



ENGINE - LP COMPRESSOR - INTRODUCE A REWORK PROCEDURE ON THE FAN FRAME ASSEMBLY -  
CATEGORY CODE 8 - MOD.ENG-72-0286

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1. Planning Information

A. Effectivity

- (1) Aircraft: (a) Airbus A320
- (2) Engine: (a) V2500-A1 Engines prior to serial number V0305.

B. Concurrent Requirements

None

C. Reason

(1) Condition

The existing IAE service bulletin No. V2500-ENG-72-0150 does not have rework procedure of the fan frame assembly. The rework is required to change secured method of mount tube stopper from rivet type to bolt type on the fan frame assembly.

(2) Background

The existing mounting tube stopper has shown damage at some locations. The operators wish to accomplish the partial application of the IAE service bulletin No. V2500-ENG-72-0150, although the operators can not accomplish the above bulletin completely.

(3) Objective

To introduce rework procedure of the fan frame assembly for the strength improvement of mount tube stopper.

(4) Substantiation

Analytically substantiated.

(5) Effects of Bulletin on Workshop Procedures:

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Removal/Installation	Not affected
Disassembly/Assembly	Affected (See Supplemental Information)
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

## (6) Supplemental Information

- (a) The Disassembly/Assembly of the post-service bulletin configuration requires instructions for mount tube stopper.

D. Description

- (1) The new mount tube stopper which is secured by the bolts and nuts are introduced (See Figure 2).

These parts are exactly same as the parts introduced by IAE Service Bulletin No. V2500-ENG-72-0150.

- (2) Rework procedure of fan frame is introduced to enlarge the current two rivet holes to bolt holes (See Figure 1).

- (3) For relationship with other Service Bulletins, See Figure 3 "Family Tree Chart".

E. Approval

The part number changes and part modifications described in sections 2 and 3 of this Service 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 8

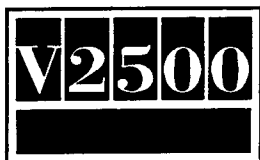
Accomplish based upon experience with the prior configuration.

G. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In service .....	Not applicable
(2) Rework of Fan Frame Assembly	

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- |     |  |            |
|-----|--|------------|
| (a) | To replace mount tube stopper .....              | 45 minutes |
| (b) | Crack Test .....                                 | 20 minutes |
| (c) | Vibro etch new part number<br>on fan frame ..... | 03 minutes |

Total 1 hour 08 minutes

## H. Material - Price and Availability

- (1) Modification kit is not required.
- (2) See "Material Information" section for prices and availability of future spares.

## I. Tooling - Price and availability

Special tools are not required to accomplish of this Bulletin.

## 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) |

## K. Electrical Load Data

This SB has no effect on the aircraft electrical load.

## L. References

- (1) Internal Reference No.  
EC97VJ016
- (2) Other References  
V2500 Engine Illustrated Parts Catalog  
V2500 Engine Manual  
V2500 Standard Practices/Processes Manual  
IAE Service Bulletin No. V2500-ENG-70-0002  
IAE Service Bulletin No. V2500-ENG-72-0009  
IAE Service Bulletin No. V2500-ENG-72-0077

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IAE Service Bulletin No. V2500-ENG-72-0051

IAE Service Bulletin No. V2500-ENG-72-0160

IAE Service Bulletin No. V2500-ENG-72-0132

IAE Service Bulletin No. V2500-ENG-72-0150

IAE Service Bulletin No. V2500-ENG-70-0266

IAE Service Bulletin No. V2500-ENG-72-0211

**M. Other publications affected**

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-03
- (2) V2500 Engine Manual, Chapter/Section 72-32-00, Disassembly-02 and Assembly-14, CONFIG-1

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2. Accomplishment Instructions

## A. Rework Instructions

- (1) Rework and reidentify the following Fan Frame Assembly (Ref. 72-32-03, Fig/Item No. 03-100);

(a) Old Part No. (Before rework)	New Part No. (After rework)
5A6592	5A1763
5A0256	5A1764
5A6596	5A1765
5A0349	5A1766
5A0856	5A1767
5A1047	5A1768
5A0362	5A1769
5A0364	5A1770
5A0363	5A1771
5A0366	5A1772
5A0365	5A1773
5A0407	5A1774
5A0401	5A1775
5A0405	5A1776
5A0403	5A1777
5A0409	5A1778
5A1167	5A1779
5A1049	5A1780
5A1064	5A1781
5A1062	5A1782
5A1068	5A1783
5A1066	5A1784

WARNING: YOU HAVE TO MAKE SURE THE STANDARD PRACTICES/PROCESSES MANUAL (SPM) TASK 70-03-00-100-501, SPECIAL HANDLING OF MATERIALS AND SOLUTIONS-01 BEFORE YOU DO STEP (h) BECAUSE THE PART MATERIAL IS TITANIUM ALLOY.

