International Aero Engines

SERVICE BULLETIN

ENGINE - LP COMPRESSOR- DELETION OF POLYRUETHANE COATING ON FRONT FAIRING ASSEMBLY - CATEGORY CODE 8 - MOD.ENG-72-0136

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engines prior to Serial Number V0266

B. Reason

(1) Condition

This Service Bulletin introduces a new Front Fairing Assembly which has been deleted the polyruethane coating on the outer surface.

(2) Background

The manufacturing process for the Front Fairing Assembly has been revised.

(3) Objective

The change introduced by this Service Bulletin is designed to ease manufacturing process.

(4) Substantiation

Substantiation testing has been successfully completed.

(5) Effects of Bulletin on workshop procedure:

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

(6) Supplemental Information

(a) Disassembly/assembly are affected due to the bonding of dimple washers on to the front fairing assembly.

(b) Inspection/Check and Repair are affected due to bonding of the dimpled washers on to the front fairing assembly.

C. Description

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

(a) The polyruethane coating on the outer surface of front fairing assembly has been deleted (See Figure 1).

(b) The dimpled washers which attach the front fairing assembly to the bracket are bonded on to the front fairing assembly (See Figure 1.).

(2) Old part can be reworked and reidentified to the new configuration which is applicable to the service use only by incorporation of bonding of the dimpled washers on to the front fairing assembly (Refer to Figure 2.).

(3) New front fairing assembly will be available for future replacement purposes.

D. Approval

The Part Number changes and part modifications described in Sections 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:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) In shop	
(a) Rework the front fairing assembly	1 hour 21 minutes
TOTAL	1 hour 21 minutes

G. Material - Price and Availability

Modification Kit is not required. Part is supplied as single line item.

H. Tooling - Price and Availability

Special tools are not required.

I. Weight and Balance

(1) Weight change .. .. .. None

(2) Moment arm .. .. .. No effect

(3) Datum .. .. Engine fromt mount centerline (Power Plant Station (P.P.S.) 100)

J. Electrical Load Data

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

K. References

(1) Internal Reference No.

EC90VJ042

(2) Other References

V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-93.

V2500 Engine Manual, 72-32-00, Assembly-14, Install the front fairing. TASK 72-32-00-430-A00.

(3) Standard Practices/Processes Manual, 70-09-00, Marking of Parts, TASK 70-09-400-501 and 70-11-14, Chemical Cleaning, TASK 70-11-14-100-501.

(4) Overhaul Processes and Consumables Index

L. Other Publications Affected

(1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-00, and 72-32-93.

(2) V2500 Engine Manual, 72-32-00, LP Compressor/Intermediate Case Module, Disassembly-02 and Assembly-14, 72-32-93, Cleaning, Inspection/Check and Repair.

(3) A320 Aircraft Maintenance Manual, 72-32-88, Removal/Installation, TASK 72-32-88-000-010, and TASK 72-32-88-400-010.

2. Accomplishment Instructions

A. Rework Instructions

	Procedure	Supplementary Information
(1)	Cold liquid degrease each mating surface of the 10 NAS1169C416L, Dimpled Washers and the dimpled holes on each 5A3447, Front Fairing Assembly.	Refer to Figure 2 and 1.K (3), TASK 70-11-14-100-501.
(2)	Hand clean each mating surface of the 10 NAS1169C416L,. Dimpled Washers and the dimpled holes on each 5A3447, Front Fairing Assembly with CoMat 05-017 Garnet paper or CoMat 05-016, Garnet paper.	Refer to Figure 2 and 1.K (4).
(3)	Do step (1) again.	
(4)	Apply a thin layer of CoMat 08-014, Primer for Silcoset 151, 152, 153 to each mating surface of the 10 Dimpled Washers and the dimpled holes on each Front Fairing Assembly then dry in air for 30 minutes.	Refer to Figure 2 and 1.K (4).
(5)	Apply the CoMat 08-013, Cold Curing Silicone Compound (Silcoset 152), to each mating surface of the Dimpled Washers and the dimple holes on each Front Fairing Assembly. Use a corrugated scraper, or other tool, to apply the compound to the mating surfaces at the necessary thickness.	Refer to Figure 2 and 1.K (4).
(6)	Assemble the 10 Dimpled Washers on to the dimpled holes on each Front Fairing Assembly immediately or not longer than three minutes after the compound is applied.	Refer to Figure 2.
(7)	Remove the unwanted compound from around the washers.	
(8)	Cure the compound at 68 deg F (20 deg C) for 48 hours. Do not apply a load during this time.	

(9) Examine the reworked area and the steps between the Dimpled Washer and the Front Fairing Assembly.

Refer to Figure 2.

(10) Renumber the identification number of the Front Fairing Assembly with the Vibro-Peening method.

