



Date: February 1/00

Subject: Transmittal of Revision 3 To Service Bulletin Number
V2500-ENG-72-0315.

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	June 25/98
Revision 1	October 30/98
Revision 2	April 27/99
Revision 3	February 1/00

Reason For Issuance Of Revision:

- (1) To add model on page 1 & 2.
- (2) Revise effectivity and correct model on page 2.
- (3) Add references paragraphs K and L on page 4.
- (4) Change part number 2A3351-001 to part number 2A2034-001.
- (5) Provide additional part numbers (when Row 5 is not replaced).

Effect on Prior Compliance:

None.

List of Effective Pages:

<u>Bulletin Page No.</u>	<u>Rev. No.</u>	<u>Effective Date</u>
1 and 2	3	Feb.1/00
3	1	Oct.30/98
4 to 31	3	Feb.1/00

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Transmittal

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ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

MODEL APPLICATION

V2500-A1
V2522-A5
V2524-A5
V2527-A5
V2527E-A5
V2527M-A5
V2530-A5
V2533-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

72-40-00

Compliance Category Code

6, 7

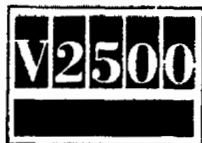
Internal Reference No.

97VC010, 97VC010-03, 97VC010K,
97VC010L

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ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320, A321
McDonnell Douglas MD-90
- (2) Engine: V2500-A1 Engines Before Serial No. V0362
V2522-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2524-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2527-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2527E-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2527M-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2530-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2533-A5 Engines Before Serial No. V10475, Except V10459, V10460,
V10465, V10466, V10469, V10470, and V10473.
V2525-D5 Engines Serial No. V20249*
V2528-D5 Engines Serial No. V20249*

*The serial Number data shown is of a preliminary nature and is
provided for advanced planning only. A future revision to this
Service Bulletin will confirm final serial number effectivity.

B. Concurrent Requirements

one

C. Reason

- (1) Condition:
Engine durability is being limited by combustion chamber distress
caused by oxidation of the fuel nozzle guide, bulkhead segments and
liner segments. This distress is responsible for a few premature
engine removals, and many more engines currently are on a reduced
borescope inspection interval.
- (2) Background:
Oxidation of burner hardware being experienced during climb and
cruise. The current design is insufficient to withstand the
environment.
- (3) Objective:
The addition of PWA 281 coating provides increased resistance to
oxidation, and will increase life expectancy of hardware.
NOTE: The PWA 281 coating is optional for Row 5 Segments.
- (4) Substantiation
The new coating successfully completed 3300 hours of long endurance
cycles on various test engines.

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(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.

D. Description

- (1) Install new Inner and Outer Combustion Chamber Liners

E. 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.

F. Compliance

Category 6 (For all V2500-A5 and V2500-D5 Engines)

Accomplish when the subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

Category 7 (For all V2500-A1 Engines)

Accomplish when supply of superseded parts has been depleted.

G. 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

H. 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.

I. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

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J. Weight and Balance

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

K. Electrical Load Data

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

L. References

(1) IAE V2500 Service Bulletins:

V2500-ENG-72-0006 - (Engine - Diffuser and Combustion Group and Stage 1 Turbine Nozzle Assembly - Thermal Barrier Coating for Combustor Liners).

V2500-ENG-72-0060 - Engine - Diffuser and Combustion Group and Stage 1 Turbine Nozzle Assembly - Introduce Thermal Barrier Coating On Inner And Outer Combustion Chamber Liners).

- (2) V2500 Standard Practices Manual (SPP-V2500-1IA), 70-09-00, Marking Of Parts
- (3) V2500-A1 Engine Illustrated Parts Catalog (S-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30
- (4) V2500-A5 Engine Illustrated Parts Catalog (S-V2500-2IA, S-V2500-2IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, S-V2500-7IB), Chapter/Section 72-42-61 and 72-44-30
- (5) V2500-D5 Engine Illustrated Parts Catalog (S-V2500-3IA, S-V2500-3IB), Chapter/Section 72-42-61 and 72-44-30
- (6) V2500 Engine Manual (E-V2500-1I-A), 72-42-60, Assembly.
- (7) V2500 Engine Manual (E-V2500-3I-A), 72-42-60, Assembly.

M. Other Publications Affected

- (1) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30, Cleaning to add the new part number.
- (2) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30, Cleaning to add the new part number.
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30, Inspection to add the new part number.
- (4) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30, Inspection to add the new part number.
- (5) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30, Repair to add the new part number.
- (6) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30, Repair to add the new part number.

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2. Accomplishment Instructions

For All V2500-A1 Engines to incorporate this Service Bulletin

- A. Replace the * 2A1613 (10 off), 2A2089 (10 off), 2A2088 (10 off), 2A2083 (9 off), 2A2084 (1 off), 2A2085 (8 off), 2A2086 (1 off), 2A2087 (1 off) and the 2A2096 (20 off) Outer Combustion Chamber Liner Segments and the 2A0959 Fuel Nozzle Guide. See Figure 1 by the procedure given in Reference (6), Chapter/Section 72-42-60 Assembly and as specified below. See Figure 1.

<u>New Part Number</u>	<u>Old Part Number</u>
* 2A3318	* 2A1613
2A3349	2A2089
2A3348	2A2088
2A3311	2A2083
2A3312	2A2084
2A3313	2A2085
2A3314	2A2086
2A3315	2A2087
2A3324	2A2096
2A3350	2A0959
Replacement of Outer Burner Liner Assembly Parts (V2500-A1) Table 1	

NOTE: * Row 5 replacement is optional

(1) Row 5 Is Replaced

- (a) Identify the 2A2837-01, 2A1620, or 2A2032 Outer Combustion Chamber Assembly as 2A3347-01, 2A3347-001, or 2A3347-002 respectively by the vibration peen method specified in Reference (2), Chapter/ Section 70-09-00, Marking of Parts.

(2) Row 5 Is Not Replaced

- (a) Identify the 2A2837-01, 2A1620, or 2A2032 Outer Combustion Chamber Assembly as 2A3347-003, 2A3347-004, or 2A3347-005 respectively by the vibration peen method specified in Reference (2), Chapter/ Section 70-09-00, Marking of Parts.

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- B. Replace the 2A2091 (10 off), * 2A1616 (10 off), 2A2094 (10 off), 2A2093 (10 off) and the 2A2092 (10 off) Inner Combustion Chamber Liner Segments by the procedure given in Reference (6), Chapter/Section 72-44-30 Assembly and as specified below. See Figure 2.

<u>New Part Number</u>	<u>Old Part Number</u>
2A3319	2A2091
* 2A3323	* 2A1616
2A3322	2A2094
2A3353	2A2093
2A3320	2A2092
Replacement of Inner Burner Liner Assembly Parts (V2500-A1) Table 1	

NOTE: * Row 5 replacement is optional

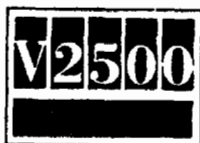
(1) Row 5 Is Replaced

- (a) Identify the 2A2838-01 or 2A2034 Inner Combustion Chamber Assembly as 2A3351-01 or 2A2034-001 respectively by the vibration peen method specified in Reference (2), Chapter/Section 70-09-00, Marking of Parts.

