

# 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

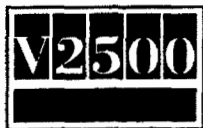
Effect on Past Compliance:

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-ENG-72-0252**  
Transmittal



# 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

7

Internal Reference No.

96VR006



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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.

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### 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.



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## 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:

<u>Venue</u>	<u>Estimated Manhours</u>
(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<br>(Power Plant Station (PPS) 100) |



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### 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.

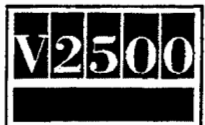
72-0235 Engine - HP Compressor - Introduction of stage 6, 7 and 8 rotor path liners with revised abradable lining

- (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.



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### 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.

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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
	<u>A1 Model</u>					
	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	6A6492C01 (72-41-15)	27	186.00	Blade stage 7 - nominal, compressor	6A5584C01 (02-315)	(A)(B)(S1)
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)



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New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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## 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.

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