## Procedure

## Supplementary Information

- (b) Remove the existing rivets  
from the fan frame assembly
- (c) Remove the mount tube stopper
- (d) Make sure the drilling position  
on the fan frame assembly
- Refer to Figure 1

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- |   |  |
|---|--|
| (e) Make the diameter of the rivet hole larger at two positions (Outside of existing rivet holes)   | Refer to Figure 1,<br>Use a 0.220 to 0.232 in.<br>(5,60 to 5,90 mm.) drill |
| (f) Examine   | Make sure holes are correctly drilled                                      |
| (g) Remove all sharp edges from the new holes and make a smooth surface   | Use standard workshop equipment  |
| (h) Clean the affected areas  | Refer to SPM TASK 70-11-26-300-503   |
| (i) Do a crack test the affected areas  | Refer to SPM TASK 70-23-05, penetrant inspection                           |
| (j) Make a mark of the new part No. on the fan frame assembly adjacent to the old part No., make two lines (====) on the old part No. to erase it | Use the Vibro-Peen method, Refer to Figure 1 and A.(1), (a)                |

## B. Assembly Instructions

- (1) Install the 5A0426, mount tube stopper to the fan frame assembly with the two 4W2326, screws and 4W0001, nuts. Refer to Figure 2.

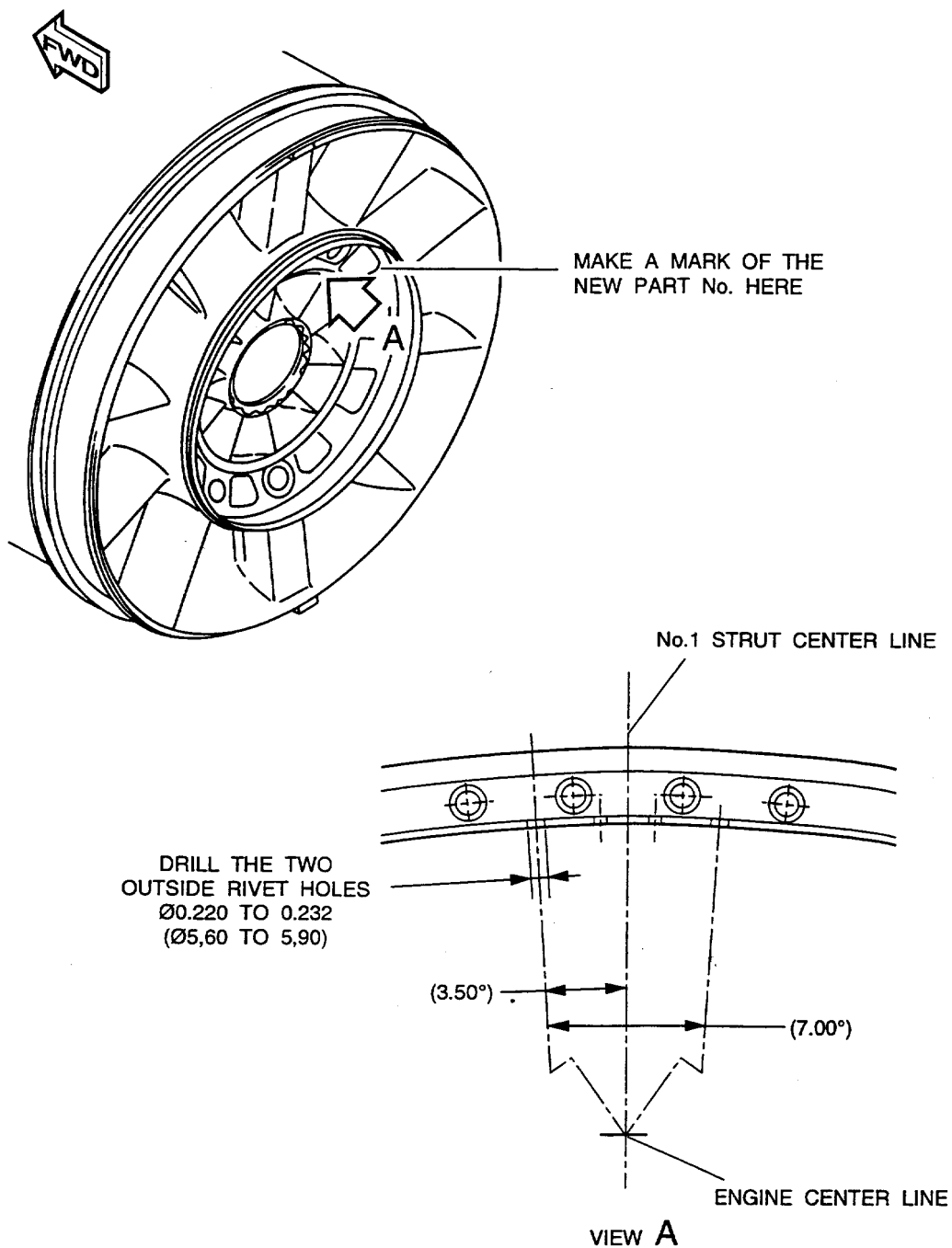
## C. Record Instructions

A record of accomplishment is required.