(2) Row 5 Is Not Replaced

- (a) Identify the 2A2838-01 or 2A2034 Inner Combustion Chamber Assembly as 2A3351-003 or 2A3351-004 respectively by the vibration peen method specified in Reference (2), Chapter/Section 70-09-00, Marking of Parts.

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For All V2500-A5/D5 Engines to incorporate this Service Bulletin

- A. Replace the * 2A1613 (10 off), 2A2342 (10 off), 2A2083 (9 off), 2A2084 (1 off), 2A2085 (8 off), 2A2086 (1 off), 2A2087 (1 off), 2A2096 (20 off) and the 2A2341 (10 off) Outer Combustion Chamber Liner Segments and the 2A2380 Fuel Nozzle Guide by the procedure given in Reference (6) or (7), Chapter/Section 72-42-60 Assembly and as specified below. See Figure 3.

<u>New Part Number</u>	<u>Old Part Number</u>
* 2A3318	* 2A1613
2A3317	2A2342
2A3311	2A2083
2A3312	2A2084
2A3313	2A2085
2A3314	2A2086
2A3315	2A2087
2A3316	2A2341
2A3324	2A2096
2A3325	2A2380
Replacement of Outer Burner Liner Assembly Parts (V2500-A5/D5) Table 2	

NOTE: * Row 5 replacement is optional

(1) Row 5 Is Replaced

- (a) Identify the 2A2723-01 Outer Combustion Chamber Assembly as 2A3345-01 by the vibration peen method specified in Reference (2), Chapter/ Section 70-09-00, Marking of Parts.

(2) Row 5 Is Not Replaced

- (a) Identify the 2A2723-01 Outer Combustion Chamber Assembly as 2A3345-001 by the vibration peen method specified in Reference (2), Chapter/ Section 70-09-00, Marking of Parts.

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- B. Replace the 2A2091 (10 off), * 2A1616 (10 off), 2A2094 (10 off), 2A2343 (10 off) and the 2A2092 (10 off) Inner Combustion Chamber Liner Segments by the procedure given in Reference (6) or (7), Chapter/Section 72-44-30 Assembly and as specified below. See Figure 4.

<u>New Part Number</u>	<u>Old Part Number</u>
2A3319	2A2091
* 2A3323	* 2A1616
2A3322	2A2094
2A3326	2A2343
2A3320	2A2092
Replacement of Inner Burner Liner Assembly Parts (V2500-A5/D5) Table 1	

NOTE: * Row 5 replacement is optional

(1) Row 5 Is Replaced

- (a) Identify the 2A2722-01 Inner Combustion Chamber Assembly as 2A3344-01 by the vibration peen method specified in Reference (2), Chapter/Section 70-09-00, Marking of Parts.

(2) Row 5 Is Not Replaced

- (a) Identify the 2A2722-01 Inner Combustion Chamber Assembly as 2A3344-001 by the vibration peen method specified in Reference (2), Chapter/Section 70-09-00, Marking of Parts.

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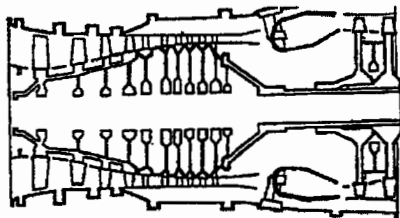
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REPLACE THE
2A2096 BULKHEAD
LINER SEGMENT
WITH THE 2A3324
BULKHEAD LINER
SEGMENT (20 off)

REPLACE THE 2A0959
FUEL NOZZLE GUIDE
WITH THE 2A3350
FUEL NOZZLE GUIDE
(20 off)

REPLACE THE
2A2086 LINER
SEGMENT WITH
THE 2A3314
LINER SEGMENT
(1 off)

REPLACE THE
2A2084 LINER
SEGMENT WITH
THE 2A3312
LINER SEGMENT
(1 off)

REPLACE THE
2A2083 LINER
SEGMENT WITH
THE 2A3311
LINER SEGMENT
(9 off)

REPLACE THE
2A2087 LINER
SEGMENT WITH
THE 2A3315
LINER SEGMENT
(1 off)

REPLACE THE 2A2088 LINER
SEGMENT WITH THE 2A3348
LINER SEGMENT (10 off)

REPLACE THE 2A2085 LINER
SEGMENT WITH THE 2A3313
LINER SEGMENT (8 off)

IDENTIFY THE OUTER COMBUSTION
CHAMBER ASSY AS FOLLOWS:

- (1) 2A2837-01 TO 2A3347-01
- (2) 2A2837-01 TO 2A3347-003
- (1) 2A1620 TO 2A3347-001
- (2) 2A1620 TO 2A3347-004
- (1) 2A2032 TO 2A3347-002
- (2) 2A2032 TO 2A3347-005

* REPLACE THE
2A1613 LINER
SEGMENT WITH
THE 2A3318
LINER SEGMENT
(10 off)

REPLACE THE
2A2089 LINER
SEGMENT WITH
THE 2A3349 LINER
SEGMENT (10 off)

* ROW 5 REPLACEMENT IS OPTIONAL

- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7975B

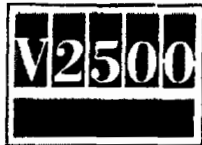
Location of the Outer Combustion Chamber Liner Assembly and Liner Segments
(V2500-A1 Engines)
Figure 1

