



ENGINE - LP COMPRESSOR - ADD PART NUMBER MARKINGS TO VARIOUS ADJUSTING WASHERS -
CATEGORY CODE 6 - MOD.ENG-72-0114

Printed in Great Britain

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) Airbus A320
(b) Airbus A321
(c) McDonnell Douglas MD-90
- (2) Engine: (a) V2500-A1 Engines prior to V0338
(b) V2527-A5 Engines prior to V10020
(c) V2530-A5 Engines prior to V10020
(d) V2525-D5 Engines prior to V20007
(e) V2528-D5 Engines prior to V20007

B. Concurrent Requirements

None.

C. Reason

To introduce marking of part number on to the HPC and the PT0 adjusting washers to ease part handling, and it is also noted that this procedure eliminates measurement work.

D. Compliance

Category Code 6

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.

E. Approval

The marking instructions of part number and the thickness of adjusting washer described in Section G of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

F. References

- (1) Internal Reference No.

V2500-ENG-72-0114



EC93VJ002

ECM93VJ002-01

(2) Other References

V2500 Engine Illustrated Parts Catalog.

V2500 Engine Manual.

V2500 Standard Practices/Processes Manual.

G. Action

- (1) Make a mark of the part number on to the existing HPC adjusting washers as follows (Refer to Figure 1 and 2);

- (a) Make sure if there is a part number marking on the HPC adjusting washer or not.

NOTE: If there is a part number marking on the HPC adjusting washer, this accomplishment is not necessary.

- (b) Identify the part number of the HPC adjusting washer which is installed between shaft & seal assembly and No.3 bearing seal assembly

NOTE: If there is no part number marking on the HPC adjusting washers, you can check the thickness of the part according to the thickness list of Table 1.

- (c) Make a mark of the part number on to the HPC adjusting washer. Use the vibro-peen method by approved procedures in Reference (3), Chapter/Section 70-09-00, Marking of Parts.

NOTE: If you have parts for spares, you should mark the part number on to the parts. The part numbers to be same as described on the packages or if the parts were already removed from the packages, do a check by Step (b) NOTE.

- (d) Remove the raised metal and burrs produced by step (c).

- (2) Make a mark of the part number on to the existing PT0 adjusting washers as follows (Refer to Figure 1 and 2);

- (a) Make sure if there is a part number marking on the PT0 adjusting washer or not.

NOTE: If there is part number marking on the PT0 adjusting washer, this accomplishment is not necessary.

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- (b) Identify the part number of PTO adjusting washer which is installed between the bevel gearshaft wheel and No.3 bearing front inner race.

NOTE: If there is no part number marking on the PTO adjusting washers, you can check the thickness of the part according to the thickness list of Table 1.

- (c) Make a mark of the part number on to the PTO adjusting washer. Use the vibro-peen method by approved procedures in Reference (3), Chapter/Section 70-09-00, Marking of Parts.

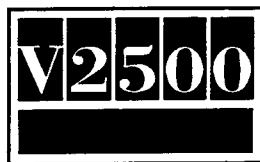
NOTE: If you have parts for spares, you should mark the part number on to the parts. The part numbers to be same as described on the packages or if the parts were already removed from the packages, do a check by Step (b) NOTE.

- (d) Remove the raised metal and burrs produced by step (c).

H. Record of accomplishment is necessary.

UIN	PART NO.	NOMENCLATURE	QTY	MODEL (V2500)	THICKNESS OF ADJUSTING WASHER
723226- 01-430	5A1001	WASHER, ADJUSTING PTO	1	A1	0.177in (4,50mm)
723226- 01-431	5A1002	WASHER, ADJUSTING PTO	Ref	A1	0.179in (4,55mm)
723226- 01-432	5A1003	WASHER, ADJUSTING PTO	Ref	A1	0.181in (4,60mm)
723226- 01-433	5A1004	WASHER, ADJUSTING PTO	Ref	A1	0.183in (4,65mm)
723226- 01-434	5A1005	WASHER, ADJUSTING PTO	Ref	A1	0.185in (4,70mm)
723226- 01-435	5A1006	WASHER, ADJUSTING PTO	Ref	A1	0.187in (4,75mm)
723226- 01-436	5A1007	WASHER, ADJUSTING PTO	Ref	A1	0.189in (4,80mm)
723226- 01-437	5A1008	WASHER, ADJUSTING PTO	Ref	A1	0.191in (4,85mm)
723226- 01-438	5A1009	WASHER, ADJUSTING PTO	Ref	A1	0.193in (4,90mm)

