

International Aero Engines
SERVICE BULLETIN

Sept.30/99

Subject: Transmittal of Revision 1 to Service Bulletin V2500-ENG-72-0337.

Service Bulletin Revision History:

Event	Date
Basic Issue	Dec. 18/98.
Revision 1	Sept. 30/99.

Reason for Revision:

(1) To add Incorporation Amendment.

Effect on Past Compliance:

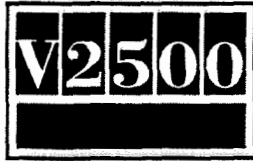
None.

List of Effective Pages:

Page No.	Revision No.	Effective Date
1 and 2	Revision 1	Sept.30/99.
3 to 8	Basic Issue	Dec. 18/98

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Transmittal
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ENGINE - HP COMPRESSOR SPLIT CASES - INTRODUCTION OF REVISED STAGE-5 AND 6
BOROSCOPE BLANKING PLUG WITH INCREASED STEM DIAMETER

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

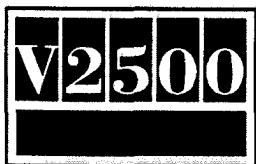
Internal Reference No.

EC98VR023

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**ENGINE - HP COMPRESSOR SPLIT CASES - INTRODUCTION OF REVISED STAGE-5 AND 6
BOROSCOPE BLANKING PLUG WITH INCREASED STEM DIAMETER**

1. Planning Information

A. Effectivity

(1) Aircraft:

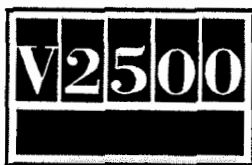
- (a) Airbus A319.
- (b) Airbus A320.
- (c) Airbus A321.
- (d) Boeing - Douglas MD-90.

(2) Engines:

- (a) V2500-A1 Engines prior to Serial No. V0362.
- R (b) V2522-A5 Engines prior to Serial No. V10572.
- R (c) V2524-A5 Engines prior to Serial No. V10572.
- R (d) V2527-A5 Engines prior to Serial No. V10572.
- R (e) V2527E-A5 Engines prior to Serial No. V10572.
- R (f) V2530-A5 Engines prior to Serial No. V10572.
- R (g) V2533-A5 Engines prior to Serial No. V10572.
- R (h) V2525-D5 Engines prior to Serial No. V20286.
- R (i) V2528-D5 Engines prior to Serial No. V20286.

B. Concurrent Requirements

None.



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C. Reason

(1) Problem

IAE Service Bulletin ENG 72-0317 introduced a temporary rework solution to prevent the premature deterioration of the Stage-5 and 6 boroscope blanking-plugs of the HP Compressor.

A subsequent review has shown that the design of the Stage-5 and boroscope blanking-plugs can be improved.

(2) Evidence

The problem was found after pass-off tests of production engines.

(3) Substantiation

An extensive engineering assessment has been done on the changes introduced by this Service Bulletin.

(4) Objective

The purpose of this Service Bulletin is to maintain reliability.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

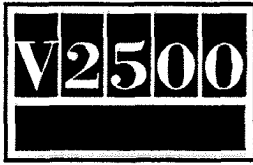
Not affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.



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(f) Fits and Clearances

Not affected.

D. Description

A1 Model

- (1) The HP Compressor Stage-5 and 6 boroscope blanking plugs are a two-piece design which consists of a stem and a locating plate. The changes introduced by this Service Bulletin affect the stem only. The changes are as follows:
 - (a) The diameter of the stem is increased from 3,0 mm to 5,8 mm nominally.
 - (b) The base of the penny is machined flat.

A5 and D5 Models

- (1) The HP Compressor Stage-5 and 6 boroscope blanking plugs are a single-piece design that consists of an integral stem and locating plate. The changes introduced by this Service Bulletin are as follows:
 - (a) The diameter of the stem is increased from 3,0 mm to 5,8 mm nominally.
 - (b) The base of the penny is machined flat.
 - (c) The radius between the stem and plate is decreased.

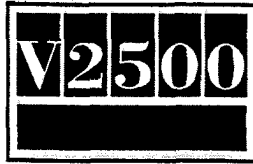
E. Compliance

Category Code 7.

Accomplish when there are no superseded 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 models listed.



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G. Manpower

Estimate of manhours 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 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

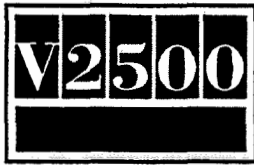
Not affected.

- (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.



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L. References

(1) IAE V2500 Service Bulletins:

- | | |
|-------------|--|
| ENG 72-0027 | HP COMPRESSOR FRONT CASE STAGE-5 BOROSCOPE ACCESS REPOSITIONED. |
| ENG 72-0317 | ENGINE - HP COMPRESSOR SPLIT CASES - INTRODUCTION OF REVISED STAGE-5 AND 6 BOROSCOPE BLANKING PLUGS WITH ADDITIONAL ATTACHING BOLT |

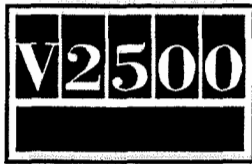
(2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-30, Disassembly and Assembly.

(3) A319/A320/A321 Aircraft Maintenance Manual (AMM), Chapter/Section 72-00-00, Removal/Installation.

M. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC) Chapter/Section 72-41-31.

(2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-31, 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
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A1 Models that embody 88VR125 only

6A7456 (72-41-31)	1	274.00	.Plug, blanking - Stage-5 and 6 boroscope	6A3986 (01-135)	(A)(S1)
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A5 and D5 Models

6A7454 (72-41-31)	1	274.00	.Plug, blanking - Stage-5 and 6 boroscope	6A7422 (01-140)	(A)(S1)
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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 Catalogue or contact IAE's spare parts sales department.

C. Instruction Disposition Codes:

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



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3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

(1) For the correct removal/installation procedures, refer to the manuals that follow:

(a) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-30, Disassembly and Assembly.

or

(b) A319/A320/A321 Aircraft Maintenance Manual (AMM), Chapter/Section 72-00-00, Removal/Installation.

C. Recording Instructions

A record of accomplishment is necessary.