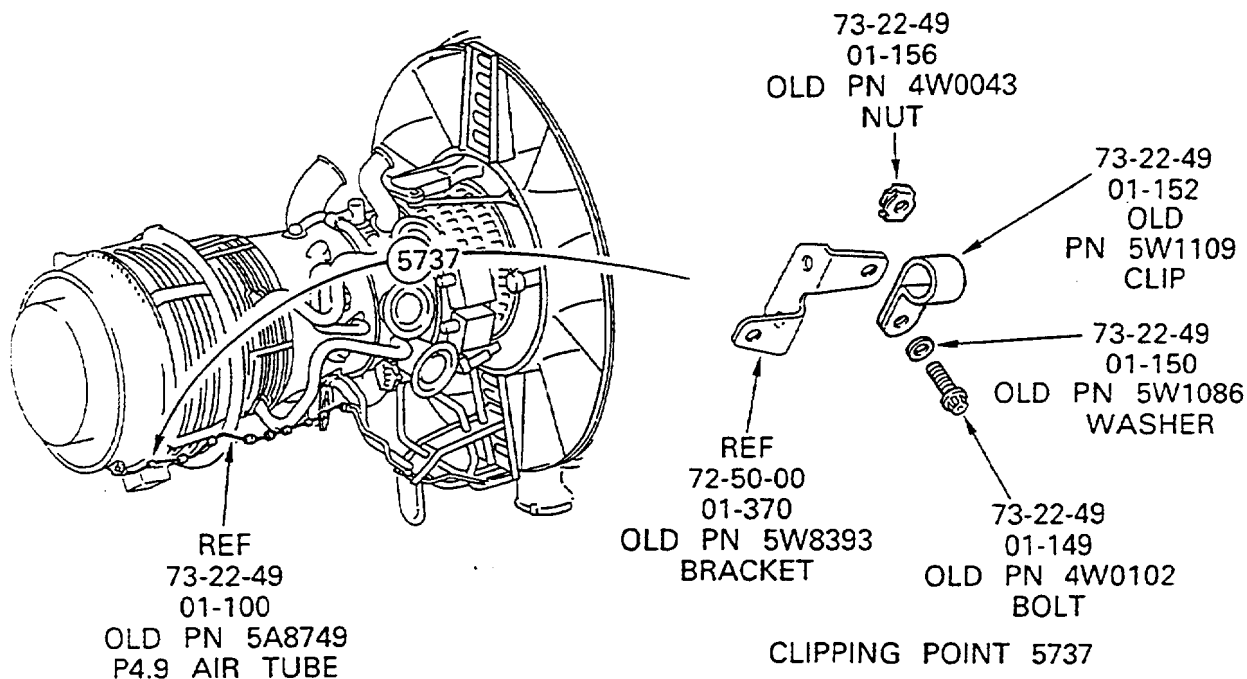
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Bracket - Turbine, LP module Before and after alteration
Fig.4



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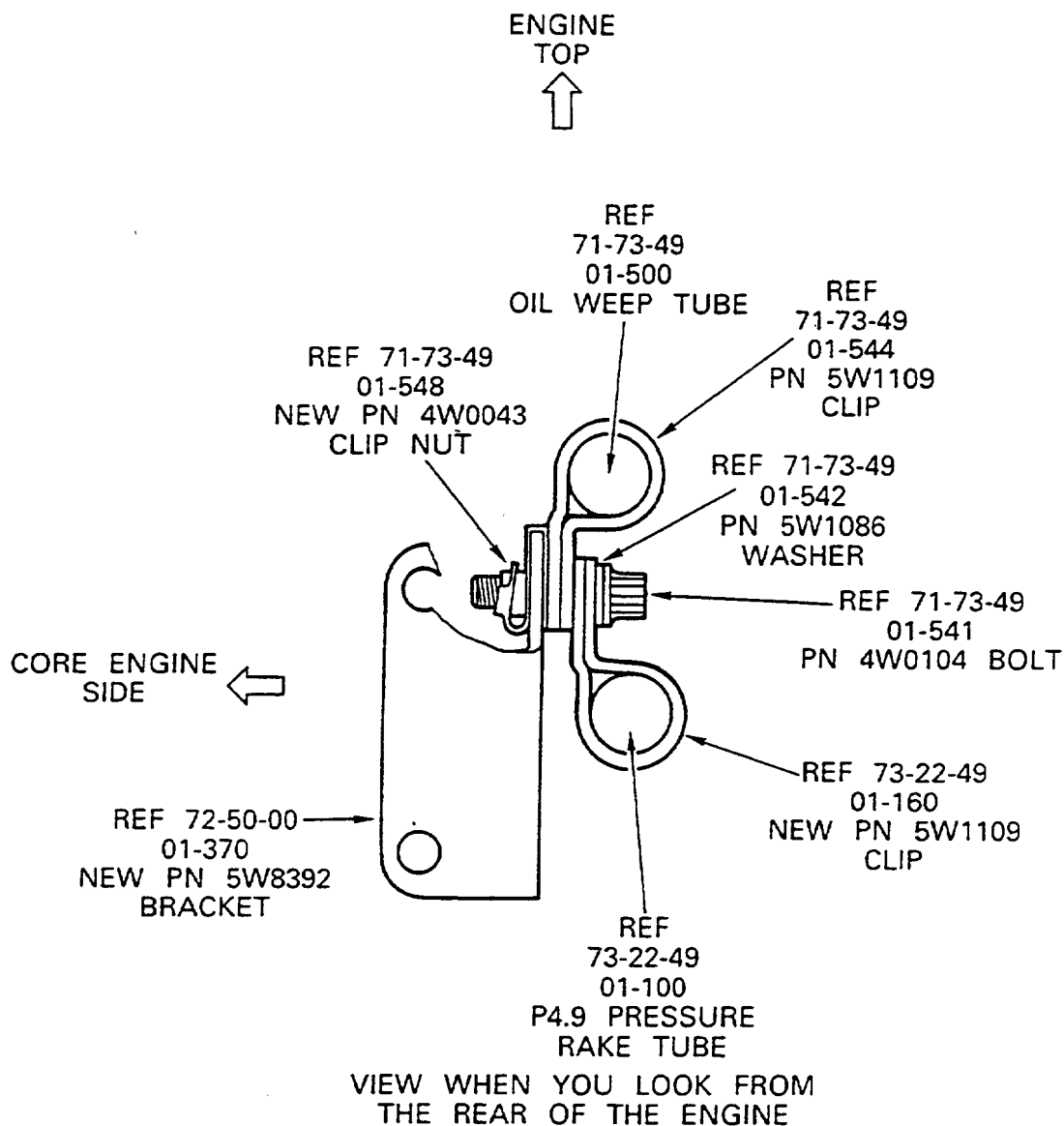
Clipping points 5201 and 5737 Before alteration
Fig.5

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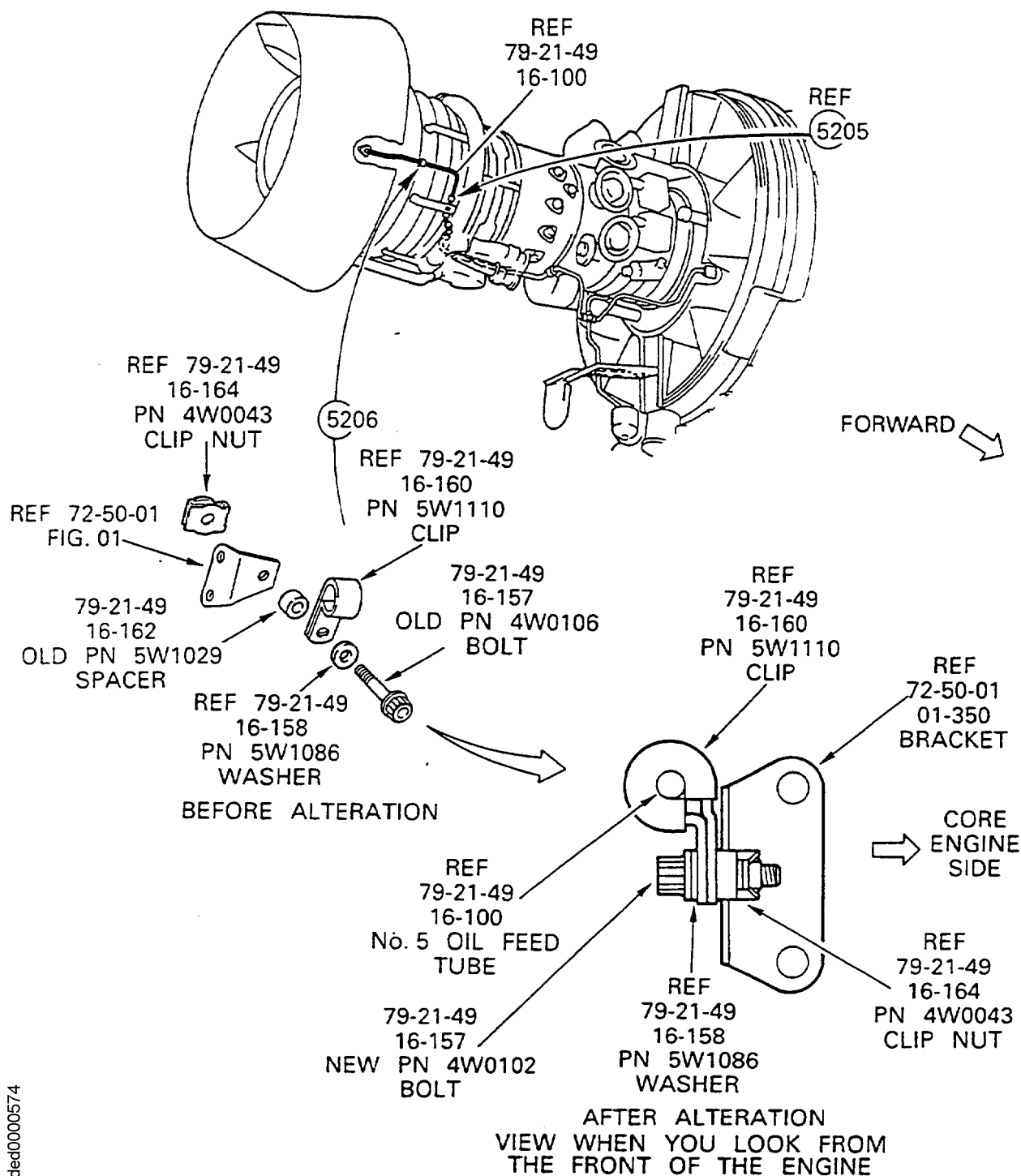
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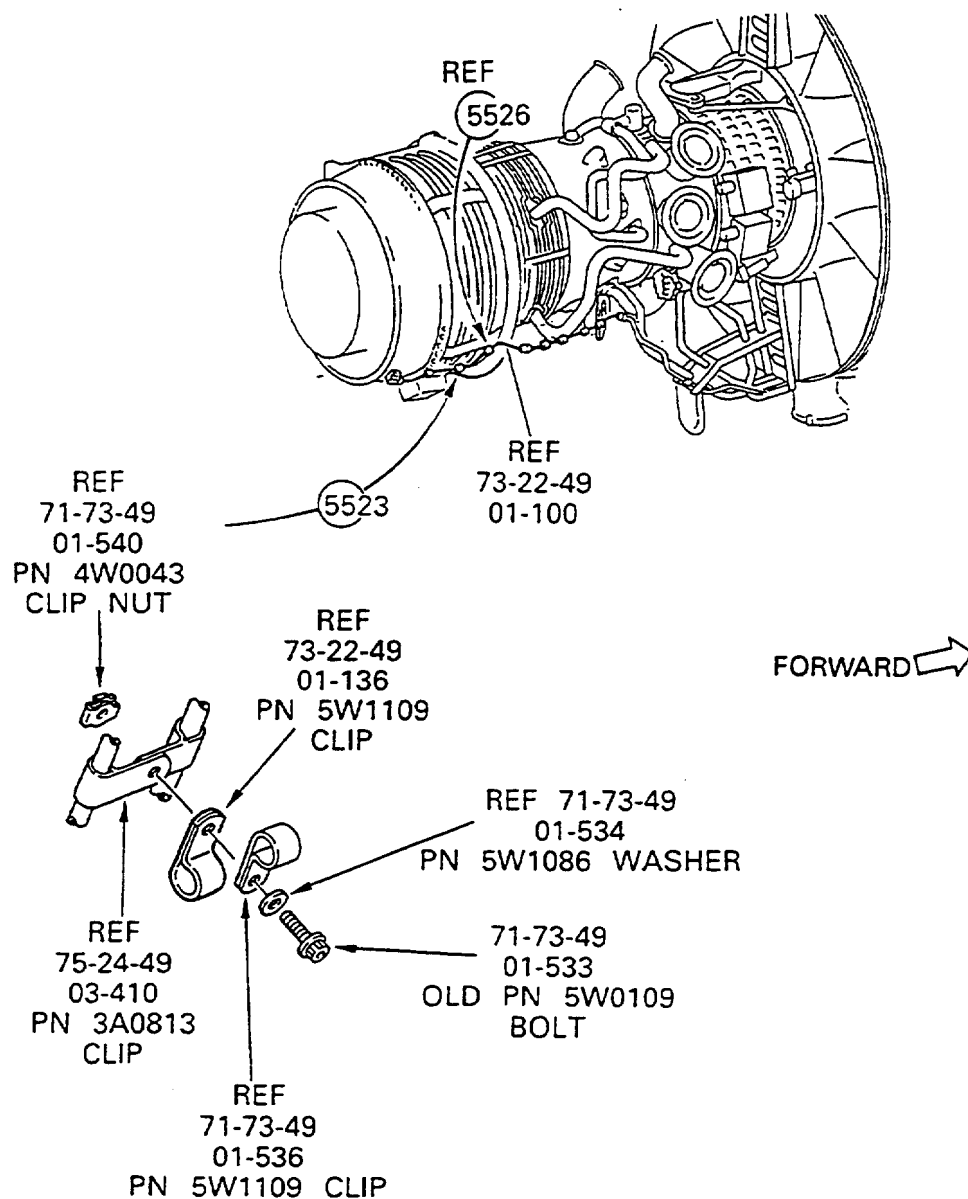
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Clipping point 5201 - After alteration
Fig.6

