



ENGINE - LP COMPRESSOR - RELOCATE THE FAN BLADE POSITION MARKING INFORMATION ON THE  
BLADE RETAINER - CATEGORY CODE 6 - MOD.ENG-72-0198

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) Airbus A320  
(b) Airbus A321  
(c) McDonnell Douglas MD-90
- (2) Engine: (a) V2500-A1 Engines prior to Serial No. V0362.  
(b) V2527-A5 Engines prior to Serial No. V10096.  
(c) V2530-A5 Engines prior to Serial No. V10096.  
(d) V2525-D5 Engines prior to Serial No. V20011.  
(e) V2528-D5 Engines prior to Serial No. V20011.
- (3) Spare: (a) Front Blade Retaining Ring prior to Serial No. JIHA657.

B. Concurrent Requirements

None.

C. Reason

To introduce new identification mark on to the front blade retaining ring in order to enable to identify the fan blade positions without removal of the nose cone A/O.

D. Compliance

Category Code 6

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.

E. Approval

The marking instructions of a new fan blade position mark is described in Section H of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

F. References

- (1) Internal Reference No.

EC93VJ163

V2500-ENG-72-0198



(2) Other References

V2500 Standard Practices/Processes Manual.

G. Other Publications Affected

- (1) V2500-A1 and V2500-A5 Engine Maintenance Manual, Chapter/Section 71-00-00 Adjustment/Test-07 Config-2 will introduce the new procedures.

H. Action

For V2500 all engines

- (1) Make a blade identification mark "1" to "3" on to the existing front blade retaining ring as follows (Refer to Figure 1 and 2);

NOTE: Blade identification mark "1" shows the location of the No.1 fan blade position, "2" shows No.2 fan blade position and "3" shows No.3 fan blade position.

- (a) Identify the marking position on the front blade retaining ring.

NOTE: Make sure the shaded area which is close the timing marking on the front blade retaining ring, and the outside of timing mark shows the No."1" blade identification mark position. This timing mark is shown by mark "\*" (Refer to Figure 2).

NOTE: The timing mark also shows the top position of the fan rotor.

- (b) Make a blade identification mark on to the front blade retaining ring, and use the vibro-peen method by approved procedures in Reference (1), Chapter/Section 70-09-00, Marking of Parts.

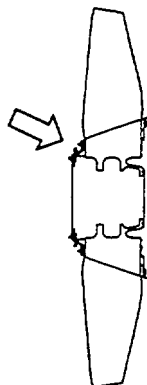
NOTE: Marking of blade identification mark can apply even the piece-parts have been assembled.

NOTE: If you have spare parts, you should identify the each serial number of the part (See Effectivity in paragraph A) and If the serial number of parts are prior to JIHA657, you should make a blade identification mark on to the parts by approved procedures in steps (1).

- (c) Remove the raised metal and burrs produced by above step (b).

I. Record of accomplishment is not necessary.

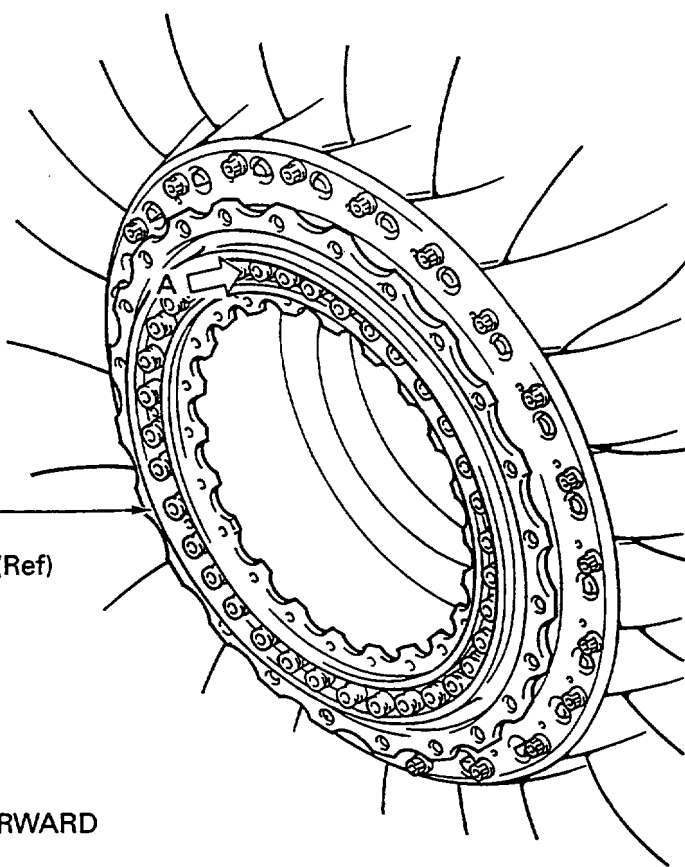
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MODULE 31

