



Date: May.30/97

Subject: Transmittal of Revision 1 to Service Bulletin Number
V2500-ENG-72-0132

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jun.30/93
Revision 1	May.30/97

Reasons For Issuance Of Revision:

- (1) To revise the Accomplishment instructions for the installation of plugs in the Fan Frame Assembly.
- (2) To revise Figure 1, Sheet 1 and add Sheets 2 through 4. Original Sheet 1 becomes new Sheet 4.
- (3) To revise the Material Information to show the various conditions for incorporation of the changes specified for the fan frame assembly.
- (4) To update the family trees given in Figure 13, Sheets 1 and 2.

Effect On Past Compliance:

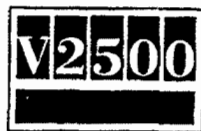
None

List Of Effective Pages:

<u>Bulletin</u> <u>Page No.</u>	<u>Rev.</u> <u>No.</u>	<u>Effective</u> <u>Date</u>
R 1	1	May.30/97
2 to 5	Basic	Jun.30/93
R 6 to 6B	1	May.30/97
7 to 9	Basic	Jun.30/93
R 10 to 10D	1	May.30/97
11 to 40	Basic	Jun.30/93
R 41 to 50	1	May.30/97
51 and 52	Basic	Jun.30/93

V2500 – ENG – 72 – 0132

Transmittal
Page 1 of 1



International Aero Engines SERVICE BULLETIN

ENGINE - LP COMPRESSOR - REMOVAL OF
STAGE 6 BUFFER AIR SYSTEM

MODEL APPLICATION

V2500-A1

BULLETIN INDEX INDICATOR

71-52-00
72-32-00
72-41-00
73-11-00
75-00-00
75-22-00
75-31-00

Compliance Category Code

8

Internal Reference No.

88VA241B
90VA194
92VA081A
92VJ106A

V2500 - ENG - 72 - 0132

June 30/93

R Revision 1 May 30/97

Page 1 of 52



International Aero Engines SERVICE BULLETIN

ENGINE - LP COMPRESSOR - REMOVAL OF STAGE 6 BUFFER AIR SYSTEM

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines before Serial No.V0266

B. Reason

(1) Condition

The Stage 6 Buffer Air System is replaced with a new configuration which reduces engine weight.

(2) Background

It was found to be necessary to reduce engine weight.

(3) Objective

To reduce weight.

(4) Substantiation

Not necessary.

(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

(6) Supplemental Information

- (a) Disassembly/Assembly of the fan frame assembly is affected due to addition of blanking plates and plugs.

C. Description

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

- (a) Remove the parts which are used to supply the stage 6 buffer air.

June 30/93

V2500 – ENG – 72 – 0132

Page 2

Printed in Great Britain



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN

- (b) Provide the blanking plugs and plates in place of the stage 6 buffer air tubes
- (c) Provide a new, lighter, No. 1 Bearing Seal Support.
- (d) Provide a new No. 3 Bearing Seal Ring Holder.
- (e) Provide new configuration No. 1 and No. 3 Bearing Seals.

D. Approval

The Part Number Changes and/or part modifications described in Section 2 and 3 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. Compliance

Category Code 8.

Accomplish based upon experience with the prior configuration.

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 (Note: The parts affected by this Service Bulletin are accessible at overhaul)	
(a) To install the Blanking Plates (2 off) on the Fan Frame Assembly	14 minutes
(b) To mark the new part number on the Fan Frame Assembly ..	<u>1 minute</u>
Total:	15 minutes

G. Material - Price and Availability

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

June 30/93

V2500 - ENG - 72 - 0132

Page 3



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN

H. Tooling - Price and Availability

The following tool is required to accomplish Sub-division 2 of this Service Bulletin:

<u>Tool No.</u>	<u>Qty</u>	<u>Description</u>	<u>Function</u>	<u>Avail.</u>
IAE1P16357	1	Leak Check Fixture	Leak check the No. 1 Bearing Seal Assembly	(1)

(1) Indicates that Tool Design Operature Cards are currently available from IAE.

I. Weight and Balance

- (1) Weight change Minus 21.5 lbs (9,75 kg)
- (2) Moment arm No effect
- (3) Datum Engine front mount Centerline
(Powerplant station P.P.S.100)

J. Electrical Load Data

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

K. Reference

(1) IAE Service Bulletins:

V2500-ENG-70-0002 - Information - Provide an Intermediate Structure That Eliminates Flight Test Information Provisions

V2500-ENG-70-0160 - Information - LP Compressor - New Fan Frame Assembly

V2500-ENG-72-0009 - Intermediate Structure - Rework The Fan Frame Assembly To Include Filler Compound In The Rear Inner Flange Area

V2500-ENG-72-0010 - Engine - LP Compressor - Replacement Of The No. 3 Bearing Seal Ring Holder

V2500-ENG-72-0051 - Engine - LP Compressor - Incorporate a Fuel Drain Tube in The Fan Frame Assembly

V2500-ENG-72-0077 - Engine - LP Compressor - Provide a Fan Frame Assembly With Revised Attachment Features

V2500-ENG-72-0082 - LP Compressor - Rework The No. 1 Bearing Seal Assembly To Incorporate A Revised Sleeve Spacer And Retaining Collar



International Aero Engines SERVICE BULLETIN

V2500-ENG-70-0096 - Information - LP Compressor - Provide An Option Number For The No. 1 Bearing Face Seal Assembly

- (2) V2500 Engine Illustrated Parts Catalog.
- (3) V2500 Engine Manual.
- (4) V2500 Standard Practices Manual/Processes Manual.

L. Other Publications Affected

- (1) The V2500 Engine Illustrated Parts Catalog, Chapter/Section 71-52-43 Figure 1, 71-52-50 Figure 4, 72-32-00 Figures 2 and 3, 72-32-03 Figure 3, 72-32-25 Figure 2, 72-32-35 Figure 1, 72-32-51 Figure 1, 72-32-53 Figure 1, 72-32-55 Figure 1, 72-41-00 Figure 3, 72-41-31 Figure 1, 73-11-49 Figure 12, and 75-31-42 Figure 1, to add the new parts.
- (2) The V2500 Engine Manual, Chapter/Section 71-52-43, 71-52-50, 72-32-00, 72-32-03, 72-32-25, 72-32-35, 72-32-51, 72-32-53, 72-32-55, 72-41-00, 72-41-31, 73-11-49, and 75-31-42 Cleaning to add the new parts.
- (3) The V2500 Engine Manual, Chapter/Section 71-52-43, 71-52-50, 72-32-00, 72-32-03, 72-32-25, 72-32-35, 72-32-51, 72-32-53, 72-32-55, 72-41-00, 72-41-31, 73-11-49, and 75-31-42 Inspection to add the new parts.
- (4) The V2500 Engine Manual, Chapter/Section 71-52-43, 71-52-50, 72-32-00, 72-32-03, 72-32-25, 72-32-35, 72-32-51, 72-32-53, 72-32-55, 72-41-00, 72-41-31, 73-11-49, and 75-31-42 Repair to add the new parts.



International Aero Engines SERVICE BULLETIN

R 2. Accomplishment Instructions

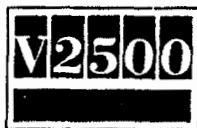
R A. Rework Instructions

- R (1) Do a modification to the 5A0401, 5A0403, 5A0405, 5A0407, 5A0409, or
R 5A0856 Fan Frame Assembly (See Reference (2), Chapter/Section 72-32-03,
R Figure/Item No. 03-100) and identify as follows:

R WARNING: YOU HAVE TO MAKE SURE THE REFERENCE (4) TASK 70-03-00-100-501
R SPECIAL HANDLING OF MATERIALS AND SOLUTIONS-01, BEFORE YOU DO
R STEP (a), BECAUSE THE MATERIAL IS TITANIUM ALLOY.

R	<u>Procedure</u>	<u>Supplementary Information</u>
R	(a) Clean the 5A1061 plugs (2 off)	Refer to reference (4), TASK
R	and the holes of the fan frame	72-11-26-300-503.
R	before welding.	
R	(b) Install the plugs into the holes	Refer to Figure 1, (Sheet
R	of fan frame, one of each part at	1 of 4) requirements.
R	two locations (2 off), and push	
R	plugs to the bottom of the holes.	
R	(c) Weld the plugs to the fan frame.	Refer to reference (4) TASK
R		70-31-02-310-501-001 ARGONARC
R		WELDING REPAIRS-01 and TASK
R		70-31-02-310-501-016. Use
R		CoMat 03-195 FILLER WIRE.
R	<u>NOTE:</u> The heat treatment is not necessary when this welding procedure was	
R	done, because this welded joint is defined by group 3.	
R	(d) Visually inspect welded area.	Refer to reference (4) TASK
R		70-31-02-310-501-001, SUBTASK
R		70-31-02-220-001 and
R		70-31-02-220-002.
R	(e) Put the fan frame on the milling	Refer to Figure 1 (Sheet 2 of
R	machine and set the datum using	of 4).
R	the smallest flange and a hole	
R	of No.1 bypass strut.	
R	(f) Cut a slot using a 0.206 in (5,25 mm)	Refer to Figure 1 (Sheet 3 or
R	or smaller diameter cutter.	of 4).
R	(g) Remove all sharp edges from area of	Use standard work shop
R	cut and make a smooth surface.	equipment.
R	(h) Clean the affected area.	Refer to reference (4), TASK
		70-11-26-300-503 solvent
		cleaning-03.

Printed in Great Britain



International Aero Engines

SERVICE BULLETIN

Procedure

Supplementary Information

R (i) Do a dimensional check of the
R affected area.

R (j) Install the 614U50-0016-1 C-seals
R (2 off) and the 5A0298 blanking
R plates (2 off), one of each part at
R two locations.

Refer to Figure 1 (Sheet 4 of
of 4).

R (k) Lubricate the 4W0166 Bolts (6 off)
R with the CoMat 10-077 Engine Oil.

R (l) Install the 4W0166 Bolts (6 off),
R 3 each at two locations A. Tighten
R with your hand.

Refer to Figure 1,
requirements.

R (m) Torque the Bolts to 85 to 105 lbfin
R (10,0 to 12,0 Nm).
R
R

Refer to Reference (4),
Control No./Task No.
70-41-00-400-501, Torque
Tightening Technique.

R (n) Make a mark adjacent to the old part
R to show the new part number. Use the
R vibration peen method.
R
R
R
R
R
R

Old Part No. New Part No.

5A0401	5A1064
5A0403	5A1068
5A0405	5A0162
5A0407	5A1049
5A0409	5A1066
5A0856	5A1167

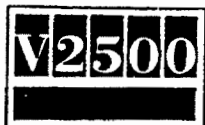
Refer to Reference (4),
Control No./Task No.
70-09-00-400-501,
Marking of Parts.

June 30/93

R Revision 1 May 30/97

V2500 – ENG – 72 – 0132

Page 6A



International Aero Engines

SERVICE BULLETIN

Printed in Great Britain

THIS PAGE INTENTIONALLY LEFT BLANK



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN

B. Assembly Instructions

- (1) When you do the procedure given in Reference (3), Chapter/Section 72-32-20, Assembly, install the 5R0068 Ring Nut Assembly (1 off) and the 2A2370 No. 3 Bearing Seal Assembly (1 off). See Figures 2 and 3.
- (2) When you do the procedure given in Reference (3), Chapter/Section 72-32-50 install the 2A1065 No. 1 Bearing Seal Assembly (1 off) and the AS3209-279 Packing (1 off). See Figure 4.

NOTE: The IAE 1P16357 Leak Check Fixture is necessary to do a leak check of the 2A1065 No. 1 Bearing Seal Assembly.

- (3) When you install the Fan Frame Assembly by the instructions given in Reference (3), Chapter/Section 72-32-00, Assembly-01, use one of the assemblies given below:

- (a) 5A1047 Fan Frame Assembly (1 off) or,
- (b) 5A1049 Fan Frame Assembly (1 off) or,
- (c) 5A1062 Fan Frame Assembly (1 off) or,
- (d) 5A1064 Fan Frame Assembly (1 off) or,
- (e) 5A1066 Fan Frame Assembly (1 off) or,
- (f) 5A1068 Fan Frame Assembly (1 off) or,
- (g) 5A1167 Fan Frame Assembly (1 off). See Figure 5.

- (4) When you do the procedure given in Reference (3), Chapter/Section 72-32-00, Assembly-07, it will be changed as follows:

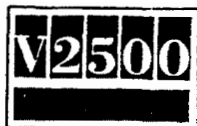
- (a) Install the 5W2078 Seal Support Assembly (1 off). See Figure 6.
- (b) Install the MS9321-10 Washers (21 off) when you install the 4W0002 Nuts (21 off) and the 4W0168 Bolts (21 off) that hold the Seal Support. See Figure 6.
- (c) Install the MS9321-10 Washers (18 off) and safety the Seal Support Assembly with the AS21013 Bolts (18 off). See Figure 6.
- (d) When you do the procedure the parts listed below will not be installed:

- 1 the 5R0245 Brackets (2 off), one each at two locations
- 2 the 4W0164 Bolts (2 off), one each at two locations
- 3 the 4W0165 Bolts (18 off),
- 4 the 4W0002 Nuts (18 off),
- 5 the 4W2622 Washers (2 off), one each at two locations
- 6 the 4W0044 Nuts (2 off), one each at two locations
- 7 the AS12820 Clips (2 off), one each at two locations
- 8 the AS12850 Clips (2 off), one each at two locations
- 9 the AS12899 Bushing (2 off), one each at two locations
- 10 the 4W0002 Nuts (4 off),
- 11 the 4W0168 Bolts (4 off),



SERVICE BULLETIN

- 12 the AS43013-115 Sealing Rings (2 off), one each at two locations
- 13 the 5R6130 Spiral Retaining Ring (1 off),
- 14 the 5R6131 FBC Front Air Seal Assembly (1 off),
- 15 the 6A2053 Brush Seal Assembly (1 off),
- 16 and the 5R0233 Air Feed Tube Assembly (1 off) or the 5R0240 Air Feed Tube Assembly (1 off). See Figure 6.
- (5) When you do the procedure given in Reference (3), Chapter/Section 72-32-00, Assembly-11, install the 5R0176 Air FBC Rear Seal Assembly (1 off). See Figure 7.
- (6) When you do the procedure given in Reference (3), Chapter/Section 72-41-00, Assembly-02, install the 6A2167 Bracket, on bolt holes 7 and 8. See Figure 8.
- (7) When you install the Stage 7 HP Compressor Bleed Valve by the procedure given in Reference (3), Chapter/Section 72-00-40, Installation-08, do not install the 5W8365 Bracket (1 off) and the 5W8394 Bracket (1 off). See Figure 9.
- (8) When you do the procedure given in Reference (3), Chapter/Section 72-00-40, Installation-09 install the parts which follow:
- (a) Install the 4W0102 Bolt (1 off) and the K8831 Washers (2 off) at clip position 5747. See Figure 10.
- (b) Install the 6A2168 Bracket (1 off). See Figure 11.
- (c) Do not install the parts listed below. These parts will not be used with the new configuration. See Figure 12 for part locations. The parts are:
- 1 the 5A9381 FBC Buffer Air Tube Assembly (1 off),
- 2 the 4W0163 Bolts (4 off), 2 each, at two locations,
- 3 the 4W0166 Bolts (6 off), 3 each, at two locations,
- 4 the 4W0102 Bolt (2 off), 1 each, at two locations,
- 5 the 5W1086 Washers (4 off), 1 each, at 4 locations,
- 6 the TA025017FT12 Clips (4 off), 1 each, at 4 locations,
- 7 the 4W0043 Nut Assembly, 1 each, at 3 locations,
- 8 the 4W0103 Bolt (2 off) 1 each, at 2 locations,
- 9 the 4W0001 Nut (1 off),
- 10 the 614U50-0016-1 C Seal (1 off),
- 11 and the 5A0174 Tube Assembly (1 off)
- (d) Install the 614U50-0016-1 C Seals (2 off) and the 6A3457 Blanking Plates (2 off), one of each part at the locations given in Figure 12.
- (e) Lubricate the AS21011 Bolts (4 off) with a CoMat 10-077 Engine Approved Engine Oil.



International Aero Engines SERVICE BULLETIN

Printed in Great Britain

- (f) Install the Bolts, two at each location given in Figure 12, and tighten them with your hand.
- (g) Torque the Bolts to 75 to 85 lbfin (8,47 to 9,64 Nm.) Refer to Refer to Reference (4), Chapter/Section 70-41-00 Torque Tightening Technique.
- (h) When you install the Electronic Engine Control Core Harness, install the parts which follow, at the specified locations:
 - 1 Install the 4W0103 Bolt (1 off) and the K8831 Washers (2 off) at clip position 5750. See Figure 10.
NOTE: The 5W1031 Sleeve Spacer is removed from this location.
 - 2 Install the 4W0102 Bolt (1 off) and the K8831 Washers (2 off) at clip position 5751. See Figure 10.
NOTE: The 5W1031 Sleeve Spacer is removed from this location.
 - 3 Install the 4W0103 Bolt (1 off) and the K8831 Washer (1 off) at clip position 5744. See Figure 10.
NOTE: The TA025074-07 Clamp (1 off) or the AS61905 Clamp (1 off) is removed from this location.
 - 4 Install the 4W0102 Bolt (1 off) and the K8831 Washer (1 off) at clip position 5745. See Figure 10.
- (i) Install the 6A2153 Raceway at clipping points 5427 and 6057. Use the 400WSS8 Clip (1 off), 4W0043 Nuts (2 off) one at each location, K8831 Washers (2 off) one at each location, and 4W0102 (2 off) one at each location. See Figure 10.
- (j) Install the 4W0105 Bolt (1 off), K8831 Washers (2 off), UP10478 Spacer (1 off) 400WSS6 Clip (1 off) and 4W0001 Nut (1 off) at clip position 6058. See Figure 10.
- (k) Install the AS21400 Bolt (1 off), K8831 Washers (2 off), AS62503 Clip (1 off) and the AS20624 Nut (1 off) at clip position 6067. See Figure 10.
- (l) Install the 400WSS8 Clip (1 off) and K8831 Washer (1 off) at clip position 5746. See Figure 10.
- (m) Install the 6A2160 Raceway at clipping points 5776 and 6056 using the 400WSS8 Clip (1 off), 4W0043 Nuts (2 off) one at each location, K8831 Washers (2 off) one at each location, 4W0102 Bolts (2 off) one at each location. See Figure 10.

F. Recording Instructions

- (1) A record of accomplishment is necessary.