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Clipping point 5206 - Before and after alteration
Fig.7



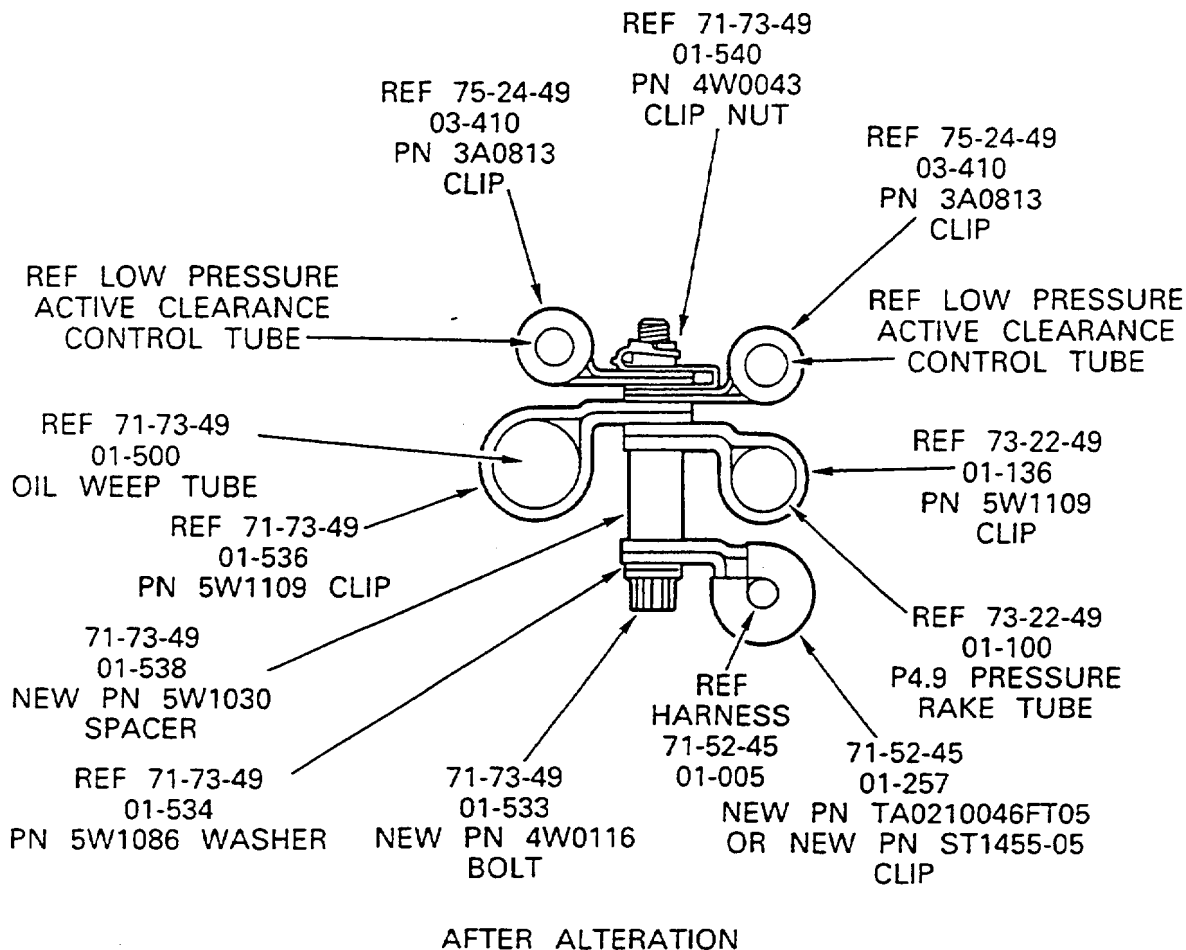
BEFORE ALTERATION

Clipping point 5523 - Before and after alteration
Fig.8 Sheet 1 of 2

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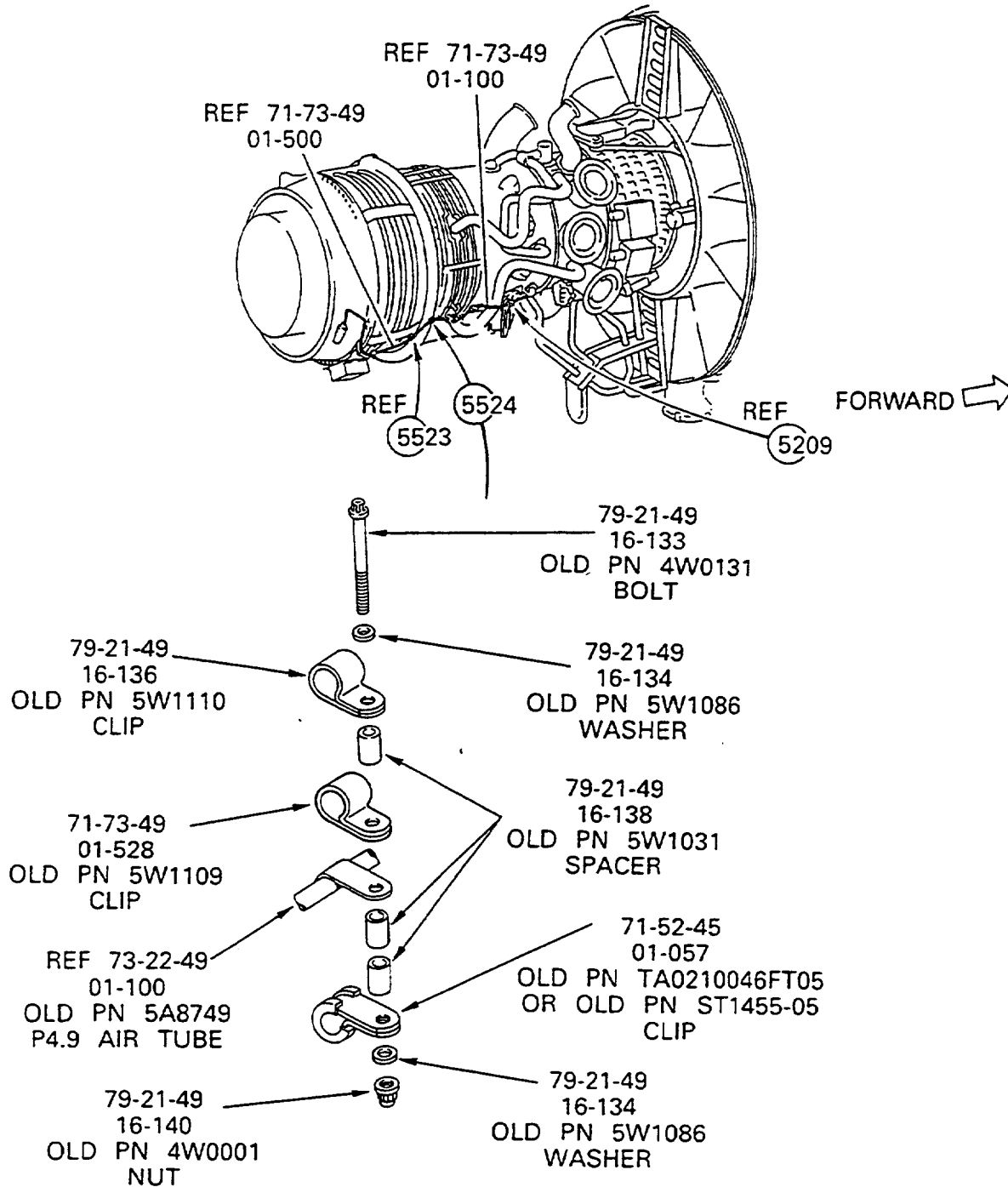
Clipping point 5523 - Before and after alteration
Fig.8 Sheet 2 of 2

