



SERVICE BULLETIN

ENGINE - MAIN GEARBOX ASSEMBLY - PROVIDE NEW CARBON SEAL MATING RINGS FEATURING ANTIROTATION PROVISIONS - CATEGORY CODE 6 - MOD.ENG-72-0199

1. Planning Information

A. Effectivity

- (1) Aircraft: McDonnell Douglas MD-90
- (2) Engine: V2525-D5 engines prior to serial number V20009
V2528-D5 engines prior to serial number V20009

B. Reason

(1) Condition

A mating ring was found rotated in its seats at the disassembly of a development gearbox.

(2) Background

This condition was observed in development.

(3) Objective

To improve engine reliability.

(4) Substantiation

this modified mating ring is currently fitted on V2500 A1 and A5 service engines and proved to be reliable.

(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

V2500-ENG-72-0199

**C. Description**

The new carbon seal mating ring features and antirotation provision to prevent movement in its seat.

D. Approval

The part number changes and part modifications described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulation and are FAA-APPROVED for the Engine Model listed.

E. Compliance

Category Code 6

Accomplish when the subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected parts and to all affected spare parts.

F. Manpower

Estimated man-hours to incorporate the full intent of this Bulletin:

Venue	Estimated Man-hours
(1) In service	Not applicable
(2) At overhaul	Not affected

G. Material – Price and Availability

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

H. Tooling – Price and Availability

Special tools are not required to accomplish this Service Bulletin

I. Weight and Balance

- | | | | | |
|-------------------|----|----|----|---|
| (1) Weight change | .. | .. | .. | No significant |
| (2) Moment arm | .. | .. | .. | No effect |
| (3) Datum | | | | Engine front mount centerline
(Powerplant Station (P.P.S) 100) |

V2500–ENG–72–0199



J. Electrical Load Data

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

K. References

- (1) Internal Reference No.

EC93VF039

- (2) Other References

V2500 Aircraft Maintenance Manual, Chapter/Section 72-60-22, 72-60-23, 72-60-25, 72-60-28 Removal/Installation.

L. Other Publications Affected

- (1) The V2500 Illustrated Parts Catalog, Chapter/Section 72-60-22, 72-60-23, 72-60-25, 72-60-28 to add the new parts.
- (2) The V2500 Power Plant Illustrated Parts Catalog, Chapter/Section 72-60-22, 72-60-23, 72-60-25, 72-60-28 to add the new parts.



2. Accomplishment Instructions

A. Rework Instructions

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

B. Assembly instructions.

- (1) Install the new rotating rings. Refer to the approved procedure in Reference 1

C. Recording Instruction

- (1) A record of accomplishment is necessary



SERVICE BULLETIN

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
7T0301 (72-60-22)	1	192.00	.Ring, Interch. Control DWG	4T0257 (01-200)	(A)(B)(S1)
7T0453 (72-60-22)	Ref	-	.Ring, Mating	4T0257 (01-200)	(A)(B)(S1)
7T0473 (72-60-22)	Ref	-	.Ring, Mating	4T0257 (01-200)	(A)(B)(S1)
7T0301 (72-60-23)	1	192.00	.Ring, Interch. Control DWG	4T0257 (01-360)	(A)(B)(S1)
7T0453 (72-60-23)	Ref	-	.Ring, Mating	4T0257 (01-360)	(A)(B)(S1)
7T0473 (72-60-23)	Ref	-	.Ring, Mating	4T0257 (01-360)	(A)(B)(S1)
7T0301 (72-60-25)	1	192.00	.Ring, Interch. Control DWG	4T0257 (01-170)	(A)(B)(S1)
7T0453 (72-60-25)	Ref	-	.Ring, Mating	4T0257 (01-170)	(A)(B)(S1)
7T0473 (72-60-25)	Ref	-	.Ring, Mating	4T0257 (01-170)	(A)(B)(S1)
7T0301 (72-60-28)	1	192.00	.Ring, Interch. Control DWG	4T0257 (01-350)	(A)(B)(S1)
7T0453 (72-60-28)	Ref	-	.Ring, Mating	4T0257 (01-350)	(A)(B)(S1)
7T0473 (72-60-28)	Ref	-	.Ring, Mating	4T0257 (01-350)	(A)(B)(S1)

V2500-ENG-72-0199



C. Instructions/Disposition Code Statements:

- (A) New part is currently available for sale
- (B) Old part will be no longer available
- (S1) Old and new parts coded (S1) are directly 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