

International Aero Engines
SERVICE BULLETIN

Oct 1/99

Subject: Transmittal of Revision 2 to Service Bulletin V2500-ENG-72-0320.

Service Bulletin Revision History:

Event	Date
Initial Issue	July 31/98.
Revision 1	Jan. 15/99.
Revision 2	Oct 1/99.

Reason for Revision:

(1) Change to Effectivity, Incorporation Amendment.

Effect on Past Compliance:

None.

List of Effective Pages:

Page No.	Revision No.	Effective Date
1 and 2	Revision 2	Oct. 1/99
3 to 8	Revision 1	Jan. 15/99.

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Transmittal
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ENGINE - HP COMPRESSOR STATOR VANES - INTRODUCTION OF REVISED STAGE-6, 7 AND 10
STATOR VANES WITH CHORDAL MACHINING OF REAR PLATFORM LOCATION FEATURES

MODEL APPLICATION

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

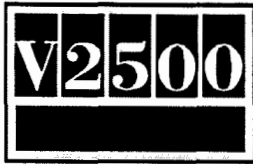
Internal Reference No.

EC98VR008

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ENGINE - HP COMPRESSOR STATOR VANES - INTRODUCTION OF REVISED STAGE-6, 7 AND 10
STATOR VANES WITH CHORDAL MACHINING OF REAR PLATFORM LOCATION FEATURES

1. Planning Information

A. Effectivity

(1) Aircraft:

(a) Airbus A319.

(b) Airbus A320.

(c) Airbus A321.

(d) Boeing-Douglas Product Division MD-90.

(2) Engines:

- R (a) V2522-A5 Engines prior to Serial No. V10600.
- R (b) V2524-A5 Engines prior to Serial No. V10600.
- R (c) V2527-A5 Engines prior to Serial No. V10600.
- R (d) V2527E-A5 Engines prior to Serial No. V10600.
- R (e) V2530-A5 Engines prior to Serial No. V10600.
- R (f) V2533-A5 Engines prior to Serial No. V10600.
- R (g) V2525-D5 Engines prior to Serial No. V20286.
- R (h) V2528-D5 Engines prior to Serial No. V20286.

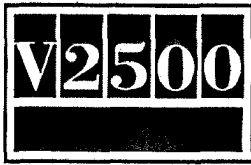
B. Concurrent Requirements

None.

C. Reason

(1) Problem

A design review has shown that the Stage-6, 7 and 10 stator vanes of the HP Compressor, can be manufactured easier.



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(2) Evidence

Refer to (1).

(3) Substantiation

A satisfactory engineering analysis has been done on the changes introduced by this Service Bulletin.

(4) Objective

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

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Affected.

(d) Repair Schemes

Not affected.

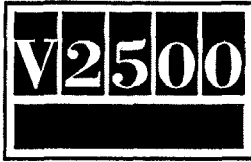
(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

R



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D. Description

- (1) The Stage-6, 7 and 10 stator vanes of the HP Compressor have been revised, the changes are as follows:
 - (a) The rear-platform location features are machined in a chordal direction and not a circumferential direction.

E. Compliance

Category Code 7.

R Accomplish when there are no supersede parts remaining.

F. Approval

The part number changes and/or part modifications are given in Section 2 and 3 of this Service Bulletin. They comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

R G. Manpower

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

- | | |
|-----------------|---|
| (1) In Service | Not applicable |
| (2) At Overhaul | No additional time is necessary to embody this Service Bulletin |

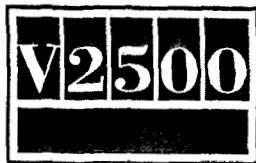
NOTE: It is possible to get access to the parts affected by this Service Bulletin at overhaul.

H. Material - Price and Availability

- (1) A modification kit is not necessary.
- (2) Refer to Section 3. Material Information for the prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not necessary.



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J. Weight and Balance

(1) Weight Change

Not affected.

(2) Moment Arm

Not affected.