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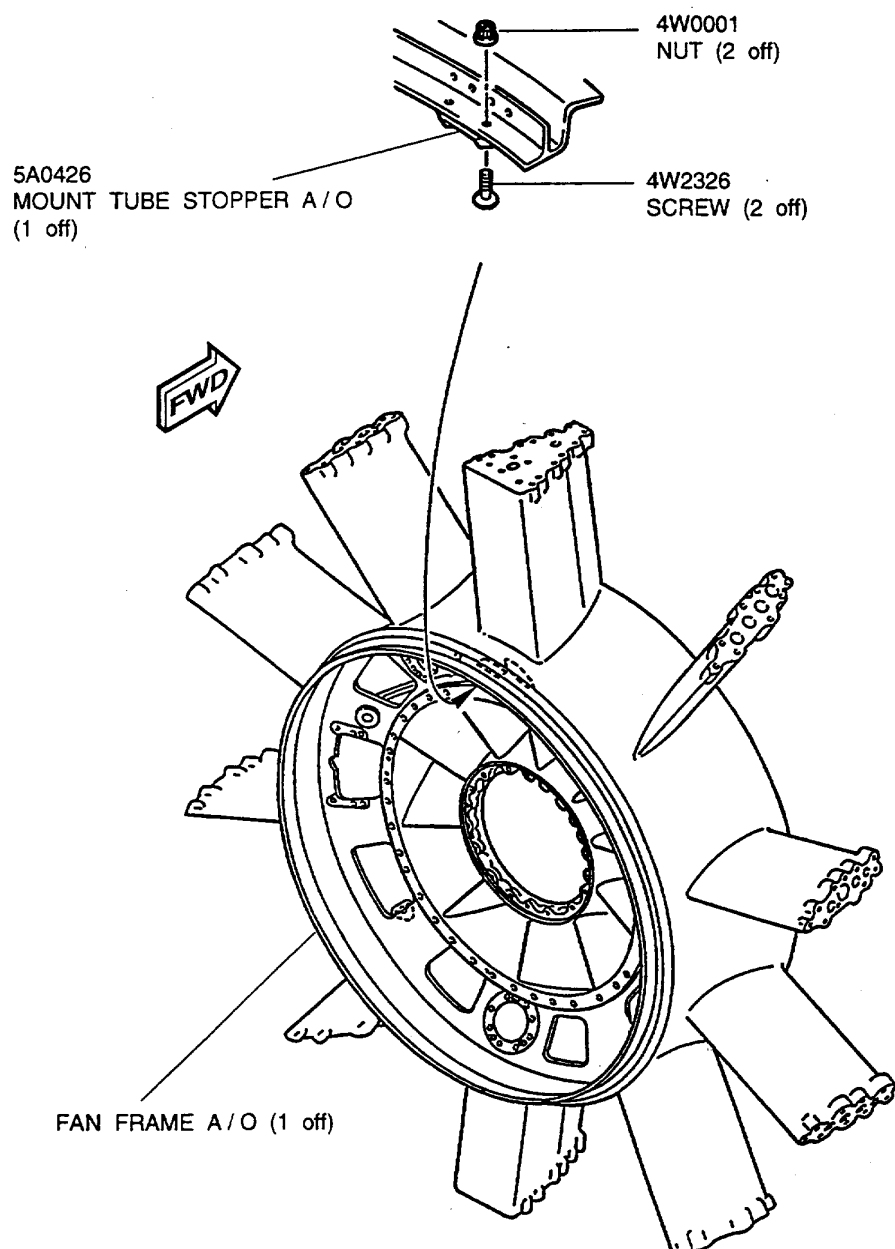
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Rework of the Fan Frame Assembly  
Fig.1

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Install the mount tube stopper on the fan frame assembly  
Fig.2

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3. Material Information

Applicability: For each V2500-A1 Engines to incorporate this Bulletin.

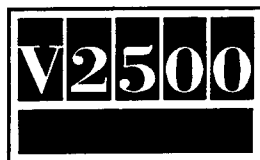
A. Kits associated with this Bulletin:

None.

