International Aero Engines

SERVICE BULLETIN

ENGINE - LP COMPRESSOR - BIFURCATION PANEL - INCORPORATION OF NEW SEALING PROCESS - CATEGORY CODE 6 - MOD.ENG-72-0083

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engine prior to Serial No.V0131

B. Reason

(1) Condition

Unnecessary clearances may exist between the bifurcation panel and the fuel supply and return tube connectors.

(2) Background

The above condition has been found on several development and production engines.

(3) Objective

To fill the sealant in to unnecessary clearances between the bifurcation panel and the fuel tube connectors to maintain engine reliability.

(4) Substantiation

Substantiation has been completed by analysis.

(5) Effect of Bulletin on Workshop Procedures:

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

(6) Supplemental Information

(a) The installation of the Post-Service Bulletin parts requires instructions for new sealing process.

(b) New cleaning procedure for sealant will be incorporated in to existing procedure in Component Maintenance Manual and Engine Manual.

C. Description

(1) Applicable sealants are as follows:

CoMat 08-013 cold curing silicone compound (silcoset 152)
or
CoMat 08-074 sealant (RTV159)

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 6

Accomplish when the sub-assembly (ie modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and all affected spare parts.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) At Overhaul (Note: The parts affected by this Service Bulletin are accessible at Overhaul.)	
(a) To accomplish the rework with new sealing process	12 minutes

G. Material - Price and Availability

(1) Modification Kit not required.

(2) See Material Information section for price 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 PPS100)

J. Electrical Load Data

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

K. References

(1) Internal Reference No.

EC89VJ097-01

(2) Other References

(1) V2500 Engine Manual, 72-00-32, Removal -03/Installation -03

(2) V2500 Standard Practises/Processes Manual, 70-11-14 Cleaning and 70-36-02 Bonding, Sealing and Filling

(3) V2500 Overhaul Processes and Consumable Index

(4) Airbus A320 Aircraft Maintenance Manual

L. Other Publications Affected

(1) V2500 Engine Manual, 72-00-32, Installation -03 will be revised to incroporate new sealing procedure.

(2) V2500 Engine Manual, 72-38-25, Cleaning will be revised to incroporate new cleaning procedure.

(3) V2500 Component Maintenance Manual (Tubes, Hoses and Ducts), 73-11-49, Cleaning will be revised to incroporate new cleaning procedure.

(4) V2500 Overhaul Processes and Consumable Index will be revised to incroporate new consumable material.

2. Accomplishment Instructions

A. Rework Instructions

	Procedure	Supplementary Information
(1)	Find the fuel supply and return tube connectors	Refer to fig.1 Sheets 1 and 2
(2)	Clean the surface of areas A, B, C and D on the bifurcation panel	Refer to fig. 1 Sheet 3. Use clean cloth or soft brush made moist with CoMat 01-076 methylethylketone CH3COC2H5
(3)	Hand clean the surfaces of areas A, B, C and D	Use CoMat 05-016 garnet paper or CoMat 05-017 garnet paper
(4)	Do step (2) again	
(5)	Dry the cleaned surfaces	Use dry compressed air or CoMat 02-099 lint free cloth

NOTE: (a) Make sure that there are no remaining cleaners in clearances between the bifurcation panel and the fuel tube connectors.

(b) The surfaces to be filled should be dry and free from grease, oil and dust.

(6)	Apply a thin layer of primer to the cleaned surfaces	Use soft brush. Use CoMat 08-014 primer for silcoset 151, silcoset 152 and silcoset 153 or CoMat 08-032 primer for RTV159

NOTE: The primer must be applied immediately after the surfaces are cleaned.

(7)	Dry the primer	For CoMat 08-014 primer: (i) Dry in air for 30 minutes For CoMat 08-032 primer: (i) Dry in air for 60 to 90 minutes
(8)	Fill the sealant to areas A, B, C and D on the bifurcation panel	Refer to Fig.1 Sheets 3 and 4. Use CoMat 08-013 cold curing silicone compound (silcoset 152) or CoMat 08-074 sealant (RTV159)

(9) Press the sealant in to positions, especially clearances between the bifurcation panel and the fuel tube connectors. Use spatula

NOTE: The sealant should be applied in a thin coating, less than 0.12in. (3,0 mm.) diameter. refer to Fig.1 Sheet 4.

(10) Cure the sealant

Curing time of each sealant is as follows:

For CoMat 08-013 cold curing silicone compound (silcoset 152)

(i) Cure the compound at 68 deg.F. (20 deg.C.), for 48 hours

NOTE: (a) The surface of the compound can be touched after 12 hours.

(b) Do not apply a load during this time.

