



SERVICE BULLETIN

ENGINE – HP TURBINE ROTOR AND STATOR ASSEMBLY – PROVIDE NEW STAGE 2 DUCT SEGMENTS
INCORPORATING REVISED COATING REQUIREMENTS – CATEGORY CODE 7 – MOD.ENG-72-0085

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engine prior to Serial No.V0165 except
Serial No's.V0156, V0160 and V0162

B. Reason

(1) Condition

Erosion and Spalling of the current Stage 2 HPT Duct Segments can cause blade tip gap unacceptable measurements.

(2) Background

It has been determined that erosion and spalling can occur on the duct segments when the coating becomes worn.

(3) Objective

To improve the durability of Stage 2 HPT Duct Segment coating and enhance engine performance.

(4) Substantiation

Successful endurance testing on several test engines.

(5) Effect of Bulletin on Workshop Procedures:

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

C. Description

- (1) The change introduced by this Service Bulletin is as follows:

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- (a) A new Stage 2 HPT Duct Segment has been provided featuring improved coating to enhance performance.

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

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Accomplish when supply of superseded parts has been depleted.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

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.

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**K. References**

- (1) Internal Reference No.

EC88VA219

EC90VK014

- (2) Other References

V2500 Engine Illustrated Parts Catalog.

V2500 Engine Manual.

L. Other Publications Affected

- (1) The V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-42-25, Figure 1, to add the new part.
- (2) The V2500 Engine Manual, Chapter/Section 72-42-25, Cleaning, to add the new part.
- (3) The V2500 Engine Manual, Chapter/Section 72-42-25, Inspection/Check, to add the new part.
- (4) The V2500 Engine Manual, Chapter/Section 72-42-25, Repair, VRS3248 and 3465 to add the new part.



2. Accomplishment Instructions

A. Rework Instructions

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

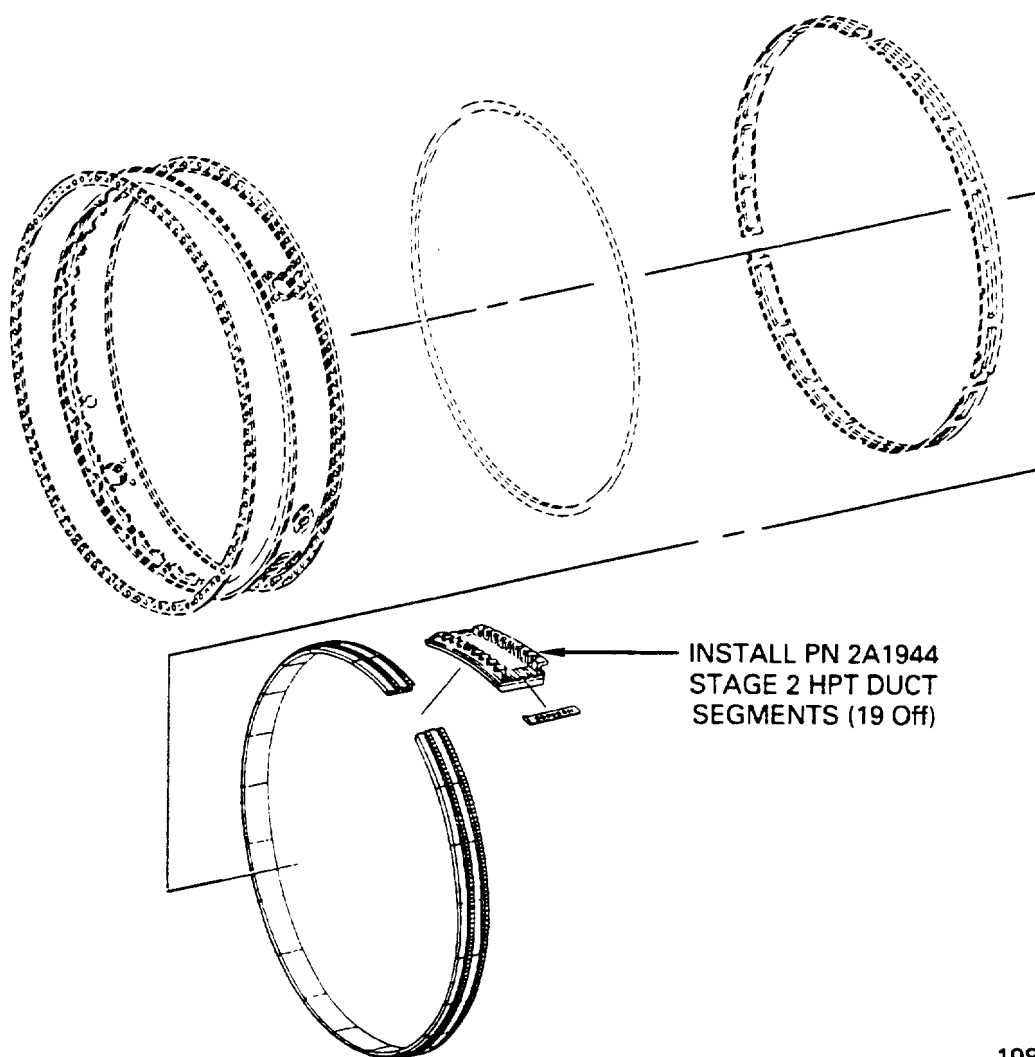
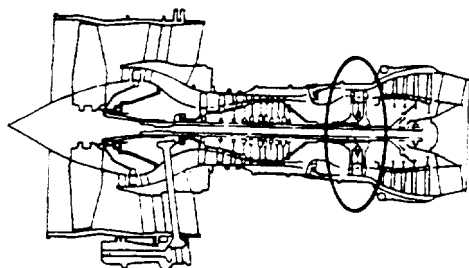
B. Assembly Instructions

(1) Replace the 2A0108 Stage 2 HPT Duct Segments with 2A1944 Stage 2 HPT Duct Segments (19 off) by the approved procedure in Reference (2), Chapter/Section 72-45-20, Assembly-02.

NOTE: The new Stage 2 HPT Duct Segments must be replaced in complete sets only. Do not mix the new segments with the old segments.

C. Recording Instructions

(1) A record of accomplishment is necessary.



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Location of stage 2 HPT duct segments
Fig.1

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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
2A1944 (72-45-25)	19	1244.00	Duct Segment - HPT, Stage 2	2A0108 (01-060)	(S1)(A) (B)

C. Instruction/Disposition Code Statements:

- (S1) New parts coded (S1) must replace old parts coded (S1) in a COMPLETE SET per Engine.
- (A) New part is currently available.
- (B) Old part will no longer continue to be available.

NOTE: The estimated 1991 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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