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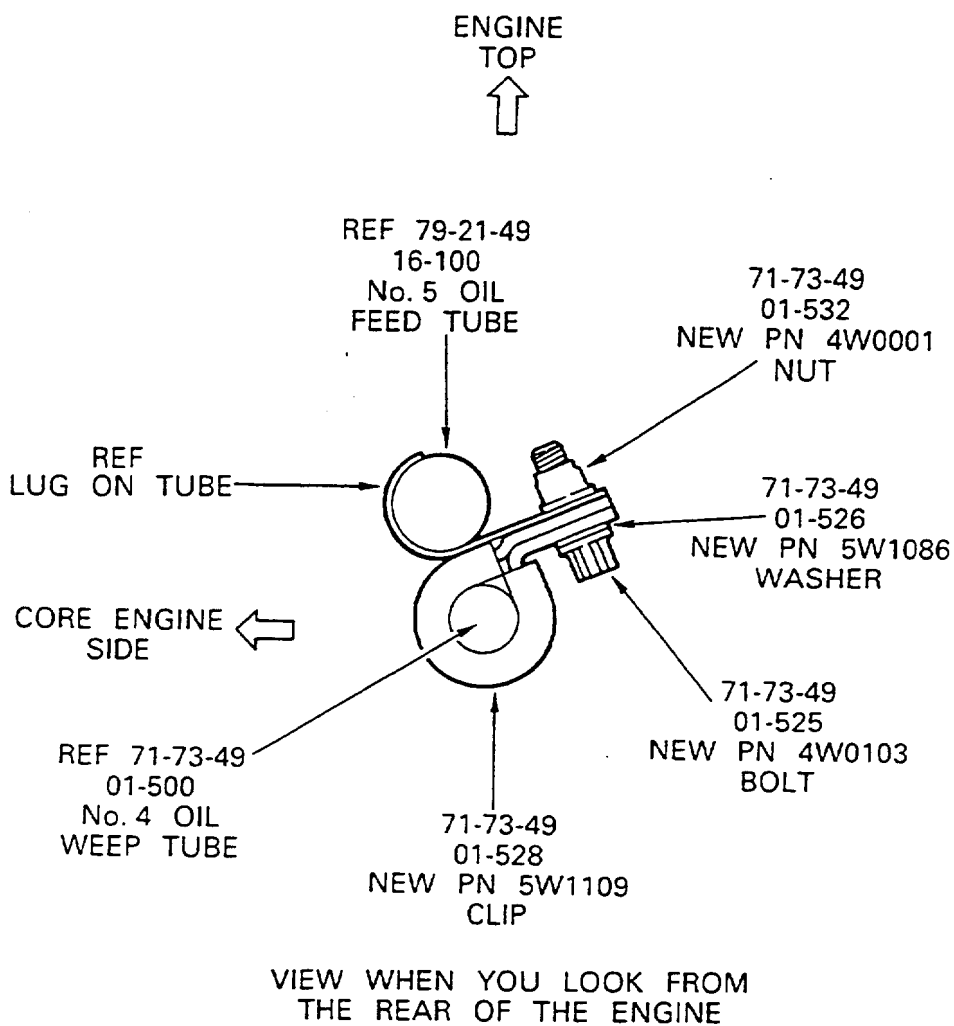
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Clipping point 5524 - Before alteration
Fig.9

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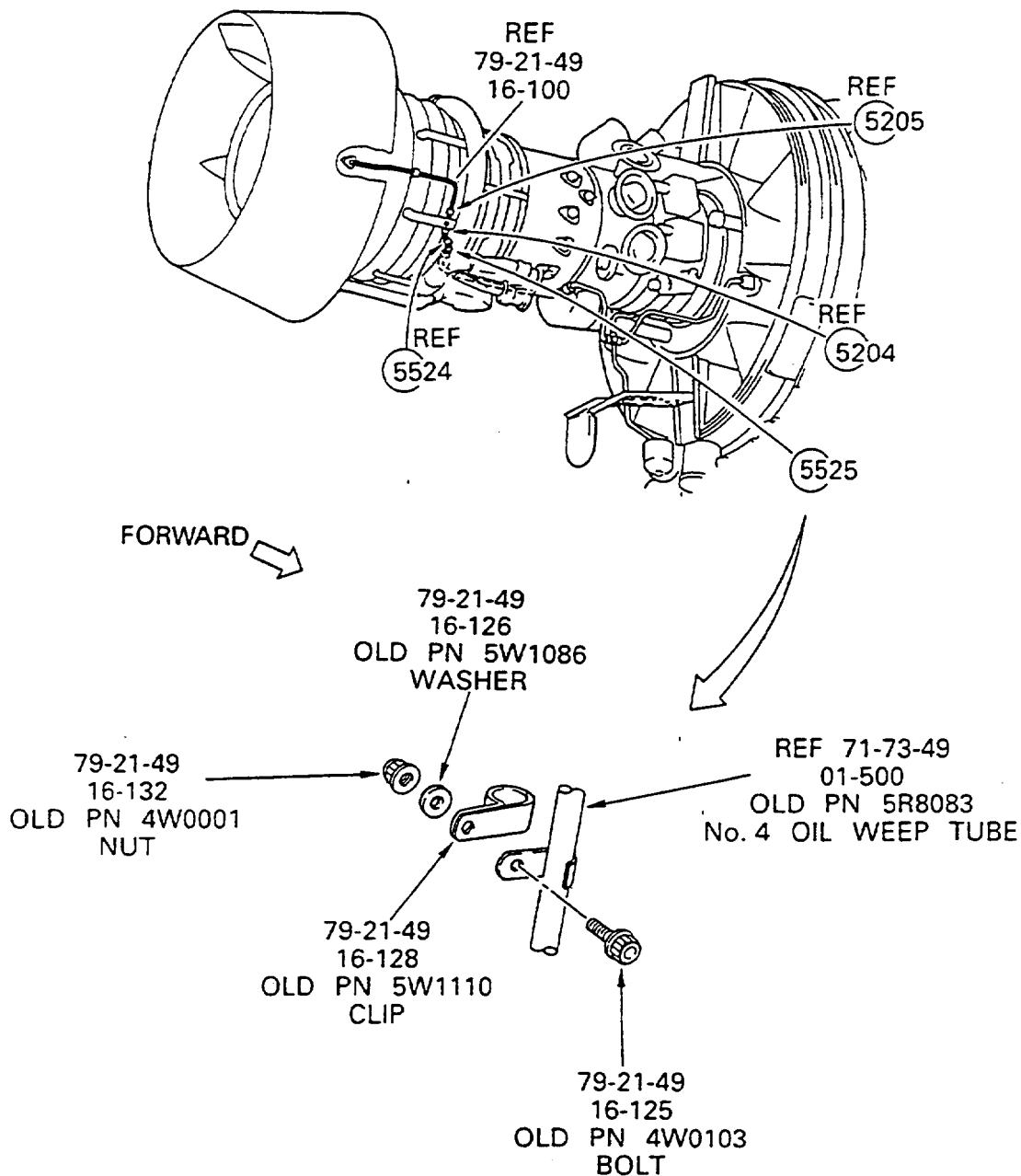
New clipping point 6050 - After alteration
Fig.10

