



ENGINE – MAIN GEARBOX ASSEMBLY TO INTRODUCE GEARBOX CASING AND IDG ADAPTER DRAWINGS
WITH REVISED DIMENSIONS FOR A1 AND A5 MODELS – CATEGORY CODE 7 – MOD.ENG-72-0153

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A319, A320, A321
- (2) Engine: V2500-A1 Engines prior to Serial No.V0362
V2527-A5 Engines prior to Serial No.V10103
V2530-A5 Engines prior to Serial No.V10103

B. Reason

(1) Condition

Gearbox casing inspections after IDG pad housing machining, have disclosed that web thickness between an oil duct (feeding starter oil nozzle) and a machined dimension was below the requested thickness value.

(2) Background

The reason of insufficient web thickness is due to internal duct core movement during casting process.

Foundry has been advised to introduce a better control during casting process.

(3) Objective

Incorporation of this Service Bulletin is designed to release a revised gearbox casing featuring new dimension on the IDG area.

This change needs the adapter change to comply with the revised gearbox housing dimension.

(4) Substantiation

By analysis. A finite elements calculation has shown that the zone of the oil duct, where the web thickness was found to be insufficient, is not affected by structural problems.

(5) Effects of Bulletin on Workshop Procedures

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Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

C. Description

This Service Bulletin introduces a new gearbox casing and IDG adapter drawings, similar to the existing item except for:

- (1) Revised dimension.

D. Approval

The part number changes and part modifications are given in Section 3 of this Service Bulletin. They obey the applicable Federal Aviation Regulation and are FAA-APPROVED for the engine model listed.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

F. Manpower

Venue	Estimated man-hours:
(1) In service	Not applicable
(2) At overhaul	Not applicable (Parts are accessible at overhaul)

G. Material – Price and Availability

- (1) A modification kit is not necessary
- (2) See 'Material Information' section for prices and availability of spares.

H. Tooling – Price and Availability

Special tools are not necessary.

I. Weight and Balance

- (1) Weight change None
- (2) Moment arm No effect

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- (3) Datum centreline Engine front mount (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.

EC94VF010

EC94VF010A

- (2) Other References

The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-60-10, Disassembly/Assembly.

L. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalog (IPC) (S-V2500-1IA and S-V2500-2IA), Chapter/Section 72-60-21 and 72-60-28 will be changed to add new part numbers (See Figure 2 and 3).
- (2) V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-60-28, Cleaning, Inspection, Repair, to extend the procedure to the new housing part number.



2. Accomplishment Instructions

A. Rework Instructions

Rework 4B0281 Housing assembly of IDG and reidentify as follows:

Procedure

Supplementary Information

- (1) Rework the chamfer in order to obtain the new dimensions (

See Figure 1

shown in Figure 1

- (2) Renumber 4B0312 adjacent to existing part number. Delete 4B0281 with a single line

Use marking pencil, vibrating

B. Disassembly Instructions

- (1) None.

C. Assembly Instructions

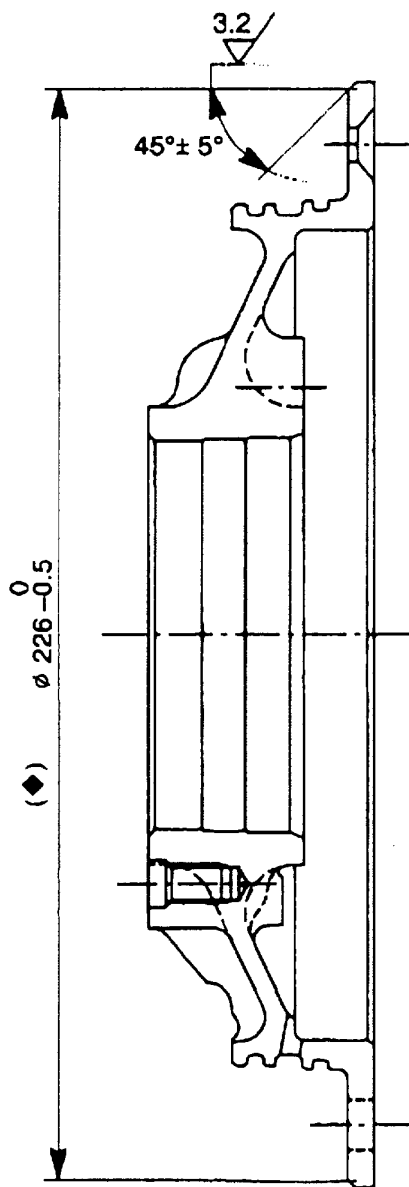
- (1) None.