June 30/93

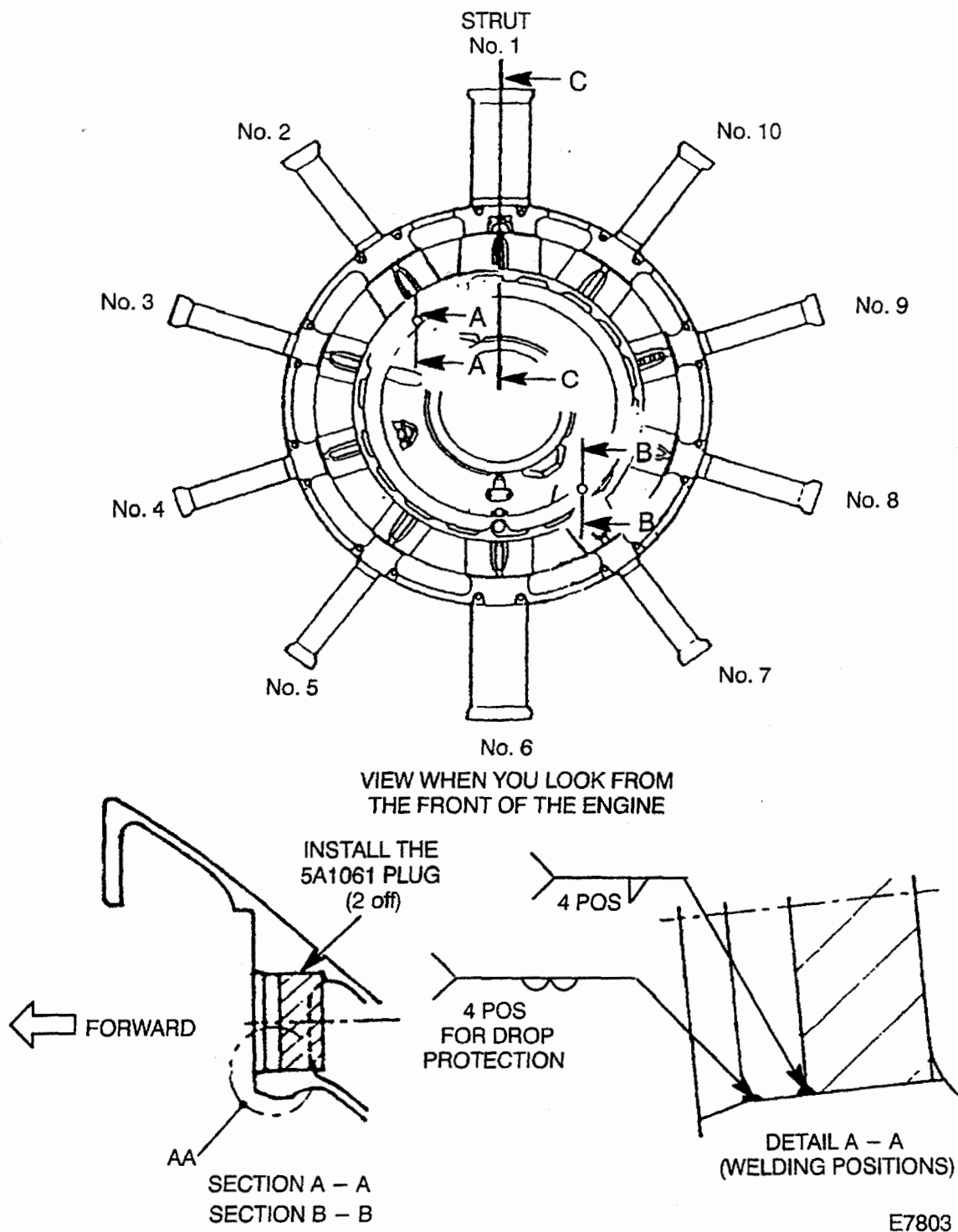
V2500 – ENG – 72 – 0132

Page 9



International Aero Engines SERVICE BULLETIN

Printed in Great Britain



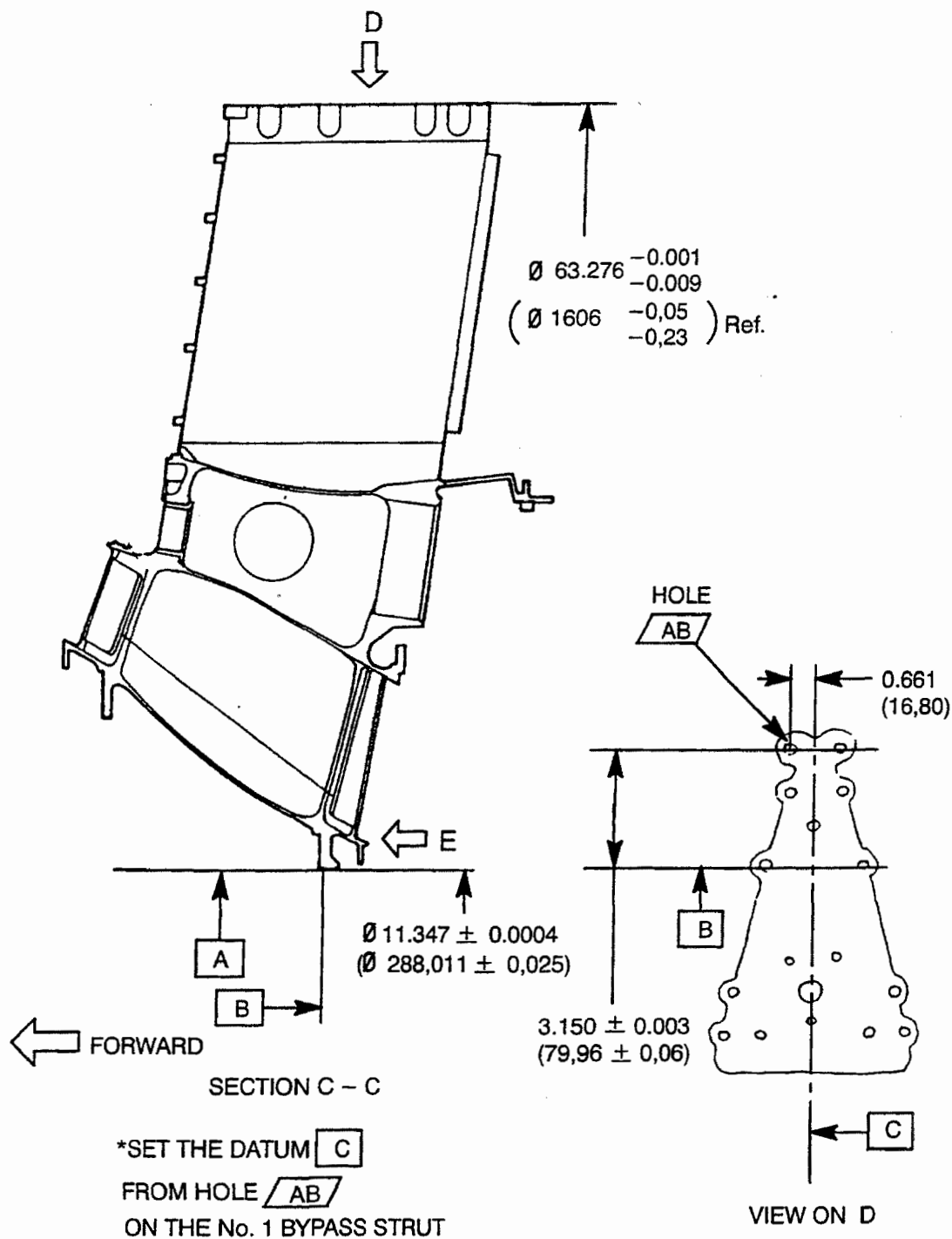
Modification of the Fan Frame Assembly
Figure 1 (Sheet 1)

V2500 - ENG - 72 - 0132

June 30/93
R Revision 1 May 30/97

Page 10

International Aero Engines SERVICE BULLETIN



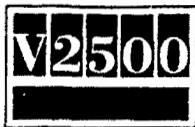
E7804

Modification of the Fan Frame Assembly
Figure 1 (Sheet 2)

Figure 1 (Sheet 2)
V2500 - ENG - 72 - 0132

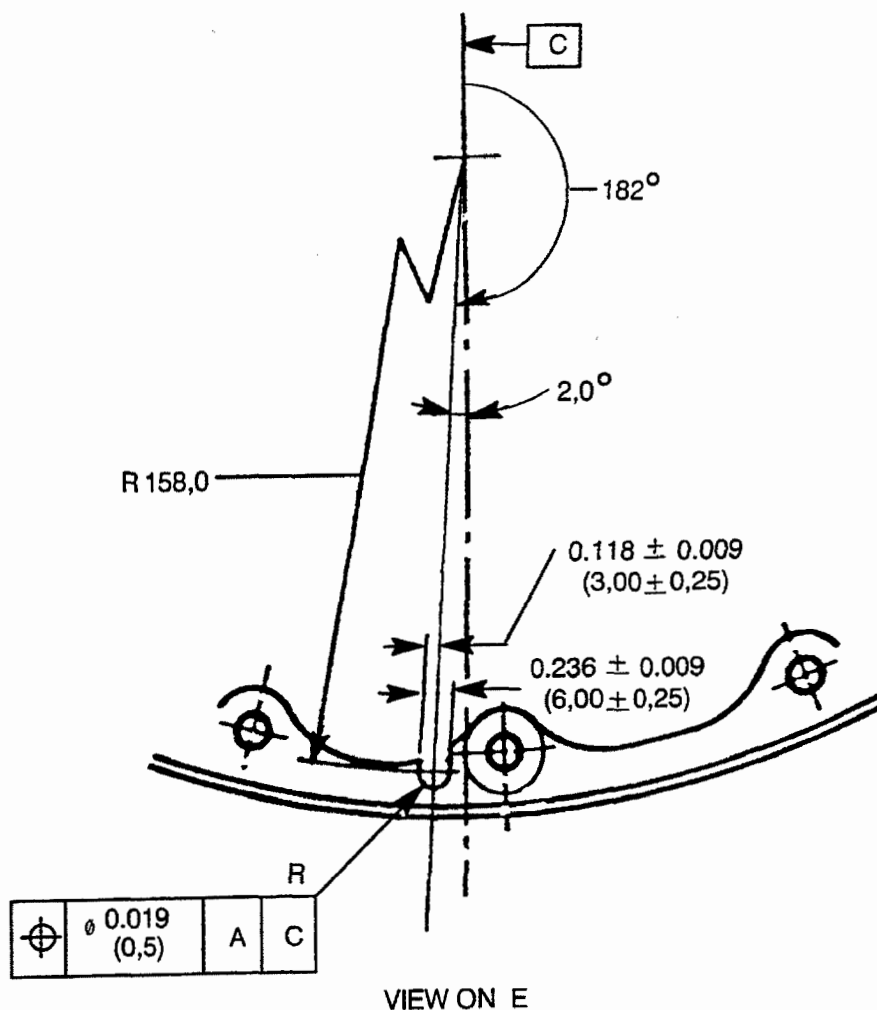
Page 10A

June 30/93
R Revision 1 May 30/97



International Aero Engines
SERVICE BULLETIN

Printed in Great Britain



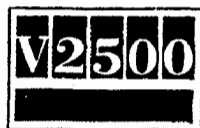
E7805

Modification of the Fan Frame Assembly
Figure 1 (Sheet 3)

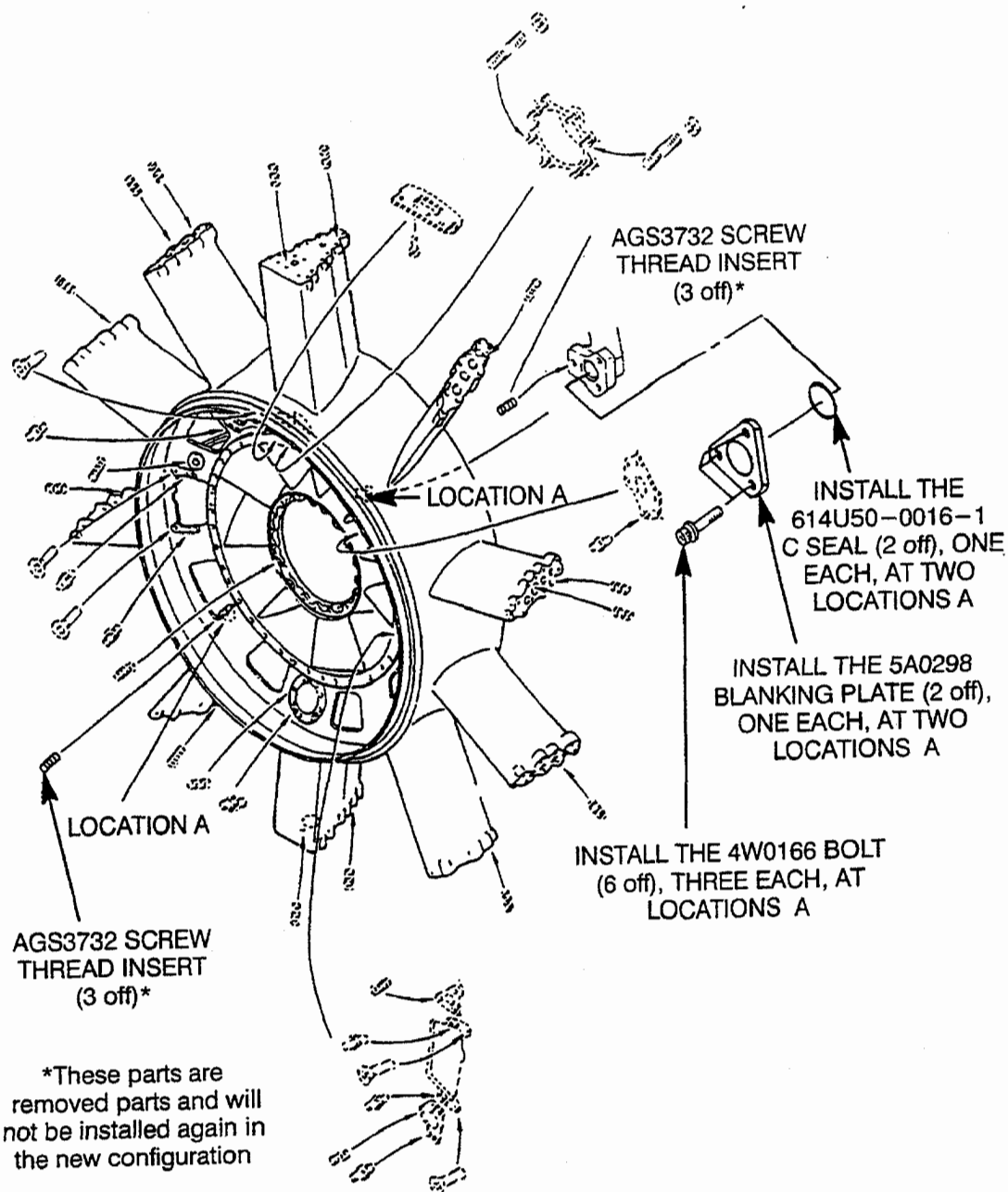
V2500 – ENG – 72 – 0132

June 30/93
R Revision 1 May 30/97

Page 10B



International Aero Engines SERVICE BULLETIN



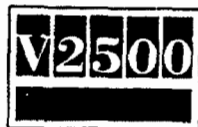
B8587B

Location of the Ring Nut Assembly
Figure 1 (Sheet 4)