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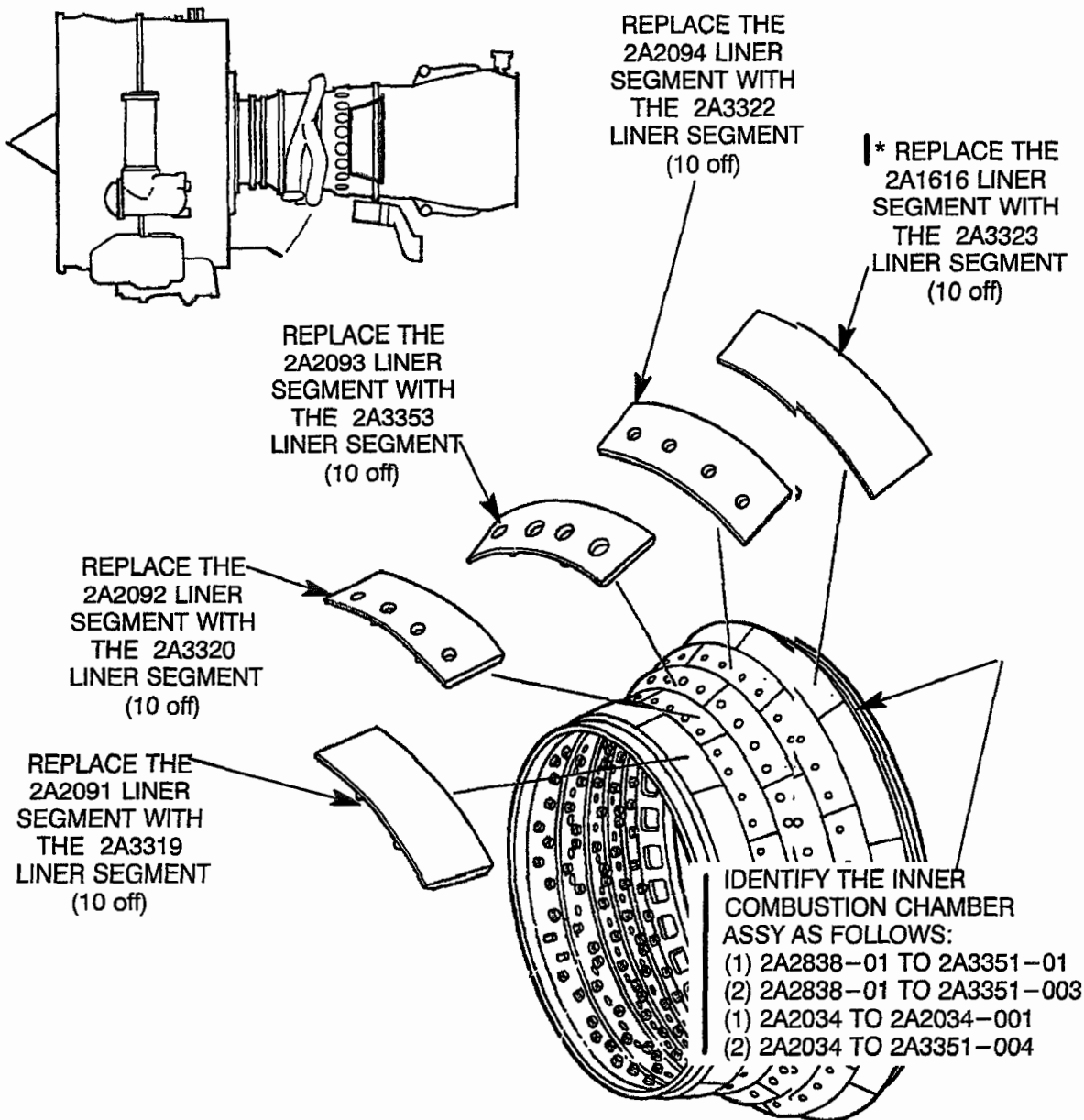
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* ROW 5 REPLACEMENT IS OPTIONAL

- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7985B

Location of the Inner Combustion Chamber Liner Assembly and Liner Segments
(V2500-A1 Engines)

Figure 2

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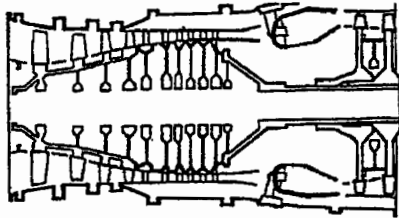
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REPLACE THE
2A2096 BULKHEAD
LINER SEGMENT
WITH THE 2A3324
BULKHEAD LINER
SEGMENT (20 off)

REPLACE THE 2A2380
FUEL NOZZLE GUIDE
WITH THE 2A3325
FUEL NOZZLE GUIDE
(20 off)

REPLACE THE
2A2086 LINER
SEGMENT WITH
THE 2A3314
LINER SEGMENT
(1 off)

REPLACE THE
2A2084 LINER
SEGMENT WITH
THE 2A3312
LINER SEGMENT
(1 off)

REPLACE THE
2A2083 LINER
SEGMENT WITH
THE 2A3311
LINER SEGMENT
(9 off)

REPLACE THE
2A2087 LINER
SEGMENT WITH
THE 2A3315
LINER SEGMENT
(1 off)

REPLACE THE 2A2341 LINER
SEGMENT WITH THE 2A3316
LINER SEGMENT (10 off)

REPLACE THE 2A2085 LINER
SEGMENT WITH THE 2A3313
LINER SEGMENT (8 off)

IDENTIFY THE OUTER COMBUSTION
CHAMBER ASSY AS FOLLOWS:

- (1) 2A2723-01 TO 2A3345-01
- (2) 2A2723-01 TO 2A3345-001

* REPLACE THE
2A1613 LINER
SEGMENT WITH
THE 2A3318
LINER SEGMENT
(10 off)

REPLACE THE
2A2342 LINER
SEGMENT WITH
THE 2A3317 LINER
SEGMENT (10 off)

* ROW 5 REPLACEMENT IS OPTIONAL

- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7984A

Location of the Outer Combustion Chamber Liner Assembly and Liner Segments

(All Except V2500-A1 Engines)

Figure 3

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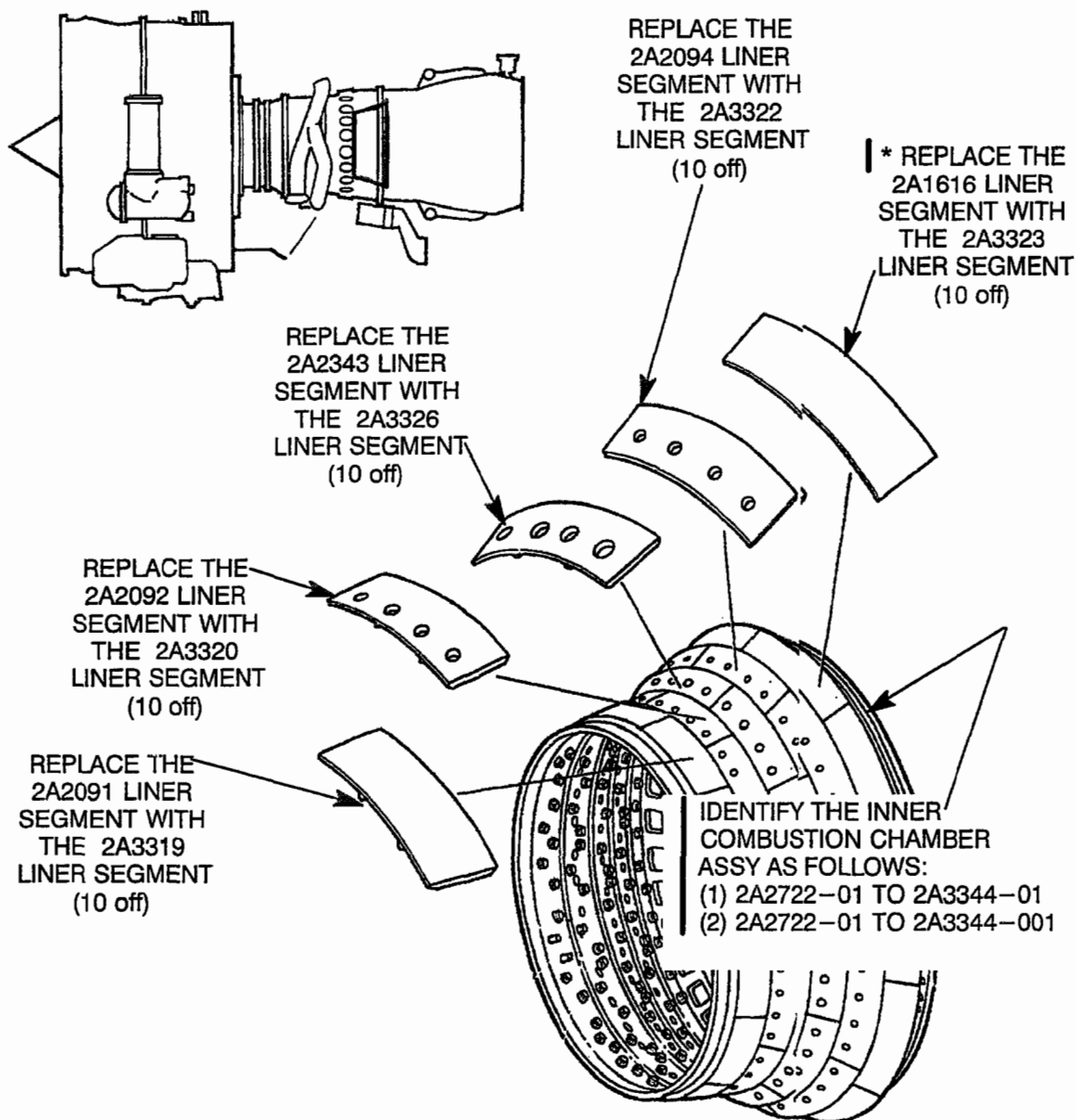
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* ROW 5 REPLACEMENT IS OPTIONAL

