



ENGINE - LP COMPRESSOR - INCORPORATE ANTI-FRET COATING ON THE ANNULUS FILLER ASSEMBLY
FRONT FACE - CATEGORY CODE 6 - MOD.ENG-72-0096

1. Planning Information

A. Effectivity

- (1) Airplane: Airbus A320
- (2) Engine: V2500-A1 Engines prior to Serial No. V0180 and Engine Serial no. V0221.

B. Reason

(1) Condition

Fretage may occur between the front face of Annulus Filler Assembly and the LP Compressor Fan Blade Front Retaining Ring.

(2) Background

This condition has been observed on the development engine during the strip inspections.

(3) Objective

The incorporation of this Service Bulletin is designed to maintain the durability of the Annulus Filler Assemblies.

(4) Substantiation

The configuration change shown in this Service Bulletin has been subjected to an endurance testing on development engine. The results obtained were satisfactory.

(5) Effects of Bulletin on Workshop Procedures:

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

(6) Supplemental Information

Inspection/Check and Repair of the post Service Bulletin configuration is affected due to the application of anti-fret coating to the front face of Annulus Filler Assembly.

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**C. Description**

- (1) The changes introduced by this Service Bulletin are as follows:
- (a) One coat of the dry film lubricant is applied to the front face of Annulus Filler Assembly to prevent fretting between the Annulus Filler Assembly and the LP Compressor Fan Blade Front Retaining Ring. (See Figure 1).
 - (b) Existing Part Number of the Annulus Filler Assembly has been changed to a new Part Number.
- (2) Existing Annulus Filler Assembly can be reworked to a new configuration. (See Figure 1).

D. Approval

The Part Number changes and part modifications described in Section 2 and 3 of this Service Bulletin have shown to comply with the applicable Federal Aviation Regulations and FAA-APPROVED for the Engine Model listed.

E. Compliance

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Accomplish when the subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to 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	TOTAL 15 hours 46 minutes

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

- (a) To rework the Annulus Filler Assembly
(22 off) 14 hours 40 minutes
- (b) To reidentify the Annulus Filler Assemblies 1 hour 6 minutes

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TOTAL 15 hours 46 minutes

G. Material - Price and Availability

- (1) Modification kit is not required. Parts are supplied as single line items.
- (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 mount centerline
(Power Plant Station (PPS) 100)

J. Electrical Load Data

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

K. References

- (1) Internal Reference No.

EC88VJ703

- (2) Other References

V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-31-11.

V2500 Engine Manual, 72-31-00, Assembly TASK 72-31-00-430-001.

V2500 Standard Practices/Processes Manual, 70-09-00, Marking of Parts TASK 70-09-00-400-501, and 70-38-03, Surface Treating TASK 70-38-03, Surface Treating TASK 70-38-03-380-501.

V2500 Overhaul Processes and Consumables Index.

L. Other Publications Affected

- (1) V2500 Powerplant Illustrated Parts Catalog, Chapter/Section 72-31-11.
- (2) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-31-11.

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- (3) V2500 Engine Manual, 72-31-11, Cleaning-01, Inspection/Check-00, -01, and Repair 001 (VRS1004), 002 (VRS1009), 003 (VRS1007), 004 (VRS1008), 005 (VRS1010).

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2. Accomplishment Instructions

