



# International Aero Engines

Subject : Transmittal of Revision 1 to Service Bulletin No. V2500-ENG-72-0164

Service Bulletin Revision History :

Event	Date
Basic Issue	Dec.22/97
Revision 1	Jul.20/98

Reason for Issuance of Revision :

To revise the engine effectivity

Effect on Past Compliance

None

List of Effective Pages:

Bulletin Page No	Rev No.	Effective Date
R 1	1	Jul.20/98
R 2	1	Jul.20/98
3	Basic	Dec.22/97
4	Basic	Dec.22/97
5	Basic	Dec.22/97
R 6	1	Jul.20/98

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Transmittal  
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**International Aero Engines**  
**SERVICE BULLETIN**

Printed in Great Britain

**ENGINE – LP TURBINE ROTOR AND STATOR ASSEMBLY**  
**– INTRODUCE A TWO PIECE LP TURBINE CASE ASSEMBLY**

**MODEL APPLICATION**

R  
R  
R  
R

V2500-A1  
V2522-A5  
V2524-A5  
V2527-A5  
V2527E-A5  
V2530-A5  
V2533-A5  
V2525-D5  
V2528-D5

**BULLETIN INDEX LOCATOR**

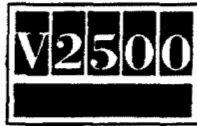
72-50-00

**Compliance Category Code**

7

**Internal Reference No.**

92VM019  
91VM009



# International Aero Engines SERVICE BULLETIN

## ENGINE - LP TURBINE ROTOR AND STATOR ASSEMBLY - INTRODUCE A TWO PIECE LP TURBINE CASE ASSEMBLY

### 1. Planning Information

#### A. Effectivity

- (1) Aircraft: Airbus A319  
Airbus A320  
Airbus A321  
Boeing Douglas Product Devision MD90

- R (2) Engine: V2500-A1 Engines prior to Serial Number V0362  
R V2522-A5 Engines prior to Serial Number V10087  
R V2524-A5 Engines prior to Serial Number V10087  
R V2527-A5 Engines prior to Serial Number V10087  
R V2527E-A5 Engines prior to Serial Number V10087  
R V2530-A5 Engines prior to Serial Number V10087  
R V2533-A5 Engines prior to Serial Number V10087  
R V2525-D5 Engines prior to Serial Number V20014  
R V2528-D5 Engines prior to Serial Number V20014

#### B. Reason

##### (1) Condition

The LP turbine case assembly is at present made by welding from 6 forged rings.

##### (2) Background

The number of weldjoints should be kept to a minimum, to reduce deflection during manufacturing.

##### (3) Objective

A new LP turbine case design was introduced, where the LP turbine case is made of two forged rings joined by one weld, to minimize tolerances build up during the manufacturing process.

##### (4) Substantiation

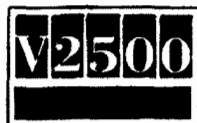
Engineering assessment has concluded that the objective of this modification will be beneficial.

##### (5) Effects of Bulletin on Workshop Procedures:

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

##### (6) Supplemental Information

None



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### D. Approval

The "compliance" statement and the procedures described in Section 2 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 7

Accomplish when the supply of superseded parts has been depleted.

### F. Manpower

Estimated Manhours to incorporate the full intent of this Service Bulletin:

<u>Venue</u>	<u>Estimated Manhours</u>
(1) In Service	Not applicable
(2) In the shop	None

No additional work required to  
assemble the LP turbine module  
with the new LP turbine case.

### G. Material – Price and Availability

(1) Modification kit not required. Parts supplied as single line items.

(2) See "Material Information" section for prices and availability.

### H. Tooling – Price and Availability

Special tools are not required to incorporate this Service Bulletin.

### I. Weight and Balance

(1) Weight change	— 2.2 lbs ( 0,998 kgs )
(2) Moment arm	— 58.76in. (149,50 mm)
(3) Datum	Engine front mount centerline (Powerplant Station (PPS)100)

### J. Electrical Load Data

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



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### **K. References**

- (1) Engineering Change 91VM009  
92VM019
- (2) V2500 Engine Illustrated Parts Catalogue
- (3) V2500 Engine Manual
- (4) V2500 Standard Practices Manual

### **L. Other Publications Affected**

- (1) V2500 Engine Illustrated Parts Catalogue Chapter/Section 72-50-10 to add the new Part Numbers.
- (2) V2500 Engine Manual, Chapter/Section 72-50-21, Cleaning to add the new Part Number.
- (3) V2500 Engine Manual, Chapter/Section 72-50-21, Inspection/Check to add new Part Number.
- (4) V2500 Engine Manual, Chapter/Section 72-50-21 Repair, to add the new Part Number and to introduce borescope replacement procedure.

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### 2. Accomplishment Instructions

#### A. Removal Instructions

Not applicable

#### B. Rework Instructions

This Service Bulletin will be introduced by replacing old and new parts.

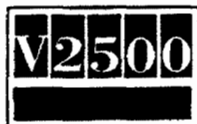
#### C. Assembly Instructions

Not applicable

#### D. Recording Instructions

A record of accomplishment is necessary.

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## 3. Material Information

Applicability: For each V2500 engine to incorporate this Service 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
R	For A1 Engines only					
	3A2265 (72-50-21)	1	--	Case, Assembly LP Turbine	3A0991 (01-010)	(A) (B) (S1)
	3A2190 (72-50-21)	2	--	Boss, Intrascop	3A0514 (01-090)	(A) (S2)
	AN123337 (72-50-21)	8	--	Rivet, Solid CSK HD	AN123685 (01-100)	(A) (S2)
R	For A5 and D5 Engines only					
R	3A2183 (72-50-21)	1	--	Case, Assembly LP Turbine	3A1908 (01-010)	(A) (B) (S1)
R	3A2190 (72-50-21)	2	--	Boss, Intrascop	3A0514 (01-090)	(A) (S2)
R	AN123337 (72-50-21)	8	--	Rivet, Solid CSK HD	AN123685 (01-100)	(A) (S2)

### C. Instruction/Disposition Code Statements:

(A) New Part available for sale.

(B) Old Part no longer manufactured

(S1) Old and new part are interchangeable.

(S2) Part introduced for repair purpose only.

R **NOTE:** The estimated 1998 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.