V2500 - ENG - 72 - 0132

Page 10C

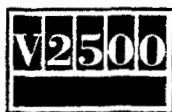
June 30/93
R Revision 1 May 30/97



International Aero Engines
SERVICE BULLETIN

Printed in Great Britain

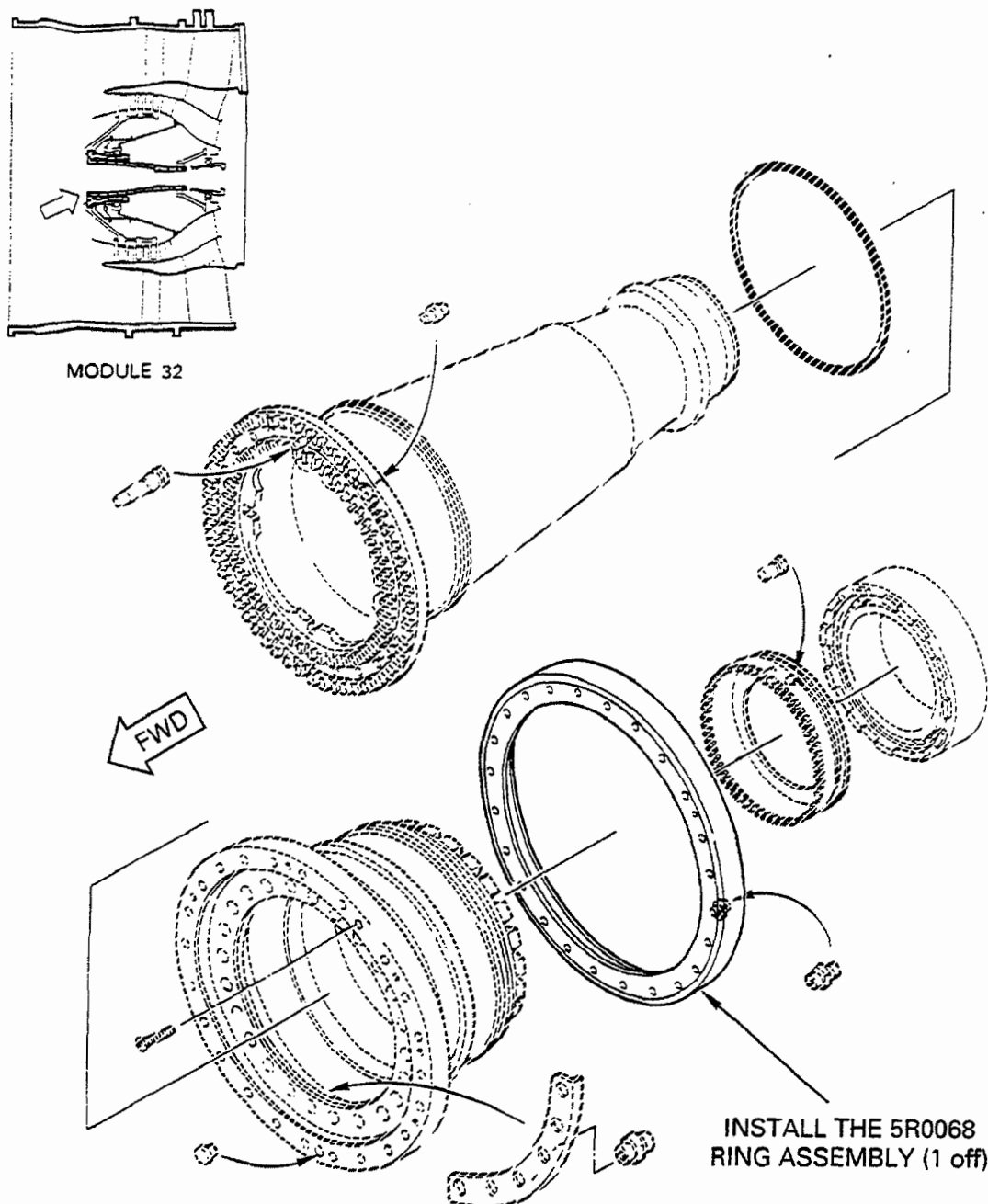
THIS PAGE INTENTIONALLY LEFT BLANK



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



B8588

Location of the Ring Nut Assembly
Figure 2

June 30/93

V2500 – ENG – 72 – 0132

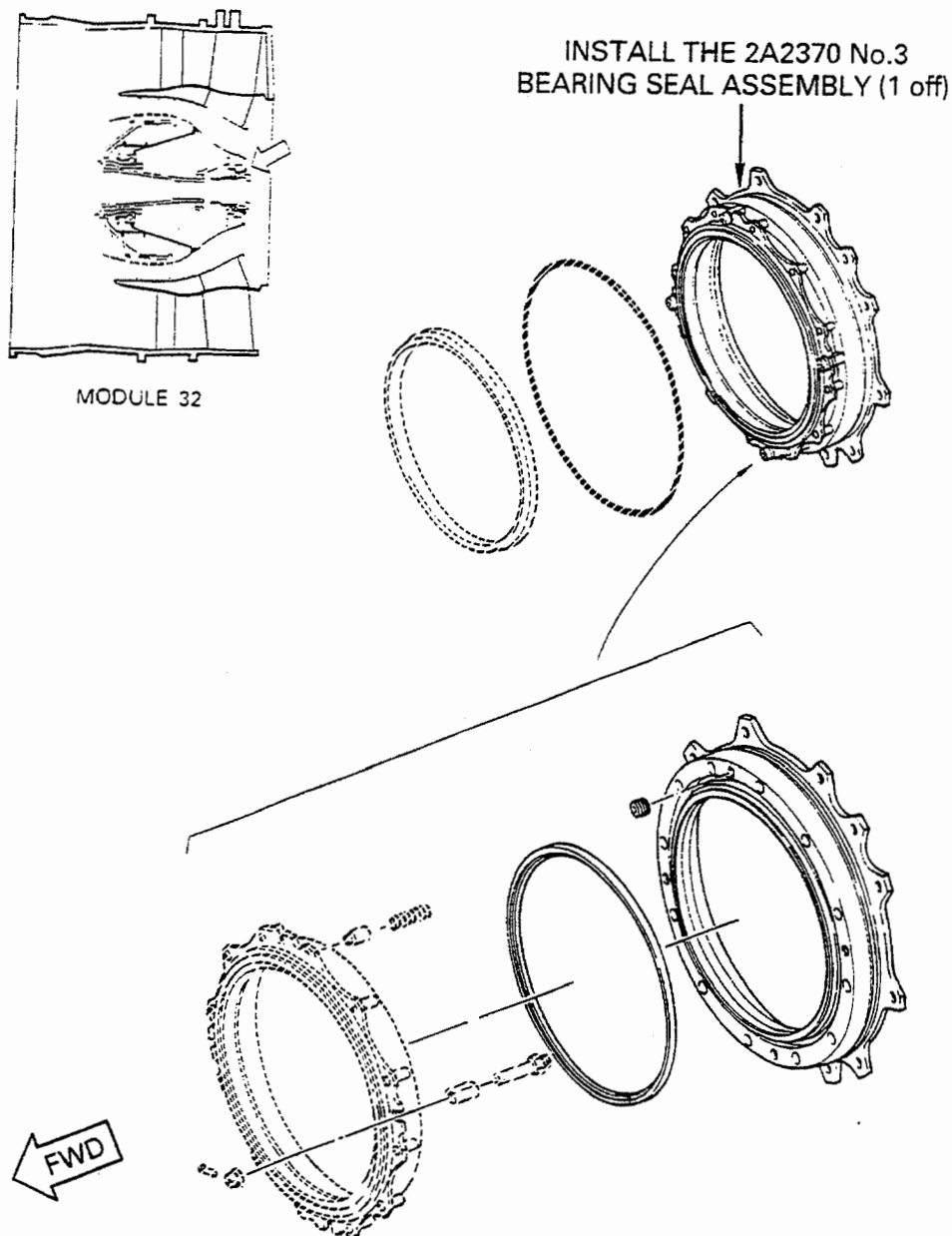
Page 11



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



B8589

Location of the No. 3 Bearing Seal Assembly
Figure 3

V2500 – ENG – 72 – 0132

Page 12

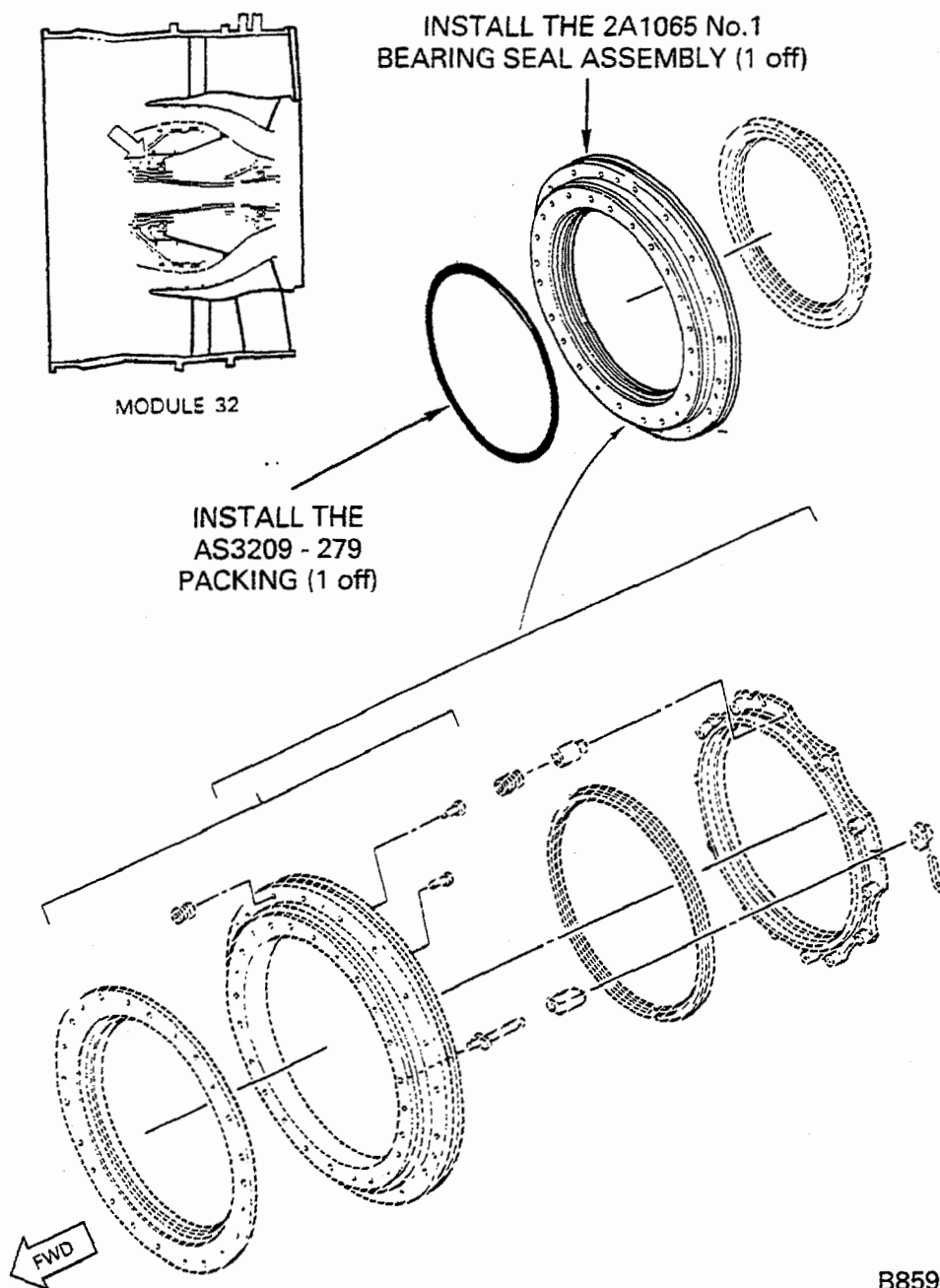
June 30/93



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN



Location of the No. 1 Bearing Seal Assembly

Figure 4

June 30/93

V2500 – ENG – 72 – 0132

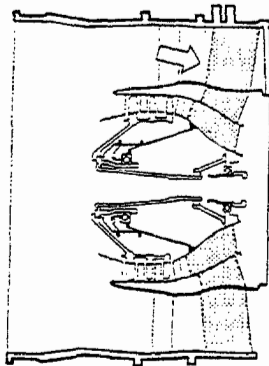
Page 13



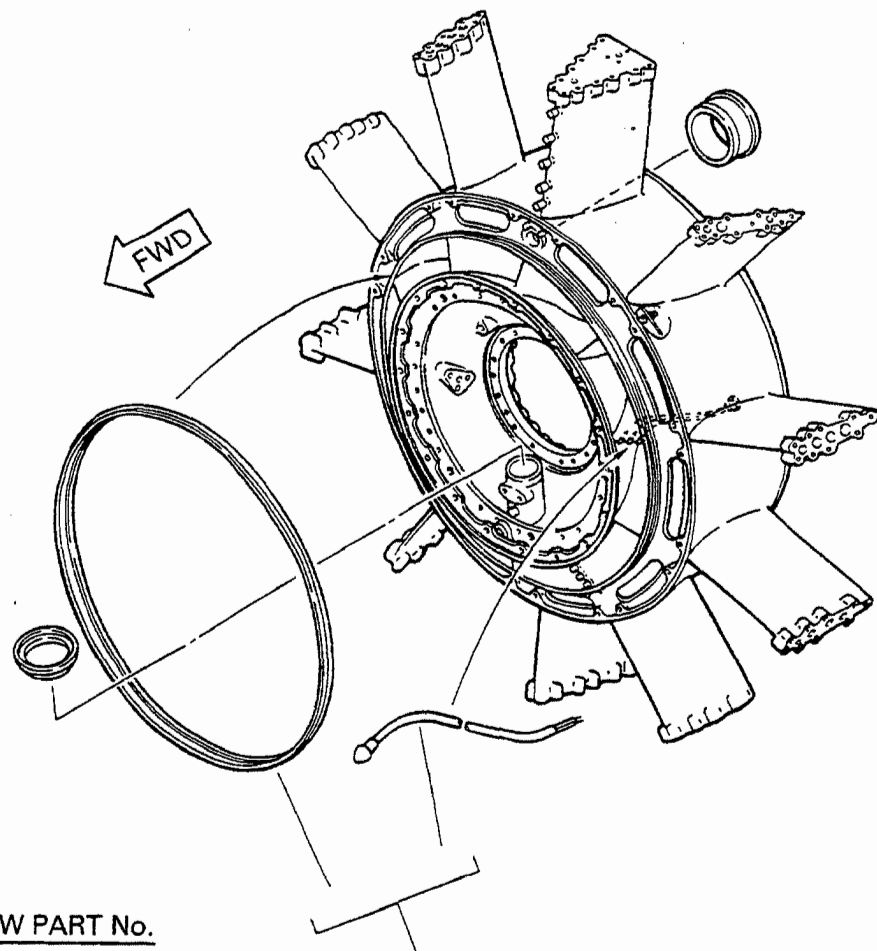
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



MODULE 32



OLD PART No.

5A0856
5A0407
5A0405
5A0401
5A0409
5A0403
5A0856

*NEW PART No.

5A1047
5A1049
5A1062
5A1064
5A1066
5A1068
5A1167

INSTALL THE APPLICABLE
FAN FRAME ASSEMBLY (1 off)*

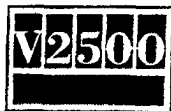
B8691A

Location of the Fan Frame Assembly
Figure 5

V2500 – ENG – 72 – 0132

Page 14

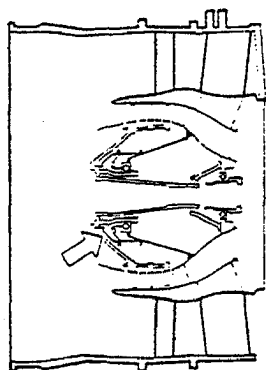
June 30/93



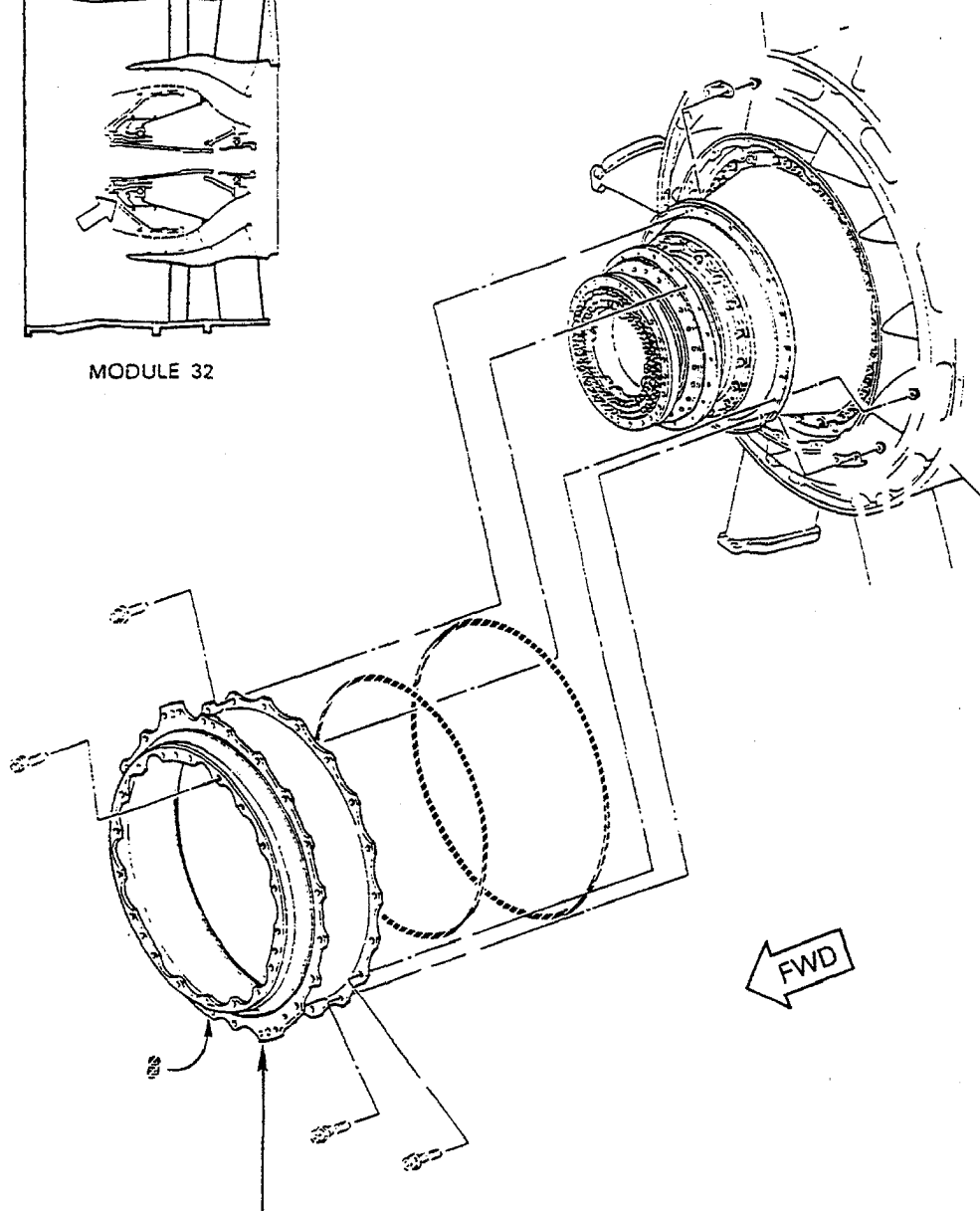
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



MODULE 32



INSTALL THE 5W2078 SEAL
SUPPORT ASSEMBLY (1 off)

B8592

Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 1 of 6)

June 30/93

V2500 – ENG – 72 – 0132

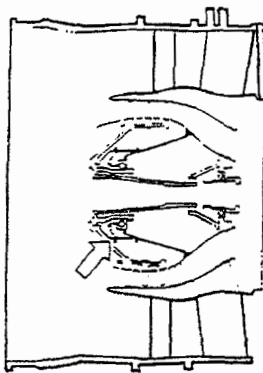
Page 15



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



MODULE 32

INSTALL THE
4W0168 BOLTS
(21 off)**

INSTALL THE
MS9321-10
WASHERS
(21 off)

4W0166
BOLTS (4 off)*

INSTALL THE
AS21013 BOLTS
(18 off)

INSTALL THE
MS9321-10
WASHERS
(18 off)

5R0245
BRACKET (1 off)*

5R0245 BRACKET
(1 off)*

4W0002 NUTS
(4 off)*

INSTALL THE
4W0002 NUTS
(21 off)**

* THESE PARTS ARE REMOVED PARTS
AND WILL NOT BE INSTALLED AGAIN IN
THE NEW CONFIGURATION

** QUANTITY AT ILLUSTRATED PARTS
CATALOG LOCATION IS INCREASED BY 4

B8593A

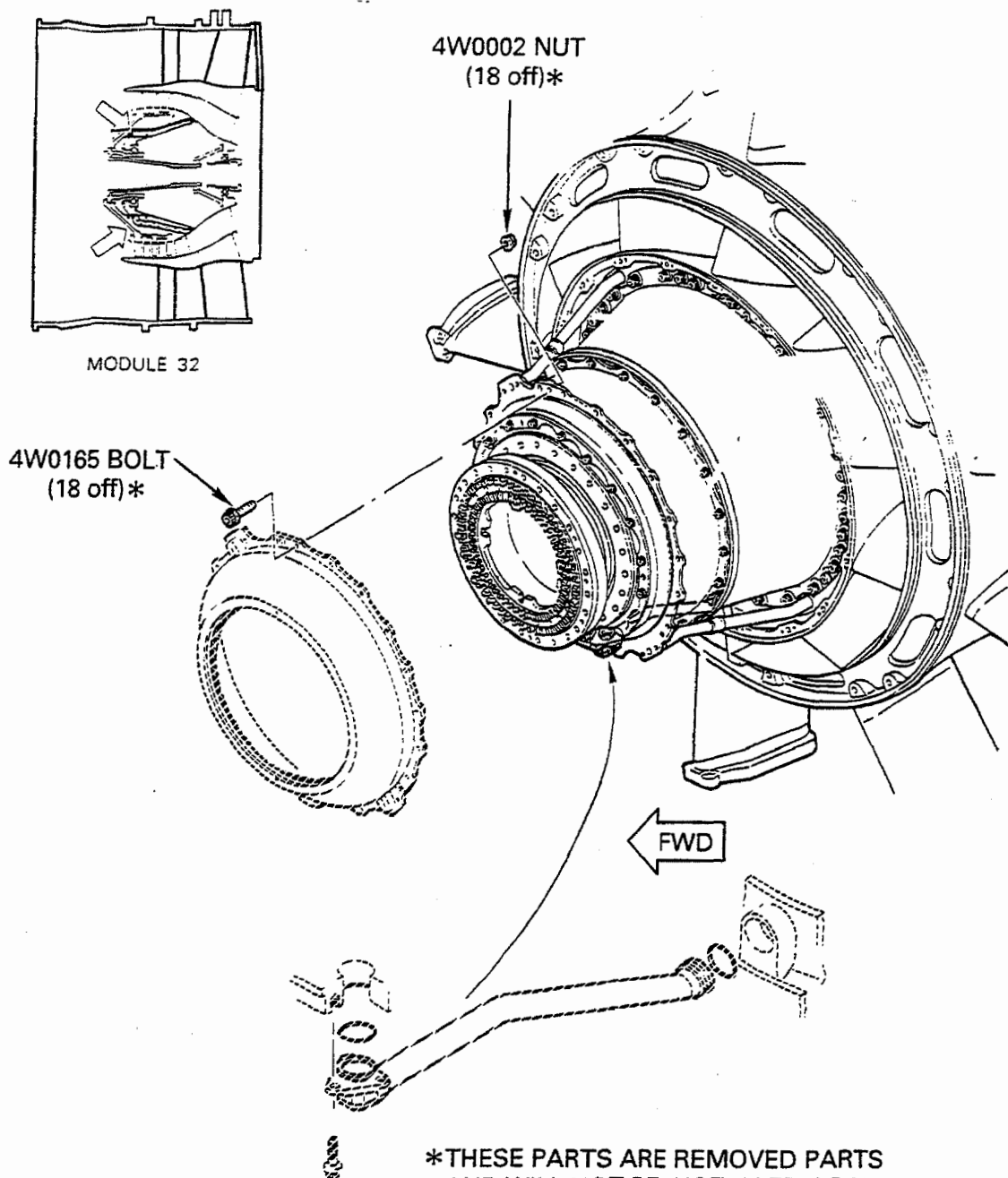
Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 2 of 6)

V2500 — ENG — 72 — 0132

Page 16

June 30/93

SERVICE BULLETIN



***THESE PARTS ARE REMOVED PARTS
AND WILL NOT BE INSTALLED AGAIN
IN THE NEW CONFIGURATION**

B8594

Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 3 of 6)

V2500 - ENG - 72 - 0132

Page 17

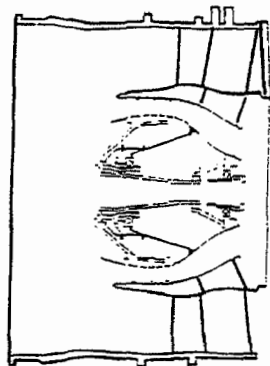
June 30/93



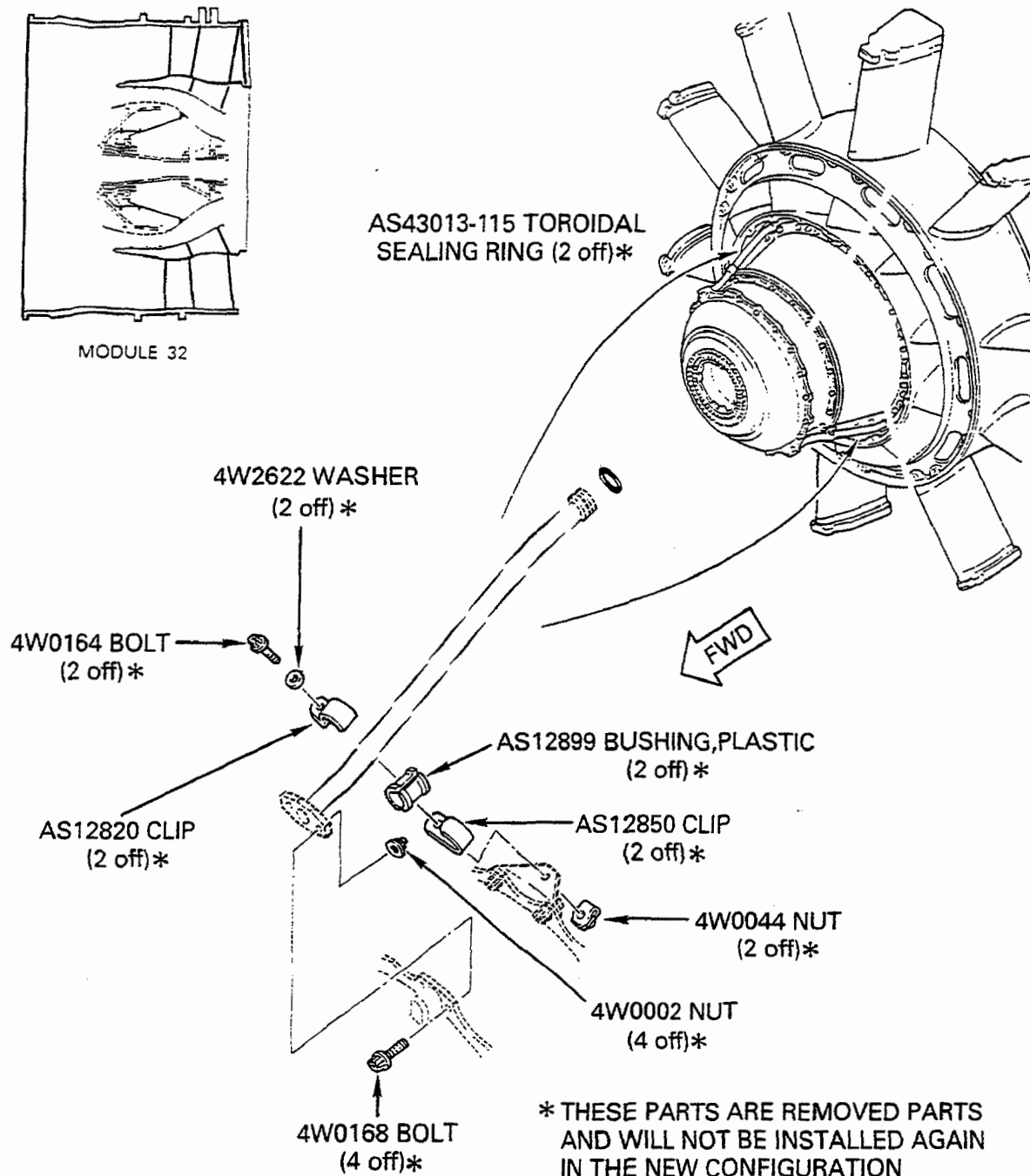
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



MODULE 32



B8595

Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 4 of 6)

V2500 – ENG – 72 – 0132

June 30/93

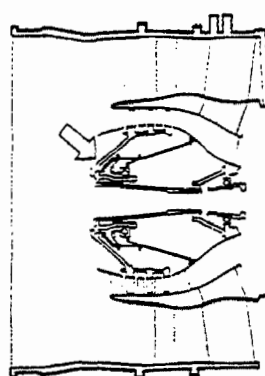
Page 18



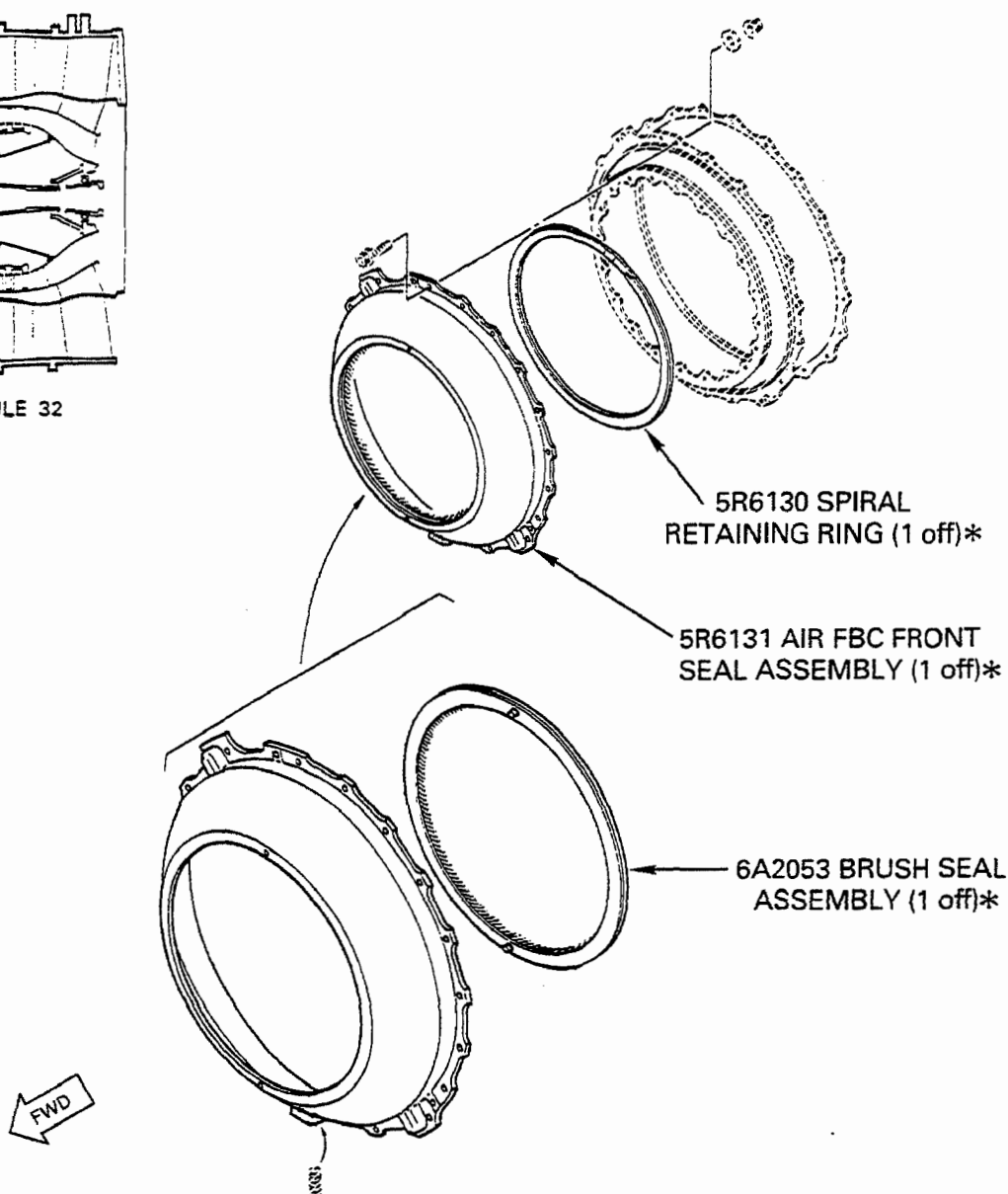
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



