International Aero Engines

SERVICE BULLETIN

ENGINE - LP TURBINE - DELETE THE MARKING REQUIREMENTS FOR THE STAGE 6 TURBINE DISK AND LP TURBINE SHAFT - CATEGORY CODE 6 - MOD.ENG-72-0067

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engines listed below:
V0003, V0005, V0008, V0010, V0012, V0013, V0014, V0016, V0018, V0020, V0022, V0024, V0026, V0028, V0030, V0032, V0034, V0036, V0038, V0040

B. Reason

(1) Condition

(1) The engine S/N's listed above have a correlation marking between the LP Turbine disk stage 6 and the LP Turbine shaft.

(2) Objective

The instructions given in Section 2 of this Service Bulletin are to remove the correlation markings on the affected stage 6 LP Turbine disks and LP Turbine shafts.

(3) Substantiation

Not applicable.

(4) 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

C. Approval

The requirements shown in Section 2 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

D. Compliance

Category Code 6

Accomplish when the subassembly (i.e. modules, accessories, components, build group) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

E. Manpower

2 hrs. 7 mins.

F. Material - Price and Availability

Not applicable

G. Tooling - Price and Availability

Not applicable

H. Weight and Balance

Not applicable

I. Electrical Load Data

Not applicable

K. References

(1) Internal Reference No.

EC89VM012

(2) Other references

V2500 Engine Illustrated Parts Catalog

V2500 Engine Manual

V2500 Standard Practices/Process Manual

2. Accomplishment Instructions

A. Accomplishment instructions for removal of correlation markings on LP Turbine disk stage 6

(1) Identify the correlation marking on the LP Turbine disk stage 6. Refer to Figure 1.

NOTE: The correlation marking may be located on the front or rear side of the LP Turbine shaft connection flange.

(2) Make sure that the correlation marking does not touch the bolt holes.

NOTE: If the correlation marking touches the bolt hole, contact:

IAE-INTERNATIONAL AERO ENGINES AG
628 HEBRON AVENUE
GLASTONBURY, CT 06033-2595 - USA

ATTN.: Head of Technical Services

(3) Remove the correlation marking from the stage 6 LP Turbine disk. Refer to Engine Manual, Chapter 72-50-31, Repair 004 (VRS4157).

PROCEDURE	SUPPLEMENTARY INFORMATION
(a) Observe general instructions for blending	Refer to EM SUBTASK 72-50-31-350-053
(b) Blend repair the stage 6 disk to remove the marking	Refer to EM SUBTASK 72-50-31-350-054
(c) Do the post repair inspection for cracks	Refer to EM SUBTASK 72-50-31-230-057

B. Accomplishment instructions for removal of correlation marking on the LP turbine shaft

(1) Identify the correlation marking on the LP turbine shaft. Refer to figue 1.

NOTE: The correlation marking may be located on the front or rear side of the stage 6 LP Turbine disk connection flange.

(2) Measure depth of correlation marking.

NOTE: If the depth of the marking is more than 0,002in. (0,05 mm) contact:

IAE-INTERNATIONAL AERO ENGINES AG
628 HEBRON AVENUE
GLASTONBURY, CT 06033-2595 - USA

ATTN.: Head of Technical Services

(3) Remove the marking from the LP Turbine shaft

PROCEDURE	SUPPLEMENTARY INFORMATION
(a) Polish out to remove correlation marking	Use hand held pneumatic grinder and abrasive stones or CoMat 05-020 abrasive paper or CoMat 05-021 abrasive paper. The surface finish of the repair must be same as the adjacent area. Polish until all correlation marking is removed.
(b) Visually examine polished area	Visually examine the repaired area for marking. Ensure that all correlation marking hve been removed
(c) Fluorescent penetrant examine polished area	Refer to TASK 70-23-05-230-501. Make sure there are no cracks in repaired area

(4) Apply the corrosion Resistance Coating to the LP turbine shaft

NOTE: 1. Corrosion resistance touch up coating is required after correlation marking removal on rear side of stage 6 disk connection flange. Refer to Figures 1 and 2.