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723226-01-439	5A1010	WASHER, ADJUSTING PTO	Ref	A1	0.195in (4,95mm)
723226-01-440	5A1011	WASHER, ADJUSTING PTO	Ref	A1	0.197in (5,00mm)
723226-01-451	5A1032	WASHER, ADJUSTING PTO	Ref	A1	0.169in (4,30mm)
723226-01-452	5A1033	WASHER, ADJUSTING PTO	Ref	A1	0.171in (4,35mm)
723226-01-453	5A1034	WASHER, ADJUSTING PTO	Ref	A1	0.173in (4,40mm)
723226-01-454	5A1035	WASHER, ADJUSTING PTO	Ref	A1	0.175in (4,45mm)

Thickness List of the PTO adjusting washer
Table 1 (Sheet 1 of 2)

UIN	PART NO.	NOMENCLATURE	QTY	MODEL (V2500)	THICKNESS OF ADJUSTING WASHER
723226-01-500	5A1022	WASHER, ADJUSTING HPC	1	A1	0.157in (4,00mm)
723226-01-501	5A1023	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.167in (4,25mm)
723226-01-502	5A1024	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.177in (4,50mm)
723226-01-503	5A1025	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.187in (4,75mm)
723226-01-504	5A1026	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.197in (5,00mm)
723226-01-505	5A1027	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.207in (5,25mm)
723226-01-506	5A1028	WASHER, ADJUSTING HPC	Ref	A1/A5/D5	0.216in (5,50mm)