MODULE 32



* THESE PARTS ARE REMOVED
AND WILL NOT BE INSTALLED AGAIN
WITH THE NEW CONFIGURATION

B8596

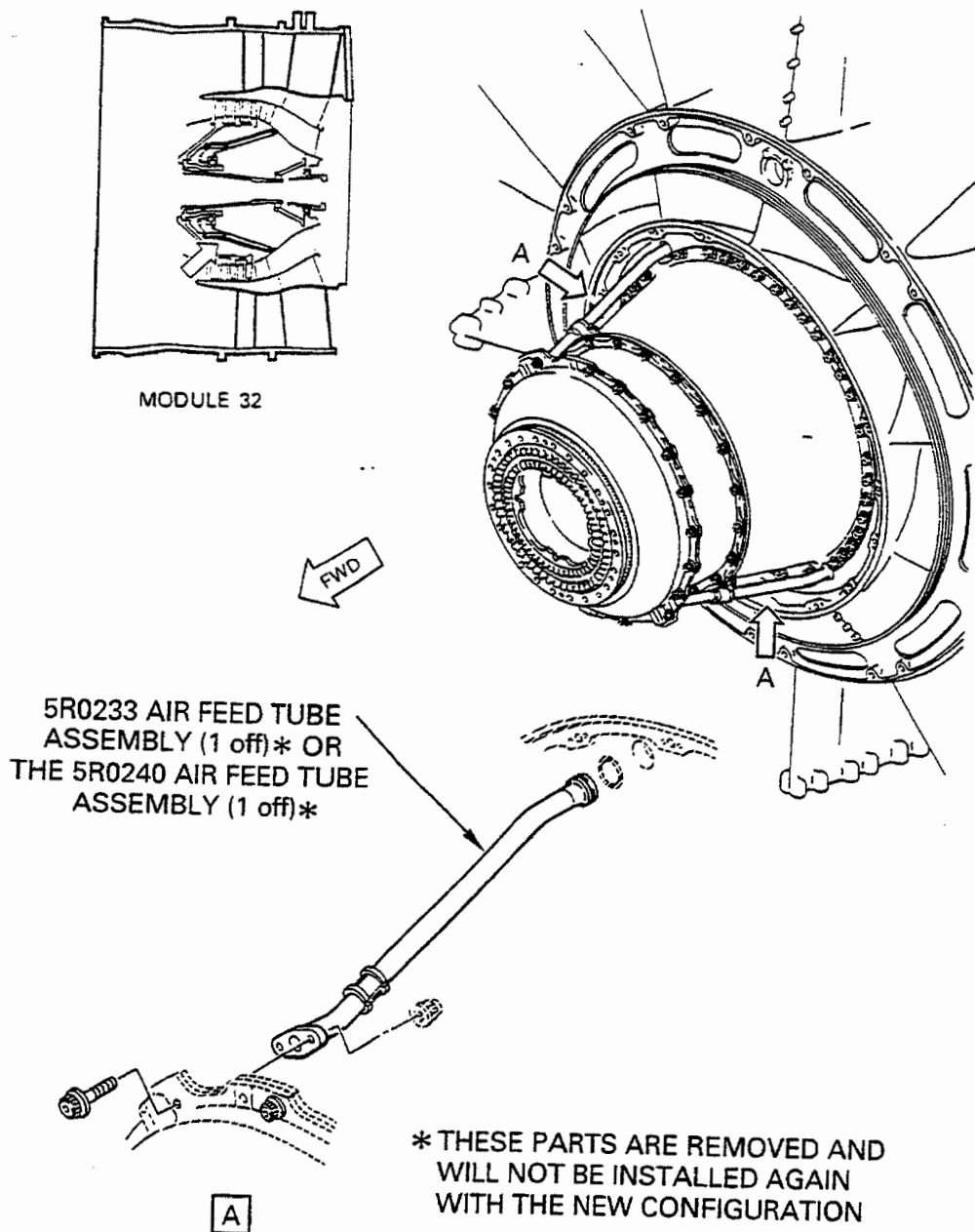
Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 5 of 6)

June 30/93

V2500 – ENG – 72 – 0132

Page 19

SERVICE BULLETIN



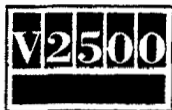
B8597

Location of the Seal Support Assembly,
Air Feed Tube Assemblies and Related Parts
Figure 6 (Sheet 6 of 6)

V2500 – ENG – 72 – 0132

Page 20

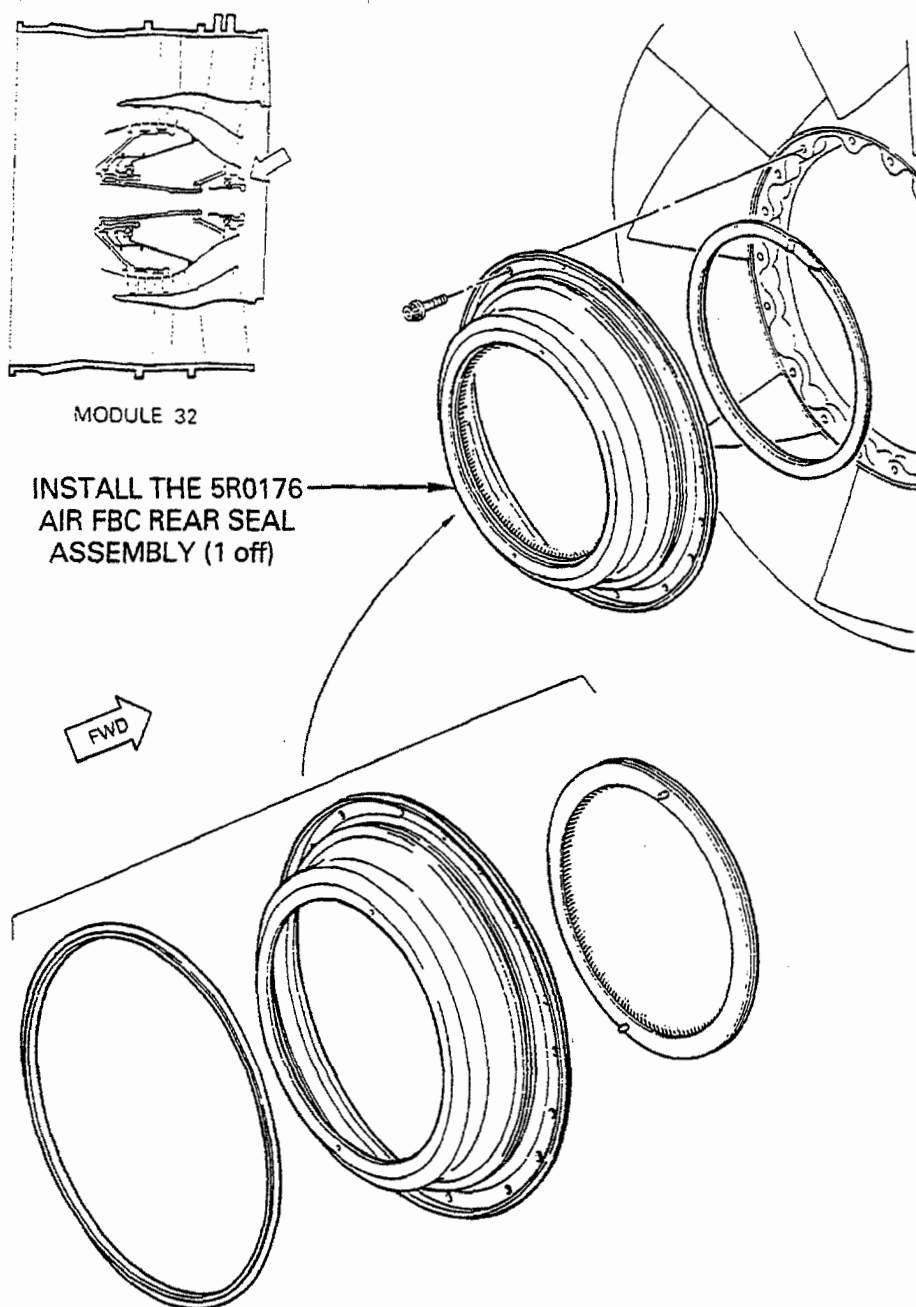
June 30/93



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



B8598

Location of the Air FBC Rear Seal Assembly
Figure 7

June 30/93

V2500 – ENG – 72 – 0132

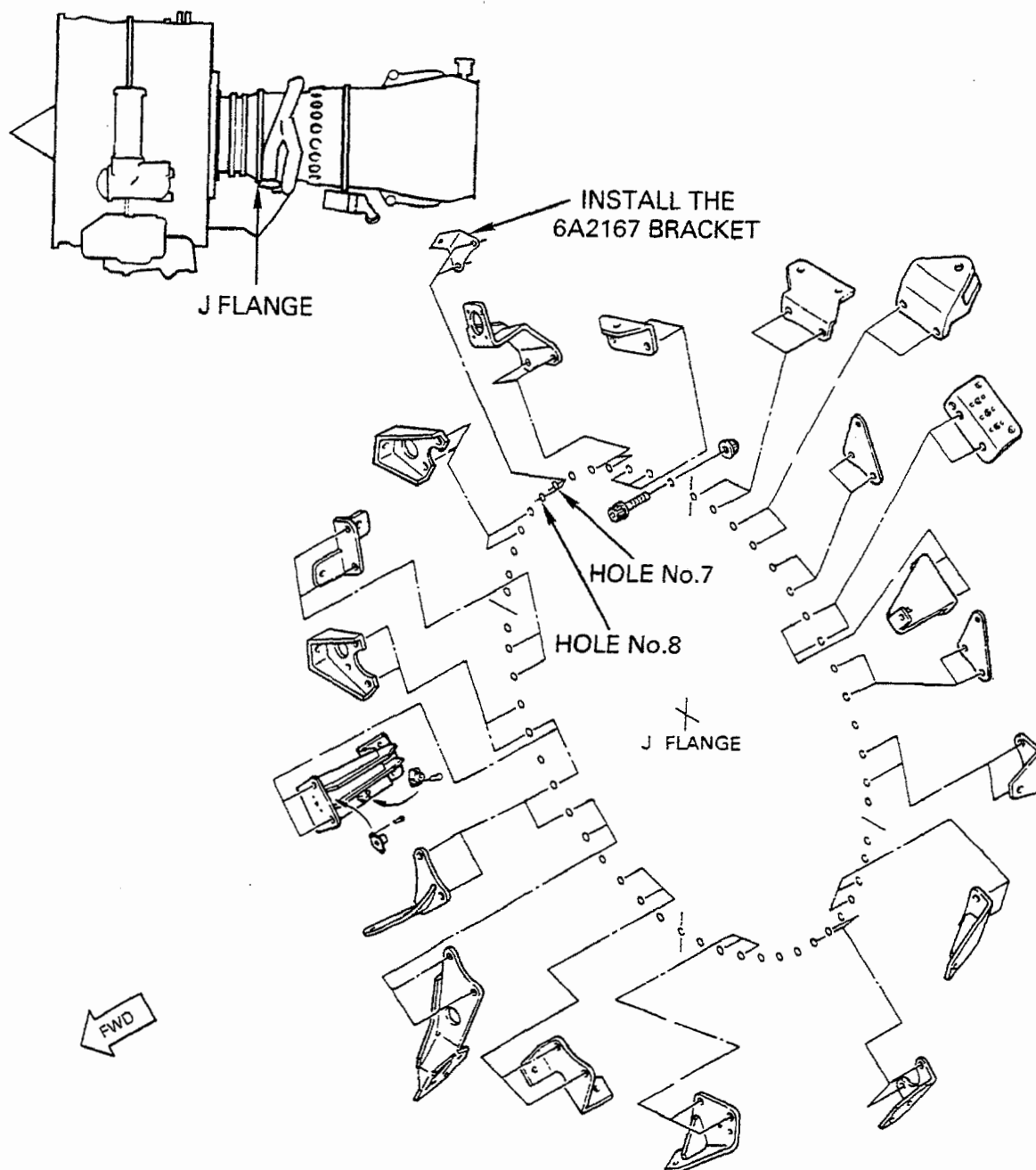
Page 21



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



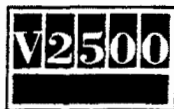
B8599A

Location of the Bracket (6A2167)
Figure 8

V2500 – ENG – 72 – 0132

Page 22

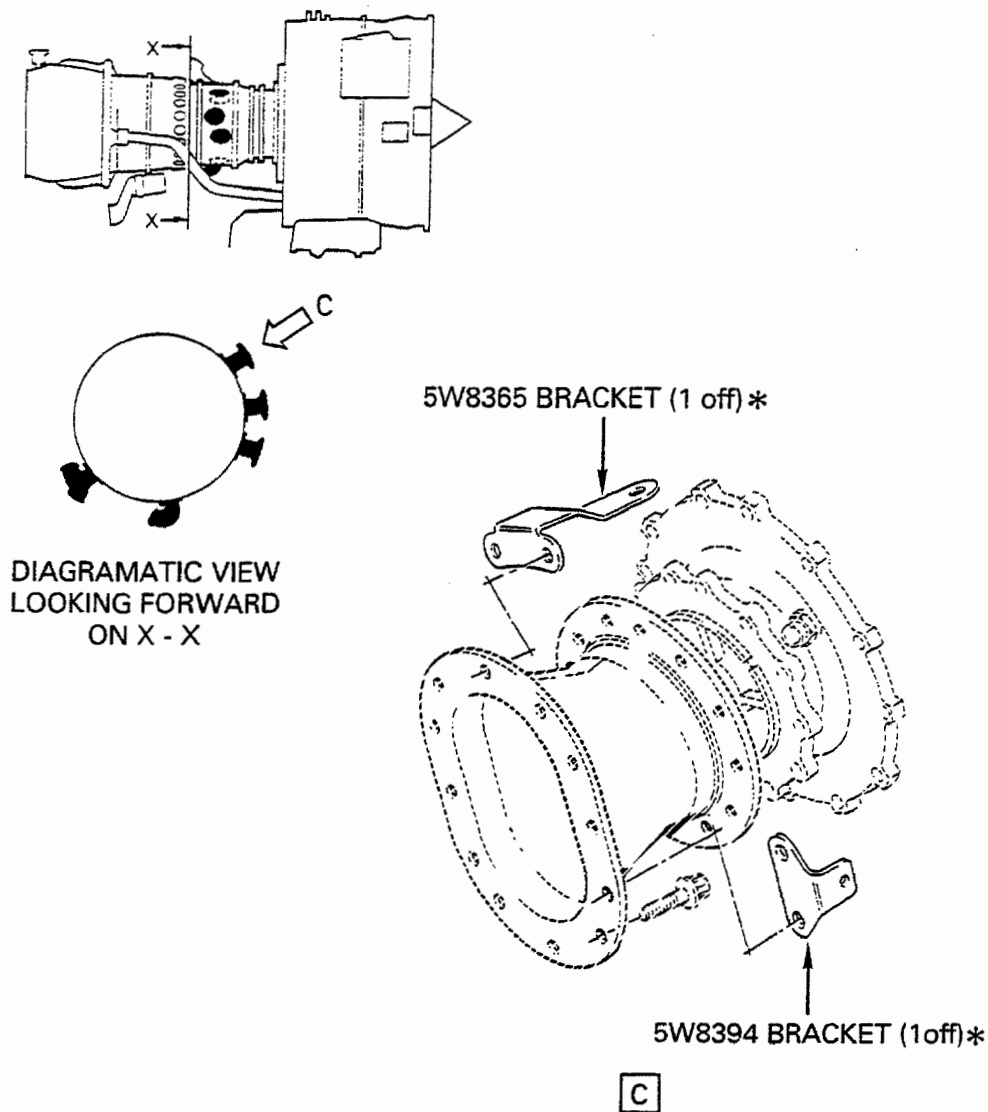
June 30/93



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN



* THESE PARTS ARE REMOVED PARTS
AND WILL NOT BE INSTALLED AGAIN
IN THE NEW CONFIGURATION

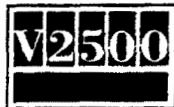
B8600

Location of the Brackets (5W8365 and 5W8394)
Figure 9

June 30/93

V2500 – ENG – 72 – 0132

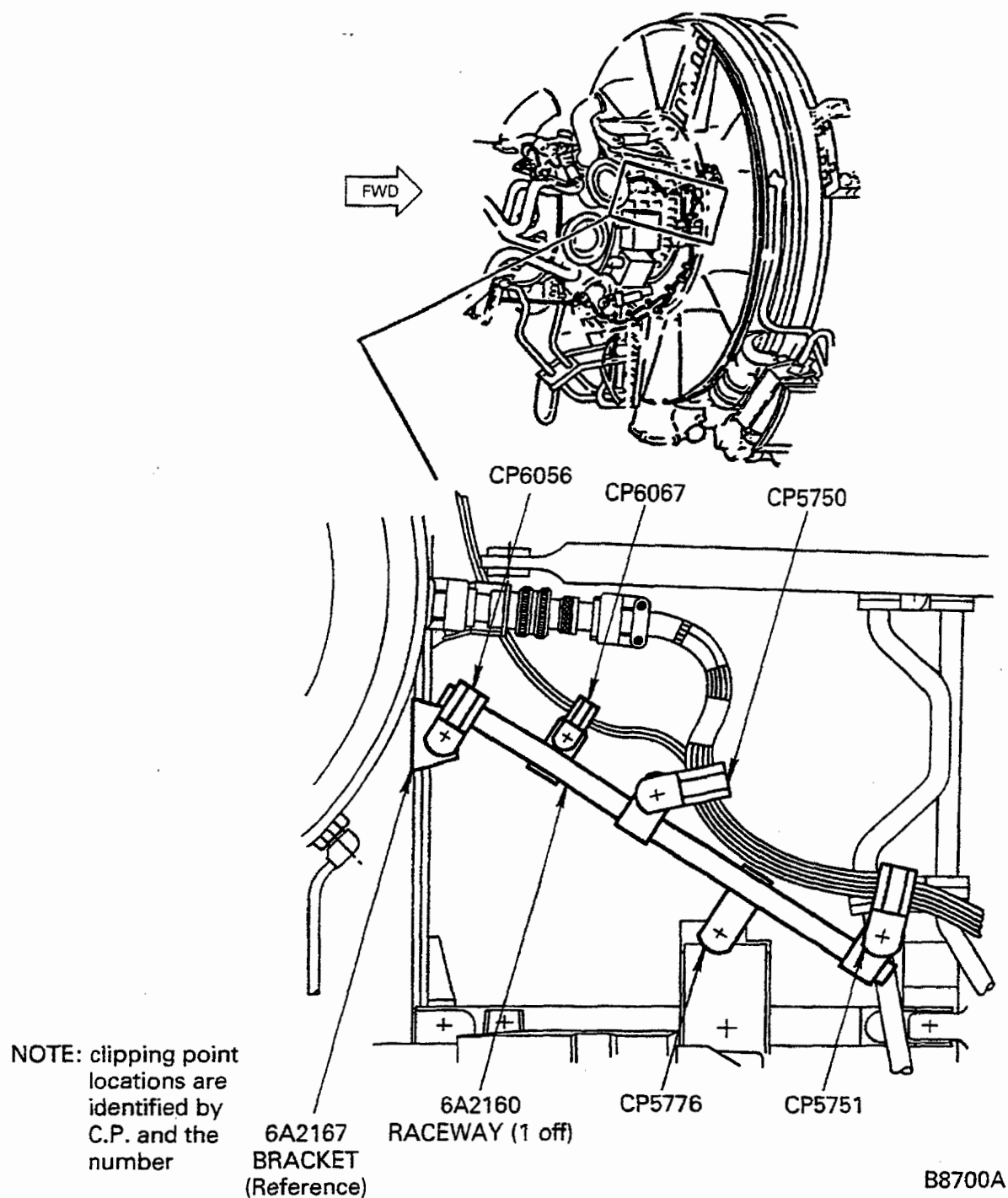
Page 23



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



Location of the LT Harness
Figure 10 (Sheet 1)

