International Aero Engines

SERVICE BULLETIN

Oct.14/99

Subject: Transmittal of Revision 2 to Service Bulletin V2500-ENG-72-0257.

Service Bulletin Revision History:

Event	Date
Basic Issue	Jan.31/97
Revision 1	June 6/97.
Revision 2	Oct.14/99.

Reason for Revision:

(1) To add referenced Instructions affected by this bulletin.

Effect on Past Compliance:

None.

List of Effective Pages:

Page No.	Revision No.	Effective Date
1	Revision 2	Oct.14/99.
2 to 5	Basic Issue	June 6/99
6 and 7	Revision 2	Oct.14/99

International Aero Engines
SERVICE BULLETIN

ENGINE - HP COMPRESSOR BLADES AND VANES - COMMONISATION OF PROCEDURE USED TO OBTAIN TIP CLEARANCES FOR NEW PRODUCTION AND OVERHAUL

MODEL APPLICATION

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

BULLETIN INDEX LOCATOR

72-41-00

Compliance Category Code

6

Internal Reference No.

96VR001

Jan.31/97
Revision 2 Oct.14/99

V2500-ENG-72-0257

ENGINE - HP COMPRESSOR BLADES AND VANES - COMMONISATION OF PROCEDURE USED TO OBTAIN TIP CLEARANCES FOR NEW PRODUCTION AND OVERHAUL

1. Planning Information

A. Effectivity

(1) Aircraft:

(a) Airbus A319
(b) Airbus A320
(c) Airbus A321
(d) McDonnell Douglas MD-90

(2) Engines:

(a) V2522-A5 Engines prior to Serial No.V10201
(b) V2524-A5 Engines prior to Serial No. V10201
(c) V2527-A5 Engines prior to Serial No V10201
(d) V2530-A5 Engines prior to Serial No. V10201
(e) V2525-D5 Engines prior to Serial No. V20088
(f) V2528-D5 Engines prior to Serial No. V20088

B. Concurrent Requirements

None.

C. Reason

(1) Condition

Unnecessary tip grinding of the HP compressor blades at overhaul can occur due to the different methods of achieving the stator to rotor tip clearances during new production build and overhaul.

(2) Background

See (1).

(3) Objective

Incorporation of the changes introduced by this Service Bulletin are designed to produce a common set of tip clearances limited for production and overhaul.

(4) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis.

(5) Effect of Bulletin on workshop procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Affected
Repair	Not affected
Testing	Not affected

(6) Supplemental Information

The change will result in an amendment to the Table of Limits.

D. Description

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

(a) A revised machining and measuring procedure to rationalise new build and overhaul tip clearances limits and establish a common practice for this process is introduced.

E. Approval

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

F. Compliance

Category code 6.

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

G. 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

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

H. Material - Price and Availability

(1) Modification Kit not required

(2) "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 Service Bulletin has no effect on the aircraft electrical load.

L. References

None.

M. Other Publications Affected

(1) V2500 Engine Manual, 72-41-10, Assembly.

2. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

(1) Refer to V2500 Engine Manual, 72-41-10, Assembly.

C. Recording Instructions

(1) A record of accomplishment is necessary.

3. Material Information

	NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE ($)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
R	6A6478 (72-41-00)	Ref		Case assy-m/c stg 7 to 12	6A6401 (99-150)	
R	- (72-41-13)	Ref		Measuring instruction - HPC rotor	6A4360 (99-350)	
R	(72-41-13)	Ref		Correlation assy-HPC	6A4358 (99-460)	
R	6A6481 (72-41-15)	Ref		Instruction, setting - rotor blades	6A4730 (99-301)	
R	6A6482 (72-41-15)	Ref		Instruction clearances - radial - HPC	6A4731 (99-302)	
R	- (72-41-15)	Ref		Correlation assy-HPC	6A4358 (99-460)	
R	6A6478 (72-41-21)	Ref		Case assy-m/c stg 7 to 12	6A6401 (99-150)	
R	6A6483 (72-41-21)	Ref		Instruction, machining-front case-HPC	6A4375 (99-151)	

Applicability : For each V2500 engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:-

None.

B. Parts affected by this Bulletin:-

None.

C. Reference Instructions affected by this Bulletin:

	NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE ($)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
R	6A6481 (72-41-21)	Ref		Instruction, setting-rotor blades	6A4730 (99-301)	
R	6A6482 (72-41-21)	Ref		Instruction clearances-radial - HPC	6A4731 (99-302)	
R	- (72-41-21)	Ref		Correlation assy-HPC	6A4358 (99-460)	
R	6A6478 (72-41-22)	Ref		Case assy-m/c stg 7 to 12	6A6401 (99-150)	
R	6A6483 (72-41-22)	Ref		Instruction, machining-front case - HPC	6A4375 (99-151)	
R	6A6482 (72-41-22)	Ref		Instruction clearances-radial - HPC	6A4731 (99-302)	
R	- (72-41-22)	Ref		Correlation assy - HPC	6A4358 (99-460)	
R	6A6482 (72-41-32)	Ref		Instruction clearances-radial-HPC	6A4731 (99-302)	