



ENGINE - LP TURBINE ASSEMBLY - PROVIDE IAE PARTNUMBER IDENTIFICATION FOR LPT ROTORNUTS
- CATEGORY CODE 6 - MOD.ENG-72-0179

Printed in Great Britain

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
Airbus A321
Mc Donnell Douglas MD90
- (2) Engine: V2500-A1 Engines after Serial Number V0291 and prior to Serial Number V0348
V2500-A1 Engines prior to V0292 incorporating Service Bulletin V2500-ENG-72-0125
V2500-A5 Engines prior to Serial Number V10070
V2500-D5 Engines prior to Serial Number V20024

B. Reason

(1) Condition

The existing nuts used at the LP-turbine disk connection are not individually marked with a part number.

(2) Background

During engine shop visit the correct part might be confused with similar parts with inferior material properties, since removed parts can be used again.

(3) Objective

To assure that only correct parts are used during module assembly.

(4) Substantiation

Not required

(5) Effects of Bulletin on Workshop Procedures

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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

C. Description

To provide individually identified LP turbine nuts.

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

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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.

F. Manpower

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

Venue	Estimated Manhours
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(1) In Service	Not applicable
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(2) At Overhaul	TOTAL 1.5 hours
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To mark parts with the correct partnumber (180 nuts per engine)	1.5 hours
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NOTE: The parts affected by this Service Bulletin are accessible at Overhaul.

G. Material – Price and Availability

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

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(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 | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front mount centerline
(Powerplant Station(PPS)100) |

K. Electrical Load Data

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

K. References

- (1) Internal Reference No.

92VM049

- (2) Other References

V2500 Engine Illustrated Parts Catalogue

V2500 Engine Manual

V2500 Standard Practices Manual

IAE Service Bulletin V2500-ENG-72-0125

L. Other Publications Affected



2. Accomplishment Instructions

A. Removal Instructions

Not applicable

B. Rework Instructions

Optional:

If the existing configuration part is in stock in unopened containers showing the old part number, it is permitted to reidentify the individual parts with the new partnumber as per section 3 of this Service Bulletin.

Mark the nuts with the respective partnumber in accordance with the approved procedure as per section 1.K. (4).

V2500 Standard Practises Manual, TASK 70-09-00, use vibro peen method or roller stamp method.

The location where the mark must be applied is shown in figure 1.

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
3A2323 (72-50-10)	36	--	Nut, double hex self locking	ST2325-10 (01-120)	(A)(B)(S1)
3A2328 (72-50-10)	ref	--	Nut, double hex self locking	ST2326-10 (01-120)	(A)(B)(S1)
3A2329 (72-50-10)	ref	--	Nut, double hex self locking	ST2327-10 (01-120)	(A)(B)(S1)
3A2330 (72-50-10)	ref	--	Nut, double hex self locking	ST2328-10 (01-120)	(A)(B)(S1)
3A2323 (72-50-10)	36	--	Nut, double hex self locking	ST2325-10 (01-170)	(A)(B)(S1)
3A2328 (72-50-10)	ref	--	Nut, double hex self locking	ST2326-10 (01-170)	(A)(B)(S1)
3A2329 (72-50-10)	ref	--	Nut, double hex self locking	ST2327-10 (01-170)	(A)(B)(S1)
3A2330 (72-50-10)	ref	--	Nut, double hex self locking	ST2328-10 (01-170)	(A)(B)(S1)
3A2323 (72-50-10)	36	--	Nut, double hex self locking	ST2325-10 (01-220)	(A)(B)(S1)
3A2328 (72-50-10)	ref	--	Nut, double hex self locking	ST2326-10 (01-220)	(A)(B)(S1)
3A2329 (72-50-10)	ref	--	Nut, double hex self locking	ST2327-10 (01-220)	(A)(B)(S1)
3A2330 (72-50-10)	ref	--	Nut, double hex self locking	ST2328-10 (01-220)	(A)(B)(S1)

