ENGINE - LP TURBINE - REMOVE THE CORRELATION MARKING ON THE STAGE 6 INNER AIRSEAL - CATEGORY CODE 6 - MOD.ENG-72-0089

1. Planning Information

A. Effectivity

(1) Aircraft: Aribus A320

(2) Engines: V2500-A1 Engines listed below:

V0008, V0010, V0012, V0014, V0016, V0018, V0020, V0022, V0024, V0026, V0028, V0030, V0032, V0034, V0036, V0038, V0040.

B. Reason

(1) Condition

The engine Serial numbers listed above have a vibroengraved correlation marking on the stage 6 Turbine inner airseal that is not required for use at engine assembly.

(2) Objective

The instructions given in Section 2 of this Service Bulletin are to remove the correlation marking on the affected stage 6 Turbine inner airseals.

(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

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) At overhaul	TOTAL 33 minutes
(a) To gain access	Parts are accessible at overhaul
(b) To embody	TOTAL 33 minutes
(i) Remove the correlation masking	7 minutes
(ii) Examine the repaired area	26 minutes

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

J. References

(1) Internal Reference No.

EC90VM504

(2) Other References

IAE Engineering Change 89VM514

V2500 Engine Illustrated Parts Catalogue

V2500 Standard Practices/Process Manual

2. Accomplishment Instructions

A. Blend repair the stage 6 turbine inner airseal, 3A0078.

(1) Identify the correlation marking on the stage 6 turbine inner airseal. Refer to Figure 1.

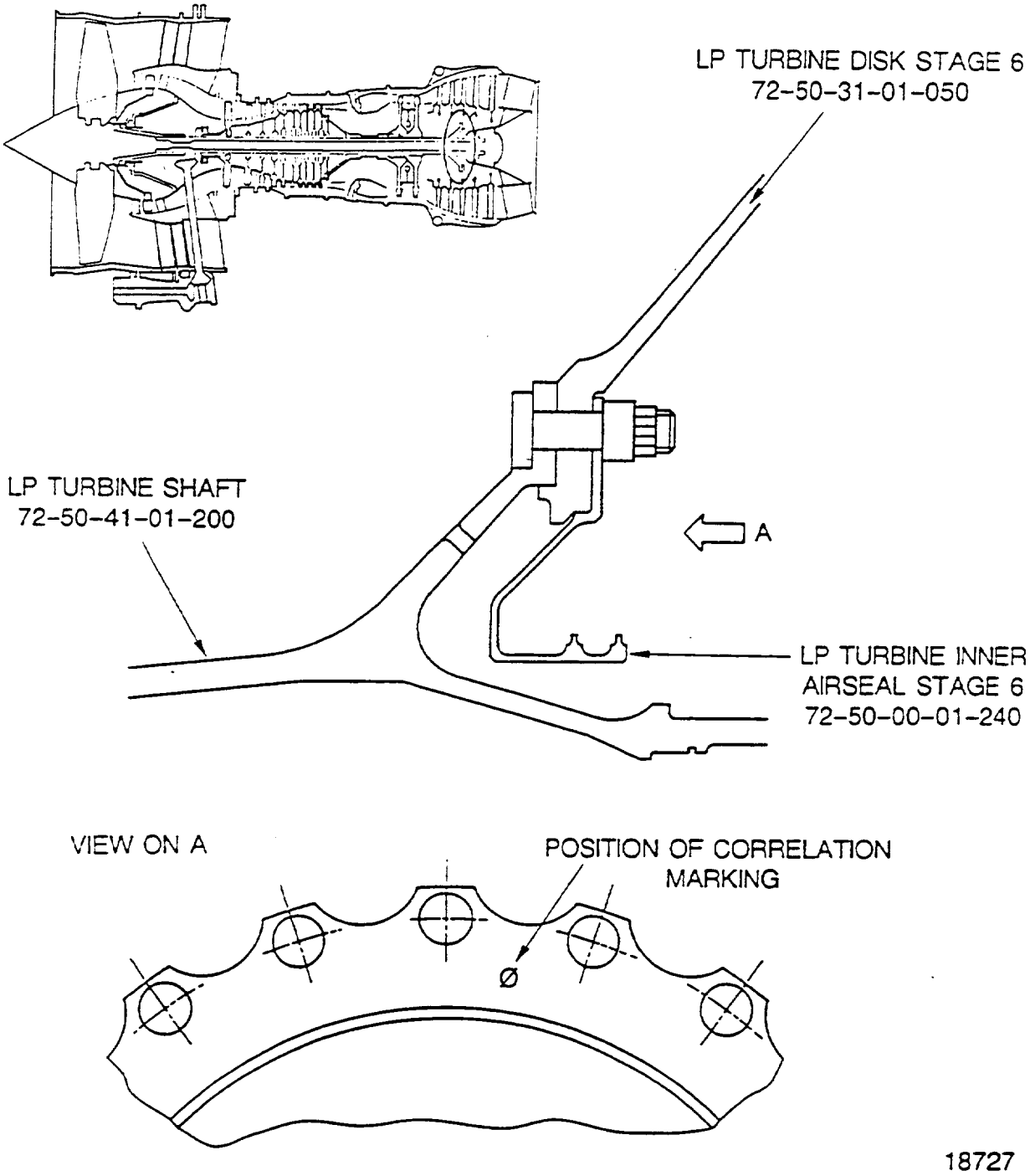
NOTE: The correlation marking is located on the rear side of the airseal flange.