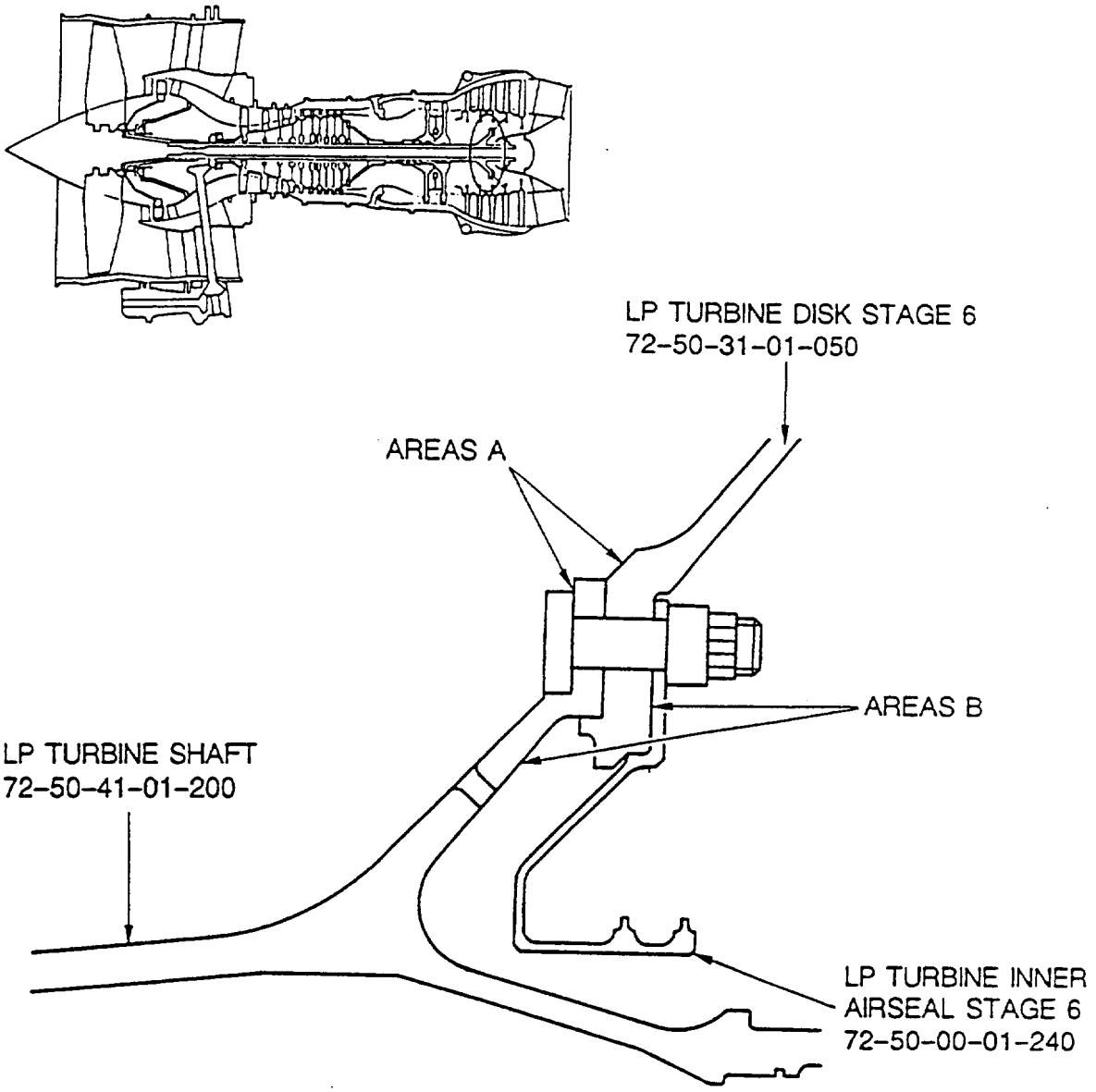
2. Do not coat abutment surface on front side of stage 6 disk connection flange. Refer to Figures 1 and 2.

