

SERVICE BULLETIN

ENGINE – HP TURBINE ROTOR AND STATOR ASSEMBLY – PROVIDE A NEW STAGE 2 TURBINE BLADE
(FOR VARIOUS MODEL PARTS COMMONALITY) – CATEGORY CODE 7 – MOD.ENG-72-0187

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320, A321
- (2) Engine: V2527-A5 Engines before Serial No.V10103
V2530-A5 Engines before Serial No.V10103

B. Reason

(1) Condition

The Stage 2 Turbine Rotor Blades now used on the V2500-A5 and V2500-D5 Engines are not the same.

(2) Background

A new part number Stage 2 Turbine Rotor Blade was made for the V2500-D5 Engine.

(3) Objective

Provide a common Stage 2 Turbine Rotor Blade part number for use in the V2500-A5 and V2500-D5 engines.

(4) Substantiation

Satisfactory endurance testing on the new parts.

(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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**C. Description**

- (1) Replace the Stage 2 Turbine Rotor Blade with one that is common with the V2500-D5 Engine.

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 7

Accomplish when supply of superseded parts has been depleted.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable
(2) At overhaul	Not applicable

G. Material – Price and Availability

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

H. Tooling – Price and Availability

Special tools are not required to accomplish Sub-division 2 of this Service Bulletin.

I. Weight and Balance

- | | | | | | |
|-----|---------------|----|----|----|-----------------------------------------------------------------|
| (1) | Weight change | .. | .. | .. | None |
| (2) | Moment arm | .. | .. | .. | No effect |
| (3) | Datum | .. | .. | .. | Engine front mount centerline
(Powerplant station P.P.S.100) |

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**SERVICE BULLETIN****J. Electrical Load Data**

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

K. Reference

- (1) Internal Reference No.

93VA037

- (2) Other References

V2500 Engine Illustrated Parts Catalog (S-V2500-2I-A), Chapter/Section 72-45-00, 72-45-30 and 72-45-32.

V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-30 and 72-45-00.

V2500 Standard Practices Manual (SPP-V2500-1IA) Chapter/Section 70-09-00.

L. Other Publications Affected

- (1) The V2500 Engine Illustrated Parts Catalog (S-V2500-2I-A), Chapter/Section 72-45-30, Figure 1, to add the new part.
- (2) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-30, Cleaning, to add the new parts.
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-30, Inspection, to add the new parts.
- (4) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-30, Repair, to add the new parts.

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2. Accomplishment Instructions

A. Rework Instructions

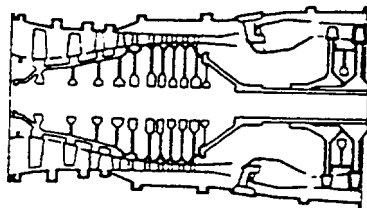
- (1) There are no rework instructions necessary to accomplish this Service Bulletin.

B. Assembly Instructions

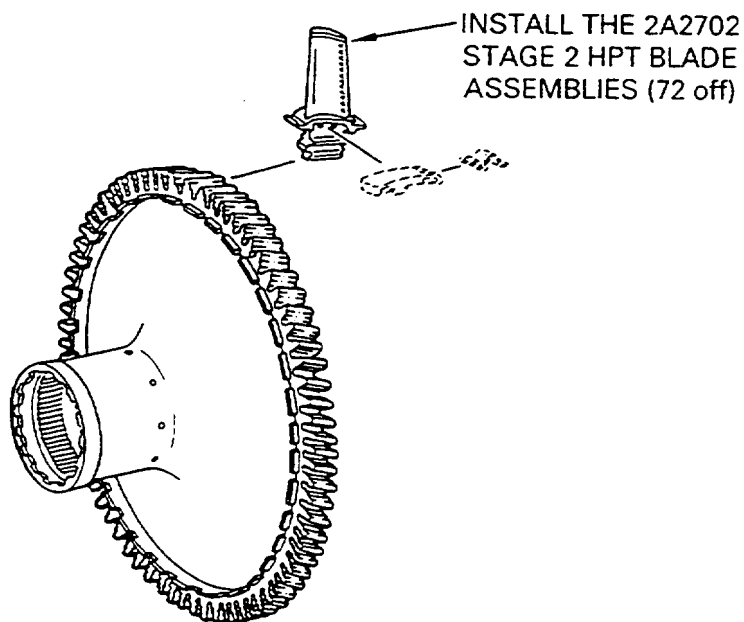
- (1) Install the 2A2702 Stage 2 HPT Blade Assemblies (72 off) by the approved procedure given in Reference (2), Chapter/Section 72-45-30, Assembly, and Figure 1.
- (2) Identify the Stage 2 Turbine Rotor Assembly by the procedure given in Reference (3), Chapter/Section 70-09-00, Marking of Parts.
 - (a) Mark the new part number, 2A2622, adjacent to the old part number, 2A2822.
 - (b) Use the vibration peen method.
- (3) When you install the Stage 2 Turbine Rotor Assembly by the procedure given in Reference (2), Chapter/Section 72-45-00 Assembly identify the HPT Rotor and Stator Assembly Module as follows:
 - (a) Use the procedure given in Reference (3), Chapter/Section 70-09-00, Marking of Parts.
 - (b) Mark the new part number, 2A7000, adjacent to the old part number, 2A4200.
 - (c) Use the vibration peen method.

C. Recording Instructions

- (1) A record of accomplishment is necessary.



MODULE 40



E2043

Location of the Stage 2 HPT Blade Assembly
Fig.1

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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
2A7000 (72-45-00)	1	-	..Rotor and Stator HPT Module	2A4200 (01-001)	(S1) (1D) (A)
2A2622 (72-45-30)	1	-	...Turbine Rotor, Stage 2, Assembly	2A2822 (01-010)	(S1) (2D) (A)
2A2702 (72-45-32)	72	3027.00Blade HPT, Stage 2 Assembly	2A2202 (01-010)	(S1) (B)

C. Instructions/Disposition Code Statements:

- (S1) Old Parts and new parts coded (S1) are freely and fully interchangeable.
- (1D) The new part number can be obtained by installation of the new Stage 2 Turbine Rotor Assembly and identification to the new HPT Rotor and Stator Module number.
- (2D) The new part number can be obtained by installation of the new Stage 2 HPT Blade Assemblies and identification to the new Stage 2 Turbine Rotor Assembly number.
- (A) New part is supplied on a lead time quotation basis only.
- (B) New part is currently available.

NOTE: The estimated 1996 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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