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instruction/ Disposition
5A1763 (72-32-03)	1		.Frame, A/O Fan	5A6592 (03-100)	(A) (S1)(1D)
5A1764 (72-32-03)	1		.Frame, A/O Fan	5A0256 (03-100)	(A) (S1)(1D)
5A1765 (72-32-03)	1		.Frame, A/O Fan	5A6596 (03-100)	(A) (S1)(1D)
5A1766 (72-32-03)	1		.Frame, A/O Fan	5A0349 (03-100)	(A) (S1)(1D)
5A1767 (72-32-03)	1		.Frame, A/O Fan	5A0856 (03-100)	(A) (S1)(1D)
5A1768 (72-32-03)	1		.Frame, A/O Fan	5A1047 (03-100)	(A) (S1)(1D)
5A1769 (72-32-03)	1		.Frame, A/O Fan	5A0362 (03-100)	(A) (S1)(1D)
5A1770 (72-32-03)	1		.Frame, A/O Fan	5A0364 (03-100)	(A) (S1)(1D)
5A1771 (72-32-03)	1		.Frame, A/O Fan	5A0363 (03-100)	(A) (S1)(1D)
5A1772 (72-32-03)	1		.Frame, A/O Fan	5A0366 (03-100)	(A) (S1)(1D)
5A1773 (72-32-03)	1		.Frame, A/O Fan	5A0365 (03-100)	(A) (S1)(1D)
5A1774 (72-32-03)	1		.Frame, A/O Fan	5A0407 (03-100)	(A) (S1)(1D)

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5A1775 (72-32-03)	1	.Frame, A/O Fan	5A0401 (03-100)	(A) (S1)(1D)
5A1776 (72-32-03)	1	.Frame, A/O Fan	5A0405 (03-100)	(A) (S1)(1D)
5A1777 (72-32-03)	1	.Frame, A/O Fan	5A0403 (03-100)	(A) (S1)(1D)
5A1778 (72-32-03)	1	.Frame, A/O Fan	5A0409 (03-100)	(A) (S1)(1D)
5A1779 (72-32-03)	1	.Frame, A/O Fan	5A1167 (03-100)	(A) (S1)(1D)
5A1780 (72-32-03)	1	.Frame, A/O Fan	5A1049 (03-100)	(A) (S1)(1D)
5A1781 (72-32-03)	1	.Frame, A/O Fan	5A1064 (03-100)	(A) (S1)(1D)
5A1782 (72-32-03)	1	.Frame, A/O Fan	5A1062 (03-100)	(A) (S1)(1D)
5A1783 (72-32-03)	1	.Frame, A/O Fan	5A1068 (03-100)	(A) (S1)(1D)
5A1784 (72-32-03)	1	.Frame, A/O Fan	5A1066 (03-100)	(A) (S1)(1D)
----- (72-32-03)	1	...Stopper, Rubber Mount	5A1300 (03-175)	(B)
----- (72-32-03)	1	...Rivet, Solid CSK Head	AS16447 (03-179)	(B)
5A0426 (72-32-03)	1	.Stopper, A/O Mount Tube	----- (02-450)	(C) (S1)(2D)
4W0001 (72-32-03)	1	.Nut, Option	----- (02-451)	(C) (S1)(2D)
4W2326 (72-32-03)	1	.Screw, Option	----- (02-454)	(C) (S1)(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.