V2500 – ENG – 72 – 0132

Page 24

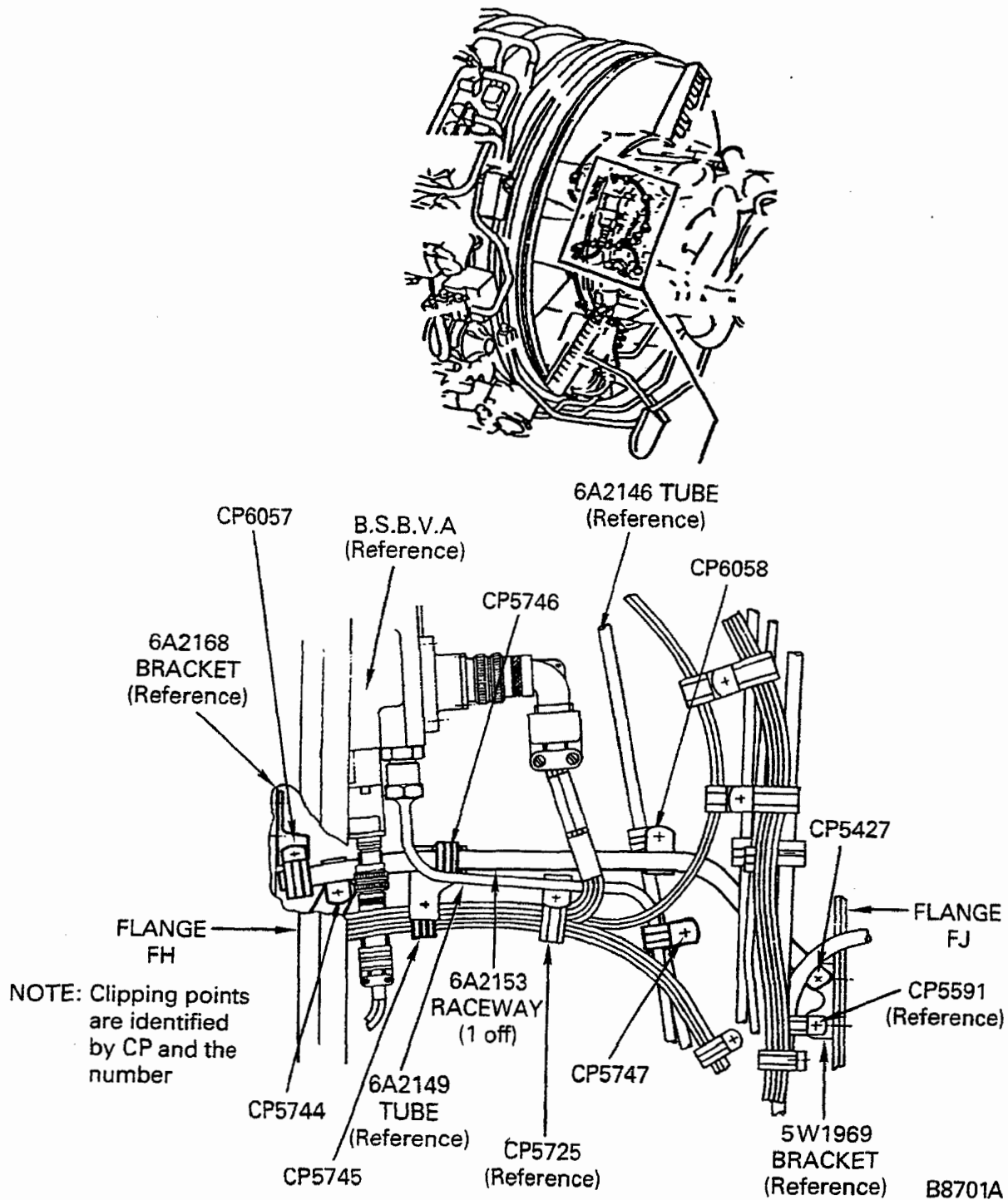
June 30/93



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



Location of the LT Harness
Figure 10 (Sheet 2)

V2500 – ENG – 72 – 0132

June 30/93

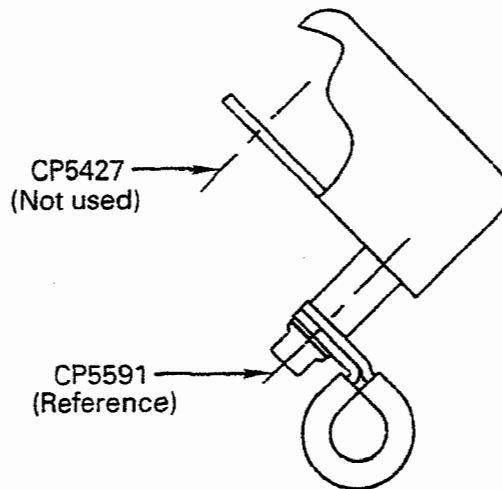
Page 25



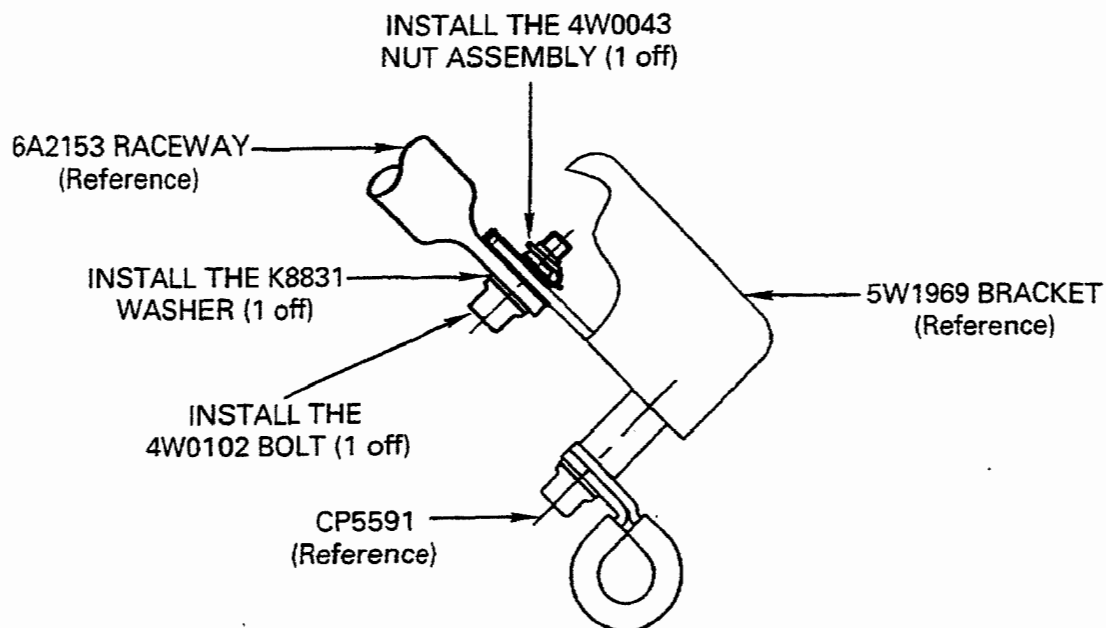
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 5427
BEFORE ALTERATION



CLIPPING POINT 5427
AFTER ALTERATION

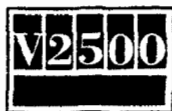
B8702A

Location of the LT Harness
Figure 10 (Sheet 3)

V2500 – ENG – 72 – 0132

Page 26

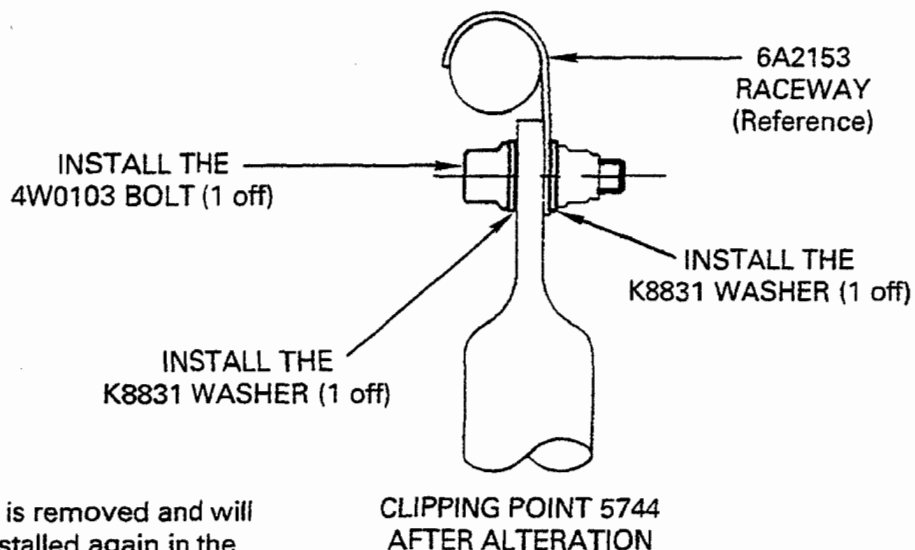
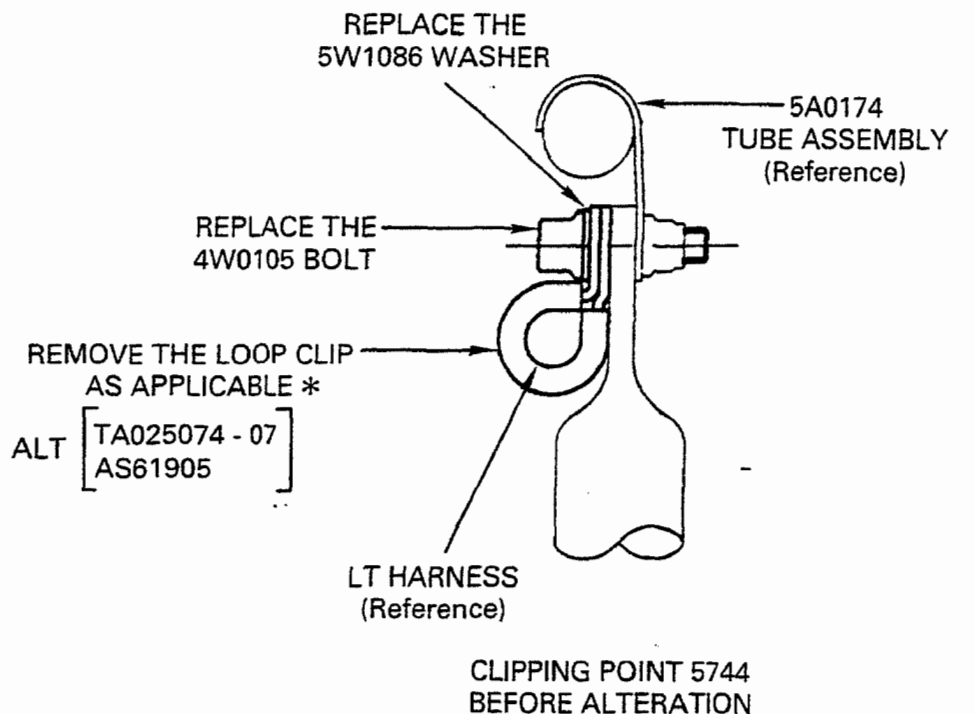
June 30/93



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



*This part is removed and will
not be installed again in the
new configuration

B8703A

Location of the LT Harness
Figure 10 (Sheet 4)

V2500 – ENG – 72 – 0132

Page 27

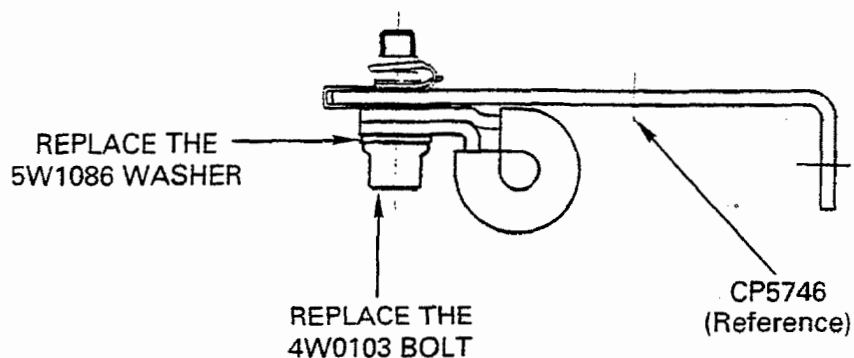
June 30/93



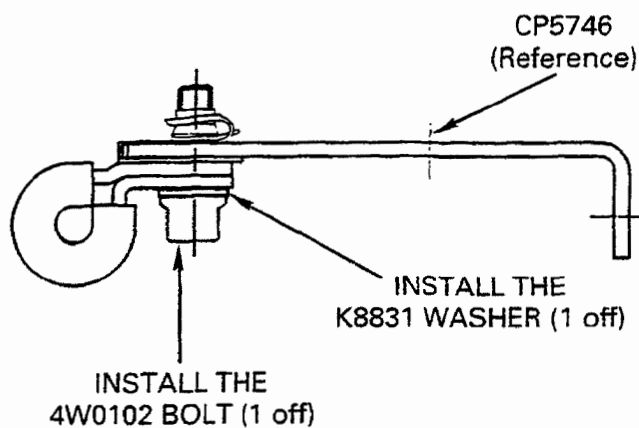
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 5745
BEFORE ALTERATION



CLIPPING POINT 5745
AFTER ALTERATION

B8704

Location of the LT Harness
Figure 10 (Sheet 5)

V2500 — ENG — 72 — 0132

Page 28

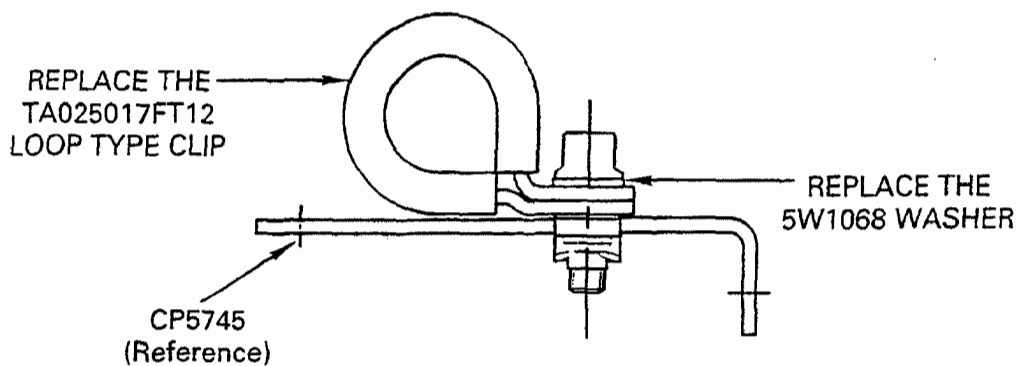
June 30/93



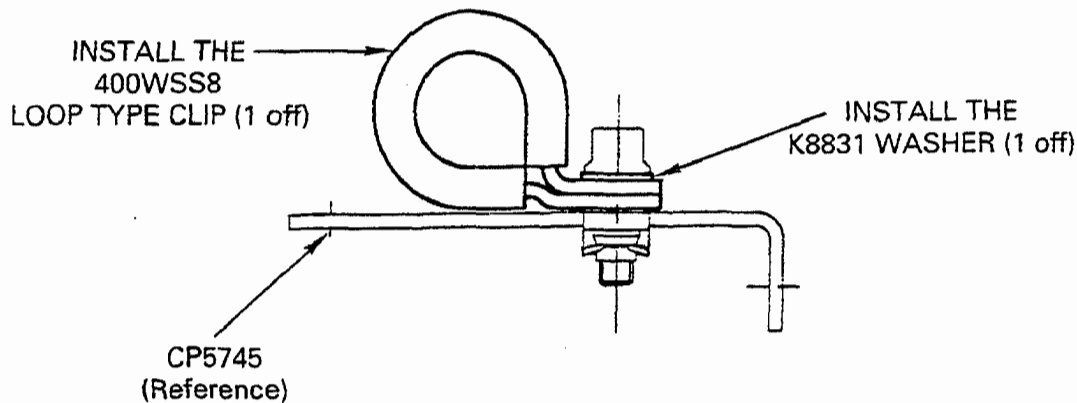
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 5746
BEFORE ALTERATION



CLIPPING POINT 5746
AFTER ALTERATION

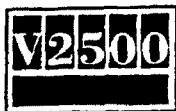
B8705

Location of the LT Harness
Figure 10 (Sheet 6)

June 30/93

V2500 – ENG – 72 – 0132

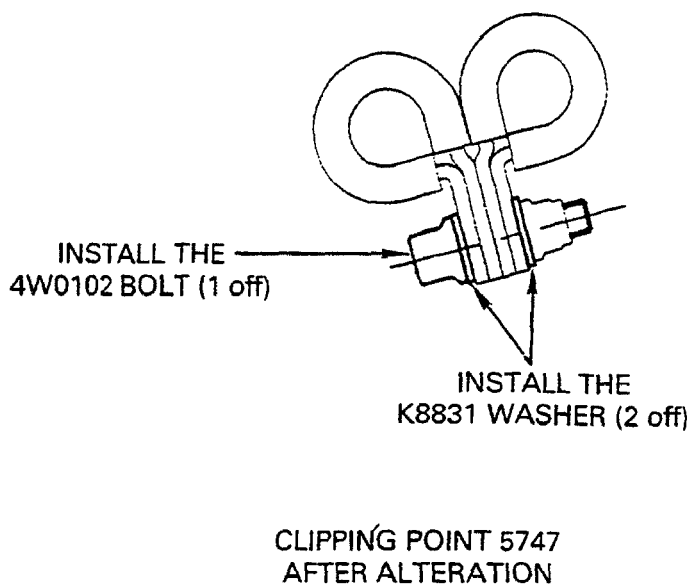
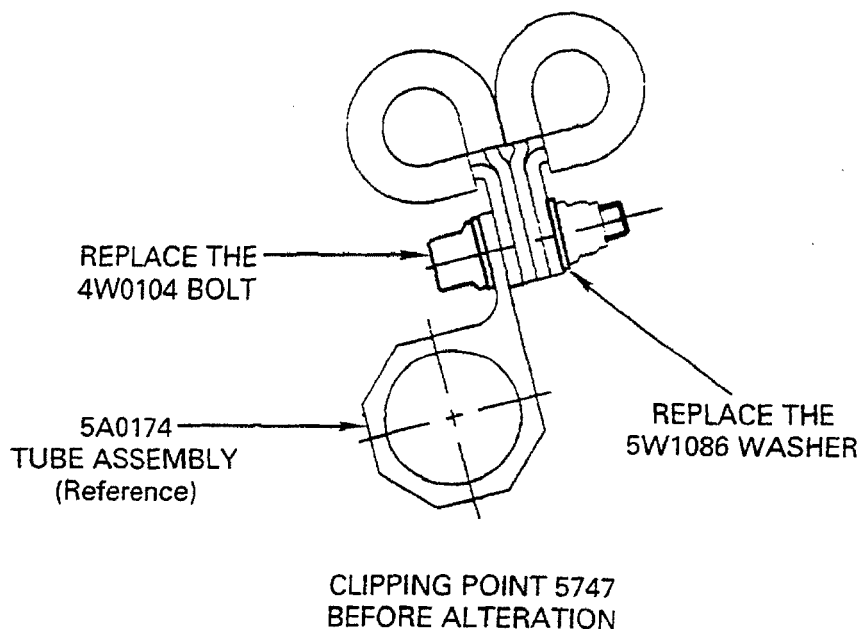
Page 29



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



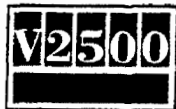
B8706

Location of the LT Harness
Figure 10 (Sheet 7)

V2500 — ENG — 72 — 0132

June 30/93

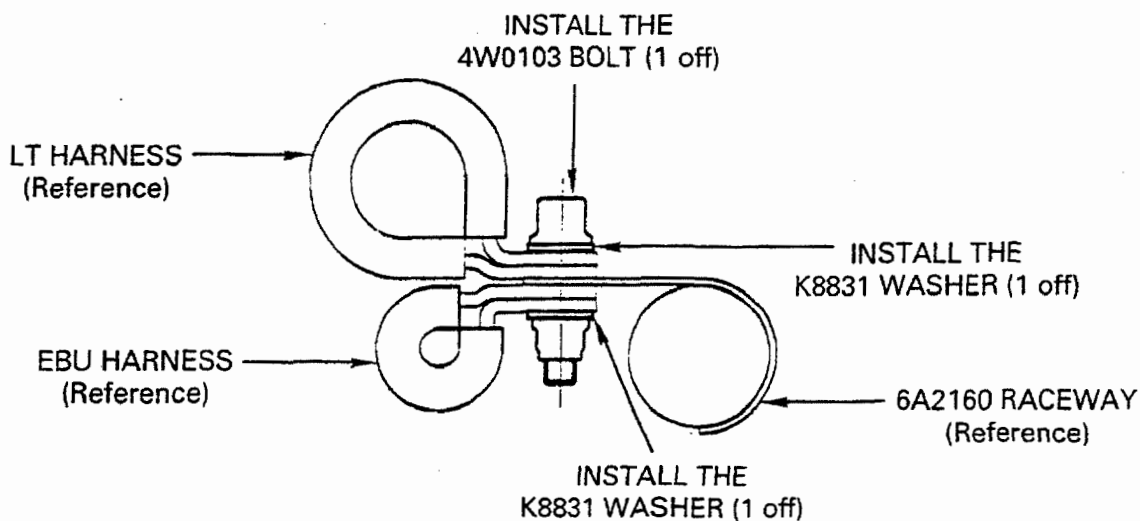
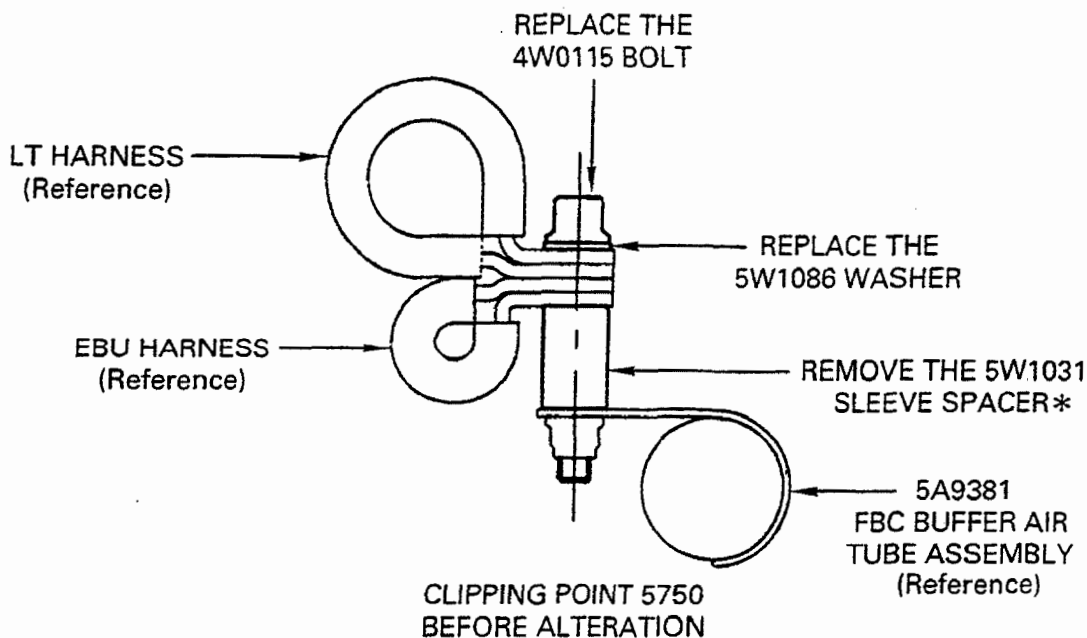
Page 30