A. Rework Instruction

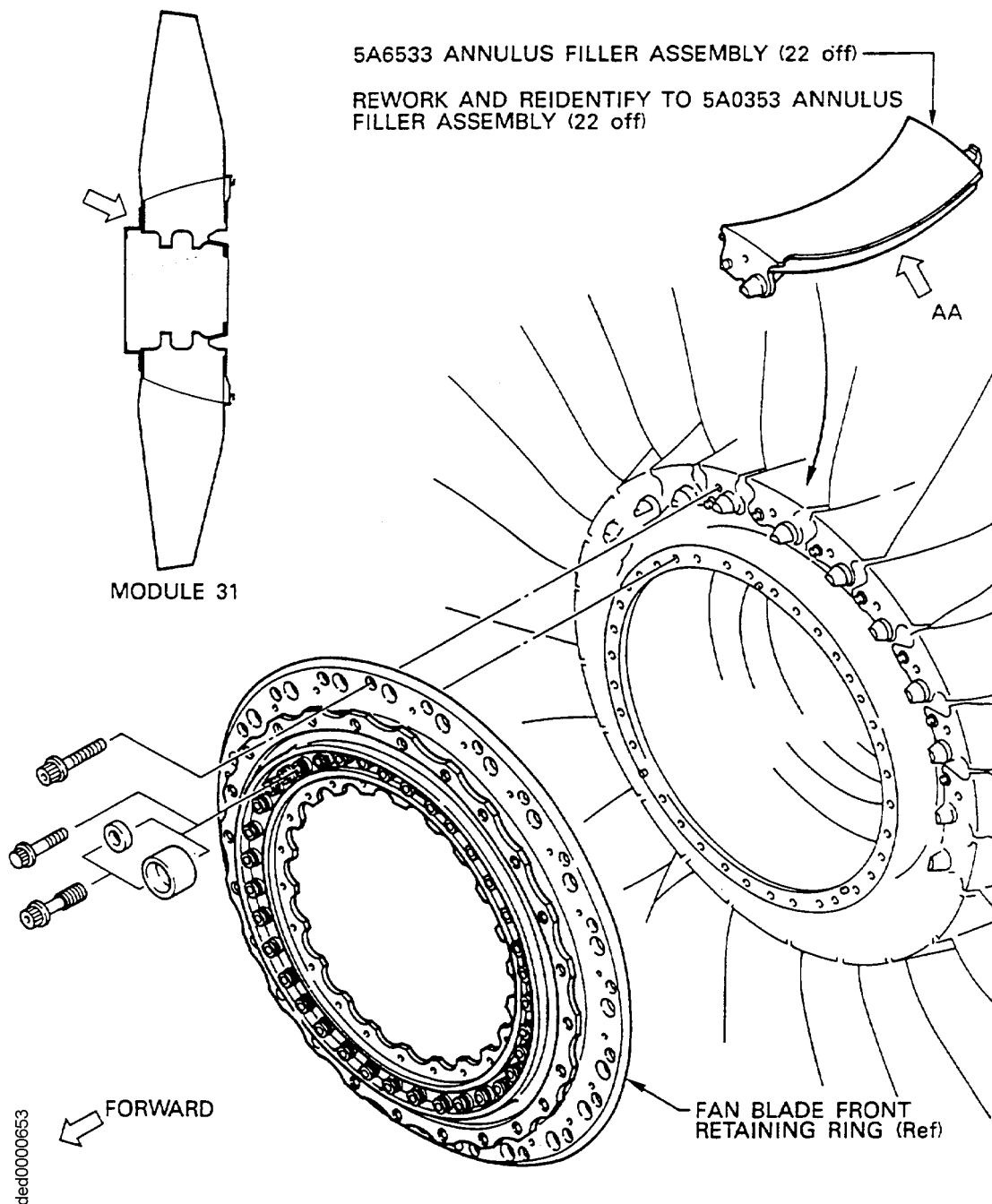
Procedures	Supplementary Information	
(1) Apply one coat of CoMat 10-004, Dry Film Lubricant PL.237, to each front face of the 22 PN 5A6533, Annulus Filler Assemblies, by the approved procedures in the Standard Practices /Processes Manual, 70-38-03.	Refer to Figure 1, 1.K. (3) and 1.K. (4). Coating thickness must be 0.00012 to 0.00059 in. (0,003 to 0,015 mm).	
(2) Renumber with Vibro-peen adjacent to the old part number marked on each rear face of Annulus Filler Assemblies by the approved procedures in the Standard Practices /Processes Manual, 70-09-00.	Refer to Figure 1, and 1.K. (3) Existing Renumber 5A6533 5A0353	