(2) Remove the correlation marking.

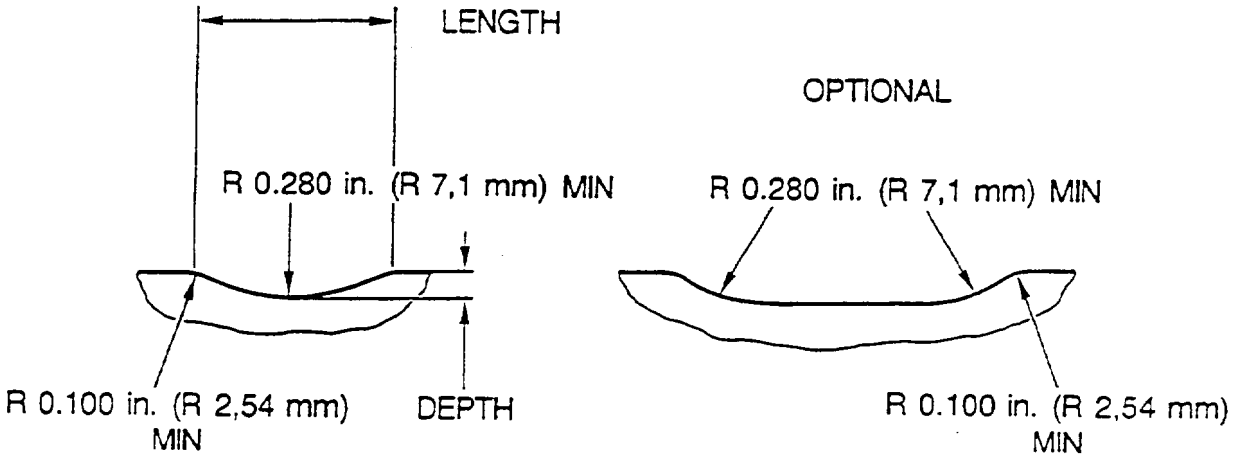
Procedure	Supplementary Information
(a) Blend repair the airseal to remove the correlation marking	Perform blend repair in circumferential direction only. keep material removal to the minimum to remove the damage. Maximum depth of blend repair is 0,010in. (0,25 mm). Length to depth blend ratio is 5:1 minimum. Refer to Fig 2.
(b) Polish the blended area	Use fine hand held stones to make the blended surface as smooth as the initial surface.

(3) Examine the repaired area of the stage 6 turbine inner seal.

Procedure	Supplementary Information
(a) Inspect for cracks	Inspect the blended area. Refer to TASK 70-23-05-230-501. No cracks are permitted.
(b) Inspect the surface finish	The surface finish of the repaired area must be 32 microinch (0,8 micrometer).



Stage 6 turbine inner airseal, position of correlation marking
Fig.1



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Blend repair information
Fig.2

3. Material Information

Not applicable.