

International Aero Engines

SERVICE BULLETIN

ENGINE - ACTUATING MECHANISM - HP COMPRESSOR VARIABLE VANES - INTRODUCTION
OF REVISED HP COMPRESSOR STAGE 5 VSV ACTUATOR RING LEVERS WITH INCREASED
BLEND RADIUS

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.

EC98VR027

Dec. 15/99

V2500-ENG-72-0335

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**ENGINE - ACTUATING MECHANISM - HP COMPRESSOR VARIABLE VANES - INTRODUCTION
OF REVISED HP COMPRESSOR STAGE 5 VSV ACTUATOR RING LEVERS WITH INCREASED
BLEND RADIUS**

1. Planning Information

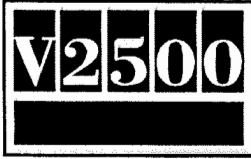
A. Effectivity

(1) Aircraft:

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

(2) Engines:

- (a) V2500-A1 Engines prior to Engine Serial No. V0362.
- (b) V2522-A5 Engines prior to Engine Serial No. V10651.
- (c) V2524-A5 Engines prior to Engine Serial No. V10651.
- (d) V2527-A5 Engines prior to Engine Serial No. V10651.
- (e) V2527E-A5 Engines prior to Engine Serial No. V10651.
- (f) V2530-A5 Engines prior to Engine Serial No. V10651.
- (g) V2533-A5 Engines prior to Engine Serial No. V10651.
- (h) V2525-D5 Engines prior to Engine Serial No. V20286.
- (i) V2528-D5 Engines prior to Engine Serial No. V20286.



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B. Concurrent Requirements

None.

C. Reason

(1) Problem

After in service problems with the lever assemblies of the Stage-3 and 4 Variable Stator Vane (VSV), a review of the VSV system was carried out. This concluded that all stages of lever assembly should be modified to maintain VSV system integrity.

(2) Evidence

Refer to C. (1).

(3) Objective

The purpose of this Service Bulletin is to maintain reliability.

(4) Substantiation

A satisfactory engineering analysis and a successful introduction of a similar modification for the Stage-3 VSV have been done on the changes introduced by this Service Bulletin.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

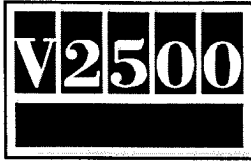
Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Not affected.



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(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

- (1) The actuator-ring lever arm assemblies of the Stage 5 VSV have been revised, the changes are as follows:

- (a) The blend radius on the lever arm is increased from 1,20 mm (plus or minus 0,30mm) to 5,00 mm (plus or minus 0,30mm).

E. Compliance

Category Code 7.

Accomplish when there are no superseded parts remaining.

F. Approval

The part number changes and/or part modification 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 models listed.

G. Manpower

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

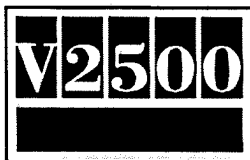
- (1) In Service

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.



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H. Material - Price and Availability

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

I. Tooling - Price and Availability

Special tools are not necessary.

J. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No effect.

(3) Datum

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

K. Electrical Load Data

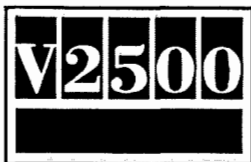
The aircraft electrical load is not affected by this Service Bulletin.

L. References

- (1) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-00, Disassembly/Assembly-02.
- (2) Airbus aircraft modification No. 21820/P6419

M. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC), Chapter/Section 72-41-34.
- (2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-34, Cleaning, Inspection/Check and Repair.



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2. Material Information

A. Kits necessary for this Service Bulletin:

None.

B. Parts affected by this Service Bulletin:

NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
6A7464 (72-41-34)	52	153.00	.Lever Assy, VSV - HP Compressor, Stage 5	6A3324 (05-100)	(A)(S1)
6A7465 (72-41-34)	8	153.00	.Lever Assy, VSV Bridge - HP Compressor, Stage 5	6A4346 (05-120)	(A)(S1)
6A7466 (72-41-34)	4	153.00	.Lever Assy, VSV Bridge Short - HP Compressor, Stage 5	6A4347 (05-140)	(A)(S1)

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

C. Instruction Disposition Codes:

- (1) (A) New part will be available from December 1999.
- (2) (S1) Old and new parts are freely and fully interchangeable.



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3. Accomplish Instructions

A. Rework Instructions

None.

B. Assembly Instructions

For the correct removal/installation procedures refer to the A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-00, Disassembly/Assembly-02.

C. Recording Instructions

- (1) A record of accomplishment is necessary.