V2500 International Aero Engines
SERVICE BULLETIN

May 23/97

Subject: Transmittal of Revision 1 to Service Bulletin No. V2500-ENG-72-0252

Service Bulletin Revision History:

Event	Date
Basic Issue	Dec.13/96
Revision 1	May 23/97

Reason for Issuance of Revision:

To correct part numbers

Effect on Past Compliance:

None

List of Effective Pages:

Bulletin Page No.	Rev. No.	Effective Date
1	1	May 23/97
2 to 6	Basic issue	Dec.13/96
7 and 8	1	May 23/97

V2500 International Aero Engines

SERVICE BULLETIN

ENGINE - HP COMPRESSOR BLADES - INTRODUCTION OF STAGE 7 AND 8 ROTOR BLADES WITH ALUMINIUM TIP COATING REMOVED

MODEL APPLICATION

V2500-A1
V2522-A5
V2524-A5
V2527-A5
V2530-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

72-00-00

Compliance Category Code	Internal Reference No.
7	96VR006

ENGINE - HP COMPRESSOR BLADES - INTRODUCTION OF STAGE 7 AND 8 ROTOR BLADES WITH ALUMINIUM TIP COATING REMOVED

1. Planning Information

A. Effectivity

(1) Aircraft

(a) Airbus A319

(b) Airbus A320

(c) Airbus A321

(d) McDonnell Douglas MD-90

(2) Engines:

(a) V2500-A1 Engine prior to Serial No.V0362

(b) V2522-A5 Engine prior to Serial No.V10197

(c) V2524-A5 Engine prior to Serial No.V10197

(d) V2527-A5 Engine prior to Serial No.V10197

(e) V2530-A5 Engine prior to Serial No.V10197

(f) V2525-D5 Engine prior to Serial No.V20089

(g) V2528-D5 Engine prior to Serial No.V20089

B. Concurrent Requirements

This modification must only be fitted to engines which embody IAE V2500 Service Bulletin ENG-72-0235.

C. Reason

(1) Condition

The aluminium oxider coating on the tips of the current stage 7 and 8 High Pressure (HP) Compressor rotor blades was originally introduced as a precaution against the occurrence of Titanium fires.

Subsequent in service experience of HP Compressors in V2500 models and other Rolls-Royce engine projects has indicated that this coating is not required.

(2) Background

See (1)

(3) Objective

Incorporation of the changes introduced by this Service Bulletin are designed to optimise the manufacturing process.

(4) Substantiation

The changes introduced by this Service Bulletin have been the subject of successful rig testing and extensive in service experience of non coated Titanium blades on other Rolls-Royce engine projects.

(5) Effect of Bulletin on Workshops Procedures:

Removal/Installation
Disassembly/Assembly
Cleaning
Inspection/Check
Repair
Testing

(6) Supplemental Information

D. Description

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

(a) This Service Bulletin introduces revised stage 7 and 8 HP Compressor rotor blades similar to existing except the aluminium oxide tip coating has been removed.

E. Approval

The part number changed and/or part modification described in Section 2 and 3 of this modification Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model Listed.

F. Compliance

Category Code 7

Accomplish when supply of superseded parts have been depleted.

G. Manpower

Estimated manhours to incorporate the full intent of this bulletin:

	Venue	Estimated Manhours
(1)	In Service	Not applicable
(2)	At Overhaul	Not affected

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

H. Material - Price and Availability

(1) Modification kit is required.

(2) See "Material Information" section for prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not required

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 modification has no effect on the aircraft electrical load.

L. References

(1) The following IAE V2500 modification must be fitted prior to or concurrently with this modification.

72-0235 Engine - HP Compressor - Introduction of stage 6, 7 and 8 rotor path liners with revised abradable lining

(2) V2500 Engine Manual 72-41-00 Assembly/Disassembly.

M. Other Publications Affected

V2500 Engine Manual Chapter/Section 72-41-15 Cleaning, Inspection and Repair.