PROCEDURE	SUPPLEMENTARY INFORMATION
(a) Remove the grease from the blended area	Refer to TASK 70-11-01-300-503. CoMat 01-001 inhibited and stabilized 1.1.1 trichloroethane. Use a clean cloth which is moist with degreasing fluid and clean damaged area. Do not immerse shaft in 1.1.1 trichloroethane

(b)	Apply the corrosion resistance coating to the blended area	Mix thoroughly the CoMat 07-037 corrosion resisting touch-up coating or CoMat 07-038 air drying heat resisting touch-up enamel and apply one coat with a brush. Refer to Figure 2 and TASK 70-38-21-380-501
(c)	Let the LP turbine shaft become dry in air for 30 minutes before handling	Let the painted area become dry in for 30 minutes before handling. Coating will air dry in 24 to 48 hours. Refer to TASK 78-38-21-380-501
(d)	Examine the coating surface	Refer to TASK 70-38-21-380-501

3. Material Information

Not applicable.



NOTE: AREAS A AND B ARE THE POSSIBLE CORRELATION MARKING LOCATIONS

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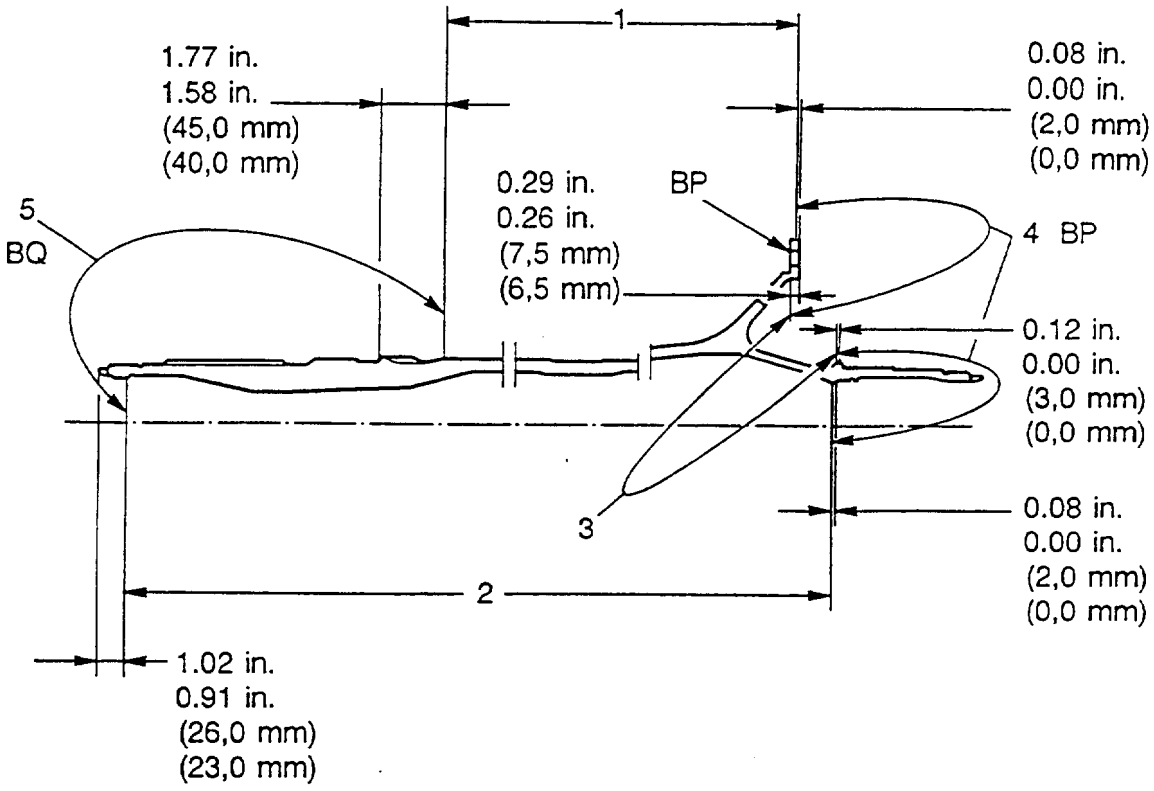
LP turbine shaft and LP turbine stage 6 disk - Position of correlation markings
Fig.1



1. APPLY CORROSION RESISTANCE TOUCH-UP COATING TO THIS AREA
2. APPLY CORROSION RESISTANCE TOUCH-UP COATING TO THIS AREA
3. APPLY CORROSION RESISTANCE TOUCH-UP COATING TO THIS AREA
4. DO NOT COAT ABUTMENT SURFACE OF AREA BP
5. DO NOT COAT ABUTMENT SURFACE OF AREA BQ

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LP turbine shaft - Corrosion resistance touch-up coating repair
Fig.2

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