



International Aero Engines

SERVICE BULLETIN

**ENGINE - HP COMPRESSOR SHAFT - REAR SHAFT ASSEMBLY - INTRODUCTION OF AN
ALTERNATIVE HEATSHIELD OF HASTALLOY-X MATERIAL**

MODEL APPLICATION

V2500-A1
V2522-A5
V2524-A5
V2527-A5
V2527E-A5
V2530-A5
V2533-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

72-41-00

Compliance Category Code

7

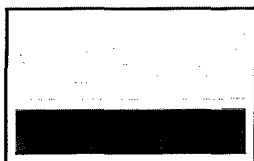
Internal Reference No.

EC98VR003

May. 22/98

V2500-ENG-72-0311

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ENGINE - HP COMPRESSOR SHAFT - REAR SHAFT ASSEMBLY - INTRODUCTION OF AN ALTERNATIVE HEATSHIELD OF HASTALLOY-X MATERIAL

1. Planning Information

A. Effectivity

(1) Aircraft

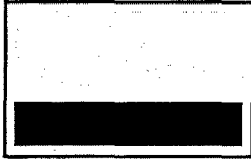
- (a) Airbus A319
- (b) Airbus A320
- (c) Airbus A321
- (d) Boeing-Douglas MD-90

(2) Engines

- (a) V2500-A1 Engines prior to V0362
- (b) V2522-A5 Engines prior to V10600
- (c) V2524-A5 Engines prior to V10600
- (d) V2527-A5 Engines prior to V10600
- (e) V2527E-A5 Engines prior to V10600
- (f) V2530-A5 Engines prior to V10600
- (g) V2533-A5 Engines prior to V10600
- (h) V2525-D5 Engines prior to V20600
- (i) V2528-D5 Engines prior to V20600

B. Concurrent Requirements

None.



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C. Reason

(1) Problem

A design review has shown that the manufacture of the heat shield for the rear shaft assembly of the HP Compressor can be easier.

(2) Evidence

Refer to Problem (1).

(3) Substantiation

A satisfactory engineering analysis and material assessment by Rolls-Royce tribology and materials laboratories, has been done on the changes introduced by this Service Bulletin.

(4) Objective

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

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

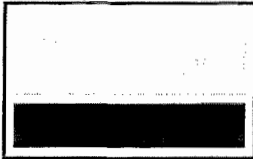
Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.



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D. Description

- (1) This Service Bulletin introduces an alternative heat shield for the rear shaft assembly of the HP Compressor, the changes are as follows:
 - (a) The alternative heat shield is produced from a Nickel alloy heat resistant material Hastalloy-X, not C263. Also, the Hastalloy-X does not need any heat treatment after it has been welded.

E. Compliance

Category Code 7.

This Service Bulletin can be done when there are no original 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 models listed.

G. Manpower

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

<u>Venue</u>	<u>Estimated Man-Hours</u>
(1) In Service	Not applicable
(2) At Overhaul	No additional time is necessary to do 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 the Material Information section for prices and availability of spares.

I. Tooling - Price and Availability

Special tools are not necessary.



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J. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

Not affected.

(3) Datum

Engine front mount centerline (Power Plant Station (PPS) - 100)

K. Electrical Load Data

This Service Bulletin does not affect the aircraft electrical load.

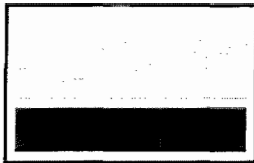
L. References

None.

M. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC), Chapter/Section 72-41-13.

(2) Engine Manual (EM), Chapter/Section 72-41-13, Cleaning, Inspection/Check and Repair.



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2. Accomplishment Instructions

A. Rework Instructions

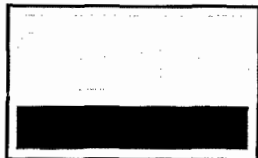
None

B. Assembly Instructions

- (1) For the correct removal/installation instructions refer to the A1/A5/D5 Engine Manual (EM), Chapter/Section 72-40-00, Disassembly/Assembly.

C. Recording Instructions

A record of accomplishment is necessary.



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3. Material Information

Applicability: For each V2500 engine for which this Service Bulletin is applicable.

A. Kits necessary for this Service Bulletin:

None.

B. Parts affected by this Service Bulletin:

NEW PART No. (ATA No.)	QTY	EST UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
A7400 (72-41-13)	1	Note	Shield assy, heat - HPC rear shaft assy	- (01-875)	(A) (B)

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 part sales department.

C. Instruction Disposition Codes:

(A) Alternative to 6A1494.

(B) New part will be available from December 1998.

