



Date: May 13/98

Subject: Transmittal of Revision 1 To Service Bulletin Number
V25000-ENG-72-0291.

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Jan 25, 1998
Revision 1	May 13, 1998

Reason For Issuance Of Revision:

(1) Update Engine Serial Numbers and revise Disposition to show "S1".

Effect on Prior Compliance:

List of Effective Pages:

<u>Bulletin Page No.</u>	<u>Rev. No.</u>	<u>Effective Date</u>
1 and 2	1	May 13/98
3 to 6	Basic	Jan. 25/98
7	1	May 13/98
8	Basic	Jan. 25/98

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Transmittal

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ENGINE - STAGE 1 HIGH PRESSURE TURBINE VANE CLUSTER ASSEMBLY - PROVIDE A NEW
FULLY CAST STAGE 1 HIGH PRESSURE TURBINE VANE ASSEMBLY

MODEL APPLICATION

V2522-A5
V2524-A5
V2527-A5
V2527E-A5
V2530-A5
V2533-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

72-40-00

Compliance Category Code

8

Internal Reference No.

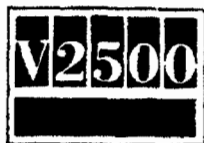
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1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320, A321
McDonnell Douglas MD-90
- (2) Engine: V2522-A5 Engines Before Serial No. V10337
V2527-A5 Engines Before Serial No. V10337
V2527E-A5 Engines Before Serial No. V10337
V2530-A5 Engines Before Serial No. V10337
V2524-A5 Engines Before Serial No. V10337
V2533-A5 Engines Before Serial No. V10337
V2525-D5 Engines Serial No. V20202
V2528-D5 Engines Serial No. V20202

B. Reason

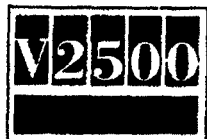
- (1) Condition: Not applicable.
- (2) Background: Not applicable
- (3) Objective: This Service Bulletin provides new cast Stage 1 High Pressure Turbine Vanes. The features to be fully cast are all shroud surfaces, including bolt hole, forward OD locating tab, with the exception of one of the platform mate-face surfaces, which will be conventionally machined. Dimensionally the new parts are the same as the old parts. The material is cast to the same specifications. The finished assembly has the same detail baffles, coatings and cooling hole patterns.
- (4) Substantiation
Not applicable.
- (5) Effects of Bulletin on Workshop Procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected
- (6) Supplemental Information
None.

C. Description

- (1) Replace the 2A2761 Stage 1 High Pressure Turbine Vane Assembly with the 2A4201 Stage 1 High Pressure Turbine Vane Assembly.

D. Approval



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D. Approval

The Part Number Changes and/or part modifications described in Section 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.

The 'compliance' statement and the procedures described in paragraph F of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-Approved for the Engine Model listed.

E. Compliance

Category 8

Accomplish based upon experience with the prior configuration.

F. 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 Applicable

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

G. Material - Price and Availability

- (1) Modification kit is not required. Parts are supplied as single line items.
- (2) See "Material Information" section for prices and availability of future spares.

H. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

I. Weight and Balance

- | | |
|-------------------|--|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine Front mount Centerline
(Power Plant station (PPS) 100) |

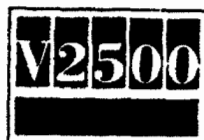
J. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

K. References

- (1) IAE V2500 Service Bulletins:

V2500-ENG-72-0147 - Engine - HP Turbine Rotor and Stator Assembly - Provide New Stage 1 HPT Support Assembly And A New Stage 1 HPT Vane Assembly



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- (2) V2500-A5 and Engine V2500-D5 Engine Illustrated Parts Catalogs (S-V2500-2IA and S-V2500-3IA).
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-44-00, Assembly.
- (4) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-44-00, Assembly.

L. Other Publications Affected

- (1) V2500-A5 Engine Illustrated Parts Catalog (S-V2500-2IA), Chapter/Section 72-44-20, Figure 1, to add the new parts.
- (2) V2500-D5 Engine Illustrated Parts Catalog (S-V2500-3IA), Chapter/Section 72-44-20, Figure 1, to add the new parts.
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-44-20, Cleaning-00 to add the new part number.
- (4) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-44-20, Cleaning-00 to add the new part number.
- (5) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-44-20, Inspection/Check-01, Config-2, to add the new part number.
- (6) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-44-20, Inspection/Check-01, Config-2, to add the new part number.
- (7) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-44-20, Repair VRS3145, VRS3164, VRS3158, VRS3498, VRS3541 and VRS3034 to add the new part number.
- (8) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-44-20, Repair VRS3145, VRS3164, VRS3158, VRS3498, VRS3541 and VRS3034 add the new part number.

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2. Accomplishment Instructions

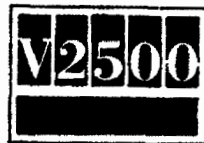
- A. Install the 2A4201 Stage 1 High Pressure Turbine Vane Assembly (40 off) by the procedure given in Reference (3) or (4), Chapter/Section 72-44-00, Assembly.