(3) Datum

Engine front mount centreline (Power Plant Station (PPS) 100)

K. Electrical Load Data

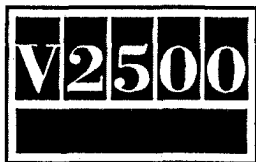
This Service Bulletin does not affect the aircraft electrical load.

L. References

- R (1) A5/D5 Engine Manual (EM), Chapter/Section 72-41-20 (Stage-7 and 10) and 72-41-30 (Stage-6)
R Disassembly/Assembly (CONFIG-01 A5).

M. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC), Chapter/Section 72-41-22.
R (2) A5/D5 Engine Manual (EM), Chapter/Section 72-41-22, Cleaning and Inspection/Check.



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R 2. Material Information

A. Kits necessary for this Service Bulletin:

None.

B. Parts affected by this Service Bulletin:

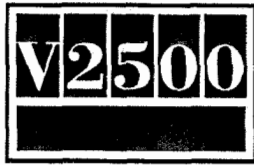
NEW PART NUMBER	QTY	EST'D UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
6A7424 (72-41-22)	4	354.00	.Vane, stage 6 - Stop, HP Compressor	6A4231 (01-350)	(A) (B) (S1)
6A7423C01 (72-41-22)	60	354.00	.Vane, stage 6 - Nominal, HP Compressor	6A4230C01 (01-400)	(A) (B) (S1)
6A7423C01 (72-41-22)	20	354.00	.Vane, stage 6 - Nominal, HP Compressor	6A4230C01 (01-448)	(A) (B) (S1)
6A7423C02 (72-41-22)	20	354.00	.Vane, stage 6 - U/Size, HP Compressor	6A4230C02 (01-450)	(A) (B) (S1)
6A7426 (72-41-22)	4	354.00	.Vane, stage 7 - LH stop, HP Compressor	6A4215 (02-150)	(A) (B) (S1)
6A7427 (72-41-22)	4	354.00	.Vane, stage 7 - RH stop, HP Compressor	6A4216 (02-350)	(A) (B) (S1)
6A7425C01 (72-41-22)	56	354.00	.Vane, stage 7 - Nominal, HP Compressor	6A4213C01 (02-400)	(A) (B) (S1)
6A7425C01 (72-41-22)	24	354.00	.Vane, stage 7 - Nominal, HP Compressor	6A4213C01 (02-448)	(A) (B) (S1)
6A7425C02 (72-41-22)	24	354.00	.Vane, stage 7 - U/Size, HP Compressor	6A4213C02 (02-450)	(A) (B) (S1)
6A7429 (72-41-22)	4	330.00	.Vane, stage 10 - RH stop, HP Compressor	6A4224 (05-350)	(A) (B) (S1)

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NEW PART NUMBER	QTY	EST'D UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
6A7430 (72-41-22)	4	330.00	.Vane, stage 10 - LH stop, HP Compressor	6A4225 (05-355)	(A) (B) (S1)
6A7428C01 (72-41-22)	60	330.00	.Vane, stage 10 - Nominal, HP Compressor	6A4223C01 (05-400)	(A) (B) (S1)
6A7428C01 (72-41-22)	32	330.00	.Vane, stage 10 - Nominal, HP Compressor	6A4223C01 (05-448)	(A) (B) (S1)
6A7428C02 (72-41-22)	32	330.00	.Vane, stage 10 - U/Size, HP Compressor	6A4223C02 (05-450)	(A) (B) (S1)

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

R

C. Instruction Disposition Codes:

- (1) (A) New part will be available from November 1998.
- (2) (B) Old part will be discontinued.
- (3) (S1) Old and new parts are freely and fully interchangeable.



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R 3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

- R (1) For the correct removal/installation procedures, refer to the A5/D5 Engine Manual (EM),
R Chapter/Section 72-41-20 (Stage-7 and 10) and 72-41-30 (Stage-6), Disassembly/Assembly
R (CONFIG-01 A5).

C. Recording Instructions

A record of accomplishment is necessary.