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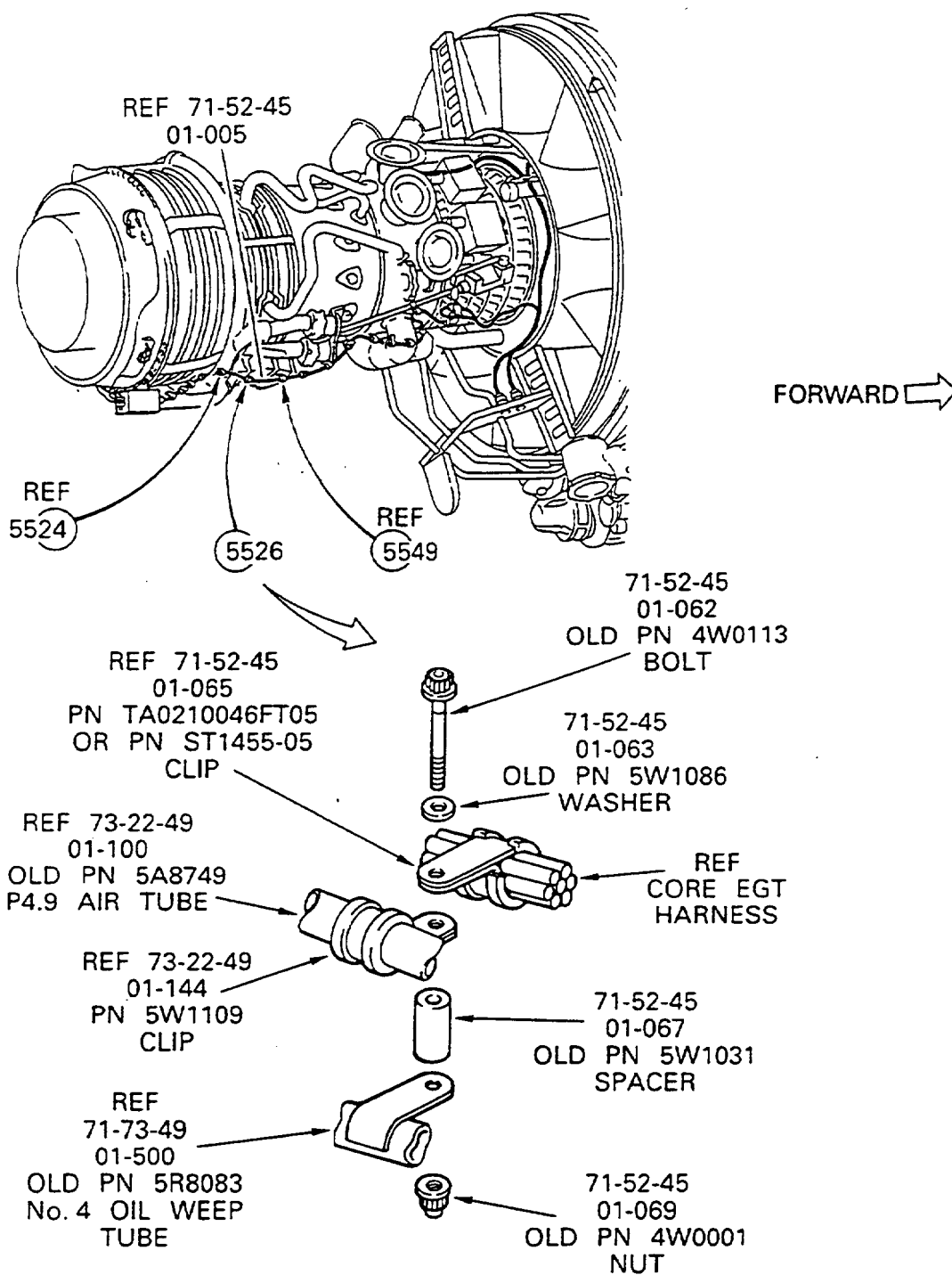
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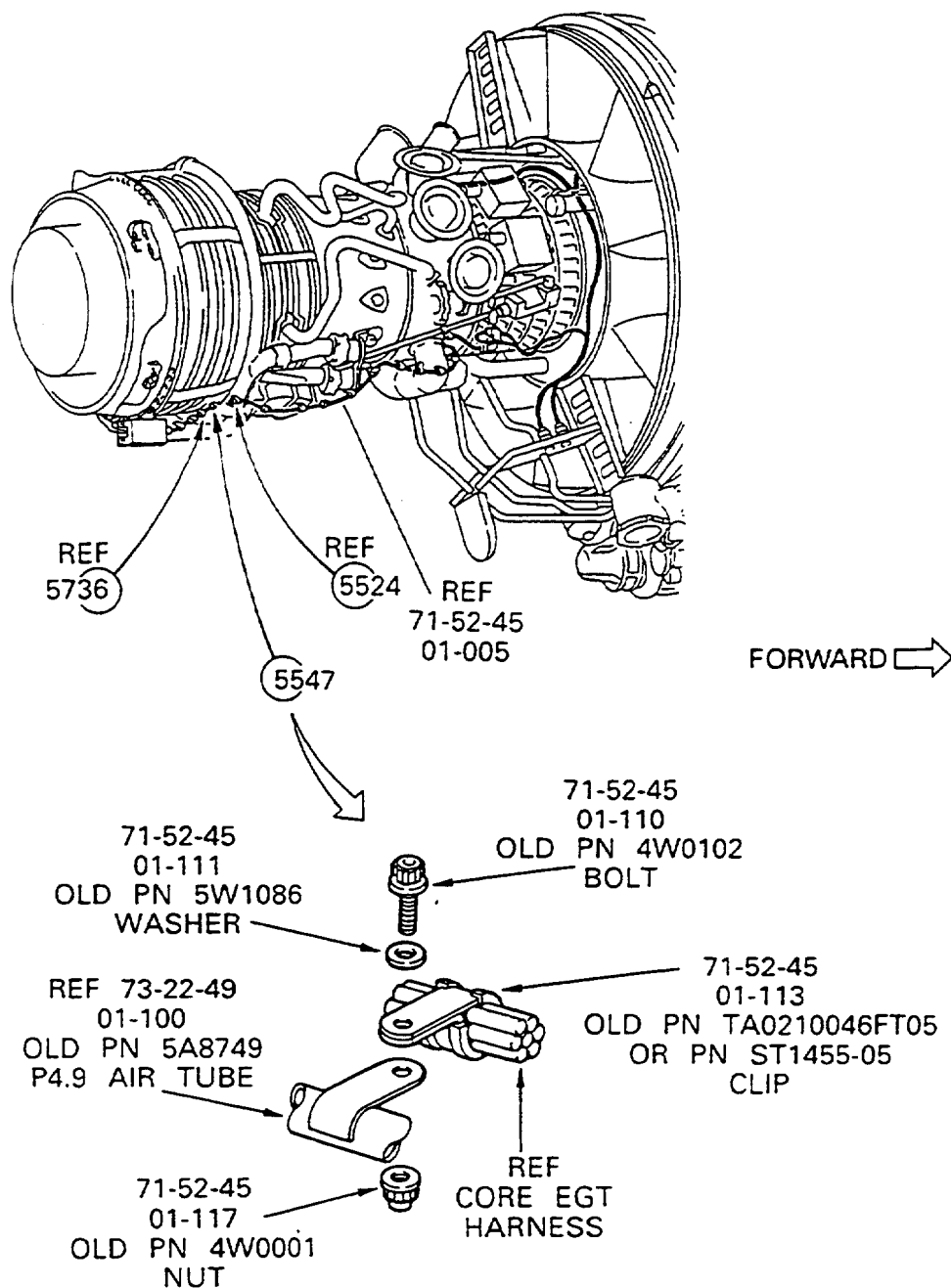
Clipping point 5525 - Before alteration
Fig.11

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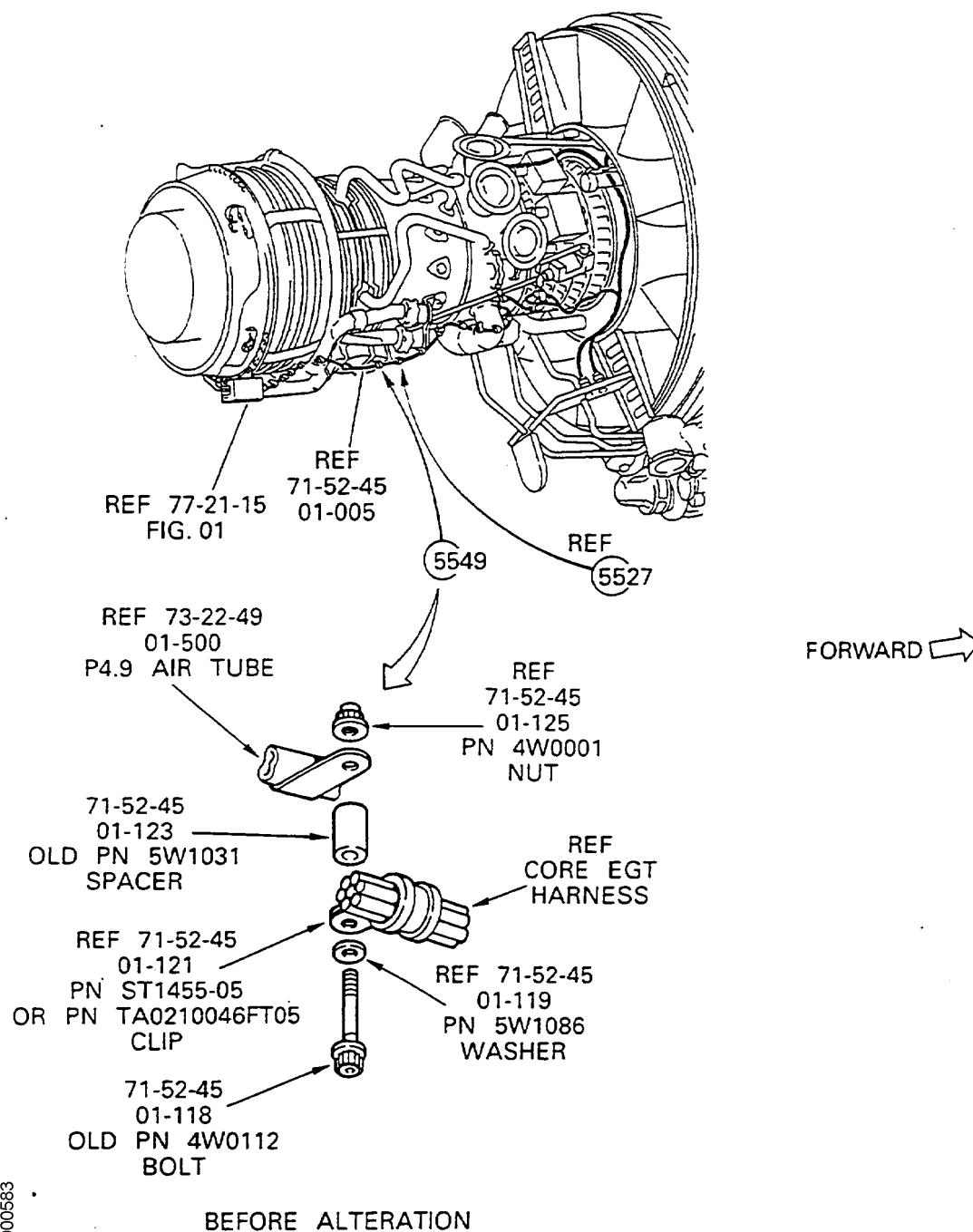
Clipping point 5526 - Before alteration
Fig.12

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Clipping point 5547 - Before alteration
Fig.13

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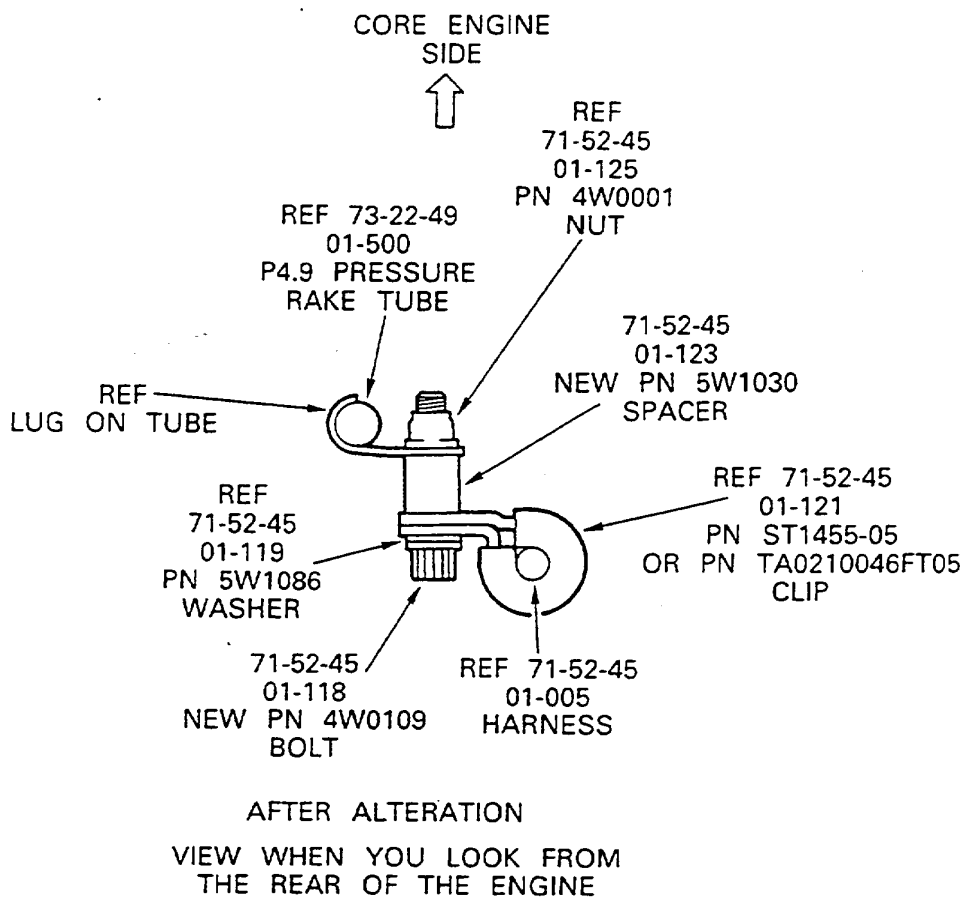
Clipping point 5549 – Before and after alteration
Fig.14 Sheet 1 of 2