(1) ROW 5 IS REPLACED
(2) ROW 5 IS NOT REPLACED

E7986A

Location of the Inner Combustion Chamber Liner Assembly and Liner Segments

(All Except V2500-A1 Engines)

Figure 4

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Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

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3. Material Information

A. Kit 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.)	Instructions Disposition
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| Applicability: For each V2500-A1 Engine with Row 5 replacement to incorporate this Service Bulletin

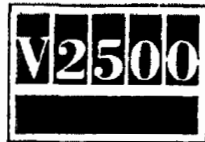
2A3347-01 (72-42-61)	1		Outer Comb. Chamber Assy. or	2A2837-01 (01-501)	(S1)(A)
2A3347-001 (72-42-61)	1		Outer Comb. Chamber Assy. or	2A1620 (01-501)	(S1)(A)
2A3347-002 (72-42-61)	1		Outer Comb. Chamber Assy.	2A2032 (01-501)	(S1)(A)
2A3318 (72-42-61)	10		Liner Segment	2A1613 (01-600)	(S1)(B)(C)
2A3349 (72-42-61)	10		Liner Segment	2A2089 (01-610)	(S1)(B)(C)
2A3348 (72-42-61)	10		Liner Segment	2A2088 (01-620)	(S1)(B)(C)
2A3311 (72-42-61)	9		Liner Segment	2A2083 (01-630)	(S1)(B)(C)
2A3312 (72-42-61)	1		Liner Segment	2A2084 (01-640)	(S1)(B)(C)
2A3313 (72-42-61)	8		Liner Segment	2A2085 (01-650)	(S1)(B)(C)
2A3314 (72-42-61)	1		Liner Segment	2A2086 (01-660)	(S1)(B)(C)
2A3315 (72-42-61)	1		Liner Segment	2A2087 (01-670)	(S1)(B)(C)
2A3324 (72-42-61)	20		Liner Segment	2A2096 (01-680)	(S1)(B)(C)
2A3350 (72-42-61)	20		Guide, Fuel Nozzle	2A0959 (01-690)	(S1)(B)(C)
2A3351-01 (72-44-30)	1		Inner Comb. Chamber Assy. or	2A2838-01 (01-401)	(S1)(A)
2A2034-001 (72-44-30)	1		Inner Comb. Chamber Assy.	2A2034 (01-401)	(S1)(A)
2QA3319 (72-44-30)	10		Liner Segment	2A2091 (01-540)	(S1)(B)(C)
2A3323 (72-44-30)	10		Liner Segment	2A1616 (01-560)	(S1)(B)(C)
2A3322 (72-44-30)	10		Liner Segment	2A2094 (01-580)	(S1)(B)(C)
2A3353 (72-44-30)	10		Liner Segment	2A2093 (01-600)	(S1)(B)(C)
2A3320 (72-44-30)	10		Liner Segment	2A2092 (01-620)	(S1)(B)(C)

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New Part No. (ATA No.)	Qty	Est'd Unit Price(\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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Applicability: For each V2500-A1 Engine without Row 5 replacement to incorporate this Service Bulletin

2A3347-003 (72-42-61)	1		Outer Comb. Chamber Assy. or	2A2837-01 (01-501)	(S1)(A)
2A3347-004 (72-42-61)	1		Outer Comb. Chamber Assy. or	2A1620 (01-501)	(S1)(A)
2A3347-005 (72-42-61)	1		Outer Comb. Chamber Assy.	2A2032 (01-501)	(S1)(A)
2A3349 (72-42-61)	10		Liner Segment	2A2089 (01-610)	(S1)(B)(C)
2A3348 (72-42-61)	10		Liner Segment	2A2088 (01-620)	(S1)(B)(C)
2A3311 (72-42-61)	9		Liner Segment	2A2083 (01-630)	(S1)(B)(C)
2A3312 (72-42-61)	1		Liner Segment	2A2084 (01-640)	(S1)(B)(C)
2A3313 (72-42-61)	8		Liner Segment	2A2085 (01-650)	(S1)(B)(C)
2A3314 (72-42-61)	1		Liner Segment	2A2086 (01-660)	(S1)(B)(C)
2A3315 (72-42-61)	1		Liner Segment	2A2087 (01-670)	(S1)(B)(C)
2A3324 (72-42-61)	20		Liner Segment	2A2096 (01-680)	(S1)(B)(C)
2A3350 (72-42-61)	20		Guide, Fuel Nozzle	2A0959 (01-690)	(S1)(B)(C)
2A3351-003 (72-44-30)	1		Inner Comb. Chamber Assy. or	2A2838-01 (01-401)	(S1)(A)
2A3351-004 (72-44-30)	1		Inner Comb. Chamber Assy.	2A2034 (01-401)	(S1)(A)
2A3319 (72-44-30)	10		Liner Segment	2A2091 (01-540)	(S1)(B)(C)
2A3322 (72-44-30)	10		Liner Segment	2A2094 (01-580)	(S1)(B)(C)
2A3353 (72-44-30)	10		Liner Segment	2A2093 (01-600)	(S1)(B)(C)
2A3320 (72-44-30)	10		Liner Segment	2A2092 (01-620)	(S1)(B)(C)

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SERVICE BULLETIN

New Part No. (ATA No.)	Qty	Est'd Unit Price(\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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Applicability: For each V2522-A5 V2524-A5 V2527-A5 V2527E-A5 V2527M-A5 V2530-A5 V2533-A5 V2525-D5 V2528-D5 Engine with Row 5 replacement to incorporate this Service Bulletin