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3A2323 (72-50-10)	36	--	Nut, double hex self locking	ST2325-10 (01-320)	(A)(B)(S1)
3A2328 (72-50-10)	ref	--	Nut, double hex self locking	ST2326-10 (01-320)	(A)(B)(S1)
3A2329 (72-50-10)	ref	--	Nut, double hex self locking	ST2327-10 (01-320)	(A)(B)(S1)
3A2330 (72-50-10)	ref	--	Nut, double hex self locking	ST2328-10 (01-320)	(A)(B)(S1)
3A2323 (72-50-10)	36	--	Nut, double hex self locking	ST2325-10 (01-370)	(A)(B)(S1)
3A2328 (72-50-10)	ref	--	Nut, double hex self locking	ST2326-10 (01-370)	(A)(B)(S1)
3A2329 (72-50-10)	ref	--	Nut, double hex self locking	ST2327-10 (01-370)	(A)(B)(S1)
3A2330 (72-50-10)	ref	--	Nut, double hex self locking	ST2328-10 (01-370)	(A)(B)(S1)

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C. Instruction/Disposition Code Statements:

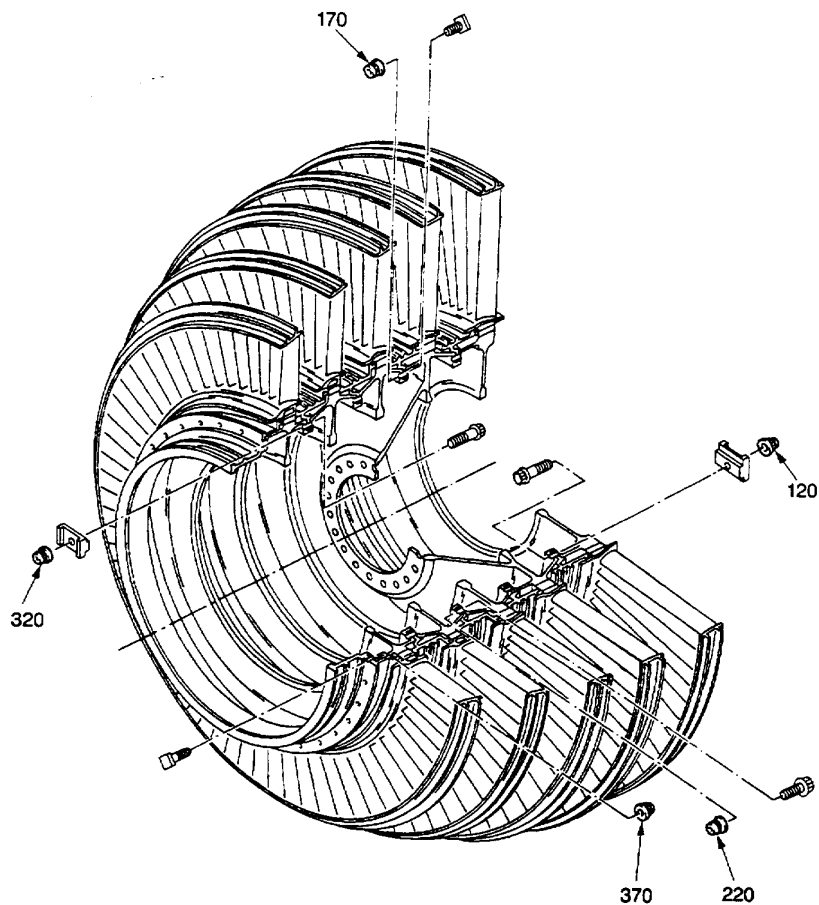
(A) Removed parts can be reworked according to Section 2 of this Service Bulletin.

(B) New part available for sale.

(S1) Old and new part are interchangeable.

NOTE: The estimated 1994 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.

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LPT rotor assembly
Fig.1

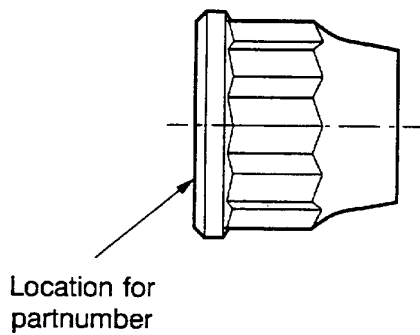
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Location of the partnumber
Fig.2

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