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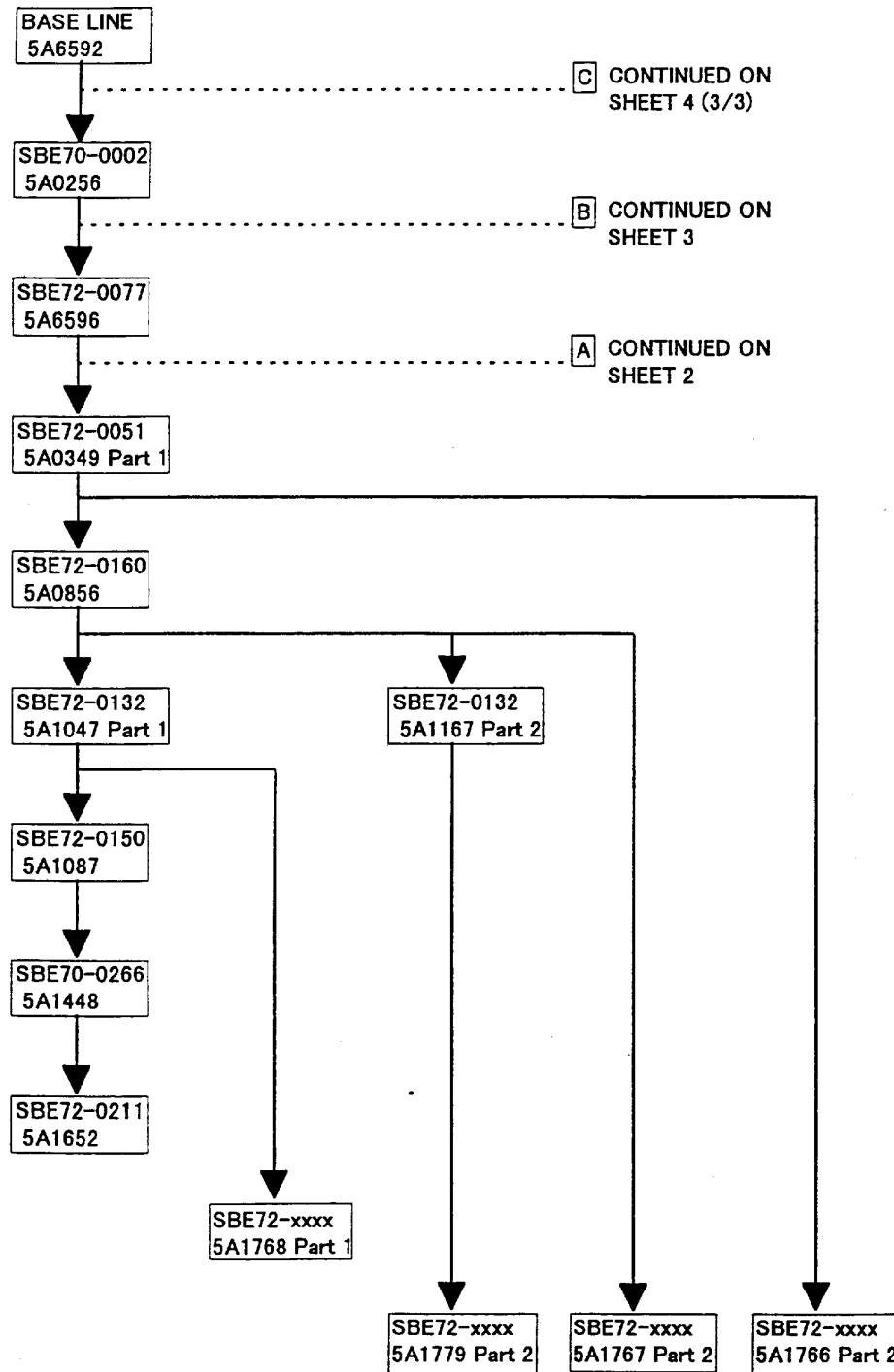


**C. Instruction/Disposition Code Statements:**

- (A) New part and old part are non-provisioning items.
- (B) Repair parts for Fan Frame Assembly (72-32-03, 03-100).
- (C) New part is currently available.
- (S1) New part coded (S1) must replace old part coded (S1) as a COMPLETE SET per engine.
- (1D) Old part can be reworked and reidentify to a new configuration.
- (2D) Additional part, same as IAE Service Bulletin No.V2500-ENG-72-0150.