2A3345-01	1		Outer Comb.	2A2723-01	(S1)(A)
(72-42-61)			Chamber Assy.	(01-501)	
2A3318	10		Liner Segment	2A1613	(S1)(B)(D)
(72-42-61)				(01-600)	
2A3317	10		Liner Segment	2A2342	(S1)(B)(D)
(72-42-61)				(01-610)	
2A3316	10		Liner Segment	2A2341	(S1)(B)(D)
(72-42-61)				(01-620)	
2A3311	9		Liner Segment	2A2083	(S1)(B)(D)
(72-42-61)				(01-630)	
2A3312	1		Liner Segment	2A2084	(S1)(B)(D)
(72-42-61)				(01-640)	
2A3313	8		Liner Segment	2A2085	(S1)(B)(D)
(72-42-61)				(01-650)	
2A3314	1		Liner Segment	2A2086	(S1)(B)(D)
(72-42-61)				(01-660)	
2A3315	1		Liner Segment	2A2087	(S1)(B)(D)
(72-42-61)				(01-670)	
2A3324	20		Liner Segment	2A2096	(S1)(B)(D)
(72-42-61)				(01-680)	
2A3325	20		Guide, Fuel	2A2380	(S1)(B)(D)
(72-42-61)			Nozzle	(01-690)	
2A3344-01	1		Inner Comb.	2A2722-01	(S1)(A)
(72-44-30)			Chamber Assy.	(01-401)	
2A3319	10		Liner Segment	2A2091	(S1)(B)(D)
(72-44-30)				(01-540)	
2A3323	10		Liner Segment	2A1616	(S1)(B)(D)
(72-44-30)				(01-560)	
2A3322	10		Liner Segment	2A2094	(S1)(B)(D)
(72-44-30)				(01-580)	
2A3326	10		Liner Segment	2A2343	(S1)(B)(D)
(72-44-30)				(01-600)	
2A3320	10		Liner Segment	2A2092	(S1)(B)(D)
(72-44-30)				(01-620)	

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SERVICE BULLETIN

New Part No. (ATA No.)	Qty	Est'd Unit Price(\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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Applicability: For each V2522-A5 V2524-A5 V2527-A5 V2527E-A5 V2527M-A5 V2530-A5 V2533-A5 V2525-D5 V2528-D5 Engine without Row 5 replacement to incorporate this Service Bulletin

2A3345-001	1		Outer Comb.	2A2723-01	(S1)(A)
(72-42-61)			Chamber Assy.	(01-501)	
2A3317	10		Liner Segment	2A2342	(S1)(B)(D)
(72-42-61)				(01-610)	
2A3316	10		Liner Segment	2A2341	(S1)(B)(D)
(72-42-61)				(01-620)	
2A3311	9		Liner Segment	2A2083	(S1)(B)(D)
(72-42-61)				(01-630)	
2A3312	1		Liner Segment	2A2084	(S1)(B)(D)
(72-42-61)				(01-640)	
2A3313	8		Liner Segment	2A2085	(S1)(B)(D)
(72-42-61)				(01-650)	
2A3314	1		Liner Segment	2A2086	(S1)(B)(D)
(72-42-61)				(01-660)	
2A3315	1		Liner Segment	2A2087	(S1)(B)(D)
(72-42-61)				(01-670)	
2A3324	20		Liner Segment	2A2096	(S1)(B)(D)
(72-42-61)				(01-680)	
2A3325	20		Guide, Fuel	2A2380	(S1)(B)(D)
(72-42-61)			Nozzle	(01-690)	
2A3344-001	1		Inner Comb.	2A2722-01	(S1)(A)
(72-44-30)			Chamber Assy.	(01-401)	
2A3319	10		Liner Segment	2A2091	(S1)(B)(D)
(72-44-30)				(01-540)	
2A3322	10		Liner Segment	2A2094	(S1)(B)(D)
(72-44-30)				(01-580)	
2A3326	10		Liner Segment	2A2343	(S1)(B)(D)
(72-44-30)				(01-600)	
2A3320	10		Liner Segment	2A2092	(S1)(B)(D)
(72-44-30)				(01-620)	

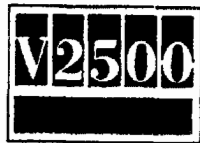
C. Consumable Materials

D. Instructions/Disposition Code Statements:

- (S1)Old and New Parts are freely and fully interchangeable
- (A) The new part is an assembly which is shown for reference only and will not be supplied for spares.
- (B) The new part will be available approximately July 31, 1998.
- (C) The old part will continue to be supplied until stock is exhausted.
- (D) 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

BASE LINE

THE COMBUSTION CHAMBER HOOD FOR 2A1385 DOES NOT HAVE THE NON-FUNCTIONAL RIBS (WHICH ARE CAST INTO THE HOOD FOR 2A1383)

V2500-ENG-72-0006
ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY - THERMAL BARRIER COATING FOR COMBUSTION LINERS

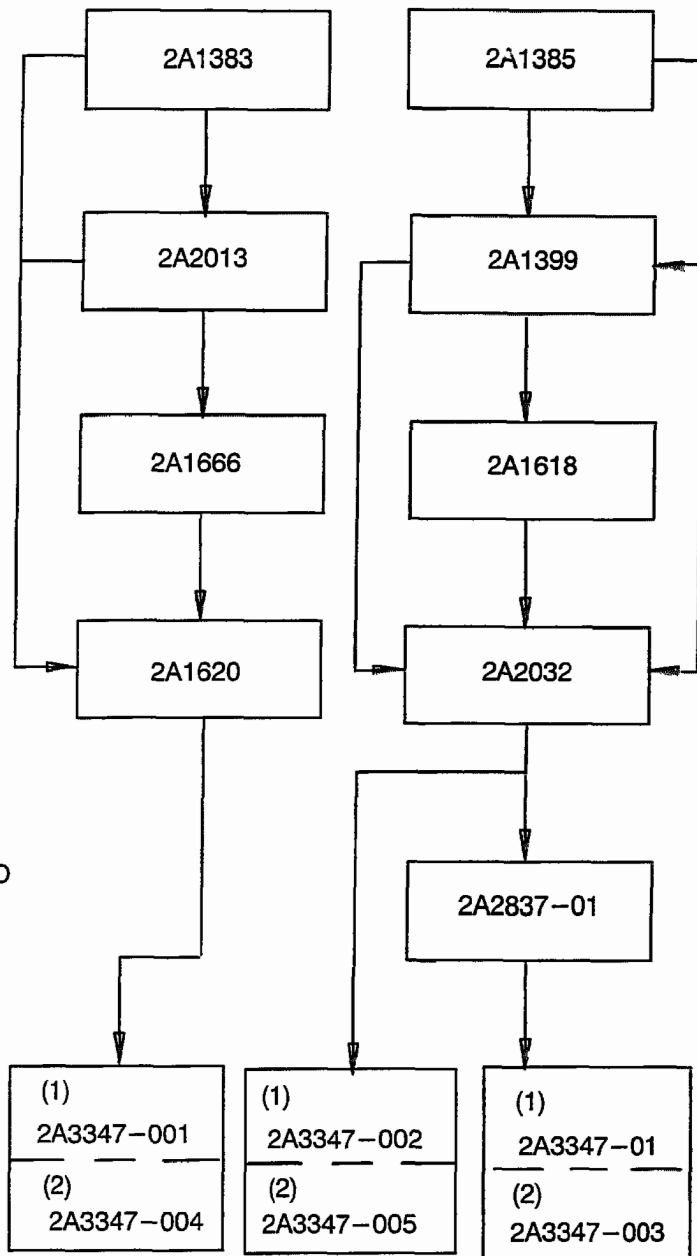
V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY - INTRODUCE THERMAL BARRIER COATING ON INNER AND OUTER COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY - PROVIDE NEW INNER AND OUTER COMBUSTION CHAMBER ASSEMBLIES WITH GENERATION II LINER ASSEMBLIES