V2500 Illustrated Parts Catalogue Chapter/Section 72-41-15.

2. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

(1) The new Stages 7 and 8 compressor blades introduced by this Service Bulletin are fully and freely interchangeable with the existing.

(2) Assemble the new Stages 7 and 8 compressor blades by the use of approved procedures, Engine Manual 72-41-00, Assembly.

C. Recording Instructions

A record of accomplishment is necessary.

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
	A1 Model					
	6A6493 (72-41-15)	2	221.00	Blade stage 7 - locking LH, compressor	6A5588 (02-270)	(A)(B)(S1)
	6A6494 (72-41-15)	2	221.00	Blade stage 7 - locking RH, compressor	6A5589 (02-285)	(A)(B)(S1)
R	6A6492C01 (72-41-15)	62	186.00	Blade stage 7 - nominal, compressor	6A5584C01 (02-300)	(A)(B)(S1)
R R	6A6492C01 (72-41-15)	27	186.00	Blade stage 7 - nominal, compressor	6A5584C01 (02-315)	(A)(B)(S1)
R R	6A6492C02 (72-41-15)	27	186.00	Blade stage 7 - undersize, compressor	6A5584C02 (02-317)	(A)(B)(S1)
R	6A6496 (72-41-15)	2	221.00	Blade stage 8 - locking LH, compressor	6A5590 (02-370)	(A)(B)(S1)
	6A6497 (72-41-15)	2	221.00	Blade stage 8 - locking RH, compressor	6A5591 (02-385)	(A)(B)(S1)
R	6A6495C01 (72-41-15)	59	186.00	Blade stage 8 - nominal, compressor	6A5585C01 (02-400)	(A)(B)(S1)
R	6A6495C01 (72-41-15)	26	186.00	Blade stage 8 - nominal, compressor	6A5585C01 (02-415)	(A)(B)(S1)
R	6A6495C02 (72-41-15)	26	186.00	Blade stage 8 - undersize, compressor	6A5585C02 (02-417)	(A)(B)(S1)

	New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
	A5 and D5 Model					
	6A6462 (72-41-15)	2	253.00	Blade stage 7 - locking LH, compressor	6A4905 (02-270)	(A)(B)(S1)
	6A6463 (72-41-15)	2	253.00	Blade stage 7 - locking RH, compressor	6A4906 (02-285)	(A)(B)(S1)
R	6A6469C01 (72-41-15)	63	221.00	Blade stage 7 - nominal, compressor	6A4907C01 (02-300)	(A)(B)(S1)
R	6A6469C01 (72-41-15)	26	221.00	Blade stage 7 - nominal, compressor	6A4907C01 (02-315)	(A)(B)(S1)
R	6A649C02 (72-41-15)	26	221.00	Blade stage 7 - undersize, compressor	6A4907C02 (02-317)	(A)(B)(S1)
	6A6464 (72-41-15)	2	253.00	Blade stage 8 - locking LH, compressor	6A4908 (02-370)	(A)(B)(S1)
	6A6465 (72-41-15)	2	253.00	Blade stage 8 - locking RH, compressor	6A4909 (02-385)	(A)(B)(S1)
R	6A6470C01 (72-41-15)	56	221.00	Blade stage 8 - nominal, compressor	6A4910C01 (02-400)	(A)(B)(S1)
R	6A6470C01 (72-41-15)	24	221.00	Blade stage 8 - nominal, compressor	6A4910C01 (02-415)	(A)(B)(S1)
R	6A6470C02 (72-41-15)	24		Blade stage 8 - undersize, compressor	6A4910C02 (02-417)	(A)(B)(S1)

C. Instruction/Disposition Codes

(A) New part is currently available
(B) Old part will be discontinued
(S1) Old and new parts are freely and fully interchangeable.

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 IAEs Spare Parts Sales Department for information concerning firm prices.