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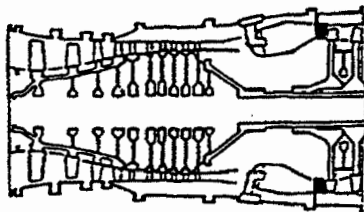
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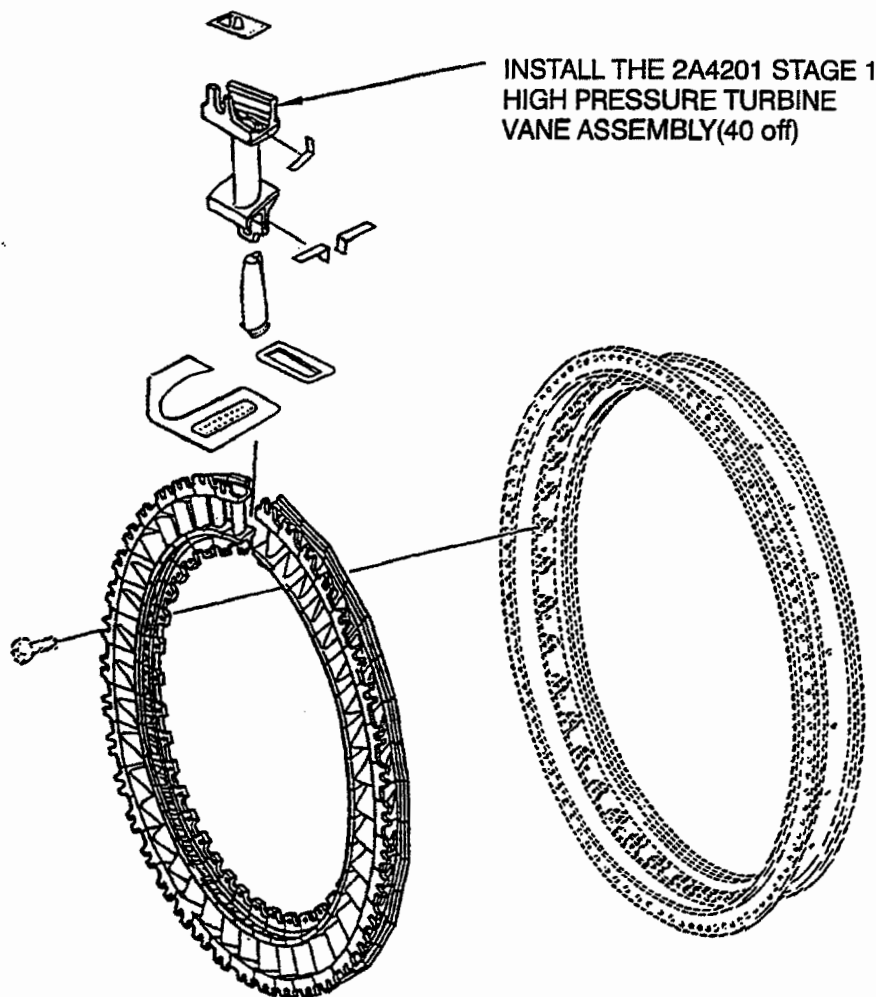
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MODULE 40



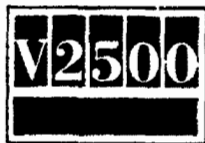
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Location of the Stage 1 High Pressure Turbine Vane Assembly
Figure 1

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3. Material Information

A. Kit associated with this bulletin.

None

B. Parts affected by this bulletin.

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

Applicability: For each V2500-A5 and V2500-D5 Engine to incorporate this Service Bulletin

2A4201	40	.Vane Assy.,	2A2761	(A)(B) (S1)
(72-44-20)		Stage 1 HPT	(01-240)	

C. Consumable Materials

D. Instructions/Disposition Code Statements:

(S1)Old and New Parts are freely and fully interchangeable

(A) The new part is currently available.

(B) The old part will no longer be supplied.

NOTE: The estimated 1998 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

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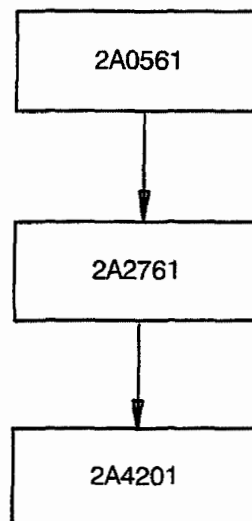
MODIFICATIONS

PART NUMBER CHANGE

BASELINE

V2500-ENG-72-0147
ENGINE - HP TURBINE ROTOR
AND STATOR ASSEMBLY - PRO-
VIDE A NEW STAGE 1 HPT SUP-
PORT ASSEMBLY AND A NEW
STAGE 1 HPT VANE ASSEMBLY

V2500-ENG-72-0291
ENGINE - STAGE 1 HPT VANE
CLUSTER ASSEMBLY - PROVIDE
A NEW FULLY CAST STAGE 1
VANE ASSEMBLY



E7856

Family Tree - Stage 1 HPT Vane Assembly
Ref. Catalog Sequence No 72-44-20. Fig. 1 Item 240
Figure 2

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