Refer to Figure 2 and 1.K (3), TASK 70-09-00-400-501.

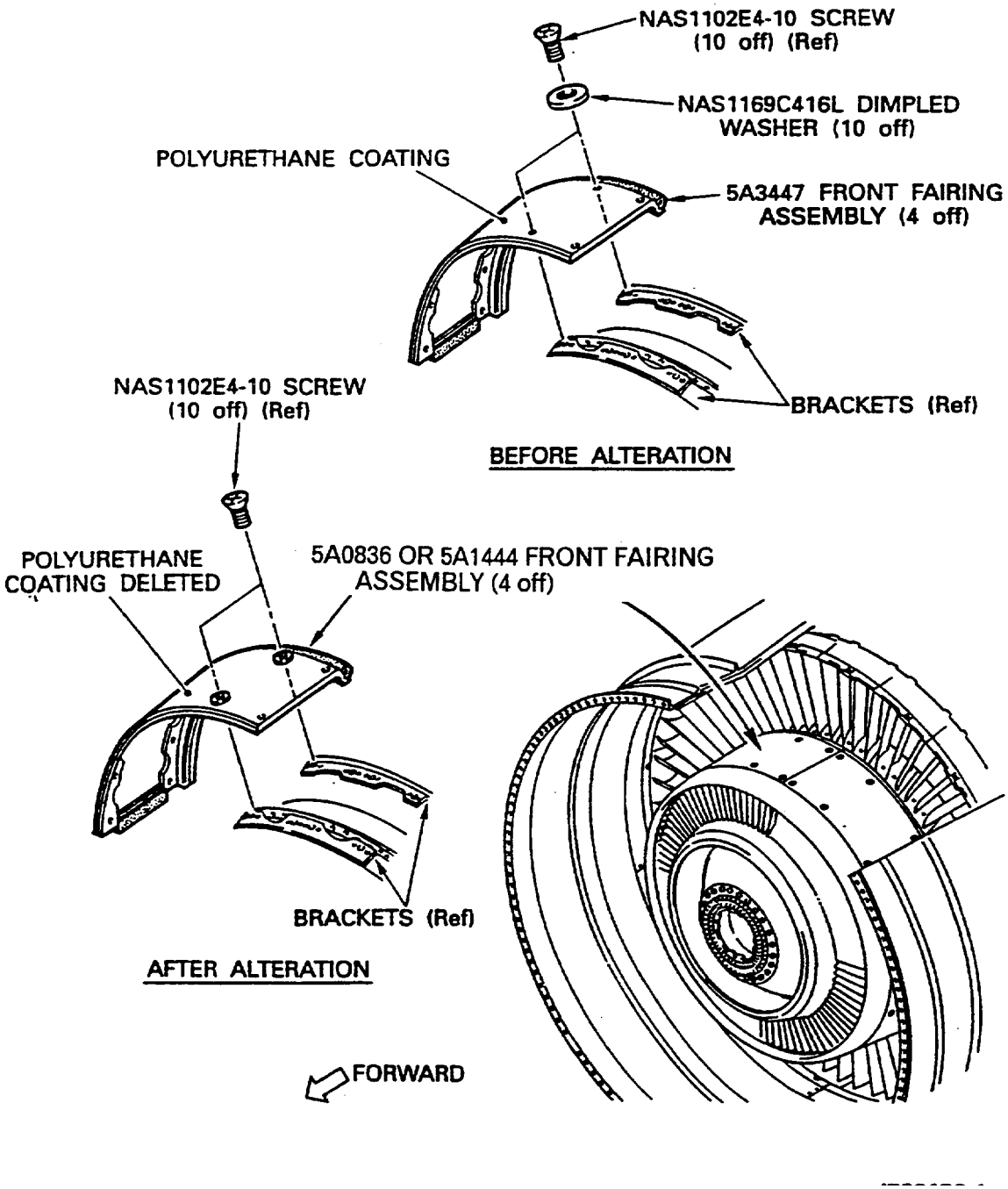
Existing	Renumber
5A3447	5A1444

Assembly Instructions

(1) Install the new 5A0836, Front Fairing Assembly or the reworked 5A1444, Front Fairing Assembly to the LP Compressor/Intermediate Case Module by the approved procedures in the Engine Manual, 72-32-00, Assembly-14 (Refer to 1.K (2)).