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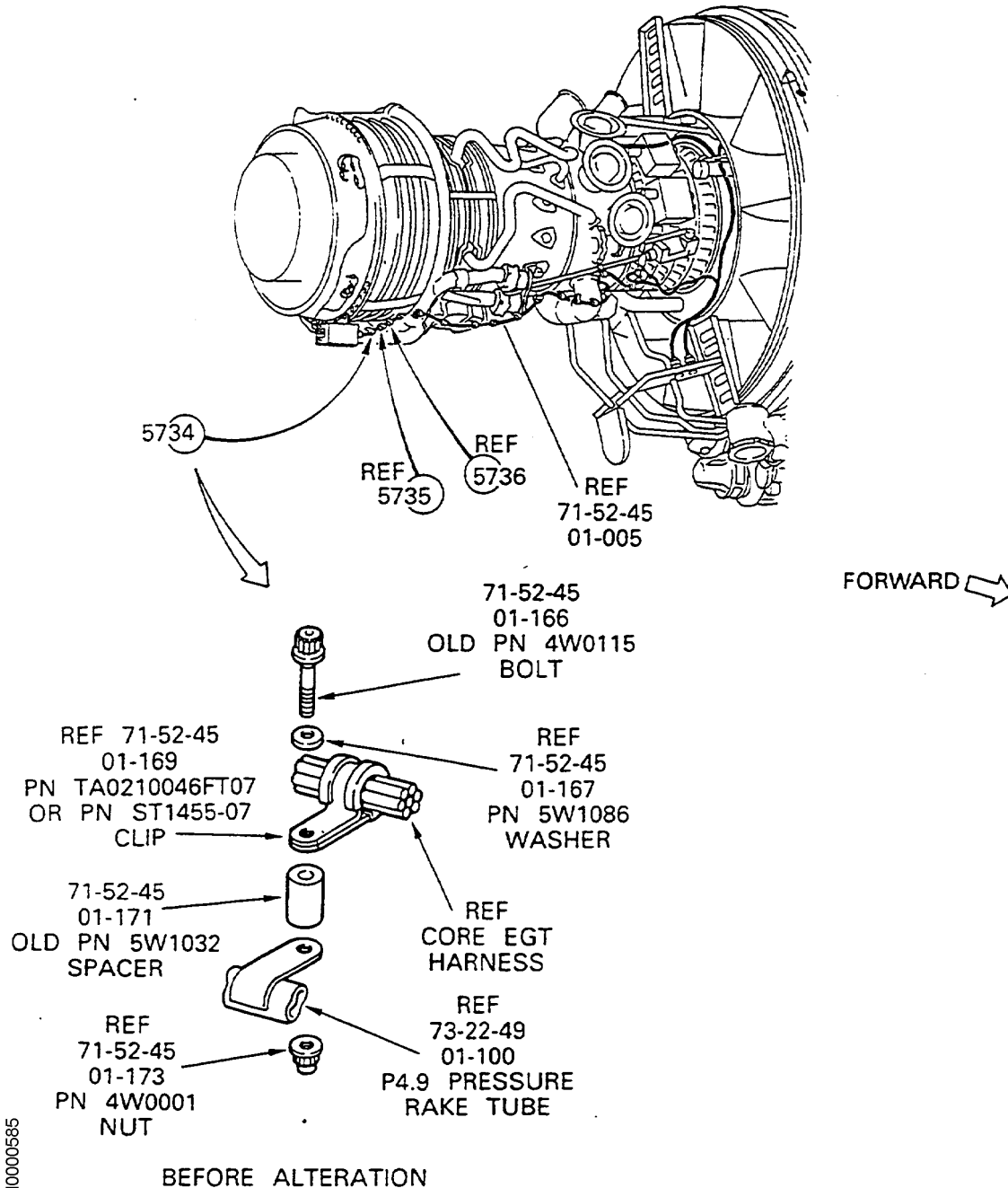
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Clipping point 5549 – Before and after alteration
Fig.14 Sheet 2 of 2

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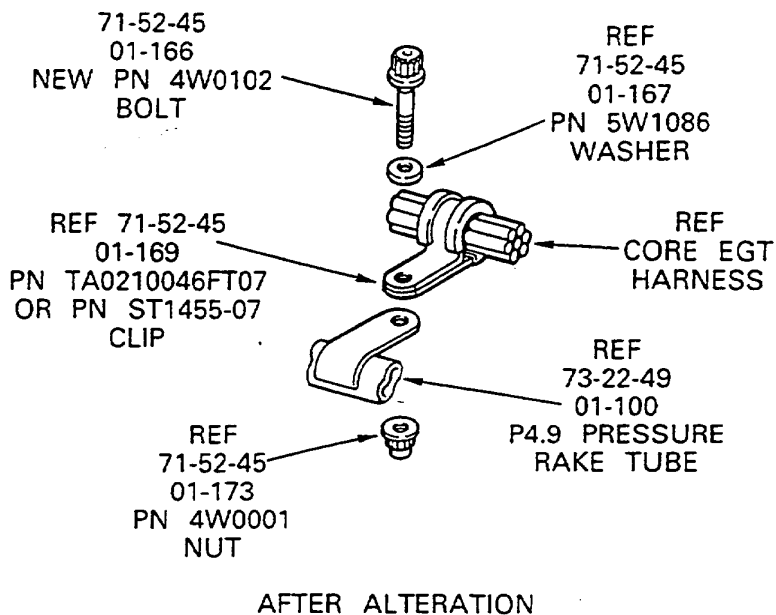
Clipping point 5734 - Before and after alteration
Fig.15 Sheet 1 of 2

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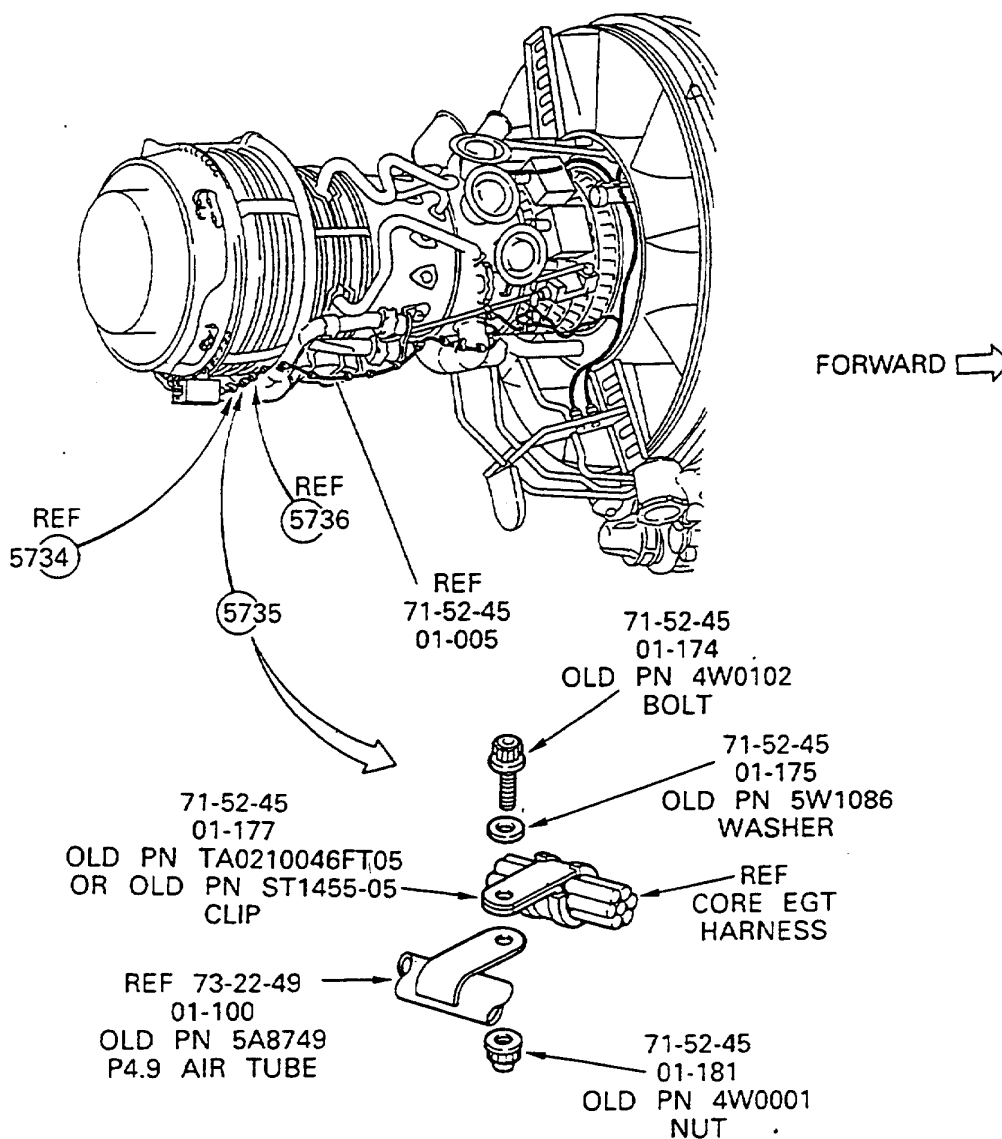
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Clipping point 5734 – Before and after alteration
Fig.15 Sheet 2 of 2

