

# P U B L I C A T I O N   T R A N S M I T T A L

## RR-DERBY



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DATE: Feb.19/01

### V2500-A1 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 2 to Service Bulletin V2500-ENG-72-0353

#### Document History

Service Bulletin Revision Status

Supplement Revision Status

Initial Issue

Revision 1

Revision 2

#### Bulletin Revision 2

Remove  
All pages

Incorporate  
Page 1 to 7 of the  
Service Bulletin

Reason for change  
To revise correct new part number  
and editorial changes.

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CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED  
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## LIST OF EFFECTIVE PAGES

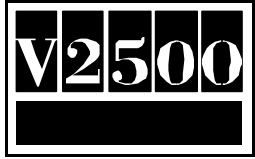
The effective pages to this Service Bulletin are as follows:

<u>Page</u>	<u>Revision Number</u>	<u>Revision Date</u>
Bulletin		
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## SERVICE BULLETIN

### MODIFICATION SERVICE BULLETIN - ENGINE - LP COMPRESSOR - INTRODUCTION OF REVISED RETAINING SPIRAL RING

#### 1. Planning Information

##### A. Effectivity

(1) Airbus A320

(a) V2500-A1 Prior to Serial Number V0362 Engines.

(2) ATA Locator

72-32-00

##### B. Concurrent Requirements

None

##### C. Reason

(1) Problem

The retaining spiral ring is not easy to remove. The surface damage of the retaining ring is caused by the removal steps of the retaining spiral ring from the FBC rear air seal assembly.

(2) Evidence

The problem has been found on in-service engines.

(3) Objective

The purpose of this Service Bulletin is to improve maintainability.

(4) Substantiation

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

(5) Effect of Bulletin on:

(a) Removal/Installation

Not affected.

(b) Disassembly/Assembly

Not affected.

(c) Cleaning

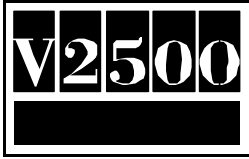
Not affected.

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(d) Inspection/Check

Not affected.

(e) Repair Schemes

Not affected.

(f) Testing

Not affected.

D. Supplemental Information

None

E. Description

(1) The change introduced by this Service Bulletin are as follows:

(a) The retaining spiral ring (P/N: 5R0268) of the FBC rear air seal have changed as follows:

(i) To add the holes at the ends of ring.

(ii) To decrease free gap the shape of the ends of ring has changed.

(iii) The scallops are deleted.

(iv) The dry film lubricant coating is added.

(b) The retaining spiral ring (P/N 5R0056) of the FBC rear air seal have changed as follows:

(i) To add the holes at the ends of ring.

(c) The old retaining spiral ring can be reworked (Refer to Figure 2).

F. Compliance

Category Code 6.

This Service Bulletin can be accomplished when the subassembly (That is modules, accessories, components, build groups) is disassembled sufficiently to get access to all affected parts.

G. Approval

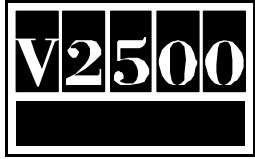
The part number changes and/or part modification are given in Section 2 and 3 of this Service Bulletin. They comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine models listed.

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### H. 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 modification.

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

### I. Weight and Balance

(1) Weight Change

None

(2) Moment Arm

No affect

(3) Datum

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

### J. Electrical Load Data

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

### K. Software Accomplishment Summary

Not applicable.

### L. References

(1) Internal Reference 99VJ004

(2) Engine Manual, 72-32-00, Disassembly and Assembly

### M. Other Publications Affected

(1) V2500 Engine Illustrated Parts Catalogue (S-V2500-1IA), 72-32-35 will be revised.

(2) V2500 Engine Manual, 72-32-35, Cleaning 01 and Inspection 01.

### N. Interchangeability of Parts

Not affected

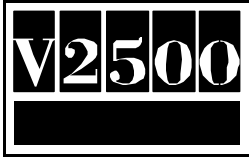
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### 2. Material Information

#### A. Material - Price and availability

The prices as shown are for estimated purposes only and as such are given in good faith without commercial liability for advanced planning purposes only. Refer to IAE Spares and/or current Price Catalog for current prices.

##### (1) Modification kit

- (a) Modification kits not required. Parts supplied as single line items.