72-31-13, 01-200  
FRONT BLADE  
RETAINING RING (Ref)

FORWARD

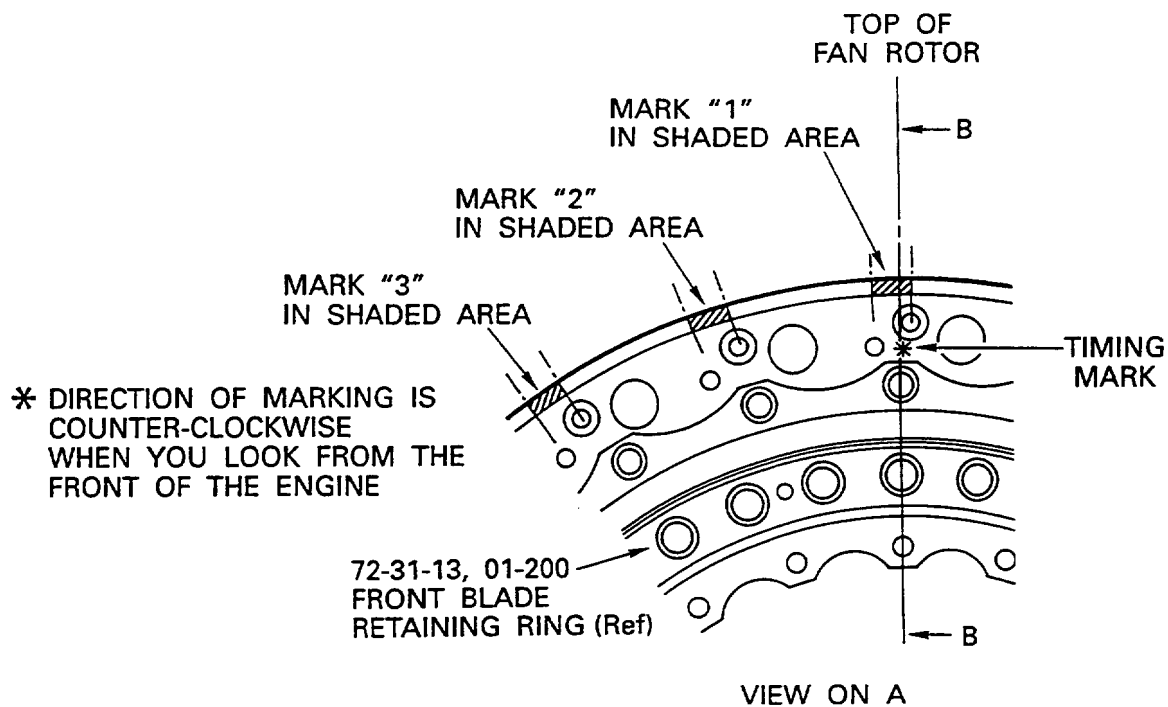


Location of the Front Blade Retaining Ring  
Fig.1

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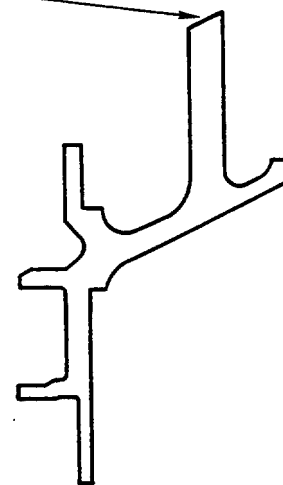


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MARK THE No. "1" TO "3" HERE  
BY VIBRO PEEN METHOD  
MARKING SIZE 0.158-0.197  
(4,00-5,00)  
MARKING DEPTH 0.008 MAX  
(0,20 MAX)

← FORWARD



SECTION B

Mark the Blade Identification on to the Front Blade Retaining Ring  
Fig.2

V2500-ENG-72-0198



**International Aero Engines**

**SERVICE BULLETIN**

Printed in Great Britain

**V2500-ENG-72-0198**

**Feb. 28/95**

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