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



*Part is removed and will not be
installed again in the new
configuration

CLIPPING POINT 5750
AFTER ALTERATION

B8707

Location of the LT Harness
Figure 10 (Sheet 8)

June 30/93

V2500 — ENG — 72 — 0132

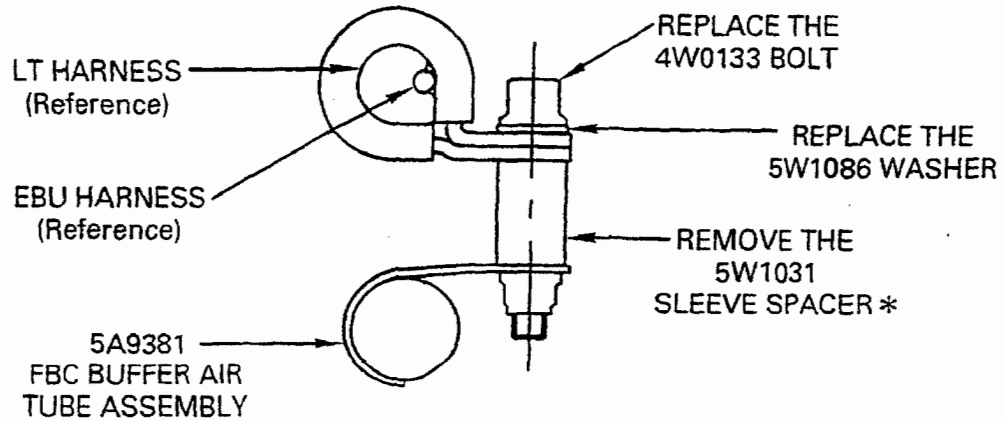
Page 31



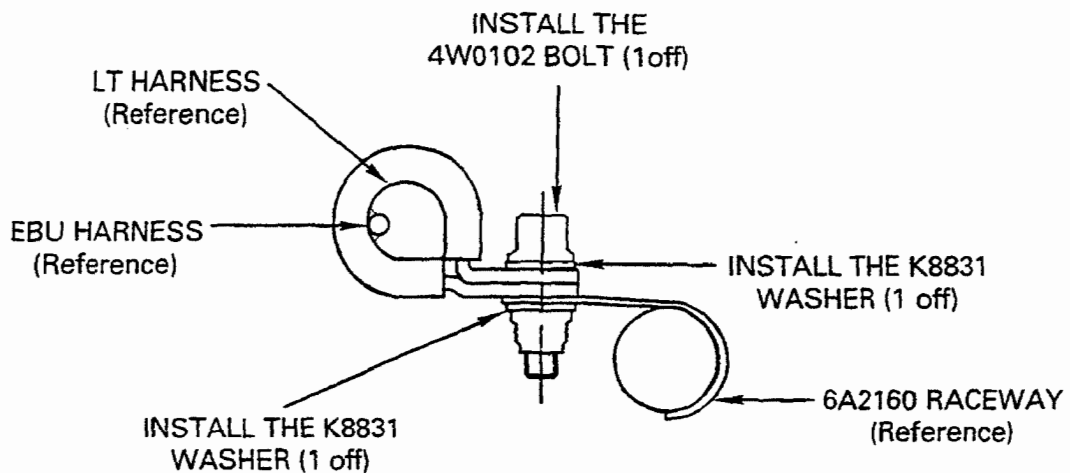
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 5751
BEFORE ALTERATION



CLIPPING POINT 5751
AFTER ALTERATION

* Part is removed and will not be
installed again in the new configuration

B8708A

Location of the LT Harness
Figure 10 (Sheet 9)

V2500 - ENG - 72 - 0132

June 30/93

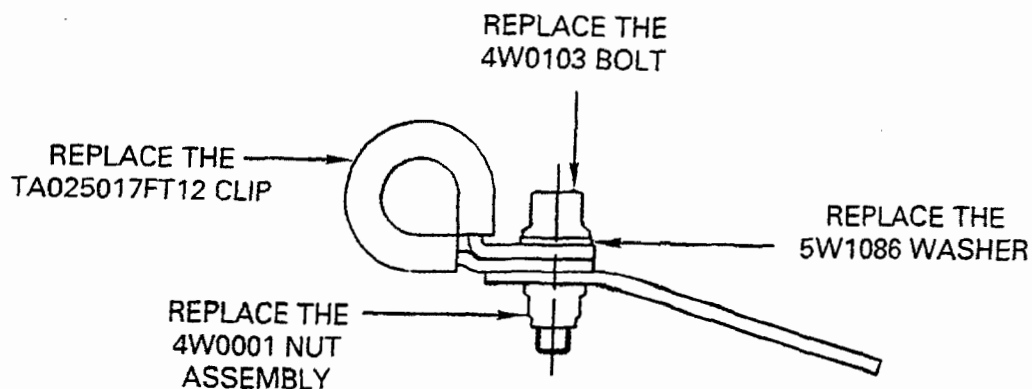
Page 32



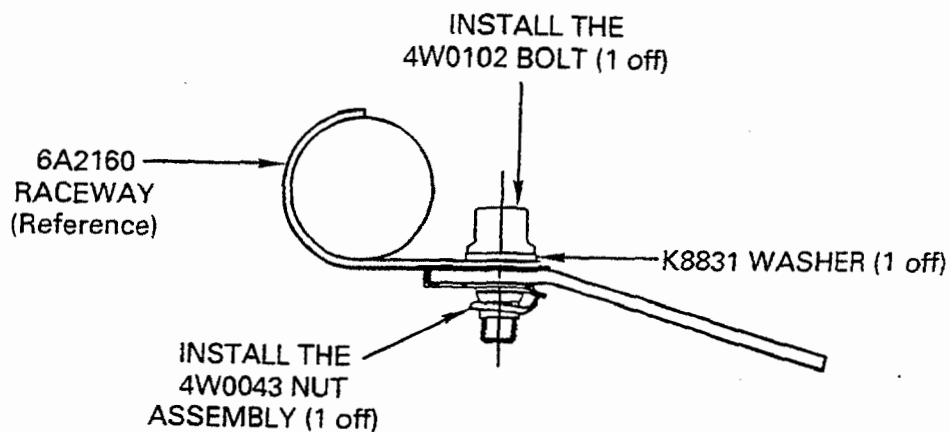
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 5776
BEFORE ALTERATION



CLIPPING POINT 5776
AFTER ALTERATION

B8709

Location of the LT Harness
Figure 10 (Sheet 10)

V2500 – ENG – 72 – 0132

Page 33

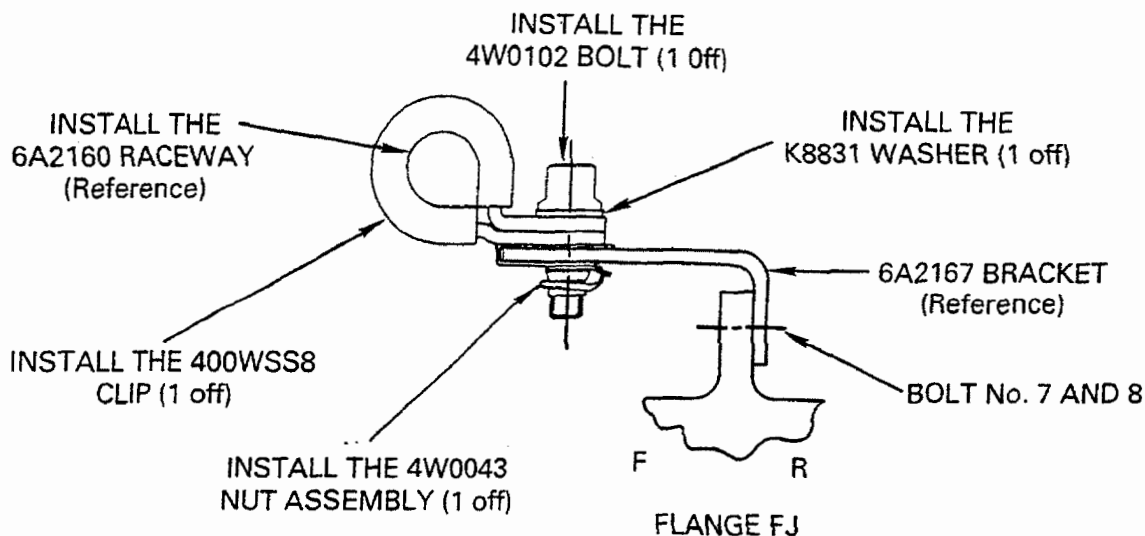
June 30/93



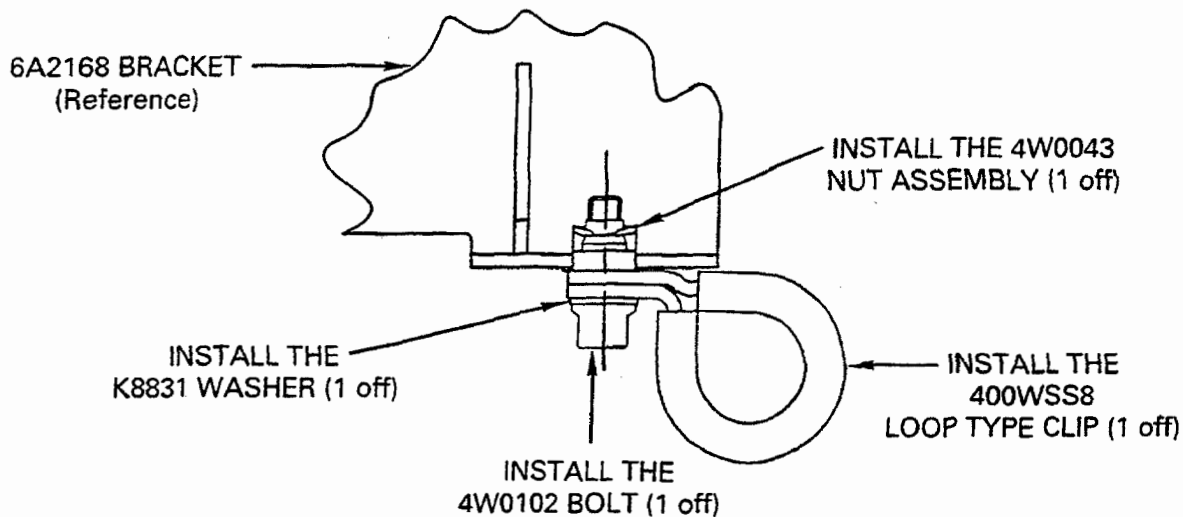
International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



CLIPPING POINT 6056
ADDITIONAL



CLIPPING POINT 6057
ADDITIONAL

B8710

Location of the LT Harness
Figure 10 (Sheet 11)

V2500 - ENG - 72 - 0132

Page 34

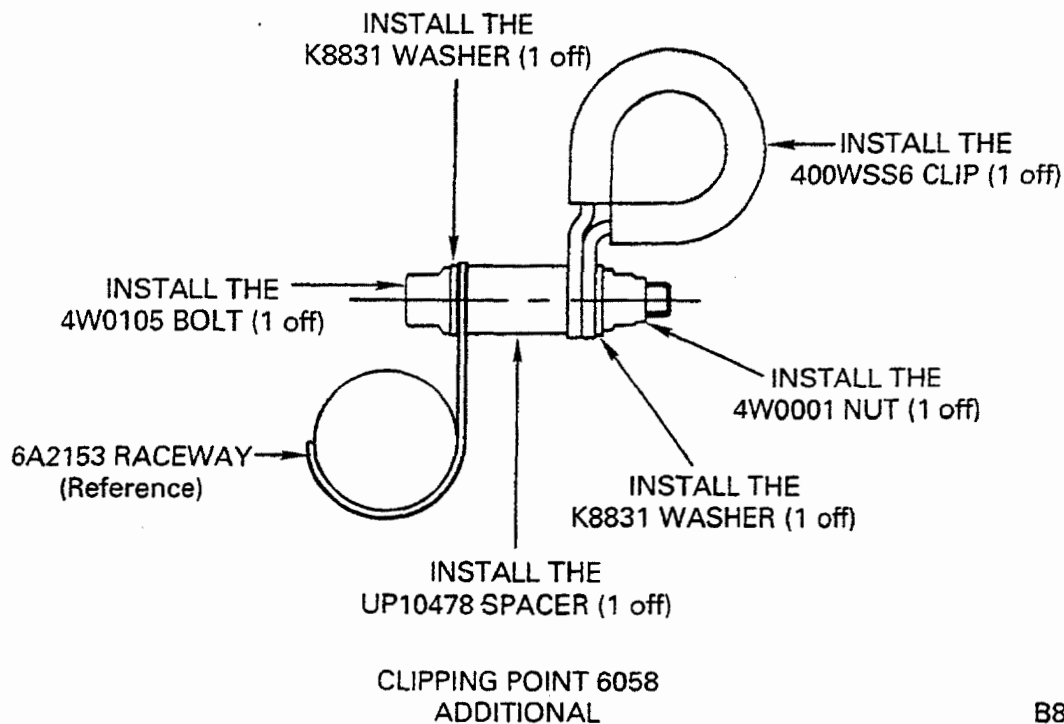
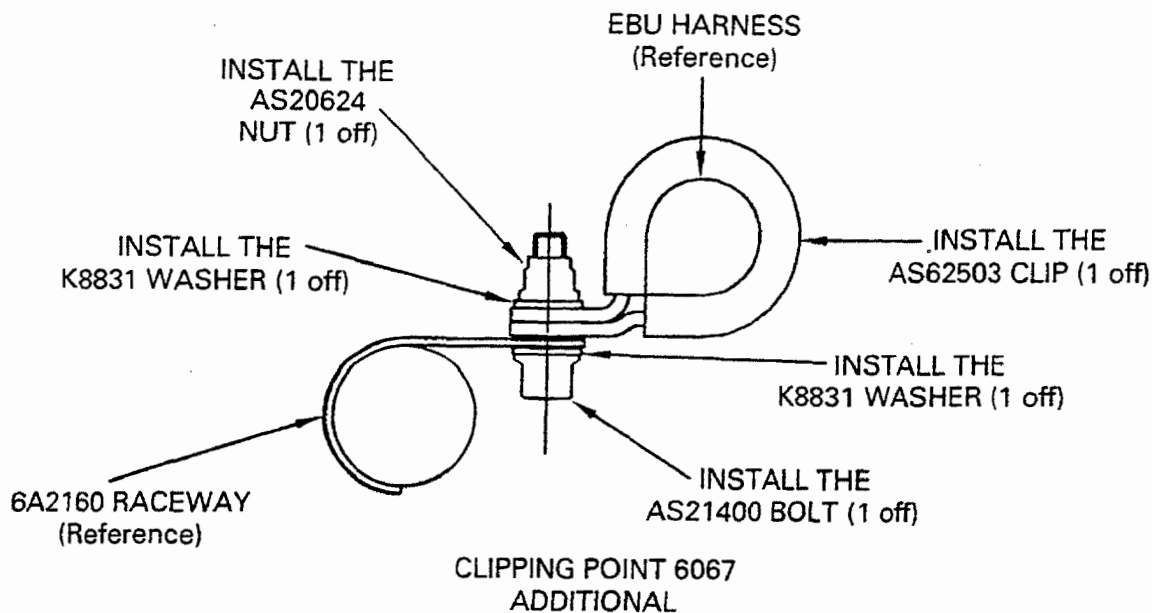
June 30/93



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



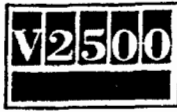
B8711A

Location of the LT Harness
Figure 10 (Sheet 12)