V2500-ENG-70-0253
INFORMATION - ENGINE - DIFFUSER AND COMBUSTION SECTION- PROVIDE NEW INNER AND OUTER COMBUSTION CHAMBERS WITH INCREASED HARDFACE THICKNESS AND RELOCATED COOLING HOLES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP AND STAGE 1 TURBINE NOZZLE ASSEMBLY - PROVIDE NEW INNER AND OUTER COMBUSTION CHAMBER LINERS WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

PART NUMBER CHANGE



- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7976B

Family Tree - Outer Combustion Chamber Case Assembly (V2500-A1 Only)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Item 600
Figure 5

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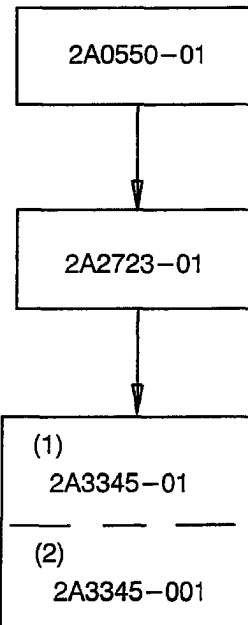
MODIFICATIONS

BASE LINE

V2500-ENG-72-0159
ENGINE - DIFFUSER AND COMBUSTION
SECTION - INTRODUCE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

PART NUMBER CHANGE



- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7987A

Family Tree - Outer Combustion Chamber Case Assembly (All Except V2500-A1)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Item 600
Figure 6



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

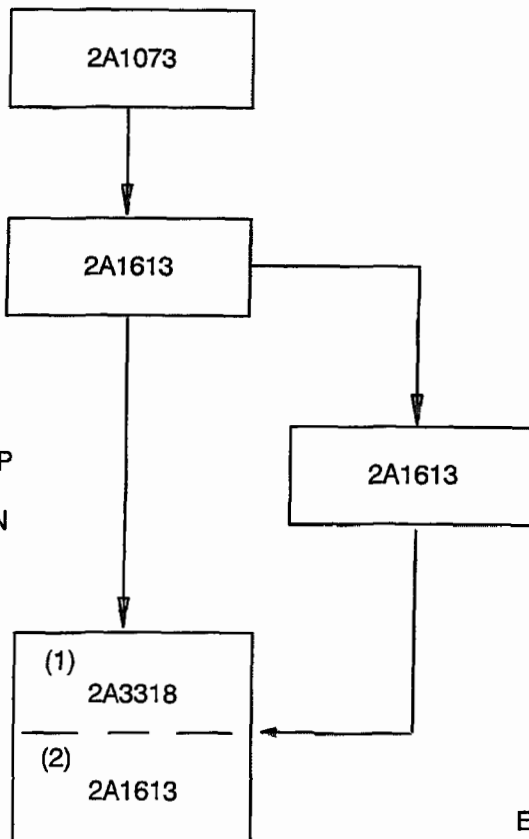
PART NUMBER CHANGE

BASE LINE

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BAR-
RIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER ASSEMBLIES WITH GENERATION II
LINER ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL



E7977A

(1) ROW 5 IS REPLACED

(2) ROW 5 IS NOT REPLACED

Family Tree - Outer Combustion Chamber Liner Segments (V2500-A1 Only)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Item 600
Figure 7

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MODIFICATIONS

BASE LINE

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BAR-
RIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

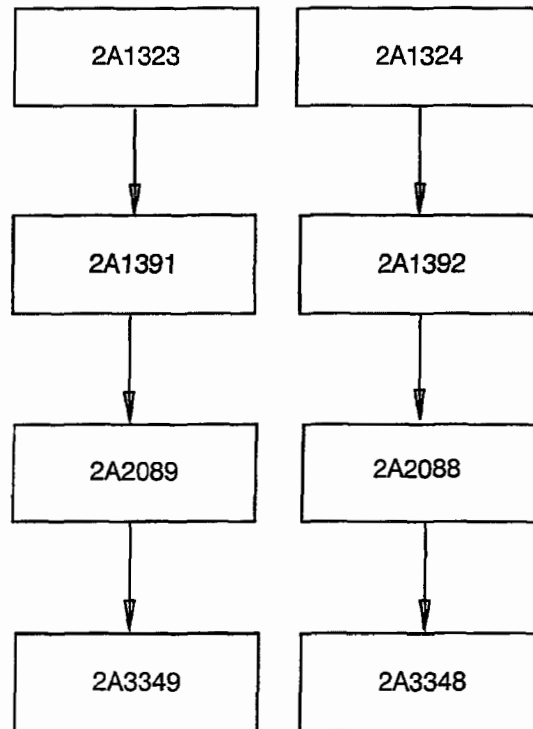
V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER ASSEMBLIES WITH GENERATION II
LINER ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 610)

(Fig. 1 Item 620)



E7978

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Family Tree - Outer Combustion Chamber Liner Segments (V2500-A1 Only)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 610 and 620
Figure 8

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MODIFICATIONS

BASE LINE

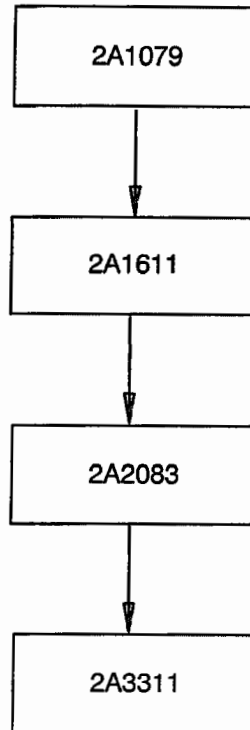
V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL
BARRIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER ASSEMBLIES WITH GENERATION II
LINER ASSEMBLIES

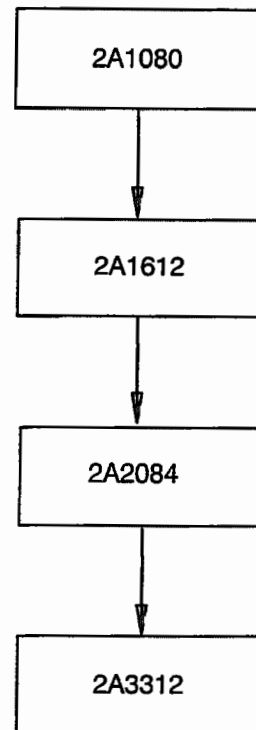
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 630)