For CoMat 08-074 sealant (RTV159)

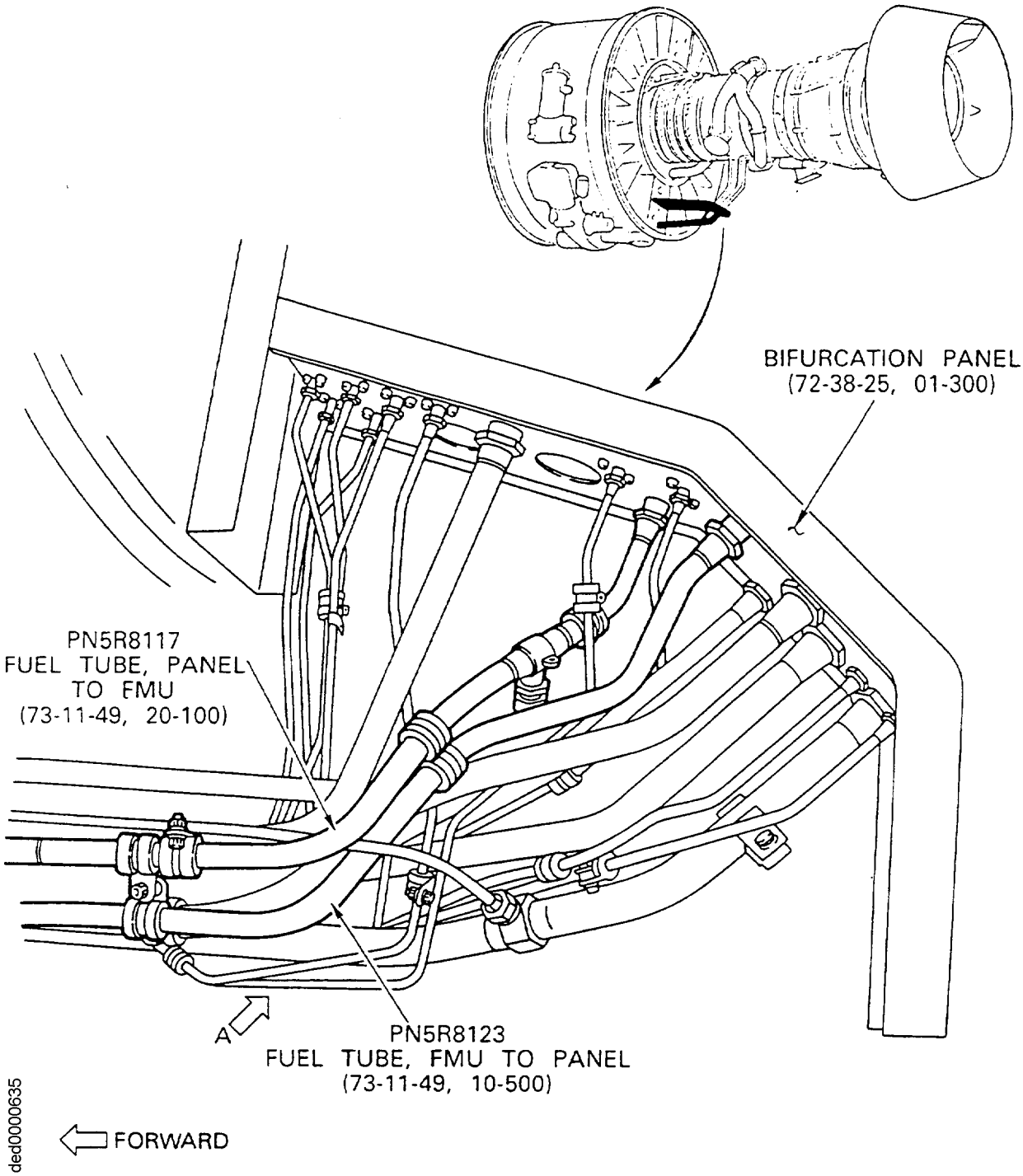
(i) Cure the compound at 77 deg.F. (25 deg.C.), for 24 hours

NOTE: (a) The surface of the sealant can be touched after one to two hours.

