



# International Aero Engines SERVICE BULLETIN

Date: Feb.29/00

Subject: Transmittal of Revision 1 to Service Bulletin  
No.V2500-ENG-72-0305

Service Bulletin Revision History:

Event	Date
Basic Issue	Oct.01/98
Revision 1	Feb.29/00

Reason for Issuance of Revision:

- (1) To add missing effectivity of aircraft.
- (2) To clarify effectivity of engines.
- (3) To clarify reference in paragraph 1.K.References.
- (4) To correct incorrect other publications affected in paragraph 1.L.  
Other Publications Affected.

Effect on Past Compliance:

None

List of Effective Pages:

Bulletin Page No.	Rev. No.	Effective Date
R 1 and 2	1	Feb.29/00
3	Basic	Oct.01/98
R 4 and 5	1	Feb.29/00
6 to 8	Basic	Oct.01/98

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Transmittal  
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**ENGINE - LP COMPRESSOR - TO INTRODUCE A CHROME PLATING PIN  
ON THE LPC BLEED VALVE RING**

## MODEL APPLICATION

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

## BULLETIN INDEX LOCATOR

72-32-00

### Compliance Category Code

6

### Internal Reference No.

97VJ027



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ENGINE - LP COMPRESSOR - TO INTRODUCE A CHROME PLATING PIN  
ON THE LPC BLEED VALVE RING

## 1. Planning Information

### A. Effectivity

#### (1) Aircraft:

- R (a) Airbus A319
- (b) Airbus A320
- (c) Airbus A321
- (d) Boeing-Douglas Product Division MD-90

#### (2) Engine:

- R (a) V2522-A5 Engines prior to Serial No.V10480
- R (b) V2524-A5 Engines prior to Serial No.V10480
- R (c) V2527-A5 Engines prior to Serial No.V10480
- R (d) V2527E-A5 Engines prior to Serial No.V10480
- R (e) V2530-A5 Engines prior to Serial No.V10480
- R (f) V2533-A5 Engines prior to Serial No.V10480
- R (g) V2525-D5 Engines prior to Serial No.V20251
- R (h) V2528-D5 Engines prior to Serial No.V20251

### B. Reason

#### (1) Condition

There is insufficient clearance between the pins and the spherical bearings on the LPC bleed valve ring. Choking of small metal particles produced by the fretting corrosion results in sticking the bleed valve.

#### (2) Background

The track check fault message of 2.5 Bleed Valve Actuating System (2.5 BLD ACT/HC/EEC) was observed on the cockpit monitor at some engines. The Tri-Flow lubricant and small diameter pin has been introduced to reduce friction load as a temporary measure.

#### (3) Objective

The hard chrome plating pin has been introduced as a best prevention. This service bulletin intends to prevent the bleed valve sticking caused by the choking up with small particles.



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### (4) Substantiation

Substantiation analysis has been completed.

### (5) Effects of Bulletin on workshop procedure:

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

### (6) Supplemental Information

- (a) The Inspection/Check of the Post-Service Bulletin configuration requires instructions for pin.
- (b) The Repair of the Post-Service Bulletin configuration requires instructions for pin.

### C. Description

This Service Bulletin introduces hard chrome plating pins on the LPC Bleed Valve Ring.

### D. Approval

The part number changes and/or part modifications 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.

### E. Compliance

Category Code 6

Accomplish when the subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to get access to the affected parts.



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## F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

<u>Venue</u>	<u>Estimated Man-hours</u>
(1) In service	Not applicable
(2) At overhaul	Not affected

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

## G. Material - Price and Availability

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

## H. Tooling - Price and Availability

Special tools are not necessary.

## I. Weight and Balance

(1) Weight change	..	..	None
(2) Moment arm	..	..	Not affected
(3) Datum	..	..	Engine front mount centerline (PowerPlant Station P.P.S 100)

## J. Electrical Load Data

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

## K. References

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-70.

R (2) V2500 Engine Manuals (E-V2500-1IA), Chapter/Section 72-32-70,  
R ASSEMBLY-01, CONFIG-2.

R (3) V2500 Engine Manuals (E-V2500-3IA), Chapter/Section 72-32-70,  
R ASSEMBLY-01.



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### **L. Other Publications Affected**

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 72-32-70 will be revised to add the new part numbers.
- R (2) V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-32-70,  
R INSPECTION/CHECK will be revised to add new procedure.
- R (3) V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-32-70,  
R INSPECTION/CHECK will be revised to add new procedure.
- (4) V2500 Engine Manual (E-V2500-1IA and E-V2500-3IA), Chapter/Section 72-32-70, REPAIR 004 (VRS 1739), will be revised to add new part number.