(Fig. 1 Item 640)



E7979

Family Tree - Outer Combustion Chamber Liner Segments (V2500-A1 Only)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 630 and 640
Figure 9

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MODIFICATIONS

BASE LINE

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BAR-
RIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

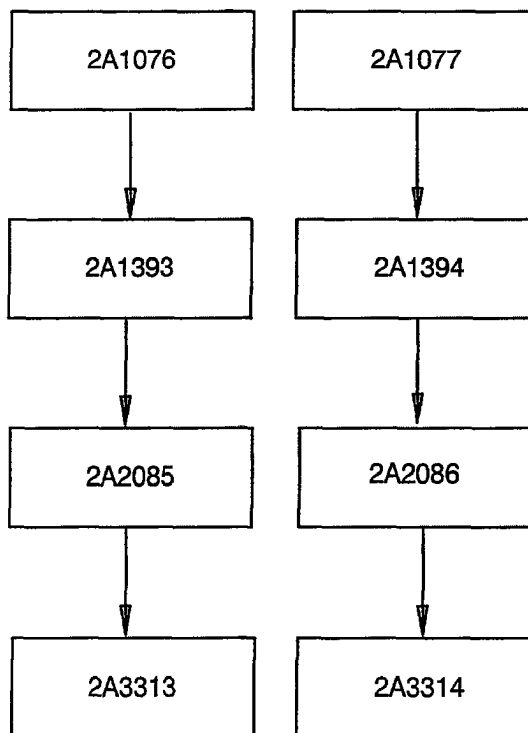
V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER ASSEMBLIES WITH GENERATION II
LINER ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 650)

(Fig. 1 Item 660)



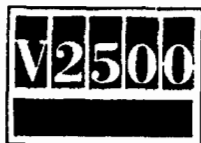
E7980

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Family Tree - Outer Combustion Chamber Liner Segments (V2500-A1 Only)

Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 650 and 660

Figure 10



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

BASE LINE

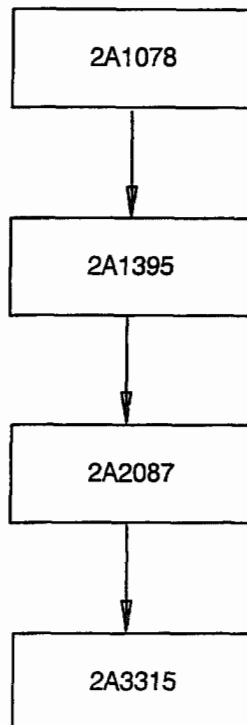
V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BAR-
RIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER ASSEMBLIES WITH GENERATION II
LINER ASSEMBLIES

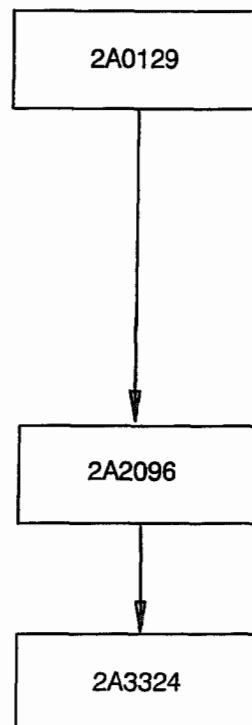
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 670)



(Fig. 1 Item 680)



E7981

Family Tree - Outer Combustion Chamber Liner Segments (V2500-A1 Only)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 670 and 680
Figure 11

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MODIFICATIONS

PART NUMBER CHANGE

BASE LINE

(Fig. 1 Item 600)

2A1613

(1)
2A3318

(2)
2A1613

(Fig. 1 Item 610)

2A2342

2A3317

(Fig. 1 Item 620)

2A2341

2A3316

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

(1) ROW 5 IS REPLACED

(2) ROW 5 IS NOT REPLACED

MODIFICATIONS

PART NUMBER CHANGE

BASE LINE

(Fig. 1 Item 630)

2A2083

2A3311

(Fig. 1 Item 640)

2A2084

2A3312

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

E7982A

Family Tree - Outer Combustion Chamber Liner Segments (All Except V2500-A1)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 600, 610, 620, 630 and 640
Figure 12



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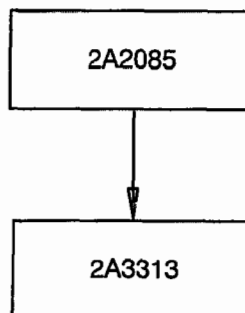
MODIFICATIONS

BASE LINE

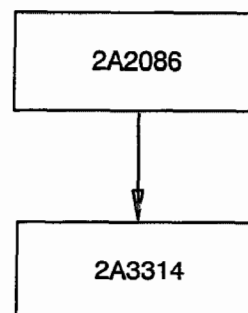
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 650)



(Fig. 1 Item 660)



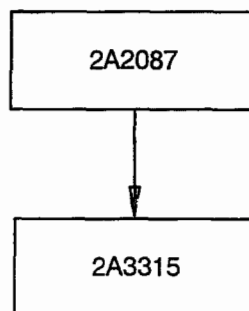
MODIFICATIONS

BASE LINE

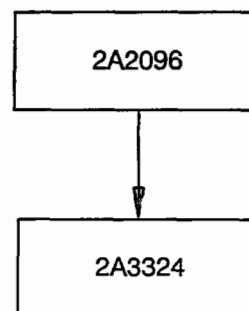
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 670)



(Fig. 1 Item 680)



E7983

Family Tree - Outer Combustion Chamber Liner Segments (All Except V2500-A1)
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Items 650, 660, 670 and 680
Figure 13

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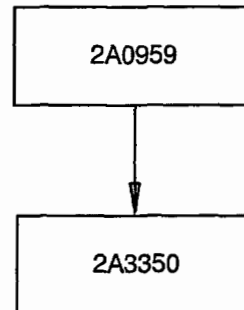
MODIFICATIONS

PART NUMBER CHANGE (V2500--A1)

(Fig. 1 Item 690)

BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

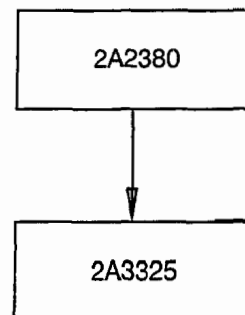


MODIFICATIONS

PART NUMBER CHANGE (ALL EXCEPT V2500-A1) (Fig. 1 Item 690)

BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING



E7987

Family Tree - Outer Combustion Chamber Fuel Nozzle Guide
Ref. Catalog Sequence No. 72-42-61. Fig. 1 Item 690
Figure 14