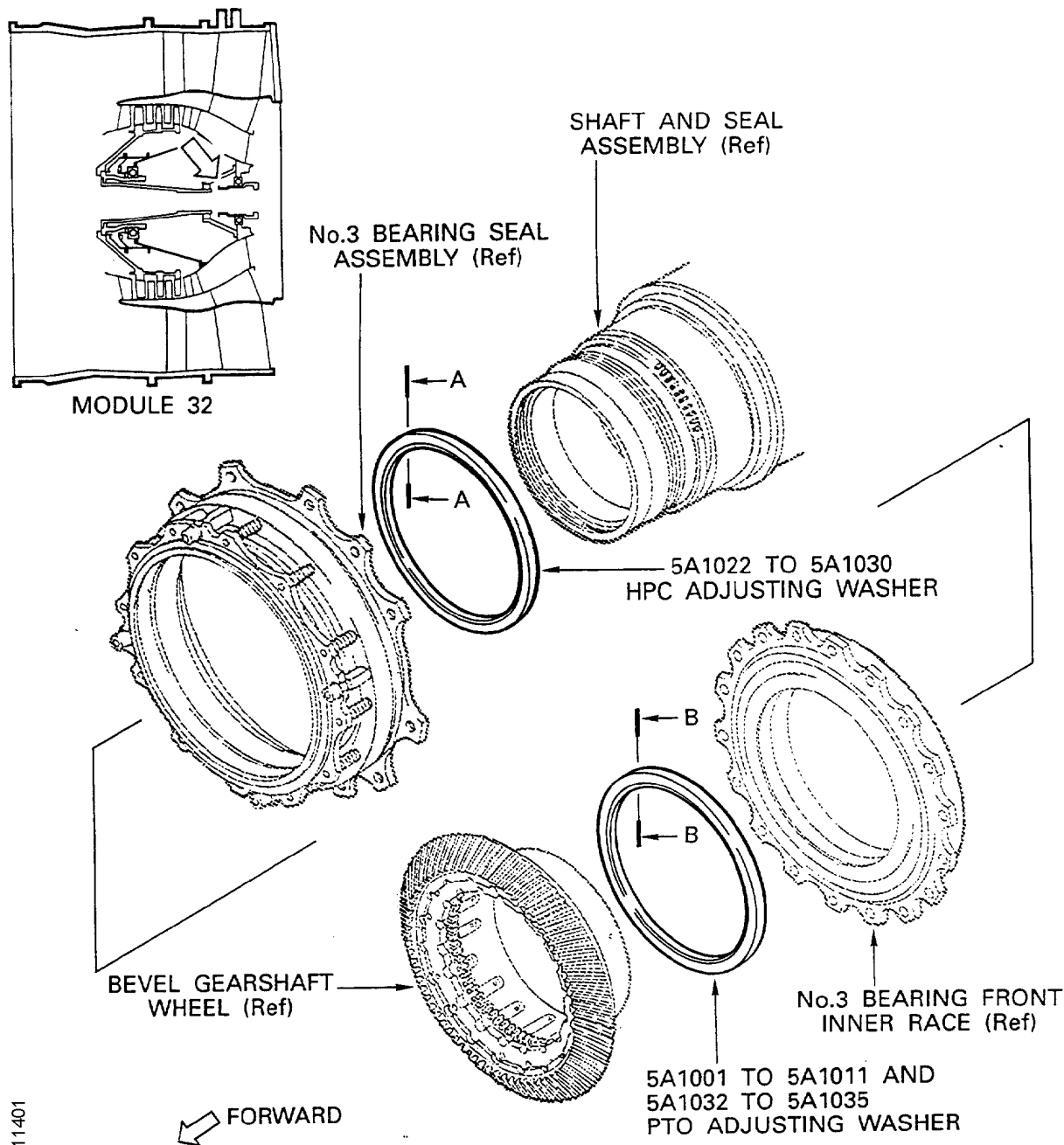
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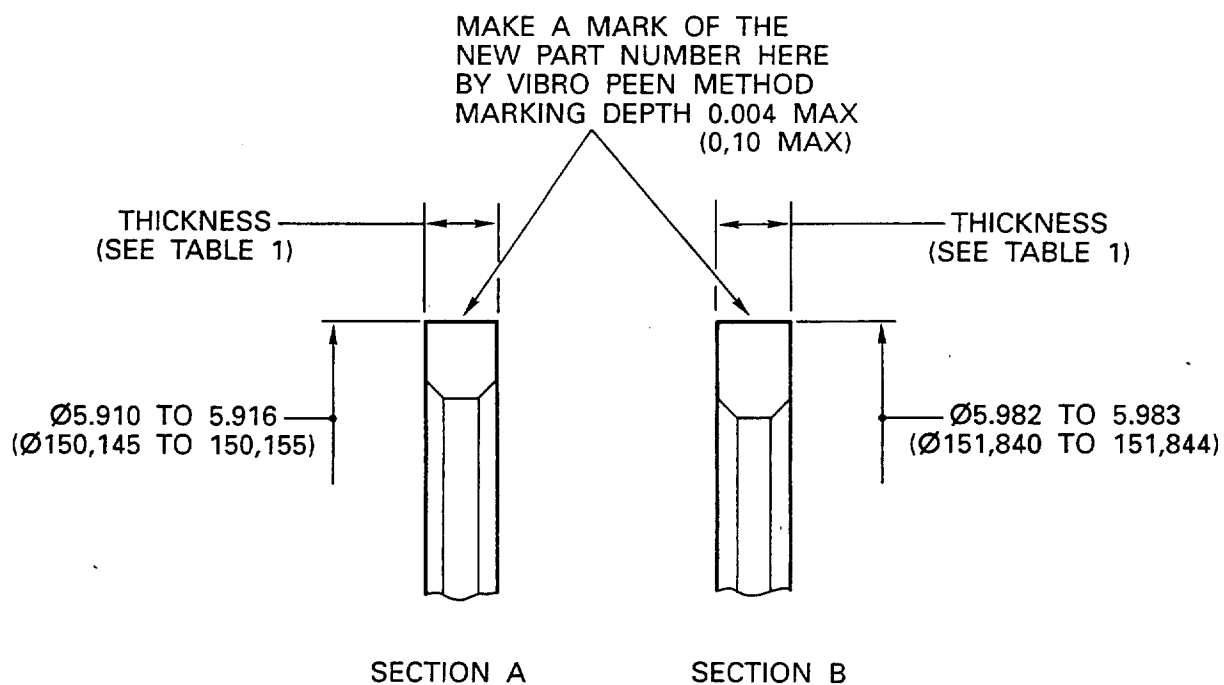
723226-01-507	5A1029	WASHER, ADJUSTING HPC	Ref	A1/A5/D5 0.226in (5,75mm)
723226-01-508	5A1030	WASHER, ADJUSTING HPC	Ref	A1/A5/D5 0.236in (6,00mm)

Thickness list of the HPC adjusting washer
Table 1 (Sheet 2 of 2)



Location of the HPC and the PTO adjusting washers
Fig.1

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Marking position of the HPC and the PT0 adjusting washer
Fig.2



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