



Subject: Transmittal of Revision 1 to Service Bulletin No. V2500-ENG-72-0094

Service Bulletin Revision History:

Event	Date
Basic Issue	Jan. 11/91
Revision 1	Jan. 6/92

Reason for Issuance of Revision:

To amend part number in the Planning Information sub-paragraph 1.C. (1) (b) and part quantity in the Material Information.

Effect on Past Compliance:

None

List of Effective Pages:

Bulletin Page No.	Rev. No.	Effective Date
R 1	1	Jan. 6/92
2	Basic	Jan. 11/91
R 3	1	Jan. 6/92
4	Basic	Jan. 11/91
R 5	1	Jan. 6/92
6 to 8	Basic	Jan. 11/91
R 9	1	Jan. 6/92

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Subject: Transmittal of Service Bulletin No. V2500-ENG-72-0094

Transmitted herewith is Initial Issue of Subject V2500 Engine Service Bulletin which consists of Page Numbers 1 through 9, inclusive. (Note: There are no blank pages.)

If any of the Service Bulletin pages associated with this transmittal are missing or illegible, please bring the matter to the attention of:

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V2500 Propulsion System — Engine

SERVICE BULLETIN

ENGINE - LP COMPRESSOR - REPLACE THE FAN EXIT GUIDE VANE
ASSEMBLY PLATFORM BOLTS

MODEL APPLICATION

V2500-A1

BULLETIN INDEX LOCATOR

72-32-00

Compliance Category Code

6

Internal Reference No.

EC90VJ001

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SERVICE BULLETIN

ENGINE - LP COMPRESSOR - REPLACE THE FAN EXIT GUIDE VANE ASSEMBLY PLATFORM BOLTS

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines Prior to Serial Number V0146

B. Reason

(1) Condition

It was determined that some Special Bolts used to secure the Fan Exit Guide Vane (FEGV) Platform may have to be shortened in length to enable the LP Compressor Stage 1.5, 2 and 2.5 Assembly to disassemble and assemble without removal of the Special Bolts.

(2) Background

With the existing configuration of longer Special Bolts which have a change letter "A" for the 5A4122, it is possible for an interference between the bolt ends and the Stage 2.0 Vane Assembly if the LP Compressor Stage 1.5, 2 and 2.5 Assembly is disassembled and assembled without removal of Bolts, though no obstruction exists with that of shorter Special Bolts which have a change letter "B" for the 5A4122.

(3) Objective

The incorporation of the Service Bulletin (Modification) is intended to permit Disassembly/Assembly of the LP Compressor Stage 1.5, 2 and 2.5 Assembly without removal of the FEGV Platform Special Bolts to improve the maintainability.

(4) Substantiation

Substantiation test is not required.

(5) Effects of Bulletin on Workshop Procedures:

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



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(6) Supplemental Information

- (a) The Post-Service Bulletin configuration permits the LP Compressor Stage 1.5, 2 and 2.5 Assembly to disassemble and assemble without removal of the FEGV Platform Special Bolts.

C. Description

- (1) The changes introduced by this Service Bulletin are as follows:

- (a) The existing Special Bolts 5A4122 with change letter "A" have been changed in length from 1.290 - 1.309in. (32,75 - 33,25 mm) to 1.211 - 1.230in. (30,75 - 31,25 mm) and reidentified to a new part number 5A0849. (See Figures 1 and 2).
- (b) The existing 1.211 - 1.230in. (30,75 - 31,25 mm) long Special Bolts 5A4122 with change letter "B" have been reidentified to a new part number 5A0849. (See Figures 1 and 2).

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- (2) The existing Special Bolts can be reworked to a new configuration. (See Figure 2).
- (3) New FEGV Platform Special Bolts will be available for future replacement purposes.

D. Approval

The Part Number changes and/or part modifications described in Section 2 and 3 of this Service Bulletin have 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 subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected parts and to all affected spare parts.



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F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin.

<u>Venue</u>	<u>Estimated Manhours</u>
(1) In service	Not applicable.
(2) At overhaul	Total 3 hours 48 minutes
(a) Identify the 40 off special bolts	3 minutes
(b) Rework the 20 off special bolts 5A4122A ..	2 hours 30 minutes
(c) Dress reworked special bolts	48 minutes
(d) Reidentify the 40 off special bolts	27 minutes
TOTAL 3 hours 48 minutes	

G. Material - Price and Availability

- (1) Modification Kit is not required.
- (2) See "Material Information" section for prices and availability of future spares.

H. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

I. Weight and Balance

- | | |
|-------------------------|--|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front centerline
(Power Plant Station (PPS) 100) |

J. Electrical Load Data

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



V2500 Propulsion System — Engine

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K. References

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-00.
- (2) V2500 Engine Manual, 72-32-00, LP Compressor/Intermediate Case Module - Disassembly, TASK 72-32-00-030-004 and Assembly, TASK 72-32-00-430-012.
- (3) V2500 Facilities Equipment Manual, Section 6.6 Repair - Machining.
- (4) V2500 Standard Practices/Processes Manual, 70-09-00, Marking of Parts, TASK 70-09-00-400-501.

L. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-00.
- (2) V2500 Engine Manual, 72-32-00, LP Compressor/Intermediate Case Module, Disassembly-06 and Assembly-10.

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2. Accomplishment Instructions

A. Rework Instructions

- (1) Collect the longer Special Bolts which have the identification number 5A4122A on the bolt head to rework and renumber.
- (2) Collect the shorter Special Bolts which have the identification number 5A4122B on the bolt head to renumber.
- (3) Rework the identification number 5A4122A, longer Special Bolts, with the identification No. RM007, Standard Precision Lathe, to decrease the length of Bolts. (Refer to Figure 2 and 1.K. (3)).

The length of Bolt	Before rework	After rework
	1. 309 (33, 25)	1. 230 (31, 25)
	1. 290 (32, 75)	1. 211 (30, 75)

- (4) Renumber the identification number 5A4122A, longer Special Bolts, and 5A4122B, shorter Special Bolts, with Vibro-peen. (Refer to Figure 2 and 1.K. (4)).

Existing	Renumber
5A4122A	5A0849
5A4122B	5A0849

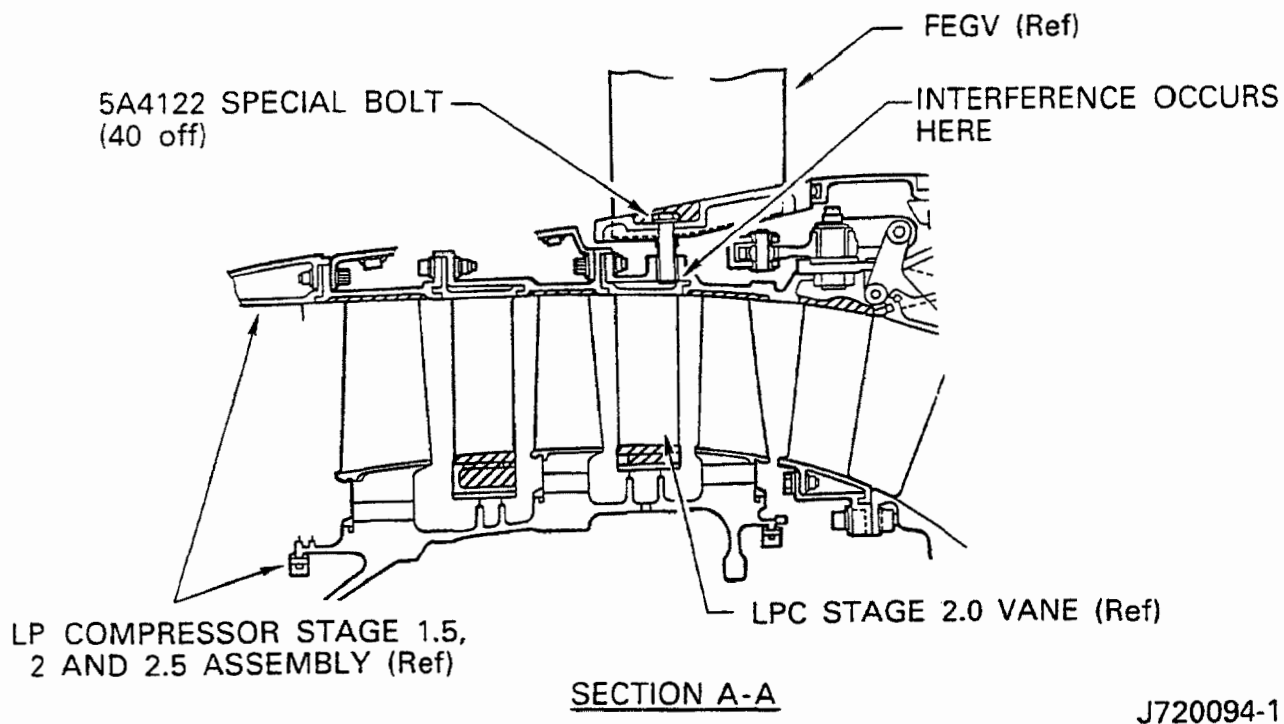
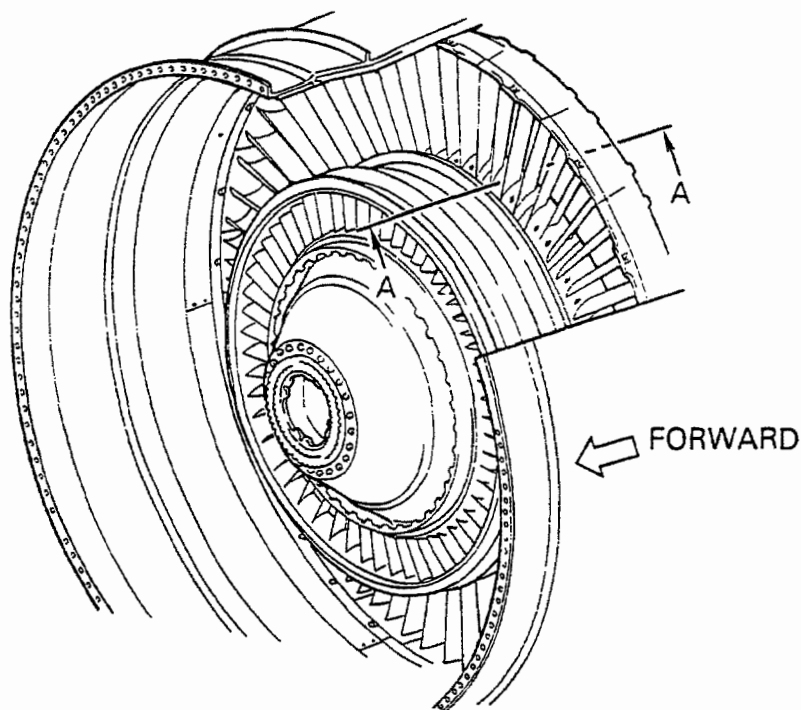
B. Assembly Instructions