D. Recording Instructions

- (1) A record of accomplishment is necessary.



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Housing IDG - Drive
Fig.1

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SERVICE BULLETIN

3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits necessary for this Service Bulletin:

None

B. Parts affected by this Service Bulletin:

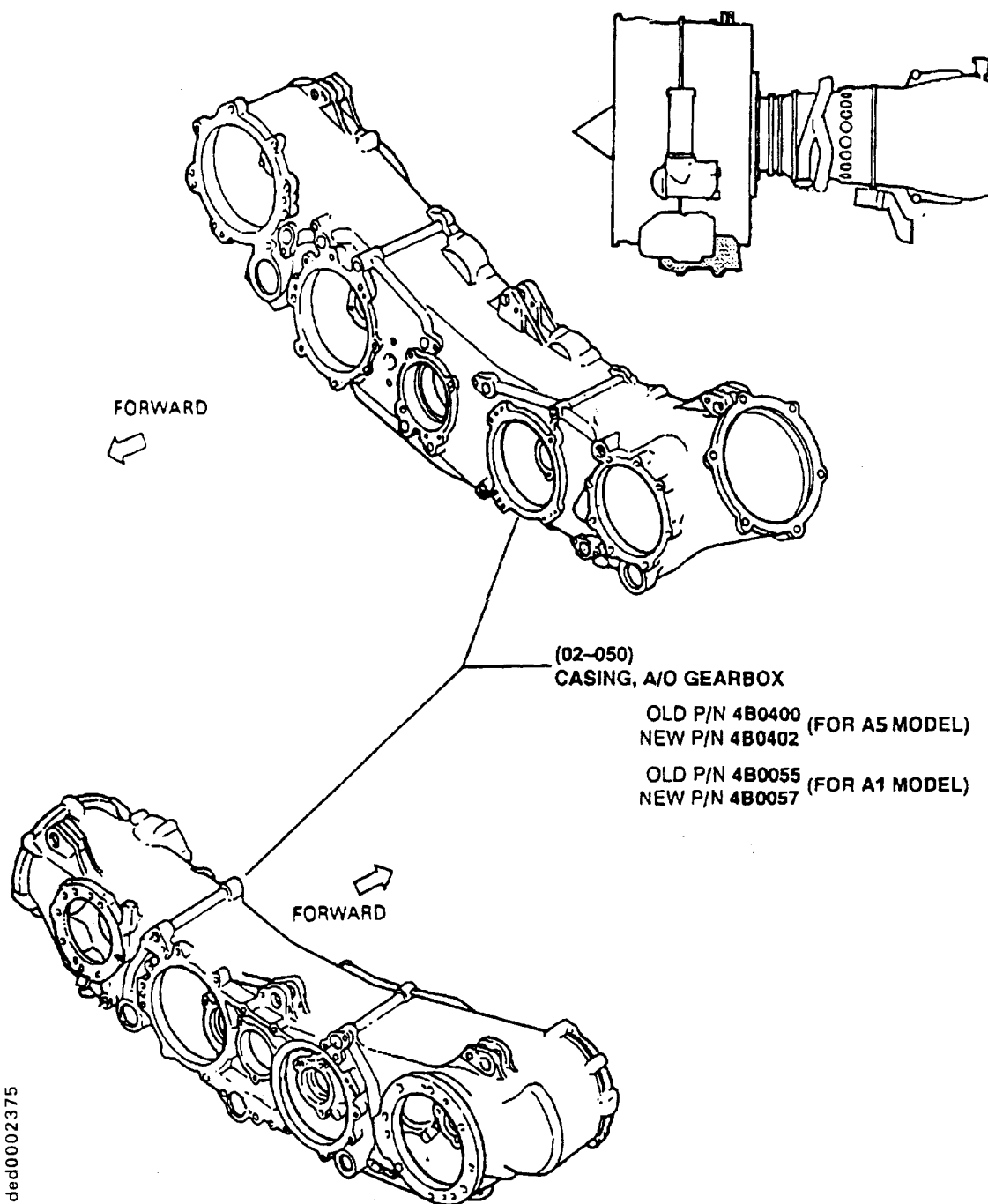
New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
4B0402 (72-60-21)	1		Casing, assembly of, gearbox	4B0400 (02-050)	(A)(B)
4B0057 (72-60-21)	1		Casing, assembly of, gearbox	4B0055 (02-050)	(A)(B)
4B0312 (72-60-28)	1		Housing, assembly of, IDG	4B0281 (01-450)	(A)(B)(1D) (S1)(S2)

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For information about actual prices, refer to the IAE Price Catalog or contact IAE's Spare Parts Sales Department.