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### **2. Accomplishment Instructions**

#### **A. Rework Instructions**

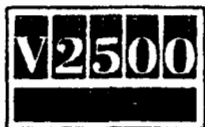
**None.**

#### **B. Assembly Instructions**

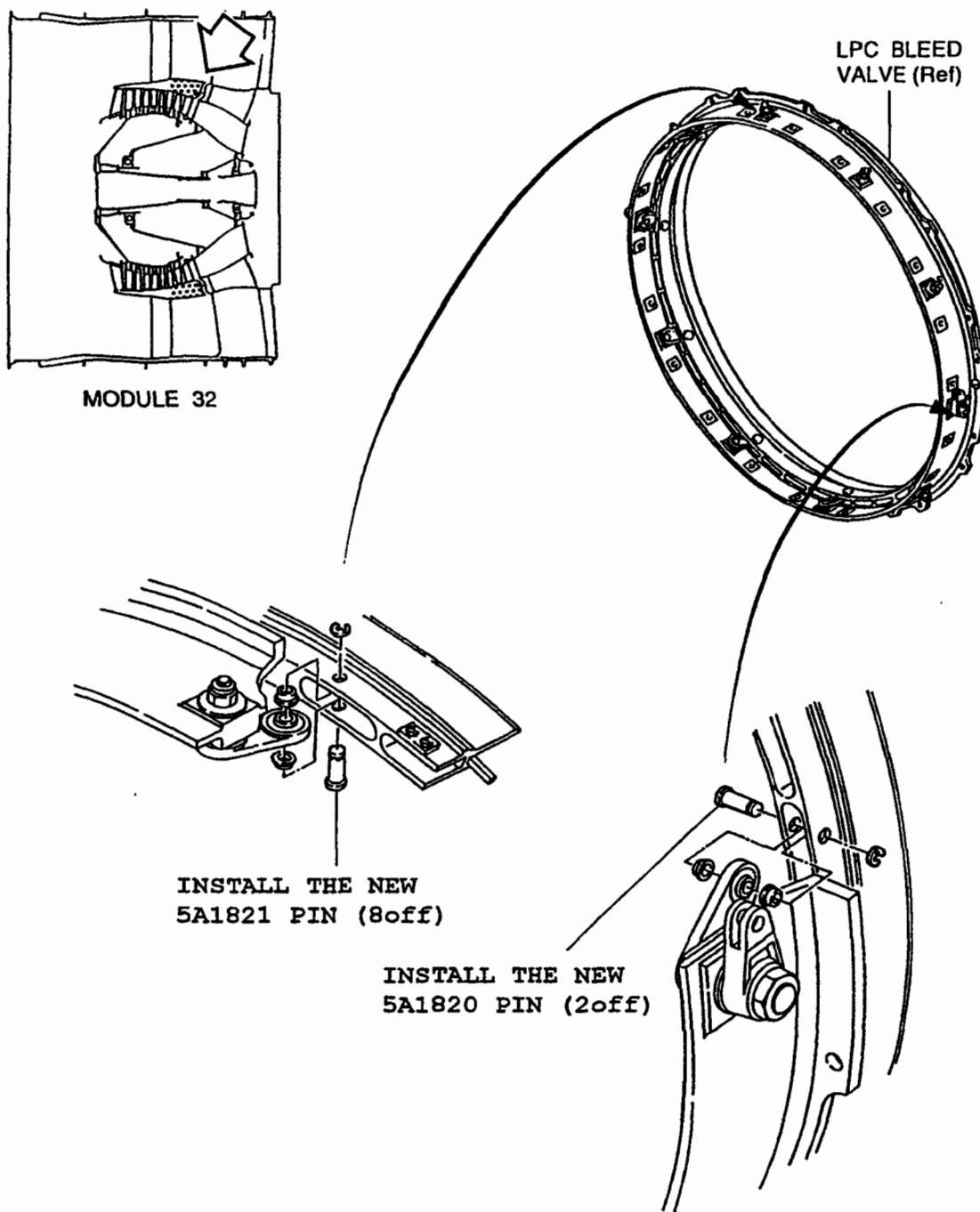
**Install the new pins (5A1820, 2 off and 5A1821, 8 off) in the LPC Bleed Valve Ring. For the correct procedure, refer to the Engine Manual(EM), Chapter/Section 72-32-70, ASSEMBLY-01, CONFIG-2 (For V2500-A5) and Chapter/Section 72-32-70, ASSEMBLY-01 (For V2500-D5). Refer to Figure 1.**

#### **C. Recording Instructions**

**A record of accomplishment is necessary.**



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Booster Stage Bleed Valve and Actuating Mechanism  
Figure 1

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## 3. Material Information

Application: For each V2500-A5 and V2500-D5 engines to incorporate this Bulletin.

### A. Kits necessary for this Service Bulletin:

None.

### B. Parts affected by this Service Bulletin:

New Part No. (ATA No.)	Est'd Unit Qty	Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions /Disposition
5A1820 (72-32-70)	2		.Pin	5A1793 (02-240)	(A) (B) (S1)
5A1821 (72-32-70)	8		.Pin	5A1794 (02-270)	(A) (B) (S1)

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

### C. Instruction and Disposition Code Statements:

(A) New part will be available from November 1998.

(B) Old part will continue to be available until the new part is supplied.

(S1) Old and New parts are freely and fully interchangeable both physically and functionally.