- (1) Install the FEGV's with the forty new 5A0849, Special Bolts, to the LP Compressor/Intermediate Case Module by the approved procedures in the Engine Manual, 72-32-00, Assembly, TASK 72-32-00-430-012. (Refer to 1.K. (2)).

C. Recording Instructions

- (1) A record of accomplishment is necessary.

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Location of the FEGV's Platform Special Bolts
Figure 1

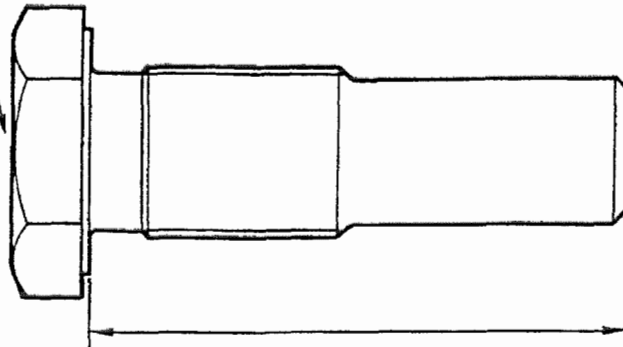
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MARK NEW PN 5A0849 WITH VIBRO-PEEN ADJACENT TO EXISTING PN 5A4122A IDENTIFIED HERE. MARK TWO LINES (≡) ON EXISTING PN WITH VIBRO-PEEN TO ERASE IT.

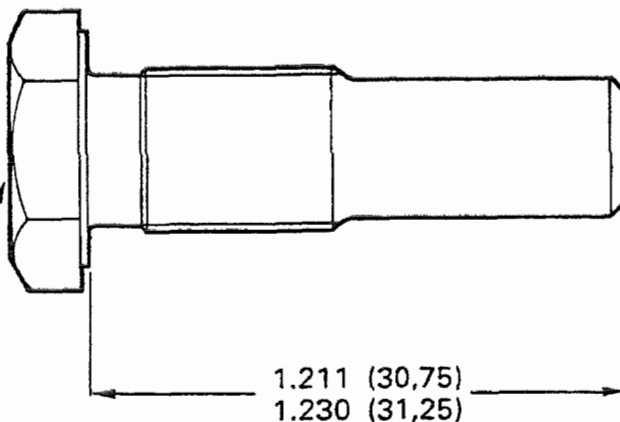


BEFORE ALTERATION 1.290 (32,75)
1.309 (33,25)

AFTER ALTERATION 1.211 (30,75)
1.230 (31,25)

CHAMFER
0.031 (0,8) x 45 DEG

MACHINE WHERE MARKED ✓ TO DECREASE THE LENGTH OF PN 5A4122A BOLT.
SURFACE TEXTURE TO BE 248 MICROINCHES (6,3 MICROMETERS).
BREAK SHARP EDGES 0.003-0.015 (0,08-0,38).



MARK NEW PN 5A0849 WITH VIBRO-PEEN ADJACENT TO EXISTING PN 5A4122B IDENTIFIED HERE. MARK TWO LINES (≡) ON EXISTING PN WITH VIBRO-PEEN TO ERASE IT.

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Rework of the FEGV's Platform Special Bolts
Figure 2



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3. Material Instruction

Applicability: For each V2500A-1 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

	New		Est'd		Keyword	Old		Instructions
	Part No. (ATA No.)	Qty	Unit	Price (\$)		Part No. (IPC No.)	Disposition	
R	5A0849 (72-32-00)	40	-		Bolt, Special	5A4122 (01-377)	(A) (B) (S1) (1D)	

C. Instruction/Disposition Code Statements:

- (A) New Parts are currently available for sale.
- (B) Old Parts will no longer be available for sale.
- (S1) Old and New Parts are freely and fully interchangeable,
both physically and functionally.
- (1D) Old Parts can be reworked and identified to new Part Number.

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.