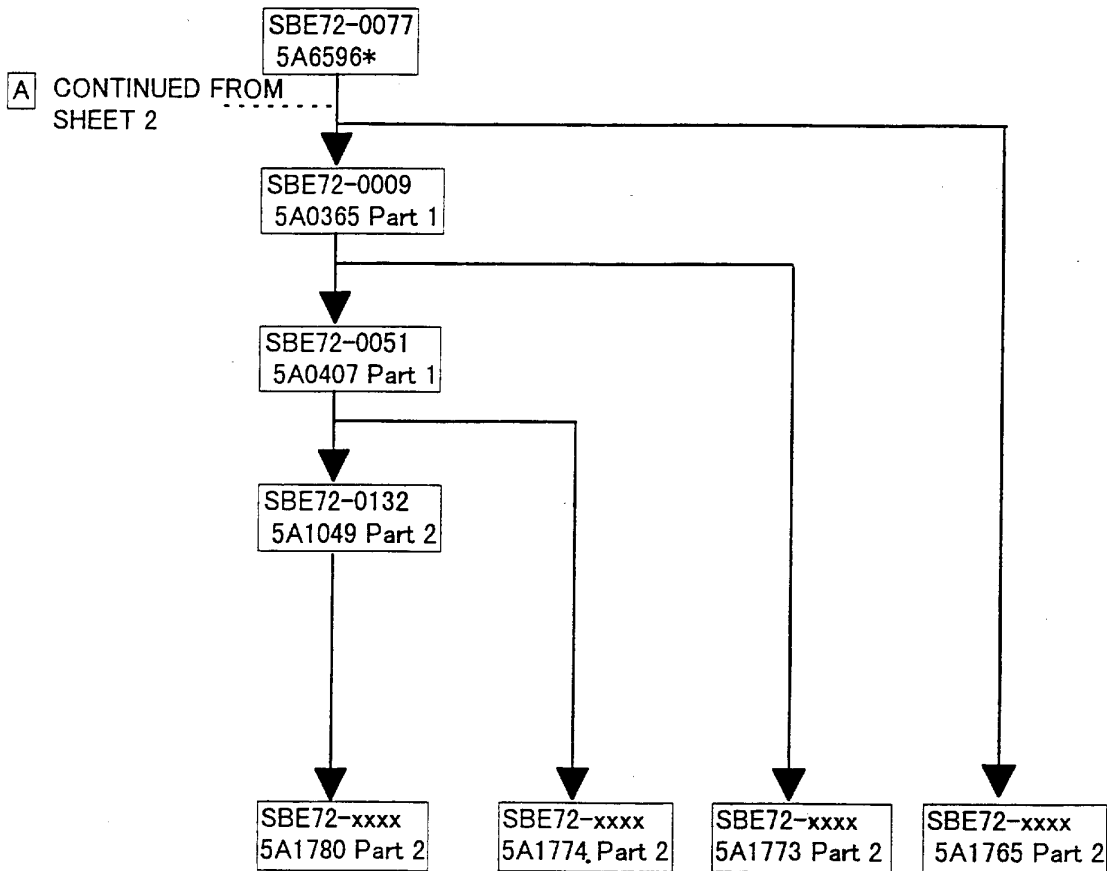


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Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 1 of 6)

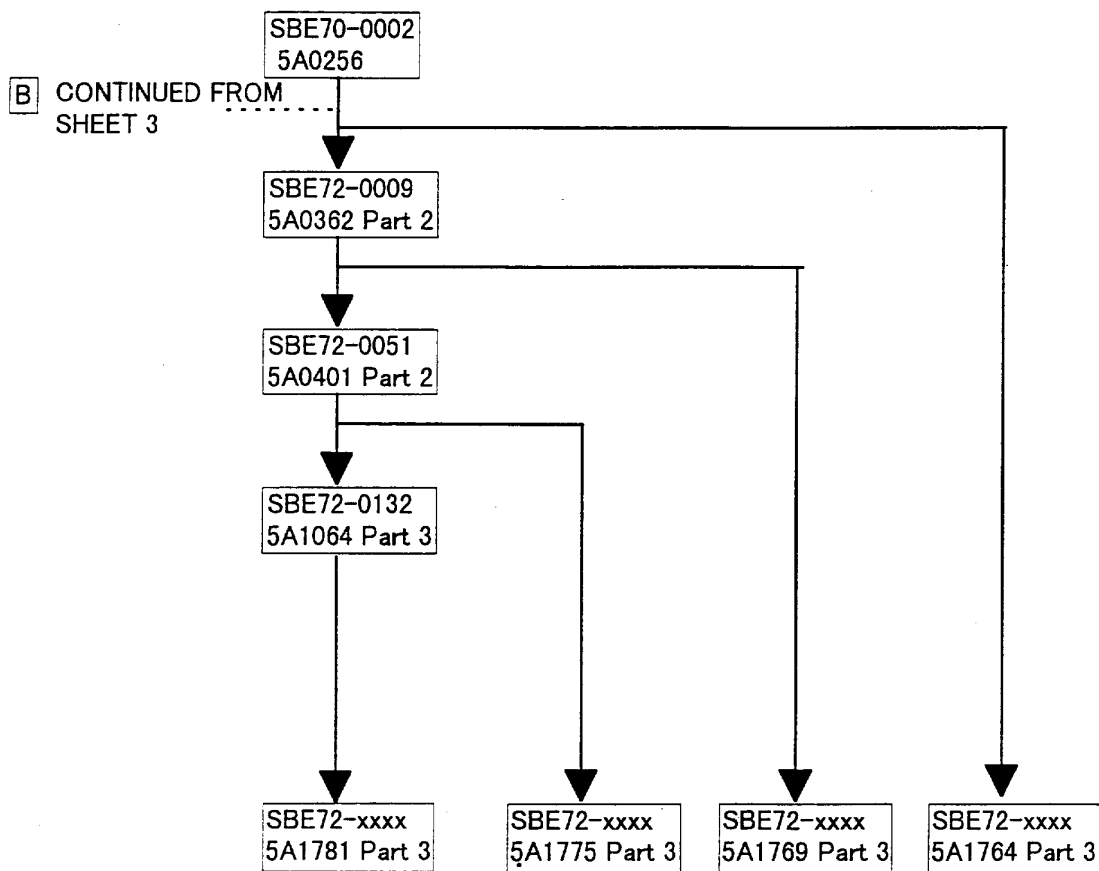
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Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 2 of 6)