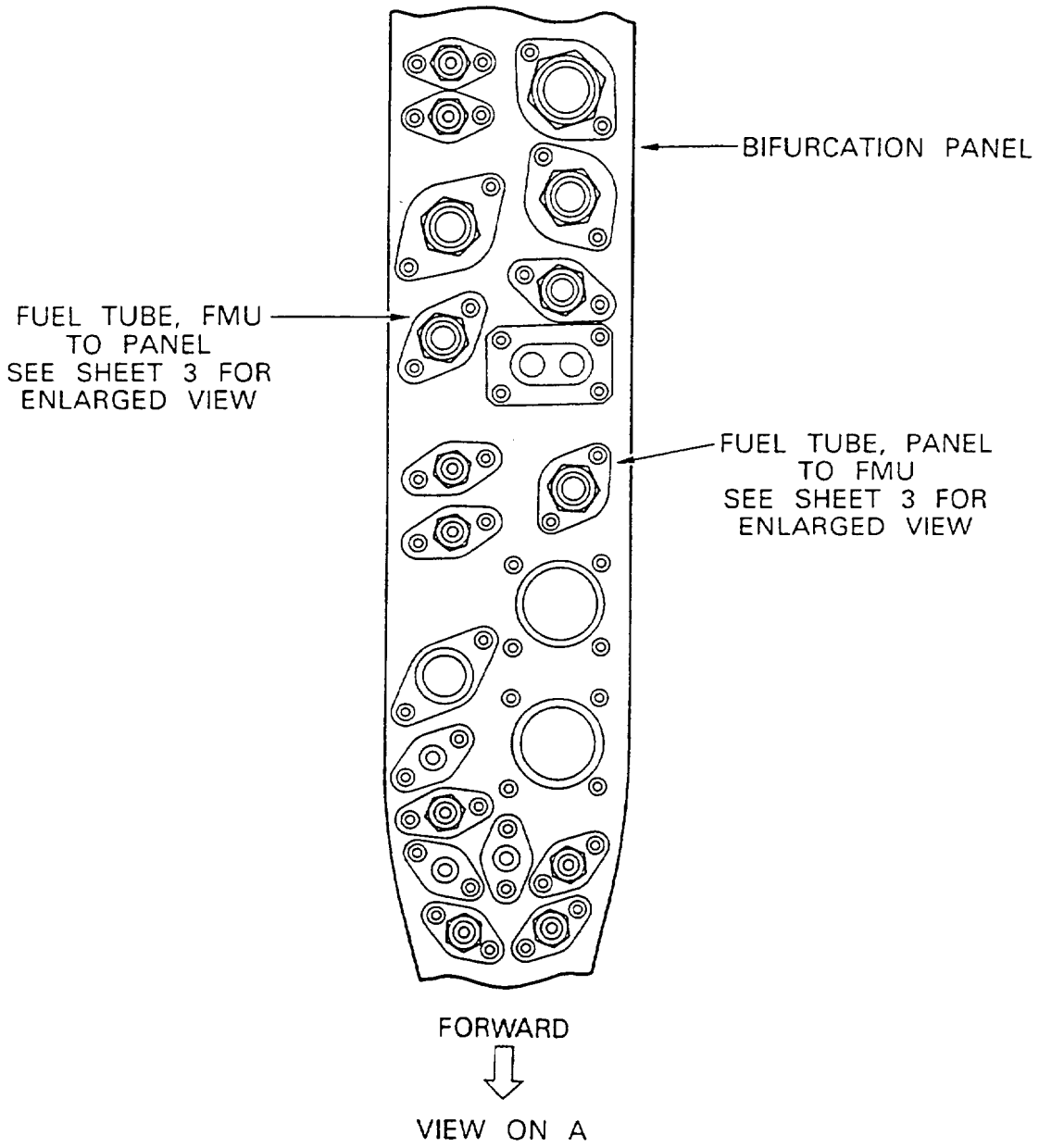
(b) Do not apply a load during this time.

B. Recording Instructions

(1) A record of accomplishment is necessary.



Incorporation of new sealing process
Fig.1(Sheet 1 of 4)



