



ENGINE - ACTUATING MECHANISM HP COMPRESSOR VARIABLE VANES CENTRALISING PADS WITH
REVISED METHOD OF MANUFACTURE - CATEGORY CODE 7 - MOD.ENG-72-0277

Printed in Great Britain

1. Planning Information

A. Effectivity

- (1) Aircraft:
- (a) Airbus A319
 - (b) Airbus A320
 - (c) Airbus A321
 - (d) Boeing-Douglas
- (2) Engine:
- (a) V2500-A1 Engines prior to Serial No.V0362
 - (b) V2522-A5 Engines prior to Serial No. V10440, but not Serial No's V10478 to V10500 and V10456 to V10468.
 - (c) V2524-A5 Engines prior to Serial No. V10440, but not Serial No's V10478 to V10500 and V10456 to V10468.
 - (d) V2527-A5 Engines prior to Serial No. V10440, but not Serial No's. V10478 to V10500 and V10456 to V10468.
 - (e) V2527E-A5 Engines prior to Serial No. V10440, but not Serial No's V10478 to V10500 and V10456 to V10468.
 - (f) V2530-A5 Engines prior to Serial No. V10440, but not Serial No's V10478 to V10500 and V10456 to V10468.
 - (g) V2533-A5 Engines prior to Serial No. V10440, but not Serial No's V10478 to V10500 and V10456 to V10468.
 - (h) V2525-D5 Engines prior to Serial No. V20236, but not Serial No's V20242 to V20244 and V20255 to V20262.
 - (i) V2528-D5 Engines prior to Serial No. V20236, but not Serial No's V20242 to V20244 and V20255 to V20262.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

A design review has shown that the manufacture of the centralising pad assembly of the Stage 3 HP variable stator vane (VSV), can be better.

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(2) Evidence

(Refer to C. (1) Problem).

(3) Substantiation

A satisfactory engineering analysis has been done on the changes contained in this Service Bulletin.

(4) Objective

The purpose of this Service Bulletin is to make the process of manufacture easier.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

No affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The changes contained in this Service Bulletin are as follows:

(a) The centralising pad of the Stage 3 VSV has changed as follows:

(i) The method of manufacture has changed from a fabrication to a one piece extrusion.

(ii) The material has been changed from EAF to EBS.

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(iii) The overall height has been increased by 0,7302 mm.

(b) Because of the increase in height of the centralising pad, the maximum number of shims in a stack is increased from two to three.

E. Compliance

Category Code 7.

This Service Bulletin can be done when there are no initial parts remaining.

F. 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.

G. Manpower

Estimate of man-hours necessary to embody this Service Bulletin in full:

Venue	Estimated Man-hours
(1) In Service	Not applicable
(2) At Overhaul	No additional time is necessary to embody this Service Bulletin

NOTE: It is possible to get access to the parts affected by this Service Bulletin at overhaul.

H. Material – Price and Availability

- (1) A modification kit is not necessary
- (2) Refer to 3. Material Information for the prices and availability of future spares.

I. Tooling – Price and Availability

Special tools are not necessary.

J. Weight and Balance

- (1) Weight change
 - Not affected
- (2) Moment arm

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Not affected

(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.

EC96VR024

M. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC), Chapter/Section 72-41-34.

(2) A1, A5 and D5 Engine Manual (EM), Chapter/Section 72-41-30,
Removal/Installation.



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2. Material Information

A. Kits necessary for this Service Bulletin:

None.

B. Parts affected by this Service Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
6A2630C01 (72-41-34)	1	5.45	Washer, adjusting (0.005in. (0,127 mm.))	6A2630C01 (03-654)	(A)(1D)
6A2630C02 (72-41-34)	1	5.45	Washer, adj (0.007in. (0.178 mm.))	6A2630C02 (03-655)	(A)(1D)
6A2630C03 (72-41-34)	1	5.45	Washer, adj (0.008in. (0,203 mm.))	6A2630C03 (03-656)	(A)(1D)
6A2630C04 (72-41-34)	1	5.45	Washer, adj (0.010in. (0,254 mm.))	6A2630C04 (03-657)	(A)(1D)
6A2630C05 (72-41-34)	1	5.45	Washer, adj (0.014in. (0.356 mm.))	6A2630C05 (03-658)	(A)(1D)
6A2630C06 (72-41-34)	1	5.45	Washer, adj (0.018in. (0,450 mm.))	6A2630C06 (03-659)	(A)(1D)
6A2630C07 (72-41-34)	1	5.45	Washer, adj (0.022in. (0,550 mm.))	6A2630C07 (03-660)	(A)(1D)
6A2630C08 (72-41-34)	1	5.45	Washer, adj (0.026in. (0,650 mm.))	6A2630C08 (03-661)	(A)(1D)
6A2630C09 (72-41-34)	1	5.45	Washer, adj (0.030in. (0,750 mm.))	6A2630C09 (03-662)	(A)(1D)
6A2630C10 (72-41-34)	1	5.45	Washer, adj (0.031in. (0,775 mm.))	6A2630C10 (03-663)	(A)(1D)
6A2630C11 (72-41-34)	1	5.45	Washer, adj (0.032in. (0,800 mm.))	6A2630C11 (03-664)	(A)(1D)
6A2630C12 (72-41-34)	1	5.45	Washer, adj (0.033in. (0,825 mm.))	6A2630C12 (03-665)	(A)(1D)

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6A2630C13 (72-41-34)	1	5.45	Washer, adj (0.034in. (0,850 mm.))	6A2630C13 (03-666)	(A)(1D)
6A6514 (72-41-34)	4	1,360.00	Pad A/O, centralising - St.3	6A3957 (01-680)	(B)(C)(S1)

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For actual prices, refer to IAE Price Catalog or contact IAE's spare parts sales department.

C. Instructions Disposition Codes:

- (A) Select as necessary
- (B) New part is available.
- (C) Old part will be discontinued
- (S1) Old and new parts are freely and fully interchangeable.
- (1D) Quantity changed from As Required (2 off maximum), to 3 off maximum.
NOTE: Old and new part numbers are the same.

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3. Accomplishment Instructions

A. Rework Instructions

None

B. Assembly Instructions

(1) Remove and discard the centralising pads 6A3957 and install the new centralising pads 6A6514.

(a) For the correct Removal/Installation procedures, refer to the applicable Engine Manual (EM), Chapter/Section 72-41-30.

C. Recording Instructions

A record of accomplishment is necessary.

