



ENGINE - SECURING FEATURES - HP COMPRESSOR CASES - REVISED BOLTS FOR FJ FLANGE BRACKETS
- CATEGORY CODE 6 - MOD.ENG-72-0215

1. Planning Information

A. Effectivity

- (1) Aircraft: (a) McDonnell Douglas MD-90
- (2) Engine: (a) V2525-D5 Engines prior to Serial No.V20009
(b) V2528-D5 Engines prior to Serial No.V20009

B. Concurrent Requirements

None.

C. Reason

(1) Condition

At different positions on flange FJ, bolts that attach brackets do not have a sufficient threaded part. These bolts do not obey the V2500 standard specification.

(2) Background

The problem was found during production engine build.

(3) Objective

The purpose of this Service Bulletin is to maintain engine production build procedures.

(4) Substantiation

The changes in this Service Bulletin have been the subject of a satisfactory engineering analysis. A satisfactory trial installation on a V2500 mock-up engine has also been done.

(5) Effect of Bulletin of 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.

D. Description

(1) The changes introduced by this Service Bulletin are as follows:

(a) The changes to the bolts at flange 'FJ' are as follows:

- (i) The length of the bolts at positions 2, 8, 9 and 37 is increased.
- (ii) The length of the bolts at positions 4, 26, 29, 51 and 52 is decreased.

E. Approval

The part number changes and/or part modification are given in Section 2 and 3 of this Service Bulletin. They obey the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model Listed.

F. Compliance

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This Service Bulletin can be done when the sub-assembly (That is, modules, accessories, components, build groups) is disassembled sufficiently to get access to the affected parts.

G. Manpower

Estimate of manhours to do this Service Bulletin in full:

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

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

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H. Material - Price and Availability

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

I. Tooling - Price and Availability

Special tools are not necessary.

J. Weight and Balance

- | | | | | | |
|-----|---------------|----|----|----|--|
| (1) | Weight change | .. | .. | .. | None |
| (2) | Moment arm | .. | .. | .. | No effect |
| (3) | Datum | .. | .. | .. | Engine front mount centreline (Power Plant Station - PPS 100) |

K. Electrical Load Data

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

L. References

- (1) Internal Reference No.

EC94VR013

M. Other Publications Affected

- (1) Illustrated Parts Catalog (IPC), Chapter/Section 72-41-00



2. Accomplishment Instructions

A. Rework Instructions

None

B. Assembly Instructions

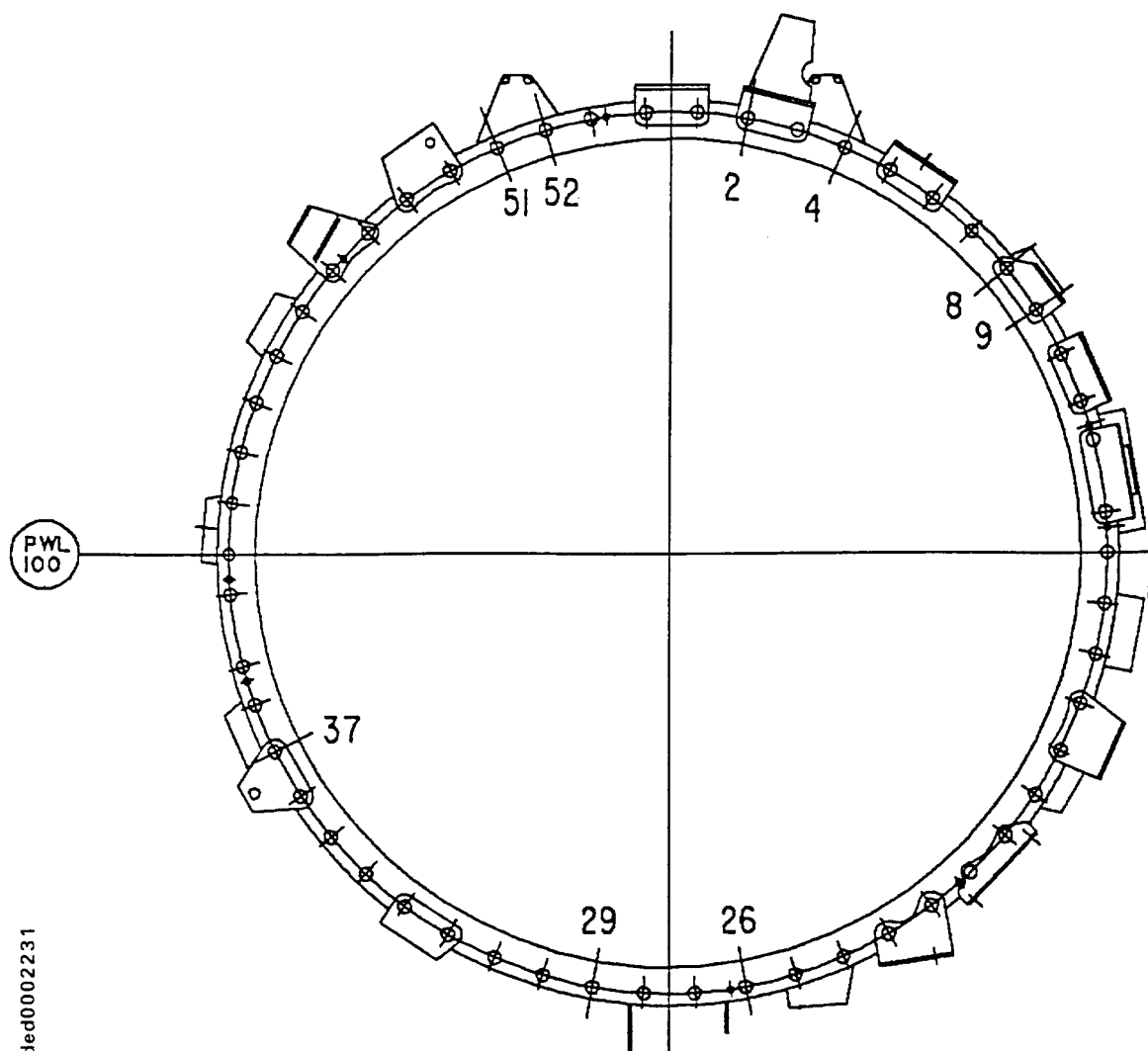
For the correct procedures to replace the affected bolts, refer to the Engine Manual (EM), Chapter/Section, 72-41-00, Assembly-02.

C. Recording Instructions

A record of accomplishment is necessary.



AT HOLE POSITIONS 4,26,29,51 AND 52 AS2III4 REPLACES AS2III7
AT HOLE POSITIONS 2,8,9 AND 37 AS2III7 REPLACES AS2III4



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View on flange 'FJ' Looking forwards
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 |
|------------------------------|-----|-----------------------------|--|------------------------------|-----------------------------|
| AS21114 (72-41-00) | 1 | 9.21 | Bolt, bihex hd (0.3125 dia x 0.875) | AS21114 (01.308) | (1D) |
| - (72-41-00) | 1 | | Bolt, bihex hd (0.3125 dia x 1.062) | AS21117 (01.314) | (2D) |

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For information about actual prices, refer to the IAE Price Catalog or contact IAE's Spare Parts Sales Department.

C. Instructions Disposition Codes:

(1D) Quantity increased from 45 to 46.

(2D) Quantity reduced from 9 to 8.

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