V2500 – ENG – 72 – 0132

June 30/93

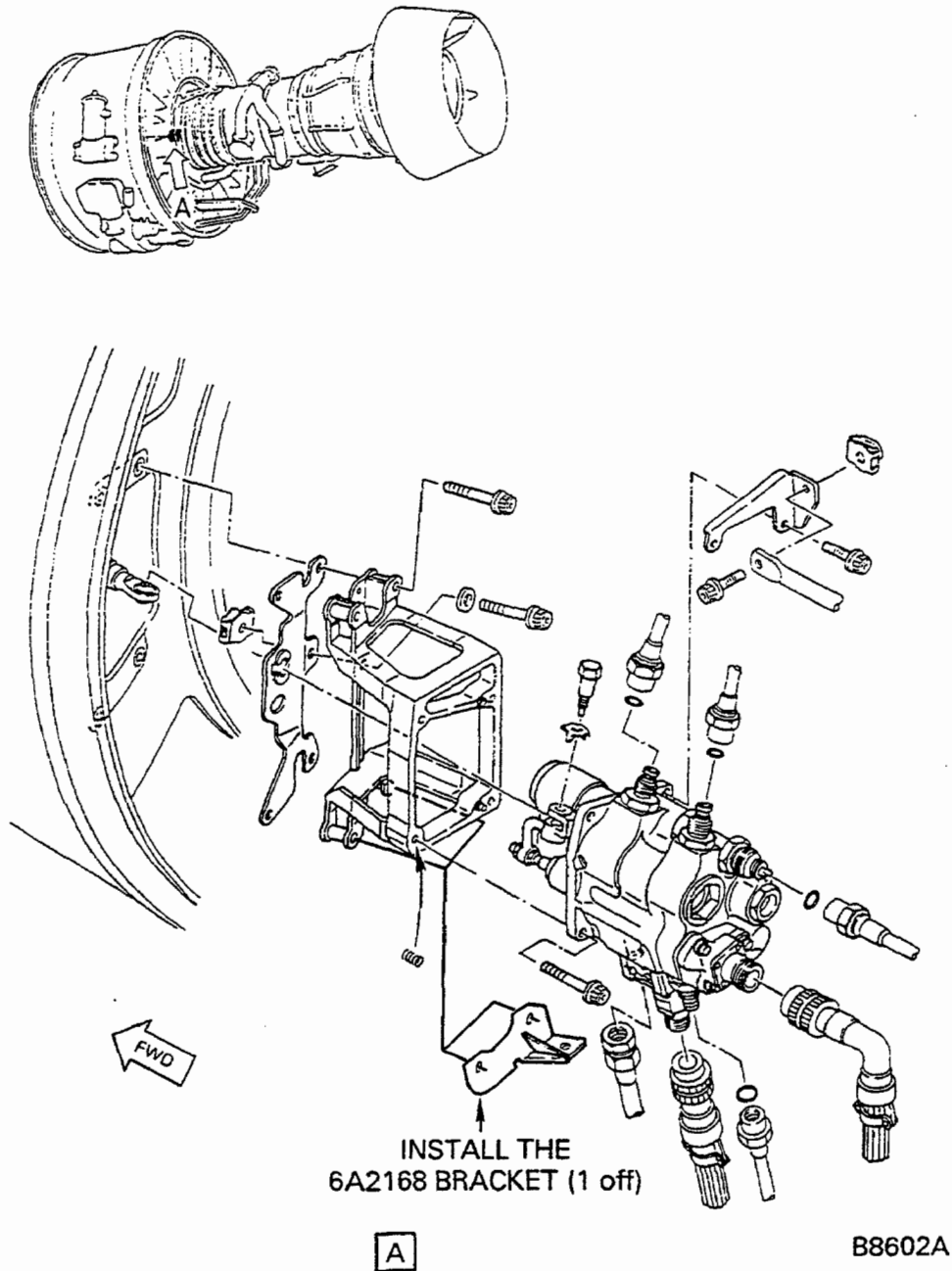
Page 35



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



Location of the Bracket (6A2168)
Figure 11

V2500 – ENG – 72 – 0132

Page 36

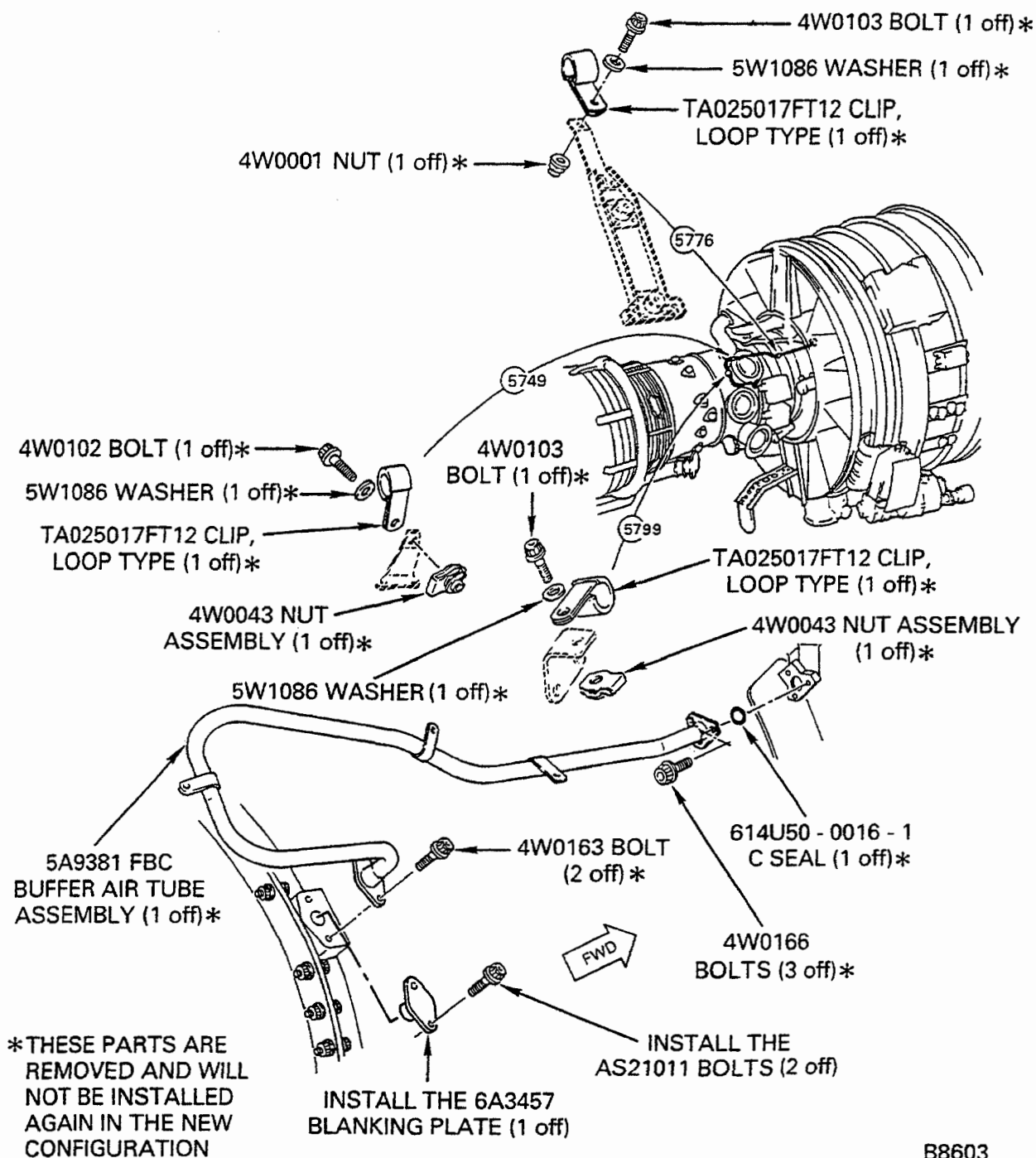
June 30/93



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



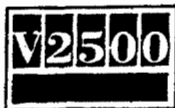
B8603

Location of the FBC Buffer Air Tube Assemblies
and Related Hardware
Figure 12 (Sheet 1 of 2)

June 30/93

V2500 - ENG - 72 - 0132

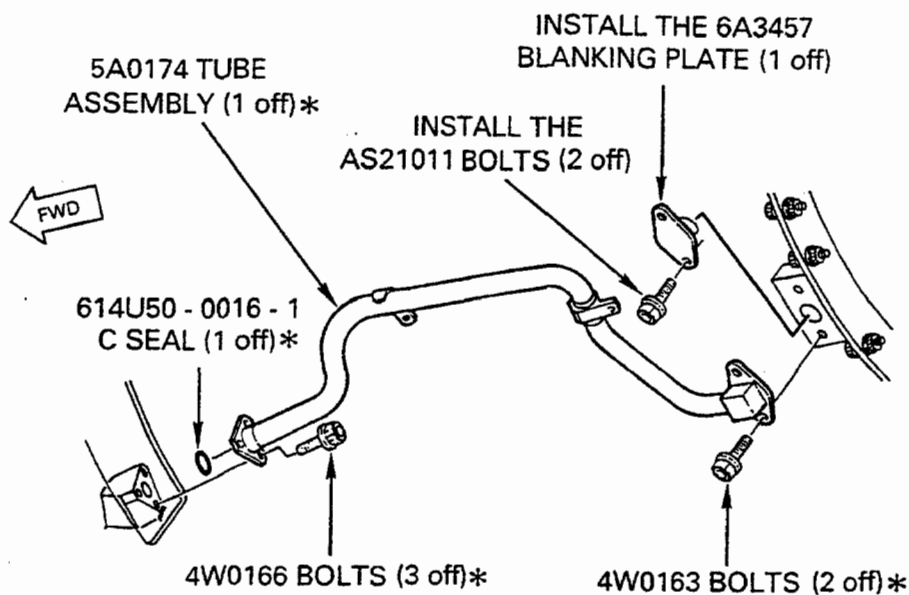
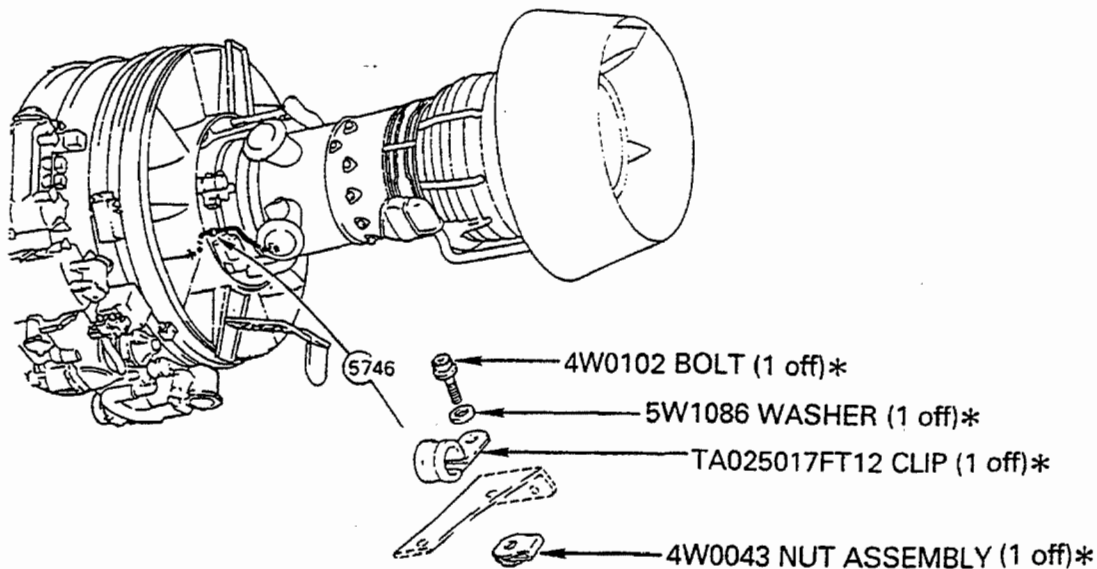
Page 37



International
Aero Engines

V2500 Propulsion System — Engine

SERVICE BULLETIN



* THESE PARTS ARE REMOVED AND WILL NOT
BE INSTALLED AGAIN IN THE NEW CONFIGURATION

B8604

Location of the FBC Buffer Air Tube Assemblies
and Related Hardware

Figure 12 (Sheet 2 of 2)

V2500 - ENG - 72 - 0132

Page 38

June 30/93



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN

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
4W0103 (71-52-43)	1	11.40	Bolt	4W0105 (01-358)	(S1) (A) (B)
K8831 (71-52-43)	2	0.15	Washer	5W1086 (01-359)	(S1) (A) (B) (C)
- (71-52-43)	1	-	Clamp, Loop	TA025074-07 (01-361)	(B)
- (71-52-43)	1	-	Clamp, Loop	AS61905 (01-361)	(B)
4W0102 (71-52-43)	1	3.73	Bolt	4W0103 (01-366)	(S1) (A) (B)
K8831 (71-52-43)	1	0.15	Washer	5W1086 (01-367)	(S1) (A) (B)
4W0102 (71-52-43)	1	3.73	Bolt	4W0113 (01-374)	(S1) (A) (B)
K8831 (71-52-43)	2	0.15	Washer	5W1086 (01-375)	(S1) (A) (B) (C)
- (71-52-43)	1	-	Spacer, Sleeve	5W1031 (01-379)	(B)
4W0103 (71-52-43)	1	11.40	Bolt	4W0115 (01-382)	(S1) (A) (B)
K8831 (71-52-43)	2	0.15	Washer	5W1086 (01-383)	(S1) (A) (B) (C)
- (71-52-43)	1	-	Spacer, Sleeve	5W1031 (01-387)	(B)
6A2153 (71-52-50)	1	270.00	Raceway	- (04-100)	(S1) (A)
4W0102 (71-52-50)	1	3.73	Bolt	- (04-125)	(S1) (A)
K8831 (71-52-50)	1	0.15	Washer	- (04-126)	(S1) (A)
4W0043 (71-52-50)	1	1.99	Nut, Assembly	- (04-132)	(S1) (A)
4W0102 (71-52-50)	1	3.73	Bolt	- (04-133)	(S1) (A)
K8831 (71-52-50)	1	0.15	Washer	- (04-134)	(S1) (A)
400WSS8 (71-52-50)	1	5.88	Clip, Loop Type	- (04-136)	(S1) (A)

June 30/93

V2500 - ENG - 72 - 0132

Page 39



**International
Aero Engines**

V2500 Propulsion System — Engine

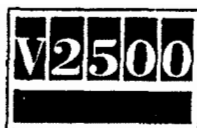
SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
4W0043 (71-52-50)	1	1.99	Nut, Assembly	- (04-140)	(S1) (A)
4W0102 (71-52-50)	1	3.73	Bolt	- (04-141)	(S1) (A)
K8831 (71-52-50)	1	0.15	Washer	- (04-142)	(S1) (A)
400WSS8 (71-52-50)	1	5.88	Clip, Loop Type	- (04-144)	(S1) (A)
4W0043 (71-52-50)	1	1.99	Nut, Assembly	- (04-148)	(S1) (A)
6A2160 (71-52-50)	1	226.00	Raceway	- (04-500)	(S1) (A)
4W0102 (71-52-50)	1	3.73	Bolt	- (04-525)	(S1) (A)
K8831 (71-52-50)	1	0.15	Washer	- (04-526)	(S1) (A)
4W0043 (71-52-50)	1	1.99	Nut, Assembly	- (04-532)	(S1) (A)
4W0102 (71-52-50)	1	3.73	Bolt	- (04-533)	(S1) (A)
K8831 (71-52-50)	1	0.15	Washer	- (04-534)	(S1) (A)
400WSS8 (71-52-50)	1	5.88	Clip, Loop Type	- (04-535)	(S1) (A)
4W0043 (71-52-50)	1	1.99	Nut, Assembly	- (04-540)	(S1) (A)
- (72-32-00)	18	-	Nut	4W0002 (01-960)	(B)
- (72-32-00)	18	-	Bolt	4W0165 (01-980)	(B)
- (72-32-00)	1	-	Bracket, Air Feed	5R0245 (02-094)	(J)
- (72-32-00)	1	-	Bracket, Air Feed	5R0245 (02-096)	(J)
- (72-32-00)	4	-	Nut	4W0002 (02-102)	(B)
- (72-32-00)	4	-	Bolt	4W0166 (02-105)	(B)
- (72-32-00)	17	-	Nut	4W0002 (02-110)	(B) (F)
4W0002 (72-32-00)	21	7.15	Nut	- (02-110)	(S1) (A) (F)
MS9321-10 (72-32-00)	21	0.03	Washer, Flat	- (02-115)	(S1) (A)

June 30/93

V2500 — ENG — 72 — 0132

Page 40



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
-	17	-	Bolt	4W0166	(B)
(72-32-00)				(02-120)	
4W0168	21	5.65	Bolt	-	(S1) (A)
(72-32-00)				(02-120)	(F)
AS21013	18	2.72	Bolt	AS21010	(S1) (A)
(72-32-00)				(02-151)	(B)
MS9321-10	18	0.03	Washer, Flat	-	(S1) (A)
(72-32-00)				(02-153)	
-	2	-	Bolt, Option	4W0164	(B)
(72-32-00)				(03-110)	
-	2	-	Washer, Option	4W2622	(B)
(72-32-00)				(03-112)	
-	2	-	Nut	4W0044	(B)
(72-32-00)				(03-114)	
-	2	-	Clip, Spring	AS12850	(B)
(72-32-00)			Tension, Outer	(03-116)	
-	2	-	Clip, Spring	AS12820	(B)
(72-32-00)			Tension, Outer	(03-117)	
-	2	-	Bushing, Plastic	AS12899	(B)
(72-32-00)				(03-118)	
-	4	-	Nut	4W0002	(B)
(72-32-00)				(03-125)	
-	4	-	Bolt	4W0168	(B)
(72-32-00)				(03-127)	
-	2	-	Ring, Sealing	AS43013-115	(B)
(72-32-00)			Toroidal	(03-129)	

R Part 1: For newly produced Frame, A/O Fan

R	5A1047	1	-	Frame A/O Fan	5A0856	(S1)
R	(72-32-03)			or	(03-100)	
R	-	3		...Insert	AGS3732	(J)
R	(72-32-03)				(03-163)	
R	-	3		...Insert	AGS3732	(J)
R	(72-32-03)				(03-313)	

Part 2: For Engines which incorporated V2500-ENG-72-0051 Part 1

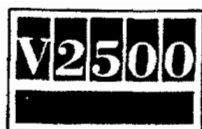
R	5A1167	1	-	Frame, A/O Fan	5A0856	(S1) (1D)
R	(72-32-03)				(03-100)	(H)
R	or					
R	5A1049	1	-	Frame, A/O Fan	5A0407	(S1) (1D)
R	(72-32-03)				(03-100)	(H)
R	5A0298	2	41.50	..Plate, Blanking	-	(K)
R	(72-32-03)				(03-104)	
R	614U50-0016-1	2	17.40	..Seal, C	-	(K)
R	(72-32-03)				(03-105)	

V2500 - ENG - 72 - 0132

June 30/93

Revision 1 May 30/97

Page 41



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
R 4W0166 (72-32-03)	6	4.21	..Bolt	- (03-106)	(K)
R 5A1061 (72-32-03)	2	58.80	..Plug	- (03-421)	(S1) (A)
R Part 3: For Engines which incorporated V2500-ENG-72-0051					
R 5A1064 (72-32-03)	1	-	Frame, A/O Fan	5A0401 (03-100)	(S1) (1D) (H)
R or R 5A1062 (72-32-03)	1	-	Frame, A/O Fan	5A0405 (03-100)	(S1) (1D) (H)
R or R 5A1068 (72-32-03)	1	-	Frame, A/O Fan	5A0403 (03-100)	(S1) (1D) (H)
R or R 5A1066 (72-32-03)	1	-	Frame, A/O Fan	5A0409 (03-100)	(S1) (1D) (H)
R 5A0298 (72-32-03)	2	41.50	..Plate, Blanking	- (03-104)	(K)
R 614U50-0016-1 (72-32-03)	2	17.40	..Seal, C	- (03-105)	(K)
R 4W0166 (72-32-03)	6	4.21	..Bolt	- (03-106)	(K)
R 5A1061 (72-32-03)	2	58.80	..Plug	- (03-421)	(K)

For Engines which do not Incorporate V2500-ENG-72-0010

2A2370 (72-32-25)	1	-	Seal Assembly, No. 3	2A1794 (02-100)	(S1) (A) (E)
2A2060 (72-32-25)	4	-	Bearing .Pin, Bearing Seal	2A1787 (02-200)	(S1) (A) (J)
2A2059 (72-32-25)	2	212.00	.Spacer, Sleeve	2A1788 (02-210)	(S1) (A) (J)
2A1916 (72-32-25)	1	4743.00	.Seal, Ring Holder	2A1790 (02-230)	(S1) (A)
- (72-32-25)	1	-	No. 3 Bearing .Seal, Ring	2A1793 (02-250)	(J)
2A1962 (72-32-25)	1	699.00	.Seal, Plain	- (02-250)	(S1) (A)
- (72-32-25)	A/R	-	.Seal Ring	2A1793P5 (02-252)	(J)
- (72-32-25)	A/R	-	.Seal Ring	2A1793P10 (02-254)	(J)
- (72-32-25)	A/R	-	.Seal Ring	2A1793P15 (02-256)	(J)

V2500 - ENG - 72 - 0132

June 30/93

R Revision 1 May 30/97

Page 42

Printed in Great Britain



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
------------------------------	------	-----------------------------	---------	------------------------------	-----------------------------

-	A/R	-	.Seal Ring	2A1793P20	(J)
(72-32-25)				(02-258)	
MS21209F4-15	4	0.51	.Insert, Screw	MS21209F4-10	(S1) (A)
(72-32-25)			Thread	(02-270)	(B)

For Engines which Incorporate V2500-ENG-72-0010

2A2370	1	-	Seal Assembly, No. 3	2A1289	(S1) (A)
(72-32-25)			Bearing	(02-100)	(J)
2A2060	4	-	.Pin, Bearing Seal	2A1787	(S1) (A)
(72-32-25)				(02-200)	(J)
2A2059	2	212.00	.Spacer, Sleeve	2A1788	(S1) (A)
(72-32-25)				(02-210)	(J)
2A1916	1	4743.00	.Seal, Ring Holder	2A1288	(S1) (A)
(72-32-25)			No. 3 Bearing	(02-230)	(J)
-	1	-	.Seal, Ring	2A1793	(J)
(72-32-25)				(02-250)	
2A1962	1	699.00	.Seal, Plain	-	(S1) (A)
(72-32-25)				(02-250)	
-	A/R	-	.Seal Ring	2A1793P5	(J)
(72-32-25)				(02-252)	
-	A/R	-	.Seal Ring	2A1793P10	(J)
(72-32-25)				(02-254)	
-	A/R	-	.Seal Ring	2A1793P15	(J)
(72-32-25)				(02-256)	
-	A/R	-	.Seal Ring	2A1793P20	(J)
(72-32-25)				(02-258)	
MS21209F4-15	4	0.51	.Insert, Screw	MS21209F4-10	(S1) (A)
(72-32-25)				(02-270)	(B)
5R0176	1	-	Seal, Assembly	5R0057	(S1) (A)
(72-32-35)			Air FBC Rear	(01-100)	(J)
5R0178	1	11.80	.Pin, Location	-	(S1) (A)
(72-32-35)				(01-205)	
-	1	-	Seal Assembly, Runner	5R0400	(J)
(72-32-51)			Front	(01-200)	
5R0068	1	-	Ring Assembly, Nut	-	(S1) (A)
(72-32-51)				(01-200)	

For Engines that do not Incorporate V2500-ENG-70-0096 and V2500-72-ENG-72-0082

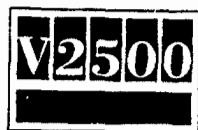
2A1065	1	-	Seal Assembly, No. 1	2A1782	(S1) (A) (E)
(72-32-53)			Bearing	(01-105)	
2A2199	1	5191.00	.Seal Assembly, Face,	2A1773	(S1) (A) (E)
(72-32-53)			No. 1 Bearing	(01-150)	
-	1	-	..Seal Face	2A1771	(H)
(72-32-53)				(01-180)	
2A0541	1	-	..Seal Option	-	(S1) (H)
(72-32-53)			Consisting of:	(01-180)	

V2500 - ENG - 72 - 0132

June 30/93

R Revision 1 May 30/97

Page 43



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
2A1771 (72-32-53)	Ref	-	..Seal, Face or	- (01-180)	(H)
2A0539 (72-32-53)	Ref	-	..Seal, Face, No. 1	- (01-180)	(H)
- (72-32-53)	1	-	..Seal Assembly, Holder No. 1 Bearing	2A1779 (01-200)	(J)
2A1066 (72-32-53)	1	6212.00	.Support, No. 1 Bearing	- (01-200)	(S1) (A)
- (72-32-53)	4	-	..Pin	2A1774 (01-220)	(J)
2A1639 (72-32-53)	4	118.00	.Pin, No. 1 Bearing Seal	-	(S1) (A)
- (72-32-53)	1	-	..Support	2A1777 (01-230)	(J)
- (72-32-53)	1	-	..Seal, Ring Holder	2A1778 (01-240)	(J)
- (72-32-53)	18	-	..Insert, Screw Thread	MS21209F4-10 (01-250)	(J)
MS21209F4-15 (G) (72-32-53)	25	0.51	.Insert, Screw Thread	- (01-250)	(S1) (A)
- (72-32-53)	12	-	.Rivet	AN125460 (01-260)	(J)
- (72-32-53)	8	-	.Rivet	AN125462 (01-270)	(J)
2A2057 (72-32-53)	2	189.00	.Spacer, Sleeve	2A1775 (01-280)	(S1) (A) (E)
2A2035 (72-32-53)	4	45.50	.Collar, Retaining	2A1776 (01-300)	(S1) (A) (E)
- (72-32-53)	1	-	.Seal, Ring	2A1781 (01-340)	(B)
2A1941 (72-32-53)	1	806.00	.Seal, Plain	- (01-340)	(S1) (A)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P5 (01-342)	(J)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P10 (01-344)	(J)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P15 (01-346)	(J)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P20 (01-348)	(J)
AS3209-279 (72-32-53)	1	30.30	Packing, Preformed O-Ring	AS3209-280 (01-400)	(S1) (A) (B)