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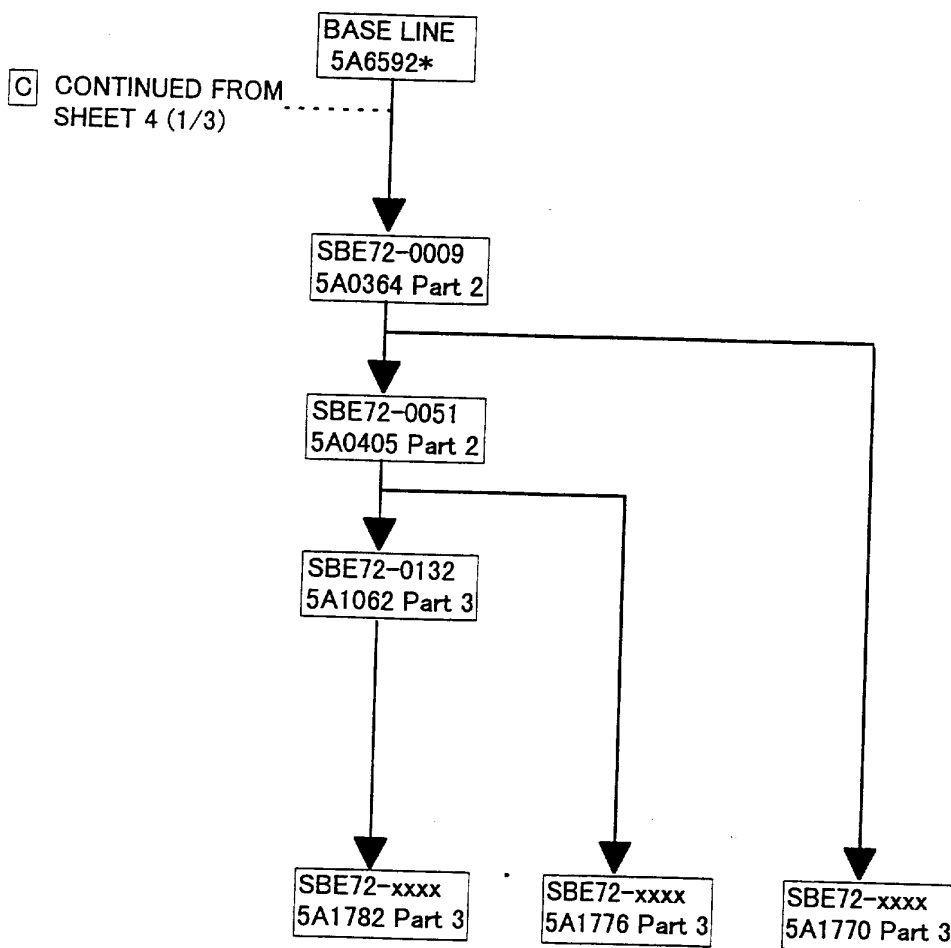
Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 3 of 6)

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Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 4 of 6)

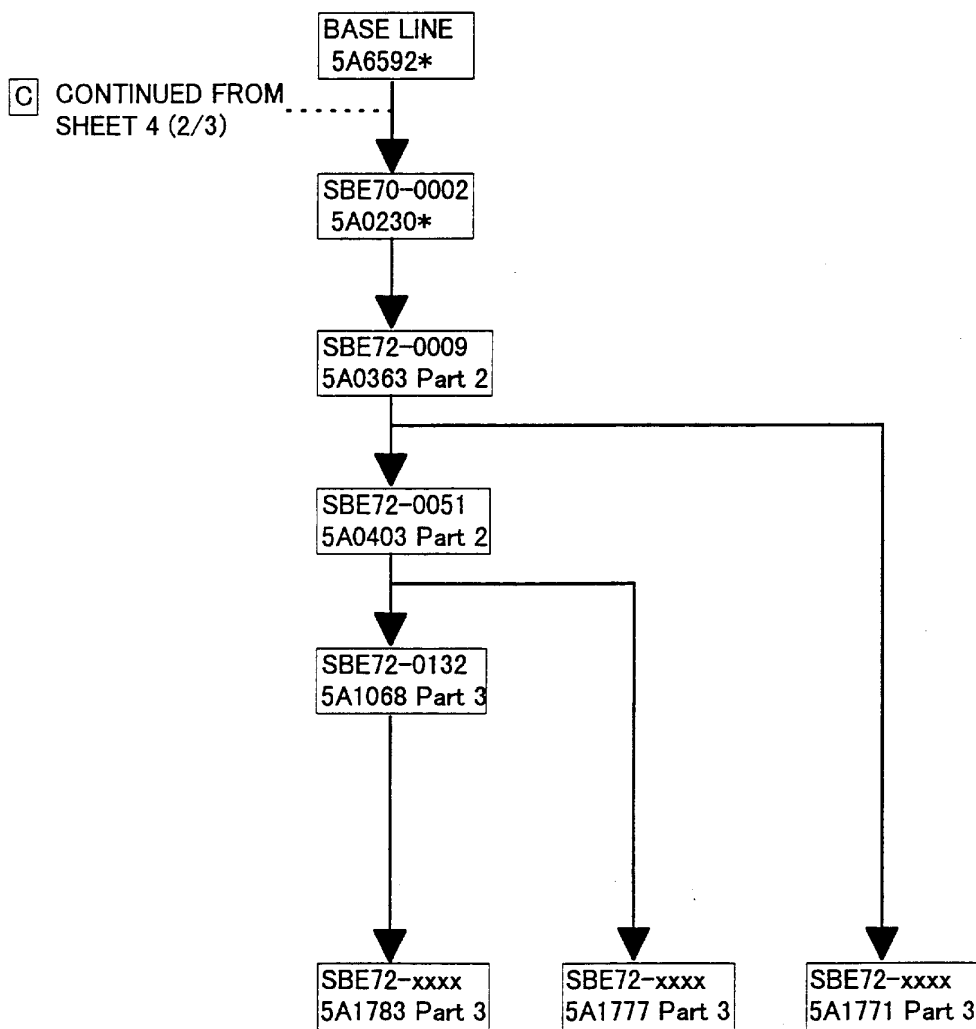
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Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 5 of 6)