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

PART NUMBER CHANGE

BASE LINE

V2500-ENG-72-0006
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - THERMAL BARRIER COATING
FOR COMBUSTION LINERS

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BAR-
RIER COATING ON INNER AND OUTER
COMBUSTION CHAMBER LINERS

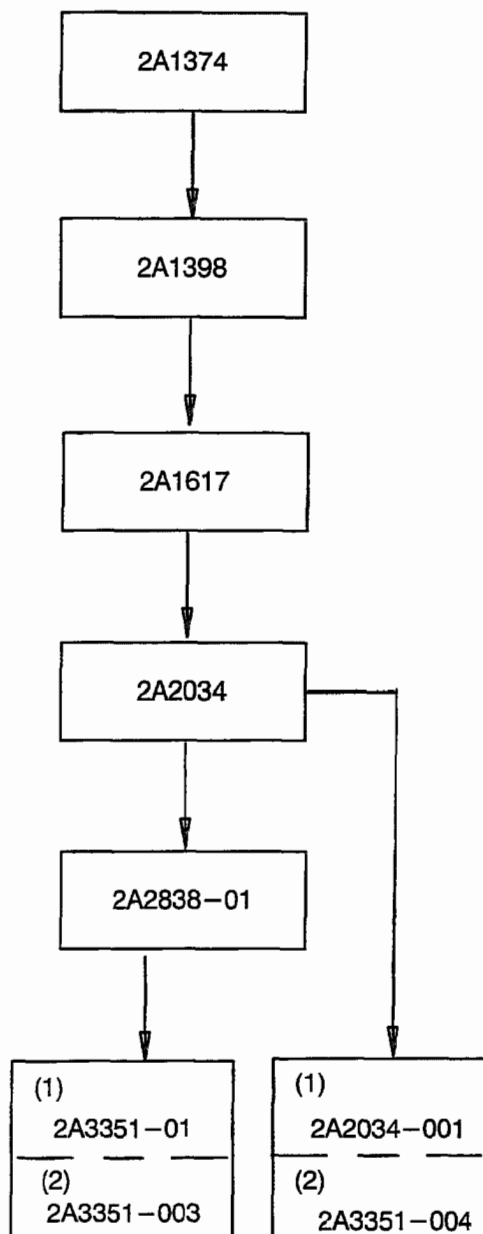
V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES WITH GENERATION II LINER
ASSEMBLIES

V2500-ENG-70-0253
INFORMATION - ENGINE - DIFFUSER AND
COMBUSTION SECTION - PROVIDE NEW
INNER AND OUTER COMBUSTION
CHAMBERS WITH INCREASED HARDFACE
THICKNESS AND RELOCATED COOLING
HOLES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

(1) ROW 5 IS REPLACED

(2) ROW 5 IS NOT REPLACED



E7988B

Family Tree - Inner Combustion Chamber Liner Assembly (V2500-A1)
Ref. Catalog Sequence No. 72-44-30. Fig. 1 Item 420
Figure 15 (Sheet 1 of 2)

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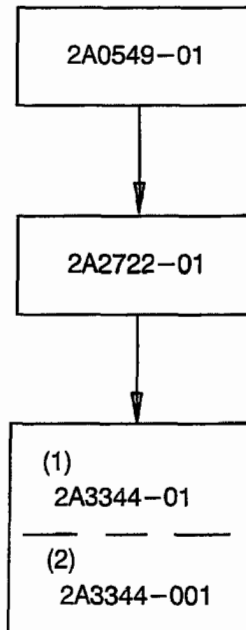
MODIFICATIONS

PART NUMBER CHANGE

BASE LINE

V2500-ENG-72-0159
ENGINE - DIFFUSER AND COMBUSTION
SECTION - INTRODUCE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES

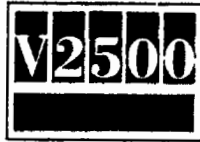
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL



- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

E7989A

Family Tree - Inner Combustion Chamber Liner Assembly (All Except V2500-A1)
Ref. Catalog Sequence No. 72-44-30. Fig. 1 Item 420
Figure 16



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

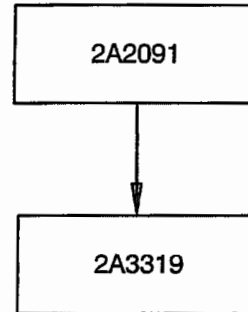
BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING
NOTE: ROW 5 REPLACEMENT IS OPTIONAL

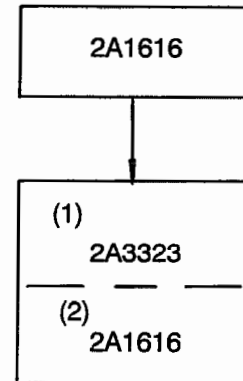
- (1) ROW 5 IS REPLACED
- (2) ROW 5 IS NOT REPLACED

PART NUMBER CHANGE

(Fig. 1 Item 540)



(Fig. 1 Item 560)



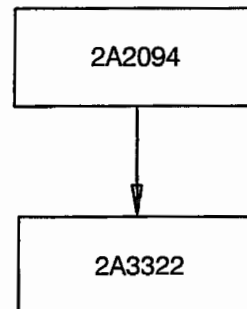
MODIFICATIONS

BASE LINE

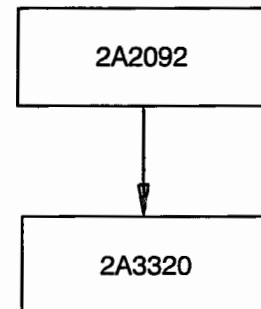
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 580)



(Fig. 1 Item 620)



E7990A

Family Tree - Inner Combustion Chamber Liner Segments
Ref. Catalog Sequence No. 72-44-30. Fig. 1 Items 540, 560, 580 and 620
Figure 17



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

PART NUMBER CHANGE

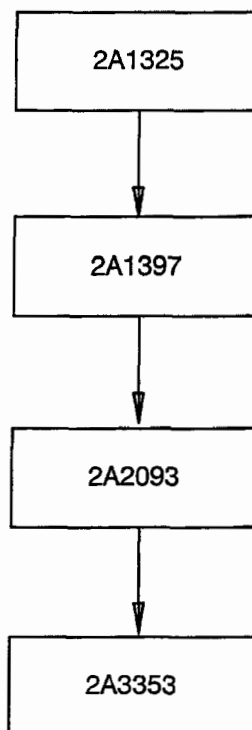
BASE LINE

V2500-ENG-72-0006
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - THERMAL BARRIER COATING
FOR COMBUSTION LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES WITH GENERATION II LINER
ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

(Fig. 1 Item 600)



Printed in Great Britain

E7991

Family Tree - Inner Combustion Chamber Liner Segments (V2500-A1)
Ref. Catalog Sequence No. 72-44-30. Fig. 1 Item 600
Figure 18



International Aero Engines SERVICE BULLETIN

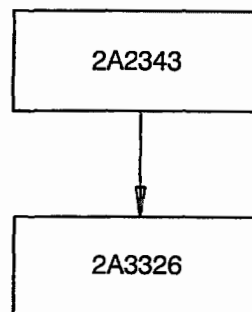
MODIFICATIONS

BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION GROUP
AND STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF PWA 281
COATING

PART NUMBER CHANGE

(Fig. 1 Item 600)



E7992

Family Tree - Inner Combustion Chamber Liner Segments (All Except V2500-A1)
Ref. Catalog Sequence No. 72-44-30. Fig. 1 Item 600
Figure 19