Printed in Great Britain

V2500 – ENG – 72 – 0132

June 30/93

R Revision 1 May 30/97

Page 44



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
------------------------------	------	-----------------------------	---------	------------------------------	-----------------------------

For Engines that Incorporate V2500-ENG-70-0096 but do not Incorporate V2500-72-ENG-72-0082

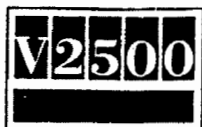
2A1065	1		Seal Assembly, No. 1	2A2036	(S1) (A)
(72-32-53)			Bearing	(01-105)	(E)
2A2199	1	5191.00	.Seal Assembly, Face,	2A1773	(S1) (A)
(72-32-53)			No. 1 Bearing	(01-150)	(E)
-	1	-	..Seal Face	2A1771	(H)
(72-32-53)				(01-180)	
2A0541	1	-	..Seal Option	-	(S1) (H)
(72-32-53)			Consisting of:	(01-180)	
2A1771	Ref	-	..Seal, Face	-	(H)
(72-32-53)			or	(01-180)	
2A0539	Ref	-	..Seal, Face, No. 1	-	(H)
(72-32-53)				(01-180)	
-	1	-	..Seal Assembly, Holder	2A1779	(J)
(72-32-53)			No. 1 Bearing	(01-200)	
2A1066	1	6212.00	.Support, No. 1	-	(S1) (A)
(72-32-53)			Bearing	(01-200)	
-	4	-	..Pin	2A1774	(J)
(72-32-53)				(01-220)	
2A1639	4	118.00	.Pin, No. 1 Bearing	-	(S1) (A)
(72-32-53)			Seal	(01-220)	
-	1	-	..Support	2A1777	(J)
(72-32-53)				(01-230)	
-	1	-	..Seal, Ring Holder	2A1778	(J)
(72-32-53)				(01-240)	
-	18	-	..Insert, Screw Thread	MS21209F4-10	(J)
(72-32-53)				(01-250)	
MS21209F4-15	25	0.51	.Insert, Screw Thread	-	(S1) (A) (G)
(72-32-53)				(01-250)	
-	12	-	.Rivet	AN125460	(J)
(72-32-53)				(01-260)	
-	8	-	.Rivet	AN125462	(J)
(72-32-53)				(01-270)	
-	1	-	.Seal, Ring	2A1781	(J)
(72-32-53)				(01-340)	
2A1941	1	806.00	.Seal, Plain	-	(S1) (A)
(72-32-53)				(01-340)	
-	A/R	-	.Seal, Ring	2A1781P5	(J)
(72-32-53)				(01-342)	
-	A/R	-	.Seal, Ring	2A1781P10	(J)
(72-32-53)				(01-344)	
-	A/R	-	.Seal, Ring	2A1781P15	(J)
(72-32-53)				(01-346)	
-	A/R	-	.Seal, Ring	2A1781P20	(J)
(72-32-53)				(01-348)	

June 30/93

R Revision 1 May 30/97

V2500 - ENG - 72 - 0132

Page 45



International Aero Engines SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
------------------------------	------	-----------------------------	---------	------------------------------	-----------------------------

AS3209-279 (72-32-53)	1	30.30	Packing, Preformed O-Ring	AS3209-280 (01-400)	(S1) (A) (B)
--------------------------	---	-------	------------------------------	------------------------	-----------------

For Engines that Incorporate V2500-ENG-70-0096 and V2500-72-ENG-72-0082

2A1065 (72-32-53)	1	-	Seal Assembly, No. 1 Bearing	2A2203 (01-105)	(S1) (A) (J)
- (72-32-53)	1	-	..Seal Assembly, Holder No. 1 Bearing	2A1779 (01-200)	(J)
2A1066 (72-32-53)	1	6212.00	.Support, No. 1 Bearing	- (01-200)	(S1) (A)
- (72-32-53)	4	-	..Pin	2A1774 (01-220)	(J)
2A1639 (72-32-53)	4	118.00	.Pin, No. 1 Bearing Seal	- (01-220)	(S1) (A)
- (72-32-53)	1	-	..Support	2A1777 (01-230)	(J)
- (72-32-53)	1	-	..Seal, Ring Holder	2A1778 (01-240)	(J)
- (72-32-53)	18	-	..Insert, Screw Thread	MS21209F4-10 (01-250)	(J)
MS21209F4-15 (72-32-53)	25	0.51	.Insert, Screw Thread	- (01-250)	(S1) (A) (G)
- (72-32-53)	12	-	.Rivet	AN125460 (01-260)	(J)
- (72-32-53)	8	-	.Rivet	AN125462 (01-270)	(J)
- (72-32-53)	1	-	.Seal, Ring	2A1781 (01-340)	(B)
2A1941 (72-32-53)	1	806.00	.Seal, Plain	- (01-340)	(S1) (A)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P5 (01-342)	(B)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P10 (01-344)	(B)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P15 (01-346)	(B)
- (72-32-53)	A/R	-	.Seal, Ring	2A1781P20 (01-348)	(B)
AS3209-279 (72-32-53)	1	30.30	Packing, Preformed O-Ring	AS3209-280 (01-400)	(S1) (A) (B)
5W2078 (72-32-55)	1	9980.00	Support Assembly Seal	5W2050 (01-100)	(S1) (A) (B)
RPNF250-28SM (72-32-55)	3	4.67	.Nut	- (01-115)	(S1) (A)
RPNF250-28SM (72-32-55)	4	4.67	.Nut	- (01-118)	(S1) (A)

V2500 – ENG – 72 – 0132

June 30/93

R Revision 1 May 30/97

Page 46

Printed in Great Britain



International Aero Engines

SERVICE BULLETIN

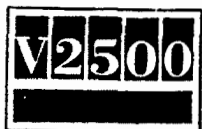
New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
- (72-32-56)	1	-	Ring, Retaining Spiral	5R6130 (01-100)	(J)
- (72-32-56)	1	-	Seal Assembly, Air FBC Front	5R6131 (01-150)	(J)
- (72-32-56)	1	-	.Seal, Assembly, Brush	6A2053 (01-160)	(J)
- (72-32-57)	2	-	Tube Assembly, Air Feed	5R0233 (01-100)	(J)
- (72-32-57)	-	-	Tube Assembly, Air Feed	5R0240 (01-100)	(J)
6A2167 (72-41-00)	1	8.60	Bracket	- (03-260)	(S1) (A)
6A3457 (72-41-31)	2	185.00	Plate, Blanking	- (01-350)	(S1) (A)
AS21011 (72-41-31)	4	2.72	Bolt	- (01-352)	(S1) (A)
4W0102 (73-11-49)	1	3.73	Bolt	4W0104 (12-165)	(S1) (A) (B)
- (73-11-49)	1	-	Washer	5W1086 (12-166)	(B)
K8831 (73-11-49)	2	0.15	Washer	- (12-166)	(S1) (A) (C)
4W0105 (73-11-49)	1	3.73	Bolt	- (12-173)	(S1) (A)
K8831 (73-11-49)	2	0.15	Washer	- (12-174)	(S1) (A)
400WSS6 (73-11-49)	1	5.29	Clip, Loop Type	- (12-176)	(S1) (A)
UP10478 (73-11-49)	1	8.72	Spacer	- (12-178)	(S1) (A)
4W0001 (73-11-49)	1	2.15	Nut Option	- (12-180)	(S1) (A)
- (75-00-49)	1	-	Bracket	5W8394 (01-092)	(J)
- (75-00-49)	1	-	Bracket	5W8365 (01-095)	(J)
- (75-22-49)	1	-	Seal, C	614U50-0016-1 (11-078)	(J)
- (75-22-49)	1	-	Tube, Assembly, FBC Buffer Air	5A9381 (11-100)	(J)
- (75-22-49)	2	-	Bolt	4W0163 (11-106)	(B)
- (75-22-49)	3	-	Bolt	4W0166 (11-114)	(B)
- (75-22-49)	1	-	Bolt	4W0102 (11-125)	(B)
- (75-22-49)	1	-	Washer	5W1086 (11-126)	(B)

June 30/93

R Revision 1 May 30/97

V2500 - ENG - 72 - 0132

Page 47



International Aero Engines

SERVICE BULLETIN

New Part No. (ATA No.)	Qty.	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
- (75-22-49)	1	-	Clip, Loop Type	TA025017FT12 (11-128)	(J)
- (75-22-49)	1	-	Nut Assembly	4W0043 (11-132)	(B)
- (75-22-49)	1	-	Bolt	4W0103 (11-141)	(B)
- (75-22-49)	1	-	Washer	5W1086 (11-142)	(B)
- (75-22-49)	1	-	Clip, Loop Type	TA025017FT12 (11-144)	(J)
- (75-22-49)	1	-	Nut, Option	4W0001 (11-148)	(B)
- (75-22-49)	1	-	Bolt	4W0103 (11-149)	(B)
- (75-22-49)	1	-	Washer	5W1086 (11-150)	(B)
- (75-22-49)	1	-	Clip, Loop Type	TA025017FT12 (11-152)	(J)
- (75-22-49)	1	-	Nut Assembly	4W0043 (11-156)	(B)
- (75-22-49)	1	-	Seal, C	614U50-0016-1 (13-078)	(J)
- (75-22-49)	1	-	Tube, Assembly	5A0174 (13-100)	(J)
- (75-22-49)	2	-	Bolt	4W0163 (13-106)	(B)
- (75-22-49)	3	-	Bolt	4W0166 (13-114)	(B)
- (75-22-49)	1	-	Bolt	4W0102 (13-125)	(B)
- (75-22-49)	1	-	Washer	5W1086 (13-126)	(B)
- (75-22-49)	1	-	Clip, Loop Type	TA025017FT12 (13-128)	(J)
- (75-22-49)	1	-	Nut	4W0043 (13-132)	(B)
6A2168 (75-31-42)	1	-	Bracket	- (01-180)	(A)

C. Consumables Required To Incorporate This Bulletin

CoMat 10-077 Approved Engine Oils

D. Instruction/Disposition Code Statements:

(S1) New parts coded (S1) must replace old parts coded (S1) in a COMPLETE SET per engine.

(1D) New part number can be obtained by rework and reidentification.

V2500 – ENG – 72 – 0132

June 30/93

R Revision 1 May 30/97

Page 48

Printed in Great Britain



International Aero Engines

SERVICE BULLETIN

- (A) New part is currently available.
- (B) Old part will continue to be available for use at other locations.
- (C) Quantity is increased from 1 to 2.
- (E) Old part will no longer be available.
- (F) Quantity is increased from 17 to 21.
- (G) Quantity is increased from 18 to 25.
- (H) Not available as a spare for replenishment purposes.
- (J) Old part will continue to be available.
- (K) New parts coded (K) are used for modification of Fan Frame Assembly (72-32-03, 03-100).

R
R

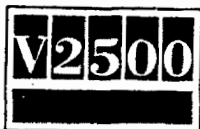
NOTE: The estimated 1993 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

June 30/93

R Revision 1 May 30/97

V2500 – ENG – 72 – 0132

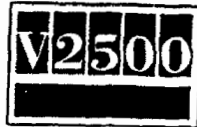
Page 48A



**International Aero Engines
SERVICE BULLETIN**

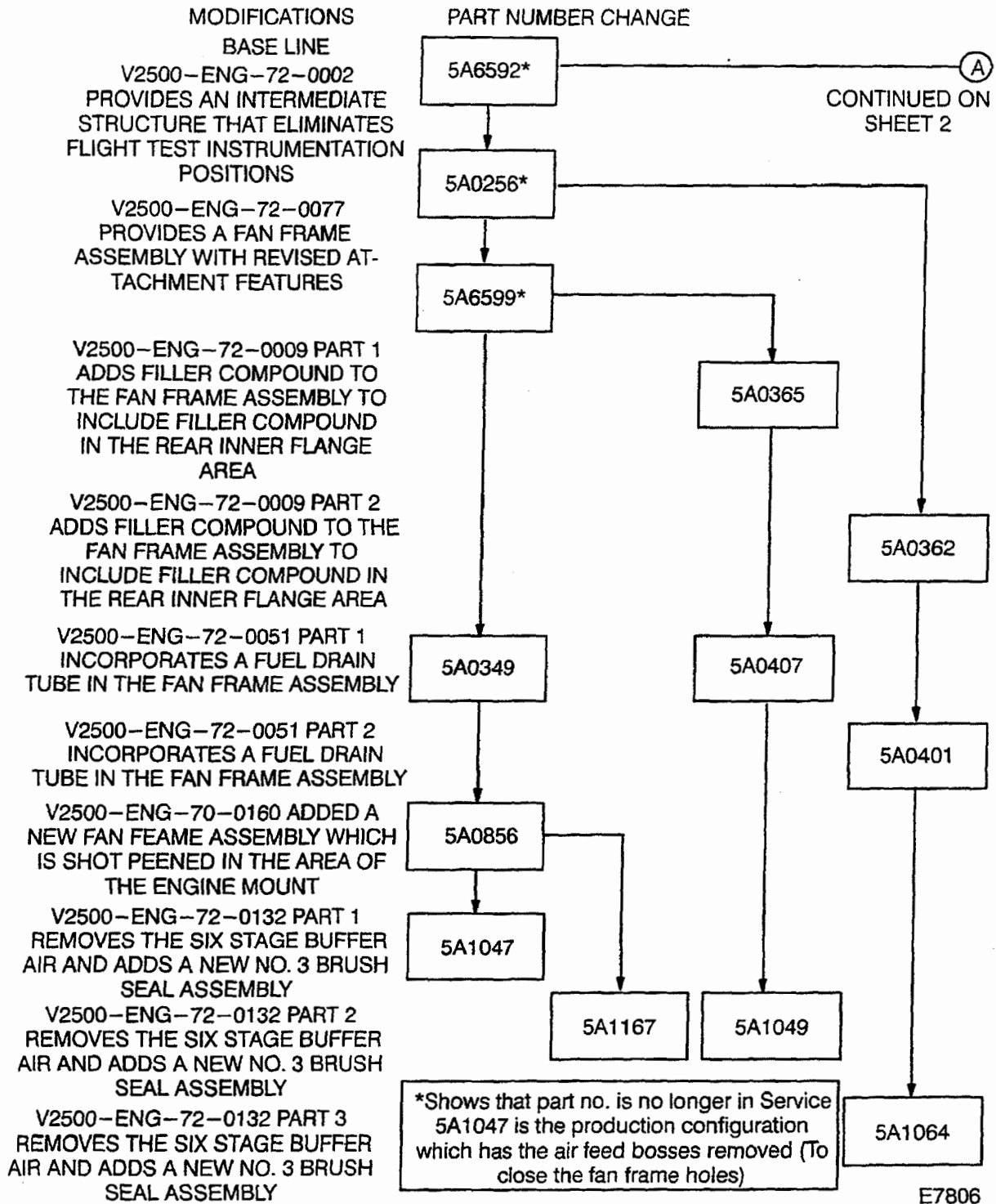
Printed in Great Britain

THIS PAGE INTENTIONALLY LEFT BLANK

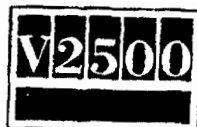


International Aero Engines SERVICE BULLETIN

Printed in Great Britain



Family Tree - Fan Frame Assembly
Ref. Catalog Sequence No.72-32-03, Fig. 03, Item 100
Figure 13 (Sheet 1)



International Aero Engines SERVICE BULLETIN

Printed in Great Britain

CONTINUED FROM
SHEET 1

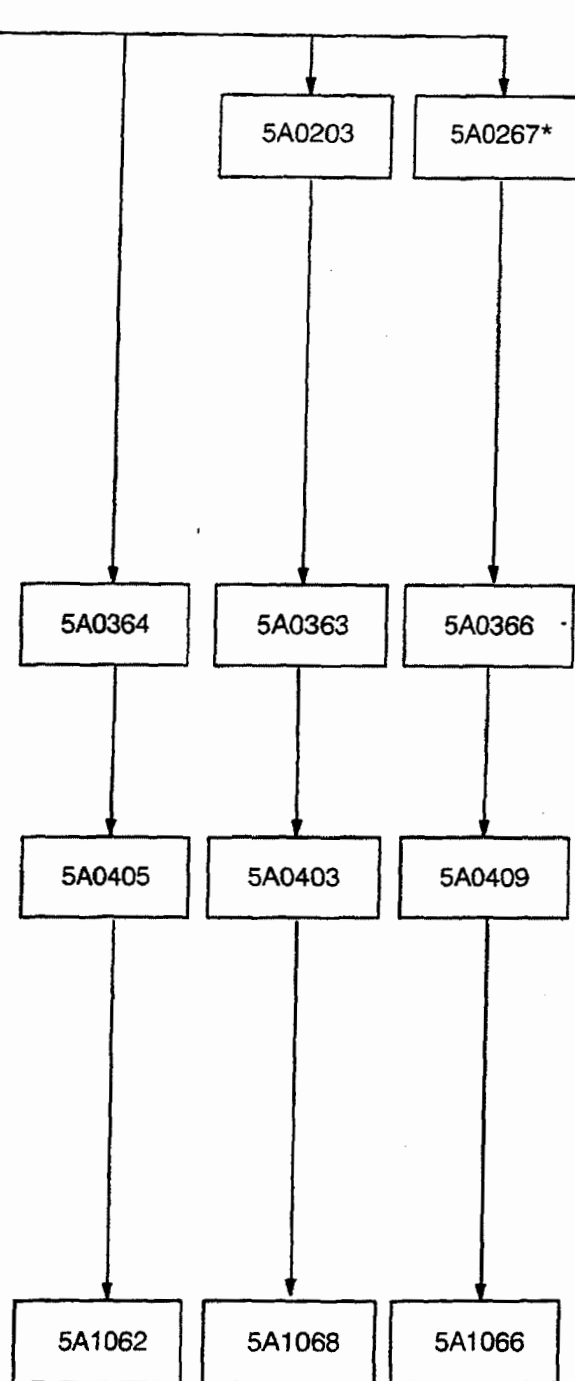
V2500-ENG-72-0002
PROVIDES AN INTERMEDIATE
STRUCTURE THAT ELIMINATES
FLIGHT TEST INSTRUMENTATION
POSITIONS

V2500-ENG-72-0009 PART 2
ADDS FILLER COMPOUND TO THE
FAN FRAME ASSEMBLY TO
INCLUDE FILLER COMPOUND IN
THE REAR INNER FLANGE AREA

V2500-ENG-72-0051 PART 2
INCORPORATES A FUEL DRAIN
TUBE IN THE FAN FRAME ASSEMBLY

V2500-ENG-72-0132 PART 3
REMOVES THE SIX STAGE BUFFER
AIR AND ADDS A NEW NO. 3 BRUSH
SEAL ASSEMBLY

* Shows that part number is no longer in Service



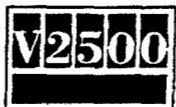
E7807

Family Tree - Fan Frame Assembly
Ref. Catalog Sequence No.72-32-53, Fig. 01, Item 105
Figure 13 (Sheet 2)

V2500 - ENG - 72 - 0132

June 30/93
R Revision 1 May 30/97

Page 50



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN

MODIFICATIONS

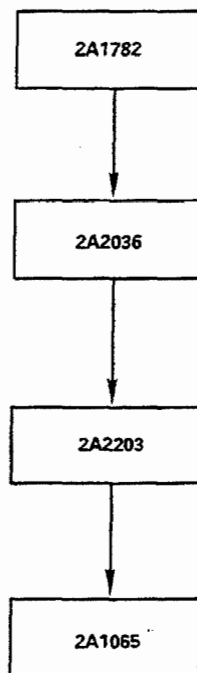
BASE LINE

V2500-ENG-72-0082
PROVIDES A NEW SLEEVE SPACER AND
RETAINING COLLAR FOR THE BEARING SEAL ASSEMBLY

V2500-ENG-70-0096
PROVIDES AN OPTION FOR THE
No.1 BEARING FRONT SEAL ASSEMBLY

V2500-ENG-72-0132
REMOVES SIXTH STAGE BUFFER AIR, PROVIDES A NEW
LIGHTER No.1 BEARING SEAL SUPPORT, AND NEW
No.1 AND No 3 BEARING SEALS

PART NUMBER CHANGE



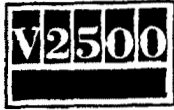
B8609

Family Tree - No. 1 Bearing Seal Assembly
Ref. Catalog Sequence No.72-32-03, Fig. 03, Item 100
Figure 14

June 30/93

V2500 – ENG – 72 – 0132

Page 51



**International
Aero Engines**

V2500 Propulsion System — Engine

SERVICE BULLETIN

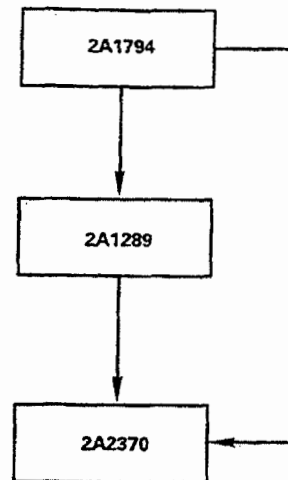
MODIFICATIONS

BASE LINE

V2500-ENG-72-0010
REPLACE THE STEEL SEAL RING HOLDER
WITH THE ONE MADE OF TITANIUM

V2500-ENG-72-0132
PROVIDES A NEW LIGHTER No.3 BEARING
SEAL SUPPORT

PART NUMBER CHANGE



B8610

Family Tree - No. 3 Bearing Seal Assembly
Ref. Catalog Sequence No.72-32-25, Fig. 02, Item 100
Figure 15

June 30/93

V2500 – ENG – 72 – 0132

Page 52