C. Instructions Disposition Codes:

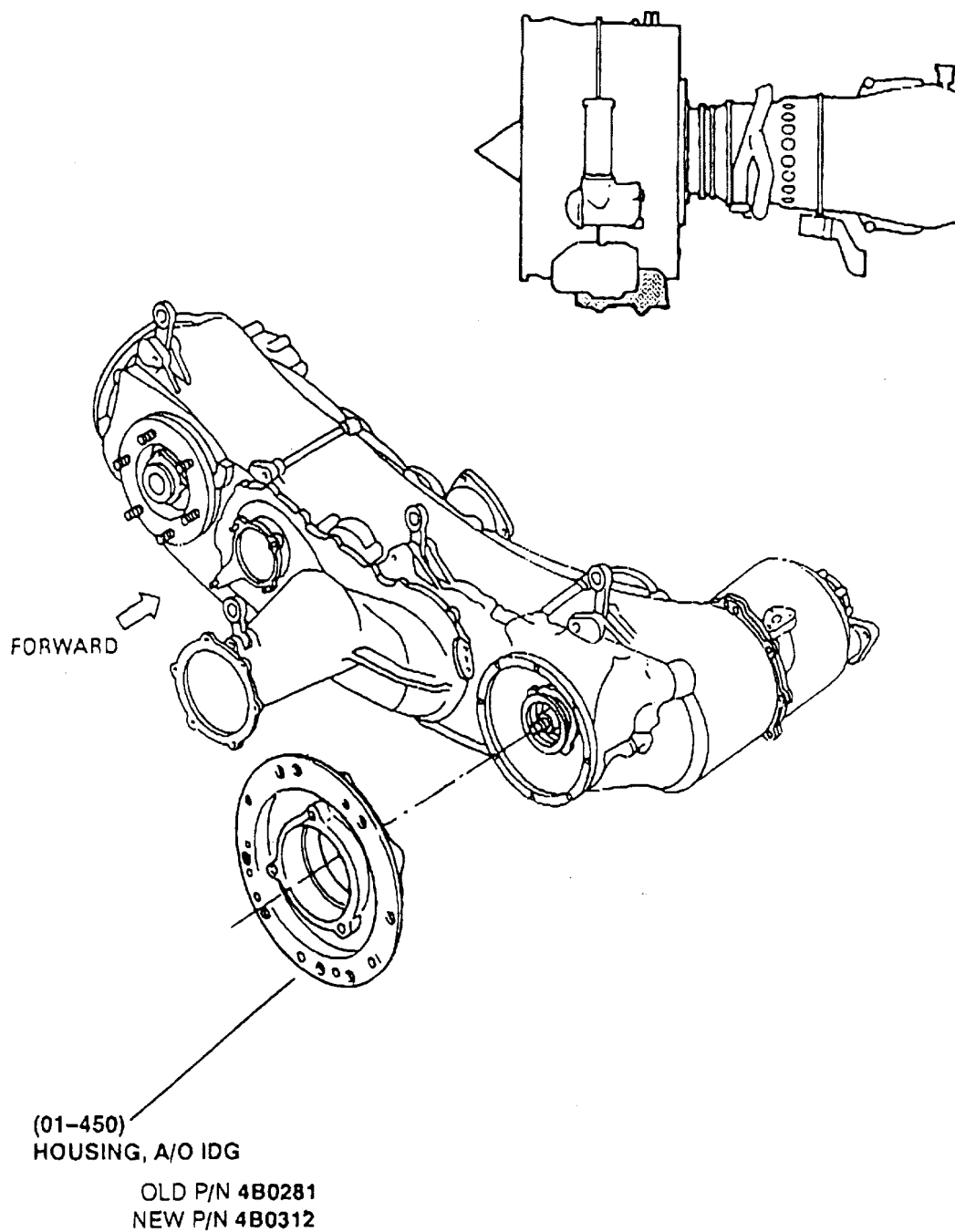
- (A) New part is available for sale.
- (B) Old part will no longer be available for sale.
- (1D) Old part can be reworked and reidentified to new Part Number.
- (S1) New part can be fitted on old gearbox casing.
- (S2) Old part can be fitted on new gearbox casing after the rework.

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Casing, assembly of, Gearbox
Fig.2

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Housing, assembly of, IDG
Fig.3

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