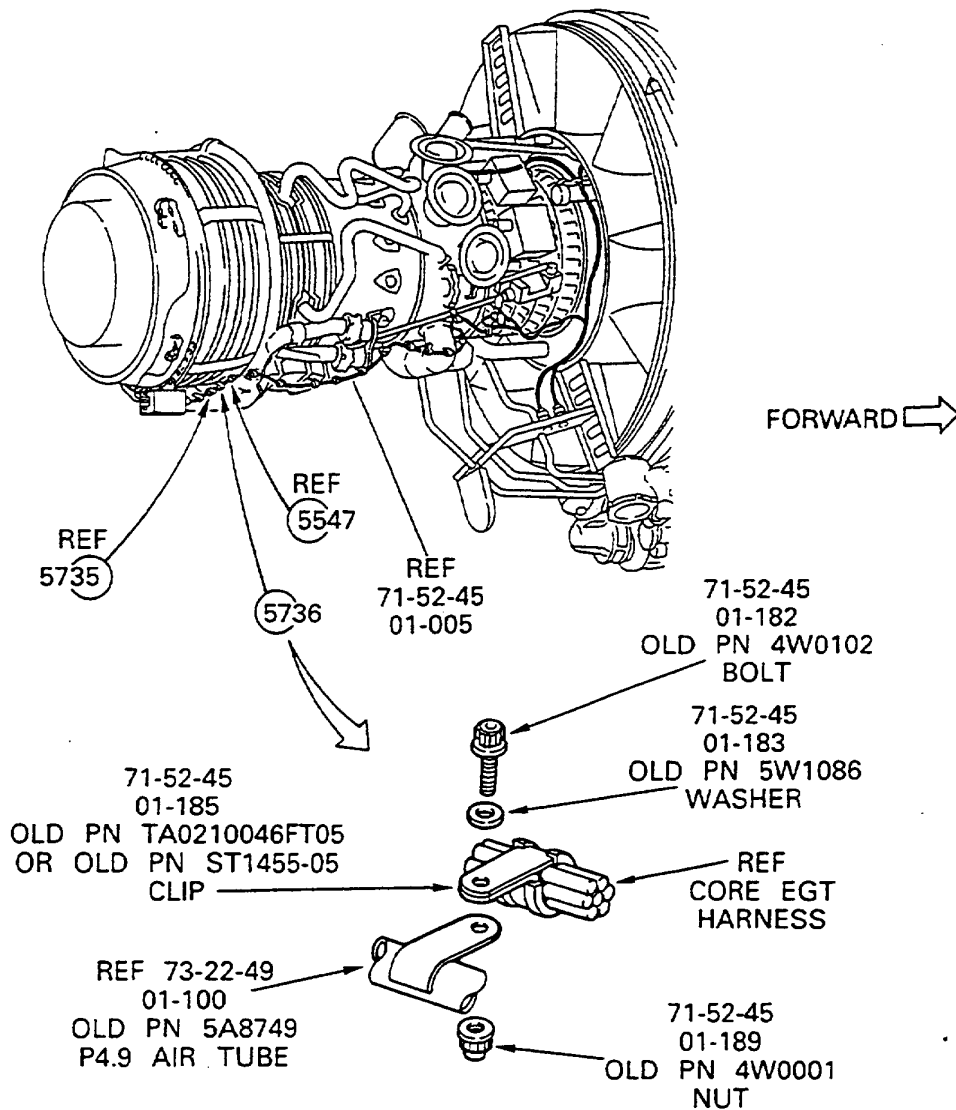
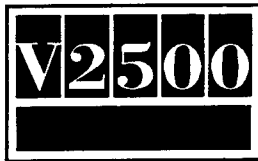
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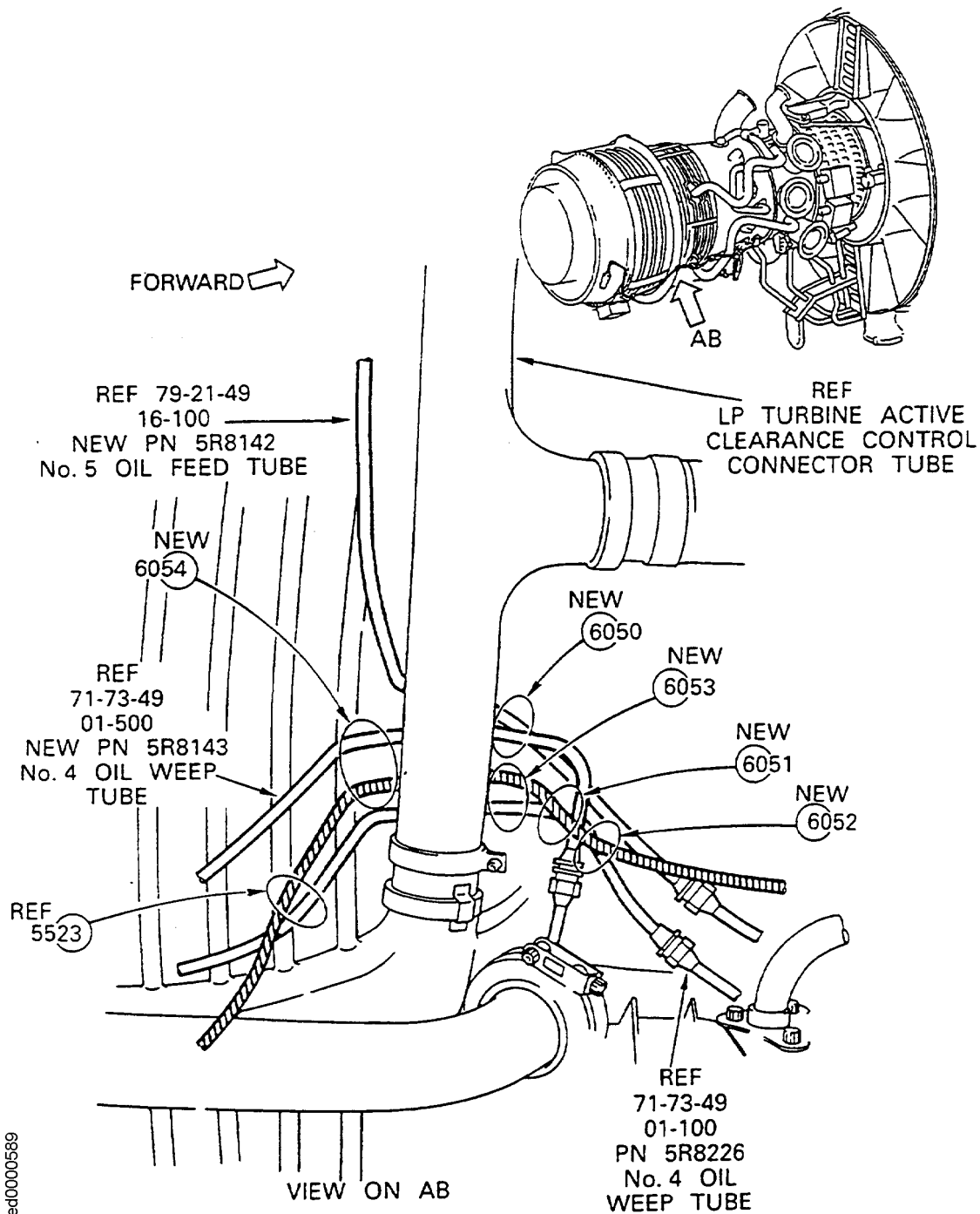
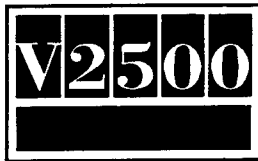
Clipping point 5735 - Before alteration
Fig.16

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Clipping point 5736 - Before alteration
Fig.17

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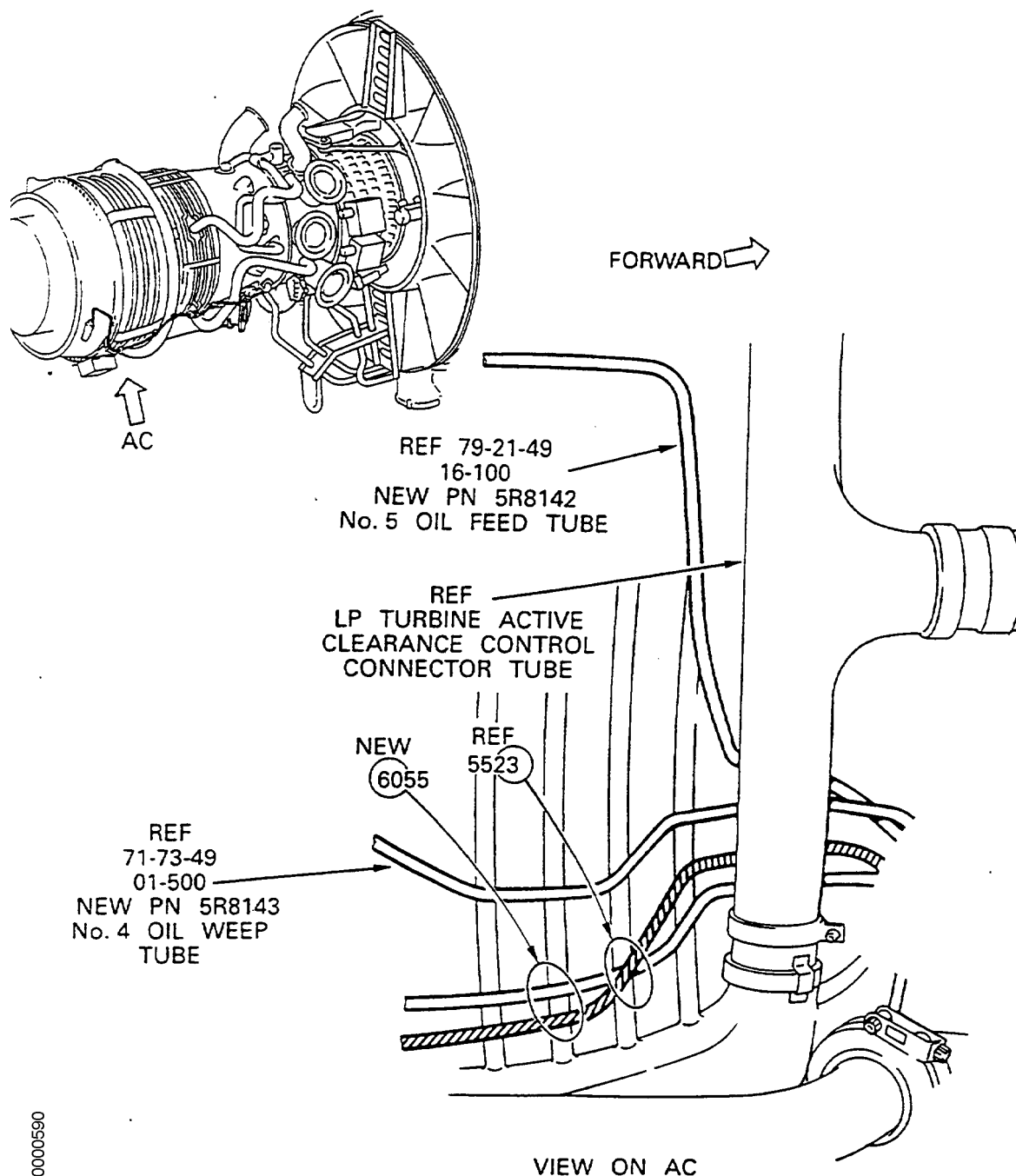


