

SERVICE BULLETIN

ENGINE - L.P. COMPRESSOR - REPLACE THE NO.3 BEARING HOUSING ASSEMBLY SHOULDER STUDS WHICH HAVE BEEN SHOT PEENED - CATEGORY CODE 5 - MOD.ENG-72-0059

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engines prior to serial No.V0129

NOTE: * The serial number data shown is of a preliminary nature and is provided for advanced planning only. A future revision to this Service Bulletin will confirm final serial number effectivity.

B. Reason

(1) Condition

The existing 2A0422 No.3 Bearing Housing Assembly Shoulder Studs were not shot peened.

(2) Background

During a engine hardware review, it was found that the shot peen requirement was not incorporated.

(3) Objective

To improve the high cycle fatigue life of the No.3 Bearing Housing Assembly Shoulder Studs.

(3) 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) Incorporate shot peened the No.3 Bearing Housing Assembly Shoulder Studs to increase the high cycle fatigue life.

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	Not applicable

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 effect
- (3) Datum Engine Front Centerline
(Powerplant Station P.P.S.100)

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**SERVICE BULLETIN****J. Electrical Load Data**

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

K. References**(1) Internal Reference No.**

89VA118

89VA118C

(2) Other References

V2500 Engine Illustrated Parts Catalog

V2500 Engine Manual

L. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-21 Figure 1, to add the new part.
- (2) The V2500 Engine Manual, Chapter/Section 72-32-21, Cleaning, to add the new part.
- (3) The V2500 Engine Manual, Chapter/Section 72-32-21, Inspection/Check, to add the new part.
- (4) The V2500 Engine Manual, Chapter/Section 72-32-21, Repair to add the new part.

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2. Accomplishment Instructions

A. Rework Instructions

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

B. Removal Instructions

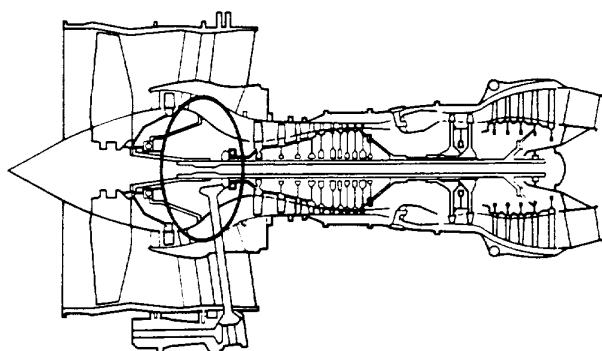
- (1) Remove the 2A0422 No.3 Bearing Housing Assembly Shoulder Studs by the instructions given in Reference (2), Chapter/Section, 72-32-20 Removal. Refer to Figure 1.

C. Assembly Instructions

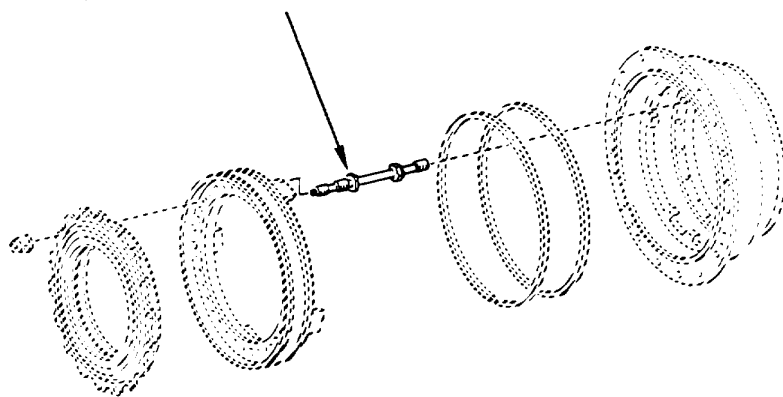
- (1) Install the 2A1667 No.3 Bearing Housing Assembly Shoulder Studs (18 off) by the instructions given in Reference (2), Chapter/Section, 72-32-20 Assembly.

D. Recording Instructions

- (1) A record of accomplishment is necessary.



REMOVE THE PN 2A0422
SHOULDER STUD AND INSTALL
PN 2A1667 SHOULDER STUD (18 Off)



19674 A

Location of No.3 bearing housing assembly shoulder stud
Fig.1

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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:

2A1667	18	194.00	Stud, Shoulder	2A0422	(S1)(A)
(72-32-21)				(01-080)	(B)

C. Instruction/Disposition Code Statements:

(S1) New Parts Coded (S1) must replace old parts coded (S1) as a COMPLETE SET per Engine.

(A) New Part is currently available.

(B) Old part will no longer be 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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