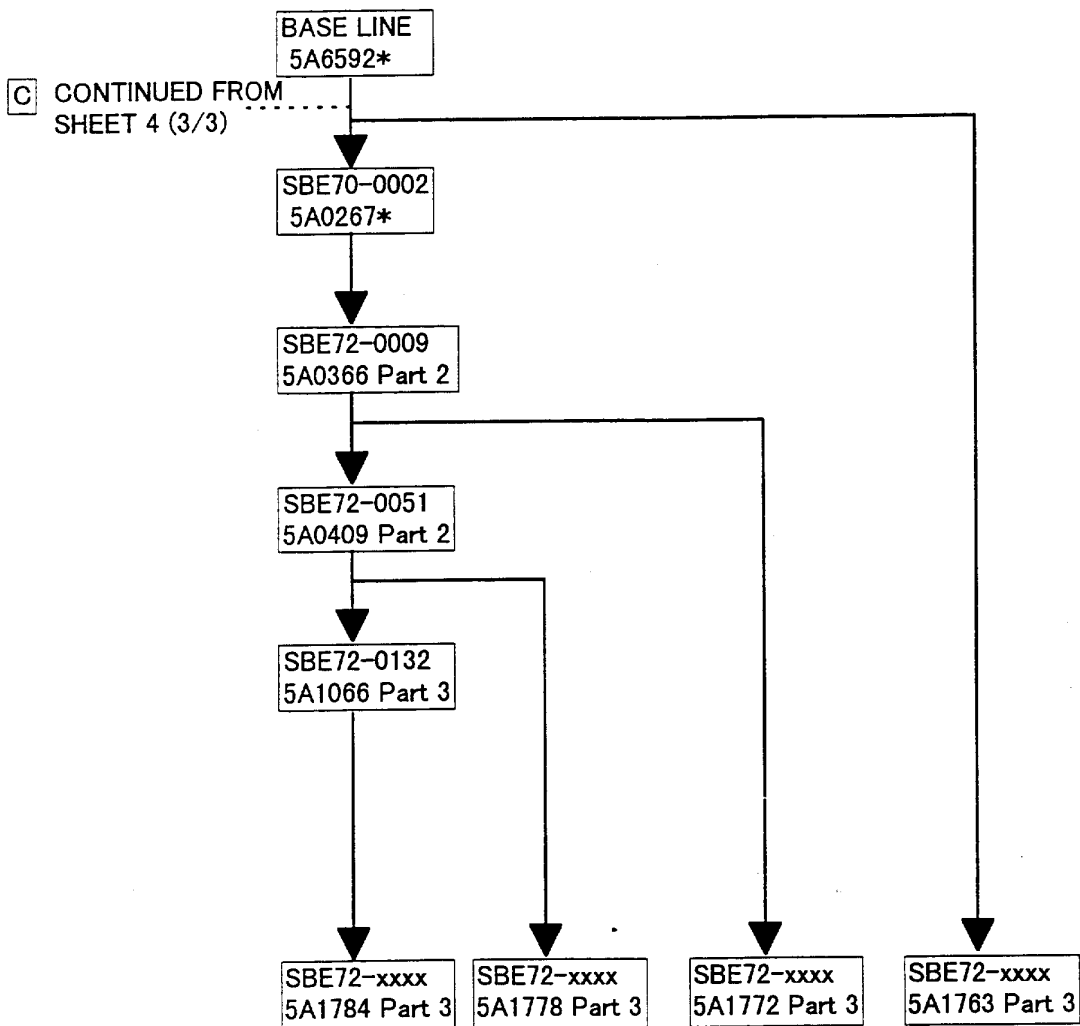
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Family Tree - Fan Frame Assembly Ref. Catalog Sequence No. 72-32-03, Fig.03, Item 100  
Fig.3 (Sheet 6 of 6)

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International Aero Engines

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