New clipping points location - After alteration
Fig.18

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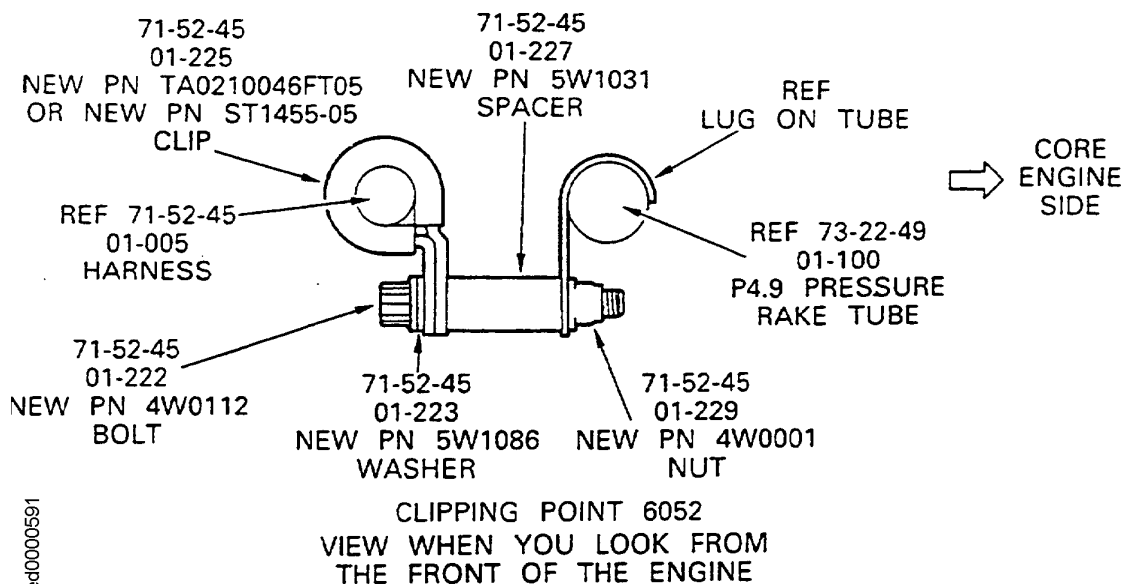
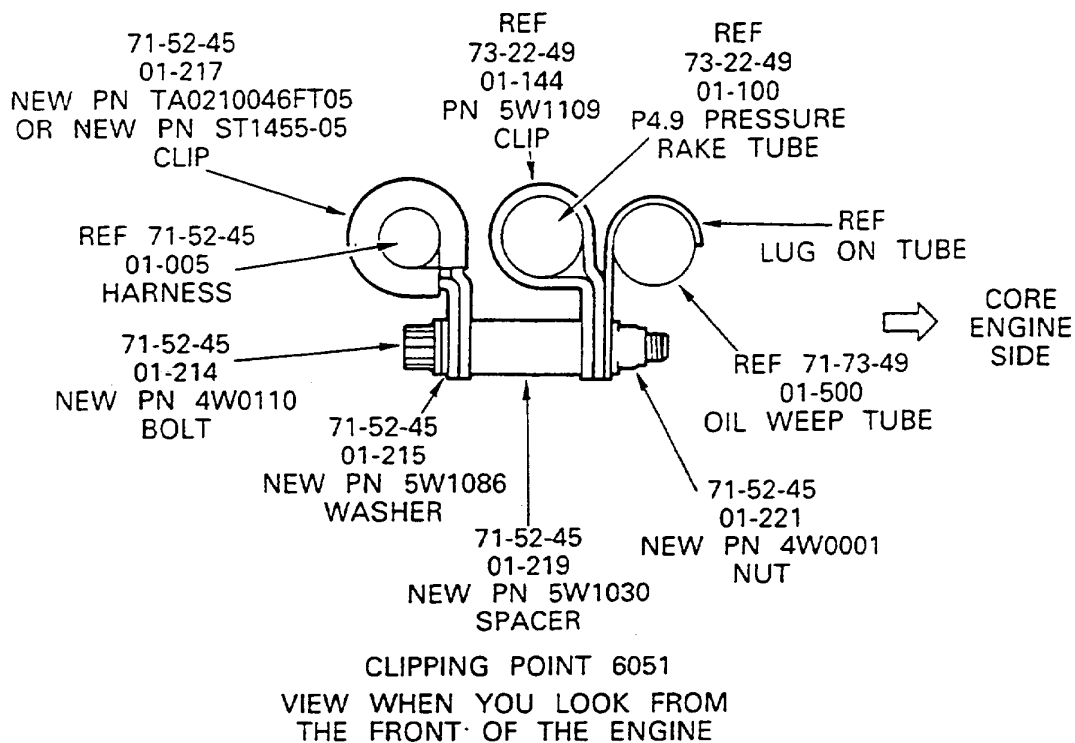
New clipping points location - After alteration
Fig.19

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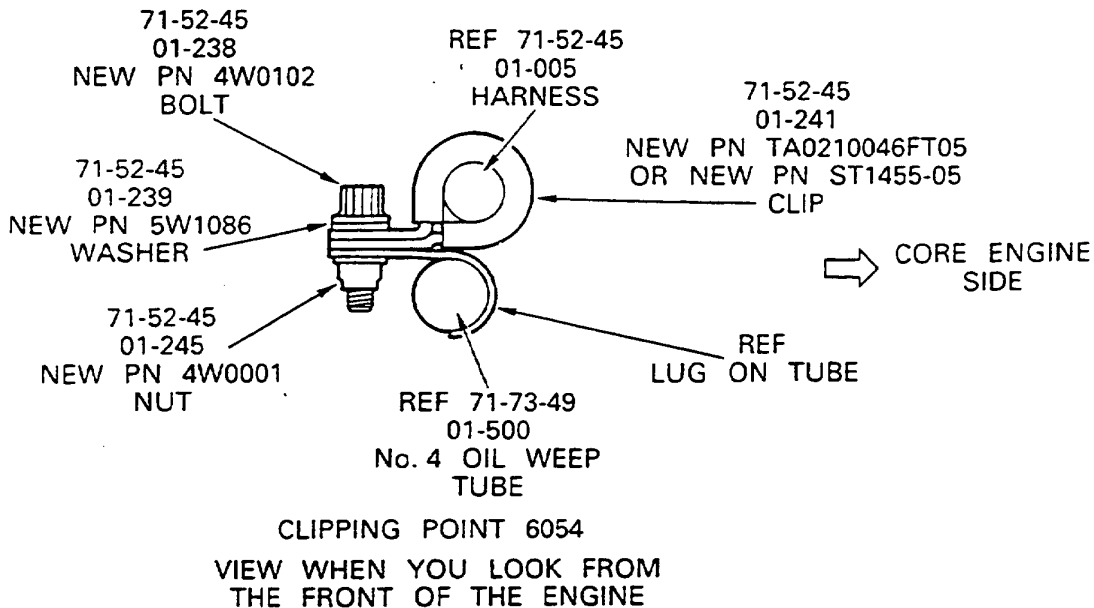
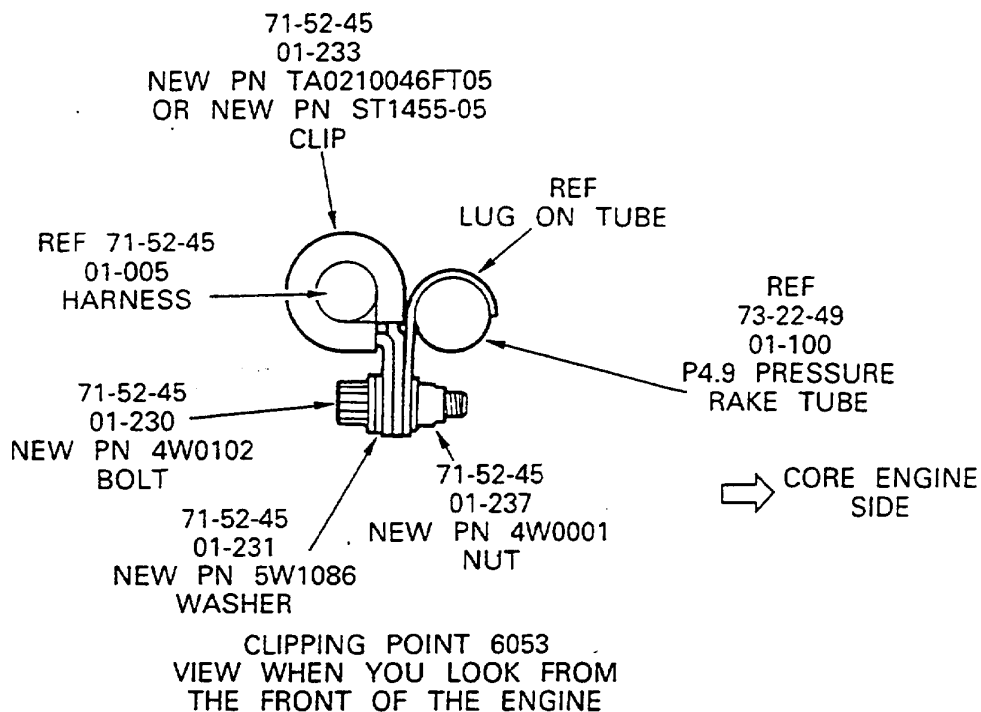
New clipping points 6051 and 6052 - After alteration
Fig.20

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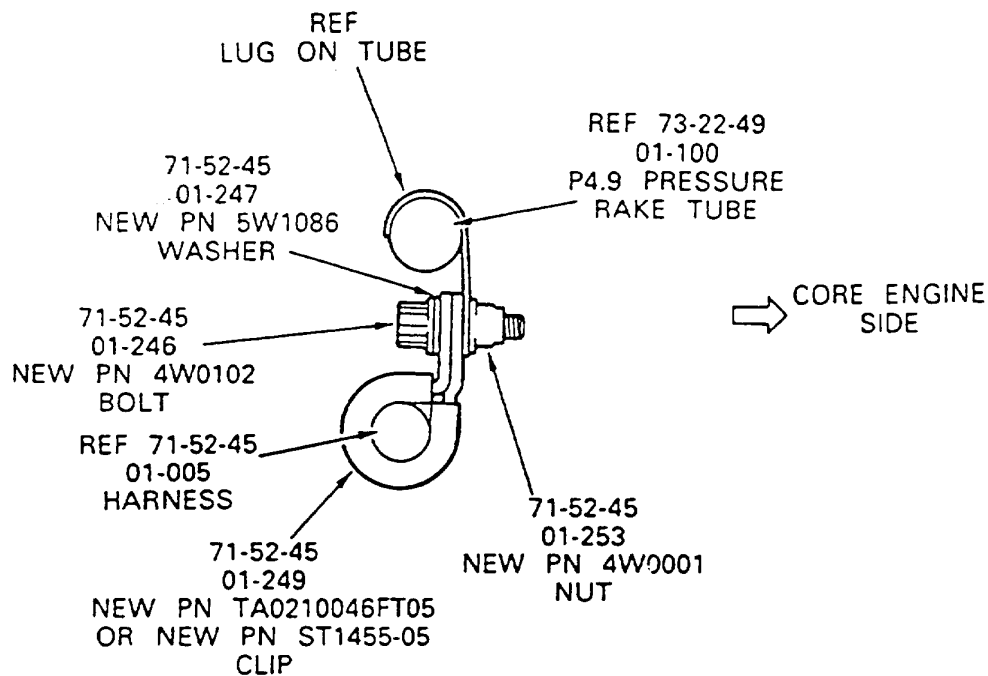
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New clipping points 6053 and 6054
Fig.21

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CLIPPING POINT 6055
VIEW WHEN YOU LOOK FROM
THE FRONT OF THE ENGINE

New clipping point 6055
Fig.22

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3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