B. Assembly Instruction

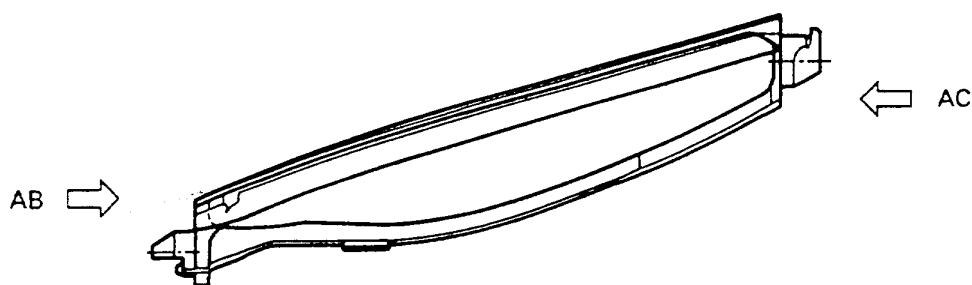
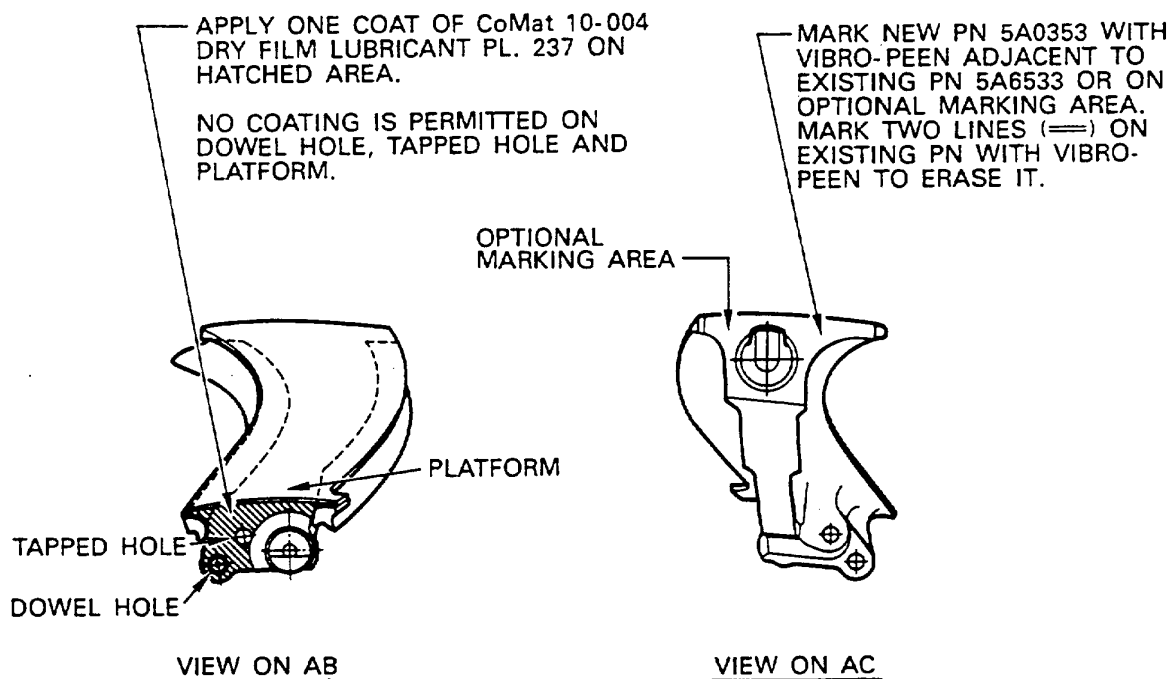
- (1) Assemble the 22 PN 5A0353, Annulus Filler Assembly, to the LP Compressor (Fan) Module by the approved procedures in the Engine Manual, 72-31-00, Assembly. (Refer to 1.K. (2).)

C. Recording Instructions

- (1) A record of accomplishment is necessary.



Modification of the Annulus Filler Assembly
Fig.1, Sheet 1 of 2

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Modification of the Annulus Filler Assembly
Fig.1, Sheet 2 of 2

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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
5A0353 (72-31-11)	22		.Filler, A/O Annulus	5A6533 (01-100)	(A)(B)(S1) (1D)

C. Instruction/Disposition Code Statements:

- (A) New Parts are currently available for sale.
- (B) Old Part 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 reidentified to the new Part Number.

NOTE: The estimated 1991 unt 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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