



ENGINE - CASE AND VANE ASSEMBLY - HP TURBINE, STAGE 1 DUCT SEGMENTS - NOT APPLICABLE
- MOD.ENG-72-0091

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: Only those V2500 Engines listed below:
Engine Serial - V0046

B. Reason

To gain service experience on a new first stage Duct Segment featuring a more durable ceramic coating. This configuration should improve wear resistance, decrease spalling, and decrease blade tip gaps which will improve engine performance.

C. Compliance

Category Code

Not applicable

This Service Bulletin is released for purposes of controlled service introduction.

D. Approval

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

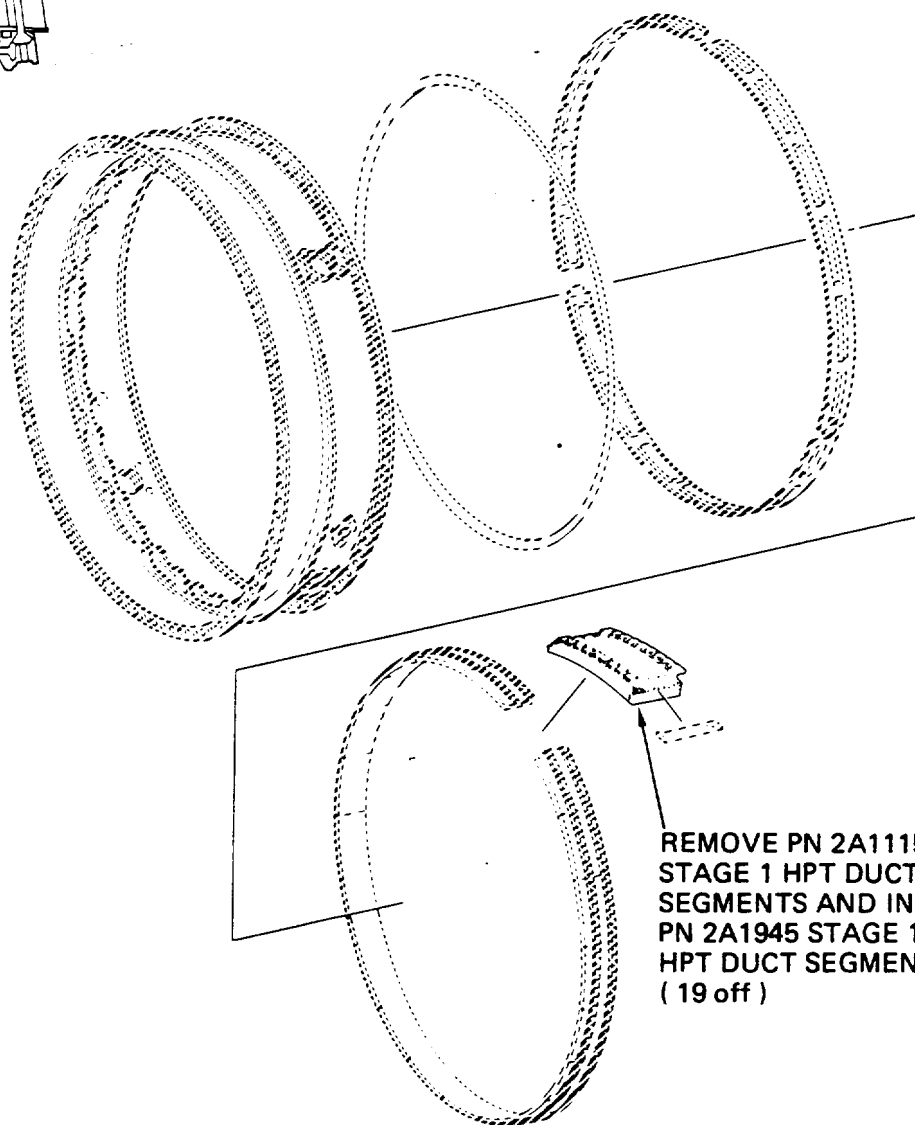
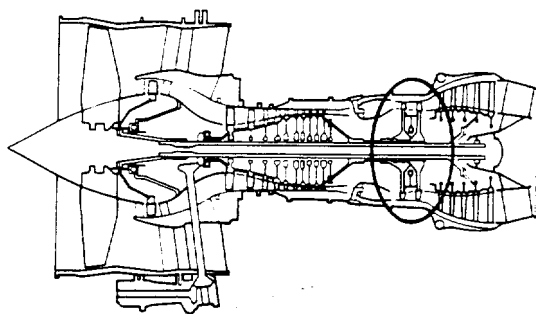
E. References

- (1) Internal Reference No.
88VA219B
- (2) Other References
V2500 Engine Manual
V2500 Standard Practices Manual
V320 Aircraft Maintenance Manual

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**F. Action**

- (1) Remove the 2A1115 Stage 1 HPT Duct Segments by the approved procedure in Reference (1) Chapter/Section 72-45-20 Disassembly.
- (2) Install the 2A1945 Stage 1 HPT Duct Segments (19 off) by the approved procedure in Reference (1) Chapter/Section 72-45-20 Assembly. See Figure 1.
- (3) Identify the 2A1357 Turbine Case and Vane Assembly as 2A2194 by the approved procedure in Reference (2), Chapter/Section 70-09-00, Marking of Parts.
 - (a) Use the vibration peen method.
- (4) Do an inspection at the times specified and by the approved procedure in Reference (3) Chapter/Section 72-00-00 Inspection/Check.
- (5) At each shop visit of the 2A2194 Stage 1 HPT Case and Vane Assembly (after the initial installation of 2A1945 Stage 1 HPT Duct Segments) do the inspections which follow.
 - (a) When the Case and Vane Assembly is disassembled, do an inspection of the Stage 1 HPT Duct Segments by the approved procedure in Reference (1), Chapter/Section 72-45-23 Inspection-04.
 - (b) When the Case and Vane Assembly will not be disassembled do a check of the HP interface by the approved procedure in 72-00-45 Inspection/Check-02.
 - (c) If at any time the Stage 1 HPT Duct Segments are not in the limits specified do the steps which follow.
 - (i) Remove 2A1945 Stage 1 HPT Duct Segments by the approved procedure in Reference (1) Chapter/Section 72-45-20 Disassembly.
 - (ii) Install 2A1115 Stage 1 HPT Duct Segments by the approved procedure in Chapter/Section 72-45-20 Assembly.
 - (iii) Identify the 2A2194 HPT Case and Vane Assembly as 2A1357 by the approved procedure in Reference (2), Chapter/Section 70-09-00, Marking of Parts. Use the vibropeen method.
 - (iv) Send all removed 2A1945 Stage 1 HPT Duct Segments together with parts time and cycle history to your IAE representative for return to International Aero Engines.



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Location of stage 1 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
2A2194 (72-45-20)	1	-	Case and Vane Assembly-Turbine	2A1357 (01-005)	(1D)(B)
2A1945 (72-45-23)	19	-	Duct Segment-HPT	2A1115 (01-060)	(A)(B)

C. Instruction/Disposition Code Statements:

- (1D) A modification can be done to the old part and it can be identified as the new part number.
- (A) Obtain the new part number from the IAE representative.
- (B) The old part will continue to be supplied.

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.