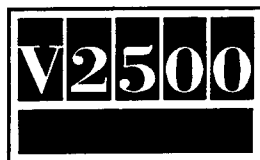
A. Kits associated with this Bulletin:

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
- (71-52-45)	1	-	Clip (CP5524)	TA0210046 FT05 (01-057) or ST1455-05 (01-057)	(2D)(S1)(S2)
- (71-52-45)	1	-	Bolt (CP5526)	4W0113 (01-062)	(2D)(S1)(S2)
- (71-52-45)	1	-	Washer (CP5526)	5W1086 (01-063)	(2D)(S1)(S2)
- (71-52-45)	1	-	Clip (CP5526)	TA0210046 FT05 (01-065) or ST1455-05 (01-065)	(2D)(S1)(S2)
- (71-52-45)	1	-	Spacer, sleeve (CP5526)	5W1031 (01-067)	(2D)(S1)(S2)
- (71-52-45)	1	-	Nut, option (CP5526)	4W0001 (01-069)	(2D)(S1)(S2)
- (71-52-45)	1	-	Bolt, machine double hex (CP5547)	4W0102 (01-110)	(2D)(S1)(S2)
- (71-52-45)	1	-	Washer (CP5547)	5W1086 (01-111)	(2D)(S1)(S2)
- (71-52-45)	1	-	Clip (CP5547)	TA0210046 FT05 (01-113) or ST1455-05 (01-113)	(2D)(S1)(S2)
- (71-52-45)	1	-	Nut, option (CP5547)	4W0001 (01-117)	(2D)(S1)(S2)
4W0109 (71-52-45)	1	2.96	Bolt, machine double hex (CP5549)	4W0112 (01-118)	(A)(2D)(S1) (S2)
5W1030 (71-52-45)	1	13.00	Spacer, sleeve (CP5549)	5W1031 (01-123)	(A)(2D)(S1) (S2)

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4W0102 (71-52-45)	1	3.10	Bolt, machine double hex (CP5734)	4W0115 (01-166)	(A)(2D)(S1) (S2)
- (71-52-45)	1	-	Spacer, sleeve (CP5734)	5W1032 (01-171)	(2D)(S1)(S2)
- (71-52-45)	1	-	Bolt, machine double hex (CP5735)	4W0102 (01-174)	(2D)(S1)(S2)
- (71-52-45)	1	-	Washer (CP5735)	5W1086 (01-175)	(2D)(S1)(S2)
- (71-52-45)	1	-	Clip (CP5735)	TA0210046 FT05	(2D)(S1)(S2)
				or	
				ST1455-05 (01-177)	(2D)(S1)(S2)
- (71-52-45)	1	-	Nut, option (CP5735)	4W0001 (01-181)	(2D)(S1)(S2)
- (71-52-45)	1	-	Bolt, machine double hex (CP5736)	4W0102 (01-182)	(2D)(S1)(S2)
- (71-52-45)	1	-	Washer (CP5736)	5W1086 (01-183)	(2D)(S1)(S2)
- (71-52-45)	1	-	Clip (CP5736)	TA0210046 FT05	(2D)(S1)(S2)
				or	
				ST1455-05 (01-185)	(2D)(S1)(S2)
- (71-52-45)	1	-	Nut, option (CP5736)	4W0001 (01-189)	(2D)(S1)(S2)
4W0110 (71-52-45)	1	3.23	Bolt, machine double hex (CP6051)	- (01-214)	(A)(S1)(S3)
5W1086 (71-52-45)	1	0.27	Washer (CP6051)	- (01-215)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.72	Clip (CP6051)	- (01-217)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP6051)	- (01-217)	(A)(B)(S1) (S3)
5W1030 (71-52-45)	1	13.00	Spacer, sleeve (CP6051)	- (01-219)	(A)(S1)(S3)
4W0001 (71-52-45)	1	5.18	Nut, option (CP6051)	- (01-221)	(A)(S1)(S3)
4W0112 (71-52-45)	1	1.97	Bolt, machine double hex (CP6052)	- (01-222)	(A)(S1)(S3)
5W1086 (71-52-45)	1	0.27	Washer (CP6052)	- (01-223)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.72	Clip (CP6052)	- (01-225)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP6052)	- (01-225)	(A)(B)(S1) (S3)
5W1031 (71-52-45)	1	13.30	Spacer, sleeve (CP6052)	- (01-227)	(A)(S1)(S3)

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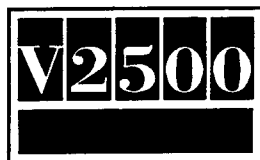
V2500-ENG-72-0053



SERVICE BULLETIN

4W0001 (71-52-45)	1	5.18	Nut, option (CP6052)	- (01-229)	(A)(S1)(S3)
4W0102 (71-52-45)	1	3.10	Bolt, machine double hex (CP6053)	- (01-230)	(A)(S1)(S3)
5W1086 (71-52-45)	1	0.27	Washer (CP6053)	- (01-231)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.72	Clip (CP6053)	- (01-233)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP6053)	- (01-233)	(A)(B)(S1) (S3)
4W0001 (71-52-45)	1	5.18	Nut, option (CP6053)	- (01-237)	(A)(S1)(S3)
4W0102 (71-52-45)	1	3.10	Bolt, machine double hex (CP6054)	- (01-238)	(A)(S1)(S3)
5W1086 (71-52-45)	1	0.27	Washer (CP6054)	- (01-239)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.72	Clip (CP6054)	- (01-241)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP6054)	- (01-241)	(A)(B)(S1) (S3)
4W0001 (71-52-45)	1	5.18	Nut, option (CP6054)	- (01-245)	(A)(S1)(S3)
4W0102 (71-52-45)	1	3.10	Bolt, machine double hex (CP6055)	- (01-246)	(A)(S1)(S3)
5W1086 (71-52-45)	1	0.27	Washer (CP6055)	- (01-247)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.27	Clip (CP6055)	- (01-249)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP6055)	- (01-249)	(A)(B)(S1) (S3)
4W0001 (71-52-45)	1	5.18	Nut, option (CP6055)	- (01-253)	(A)(S1)(S3)
TA0210046 FT05 (71-52-45)	1	2.72	Clip (CP5523)	- (01-257)	(A)(S1)(S3)
ST1455-05 (71-52-45)	REF	-	Clip (CP5523)	- (01-257)	(A)(B)(S1) (S3)
5R8143 (71-73-49)	1	511.00	Tube A/O No.4 oil weep	5R8083 (01-500)	(A)(1D)(S1)
4W0103 (71-73-49)	1	9.47	Bolt, machine double hex (CP6050)	- (01-525)	(A)(S1)(S3)
5W1086 (71-73-49)	1	0.27	Washer (CP6050)	- (01-526)	(A)(S1)(S3)
- (71-73-49)	1	-	Clip (CP5524)	5W1109 (01-528)	Not applicable
5W1109 (71-73-49)	1	6.49	Clip (CP6050)	- (01-528)	Not applicable
4W0001	1	5.18	Nut option (CP6050)	-	(A)(S1)(S3)

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SERVICE BULLETIN

(71-73-49)				(01-532)	
4W0116	1	8.20	Bolt, machine	4W0109	(A)(2D)(S1)
(71-73-49)			double hex (CP5523)	(01-533)	(S2)
5W1030	1	13.00	Spacer, sleeve	-	(A)(S1)(S3)
(71-73-49)			(CP5523)	(01-538)	
4W0104	1	3.10	Bolt (CP5201)	4W0104	(A)(2D)(S1)
(71-73-49)				(01-541)	(S2)
5W1086	1	0.27	Washer (CP5201)	5W1086	(A)(2D)(S1)
(71-73-49)				(01-542)	(S2)
4W0043	1	1.65	Nut, clip	4W0043	(A)(D1)(S1)
(71-73-49)			(CP5201)	(01-548)	(S2)
5W8392	1	9.71	Bracket	5W8393	(A)(1D)(S1)
(72-50-00)				(01-370)	
5A8793	1	941.00	Tube A/O - Air P4.9	5A8749	(C)(1D)(S1)
(73-22-49)				(01-100)	
-	1	-	Bolt, machine	4W0102	(2D)(S1)(S2)
(73-22-49)			double hex (CP5737)	(01-149)	
-	1	-	Washer (CP5737)	5W1086	(2D)(S1)(S2)
(73-22-49)				(01-150)	
-	1	-	Clip (CP5737)	5W1109	(2D)(S1)(S2)
(73-22-49)				(01-152)	
-	1	-	Nut, A/O self locking	4W0043	(2D)(S1)(S2)
(73-22-49)			(CP5737)	(01-156)	
5W1109	1	6.49	Clip, loop type	-	(A)(S1)(S3)
(73-22-49)			(CP5201)	(01-160)	
5R8142	1	655.00	Tube A/O No.5	5R8225	(A)(1D)(S1)
(79-21-49)			oil feed	(16-100)	
-	1	-	Bolt, machine	4W0103	(2D)(S1)(S2)
(79-21-49)			double hex (CP5525)	(16-125)	
-	1	-	Washer (CP5525)	5W1086	(2D)(S1)(S2)
(79-21-49)				(16-126)	
-	1	-	Clip, loop type	5W1110	(2D)(S1)(S2)
(79-21-49)			(CP5525)	(16-128)	
-	1	-	Nut, option	4W0001	(2D)(S1)(S2)
(79-21-49)			(CP5525)	(16-132)	
-	1	-	Bolt, machine	4W0131	(2D)(S1)(S2)
(79-21-49)			double hex (CP5524)	(16-133)	
-	2	-	Washer (CP5524)	5W1086	(2D)(S1)(S2)
(79-21-49)				(16-134)	
-	1	-	Clip, loop type	5W1110	(2D)(S1)(S2)
(79-21-49)			(CP5524)	(16-136)	
-	3	-	Spacer, sleeve	5W1031	(2D)(S1)(S2)
(79-21-49)			(CP5524)	(16-138)	
-	1	-	Nut, option	4W0001	(2D)(S1)(S2)
(79-21-49)			(CP5524)	(16-140)	
4W0102	1	3.10	Bolt, machine	4W0106	(A)(2D)(S1)
(79-21-49)			double hex (CP5206)	(16-157)	(S2)
-	1	-	Spacer, sleeve	5W1029	(2D)(S1)(S2)
(79-21-49)			(CP5206)	(16-162)	

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C. Instruction/Disposition Code Statements:

- (A) New part is currently available for sale.
- (B) New part is incorporated as alternative.
- (C) New part will be available approximately June 1990.
- (1D) Old part will continue to be available until stock has been exhausted.
- (2D) Old part will continue to be available for sale on other applications. Do not discard.
- (S1) New parts coded (S1) must replace old parts coded (S1) as a COMPLETE SET per engine.
- (S2) Old part can be used up on other application.
- (S3) Additional part.

NOTE: The estimated 1990 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