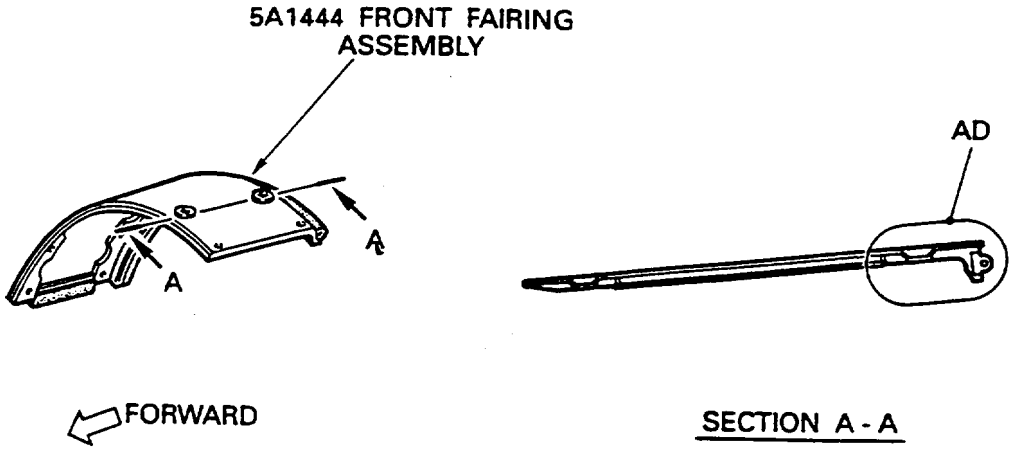
C. Recording Instructions

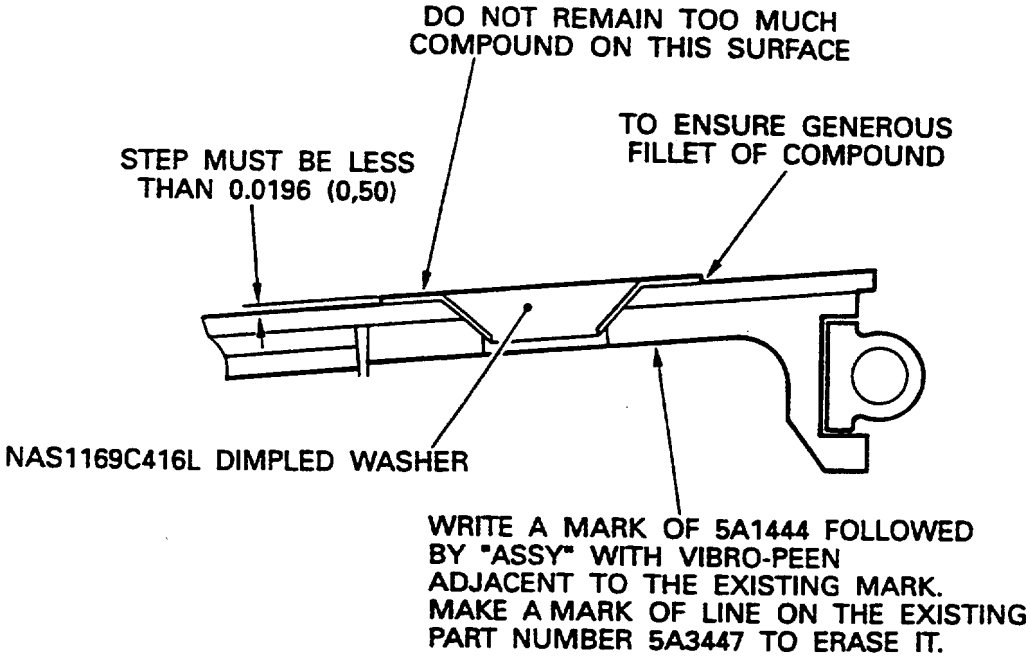
(1) A record of accomplishment is necessary.



ded0000709

Installation of the Front Fairing Assembly - Before and After Alteration
Fig.1





ded0000710

Rework of Front Fairing Assembly
Fig.2

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
- (72-32-00)	40		.Washer, Dimpled	NAS1169C416L (01-208)	(E) (S1) (S2)
5A1444 (72-32-93)	4		.Fairing, A/O Front	5A3447 (01-200)	(B) (C) (1D) (S1) (S3)
5A0836 (72-32-93)	4	2457.00	.Fairing, A/O Front	5A3447 (01-200)	(A) (B) (S2) (S3)
NAS1169C416L (72-32-93)	10	0.82	..Washer, Dimpled	- (01-205)	(A) (2D) (3D)

NOTE: The estimated 1995 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

C. Instruction/Disposition Code Statements:

(A) New Part is currently available for sale.
(B) Old part wil no longer be available for sale.
(C) New part is not available for sale.
(E) Old Part will continue to be available for other application.
(S1) Old and New Parts are interchangeable in sets by location.
(S2) Old and New parts are interchangeable in sets by location.
(S3) Mixing of New parts is permissible.
(1D) Old Part can be reworked and reidentified to the new configuration which is applicable to the service use only.
(2D) New Parts are used to rework the part number 5A3447.
(3D) New parts are used to repair the part numbers 5A1444 and 5A0836