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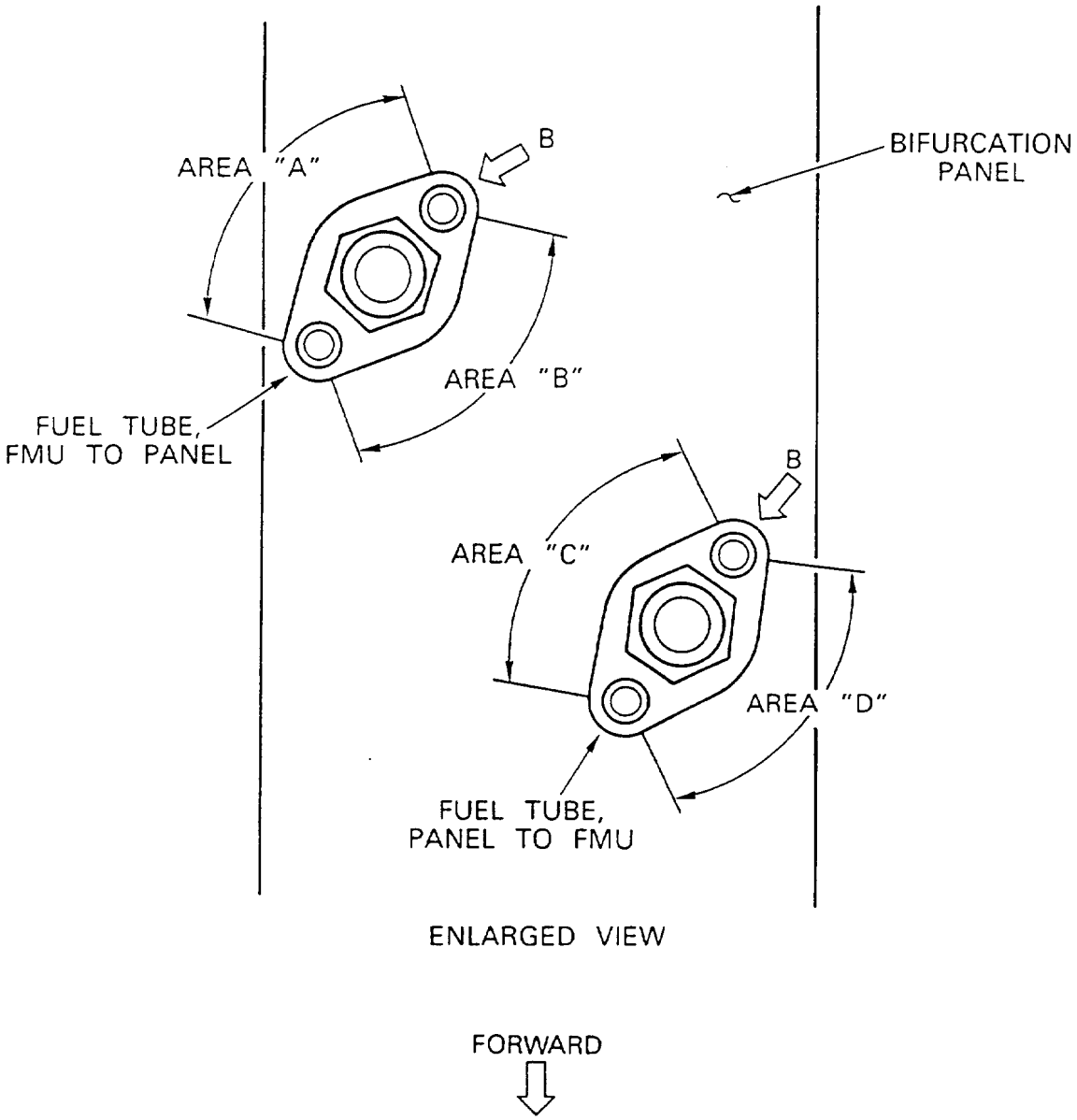
Incorporation of new sealing process
Fig.1(Sheet 2 of 4)



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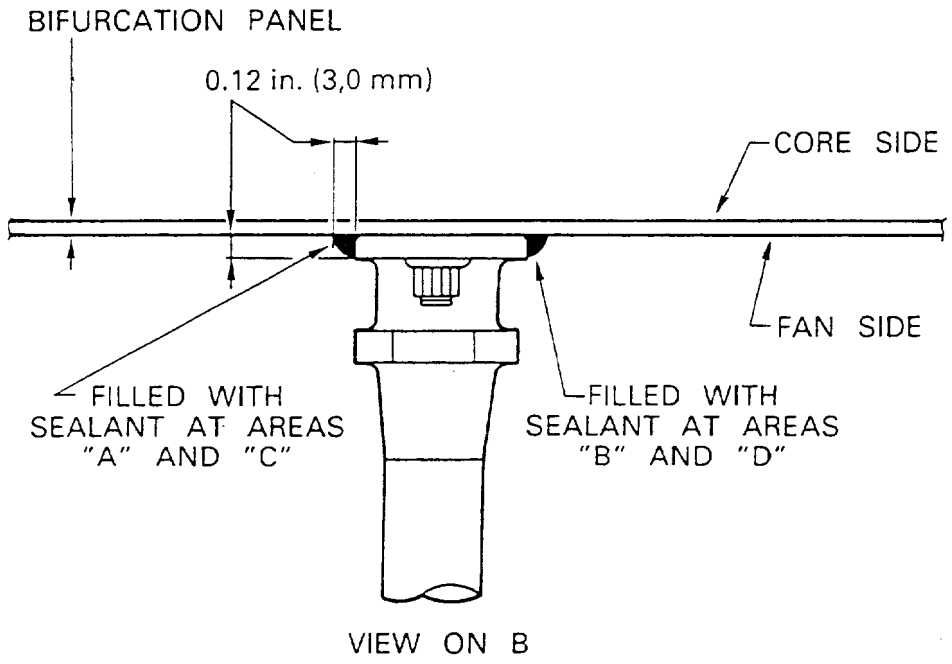
Incorporation of new sealing process
Fig.1(Sheet 3 of 4)



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Incorporation of new sealing process
Fig.1(Sheet 4 of 4)

3. Material Information

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

None

C. Instruction/Disposition Code Statements:

Not applicable - no new parts introduced