##### (2) Parts affected by this Bulletin:

Part No.	Qty	Unit Price
5R0287	1	180.0

Applicability: For each V2500 engines to incorporate this Bulletin:

##### A1 Models

NEW PART NO. (ATA No.)	QTY	PART TITLE OLD	INSTR PART No. (IPC No.)	DISP
5R0287 (72-32-35)	1	.Ring retaining, spiral	5R0268 (01-090)	(A)(B)(1D) (S1)
5R0287 (72-32-35)	1	.Ring retaining, spiral	5R0056 (01-090)	(A)(B)(1D) (S1)

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#### B. Instruction Disposition Codes

- (1) (A) New part will be available for future releases.
- (2) (B) Old part will be discontinued.
- (3) (1D) Old part can be reworked and re-identified to the new part number.
- (4) (S1) New parts can replace old part, but old parts cannot replace new part.

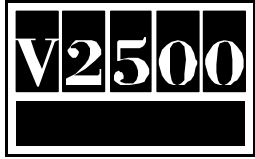
#### C. Tooling - Price and Availability

Refer to the Special tools given in the referenced Engine Manual TASK to accomplish this Service Bulletin. See Section 3. Accomplishment Instructions.

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### 3. Accomplishment Instructions

#### A. Rework Instructions

- (1) Rework the retaining spiral ring as follows (Refer to Figure 2):
  - (a) Cut the edges with standard work shop equipment take care not to damage the other surface, (if necessary, P/N 5R0268 only).
  - (b) Drill the holes in the areas shown with the drilling machine and standard work shop equipment.
  - (c) Remove any sharp edges with standard work shop equipment.
  - (d) Do a local penetrant crack test on the rework area with CoMat 06-022 fluorescent penetrant and penetrant inspection equipment, refer to SPM TASK 70-23-05-230-501.
  - (e) Visually examine and measure the dimensions of the reworked areas.
  - (f) Delete current part number (P/N 5R0056 or 5R0268) with a single line and renumber with new part number (P/N 5R0287) adjacent to existing part number by vibrating marking pencil.
  - (g) Apply the dry film lubricant with CoMat 10-005 colloidal molybdenum disulphide in toluene, refer to SPM TASK 70-38-03-380-501.

#### B. Recording Instructions

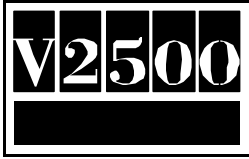
A record of accomplishment is required.

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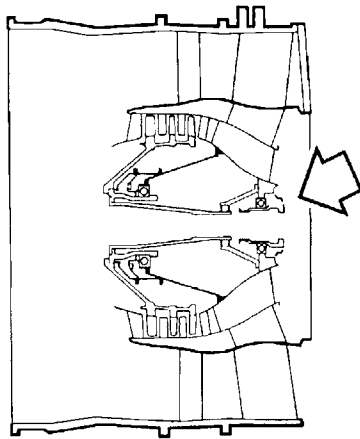
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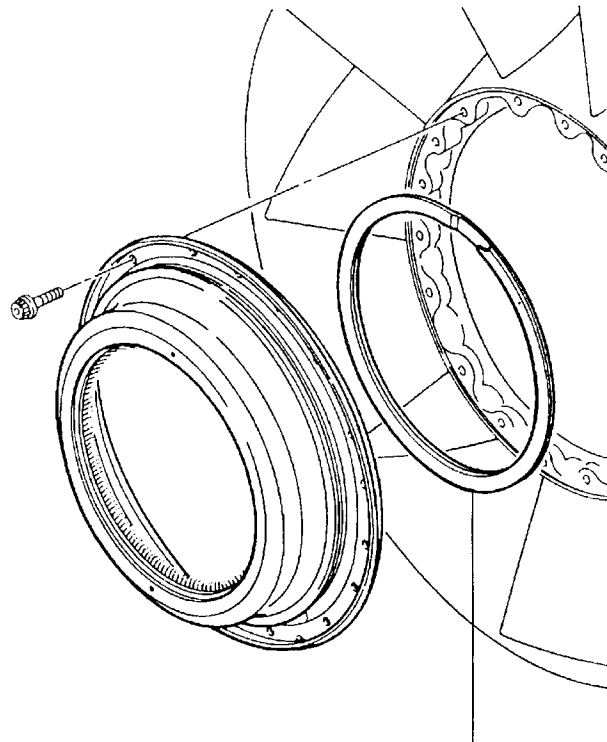


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## SERVICE BULLETIN



MODULE 32



INSTALL THE 5R0287 RETAINING  
SPIRAL RING(1 off)

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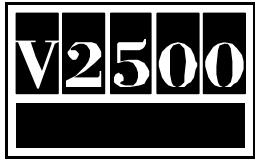
Location of the Retaining Spiral Ring  
Figure 1

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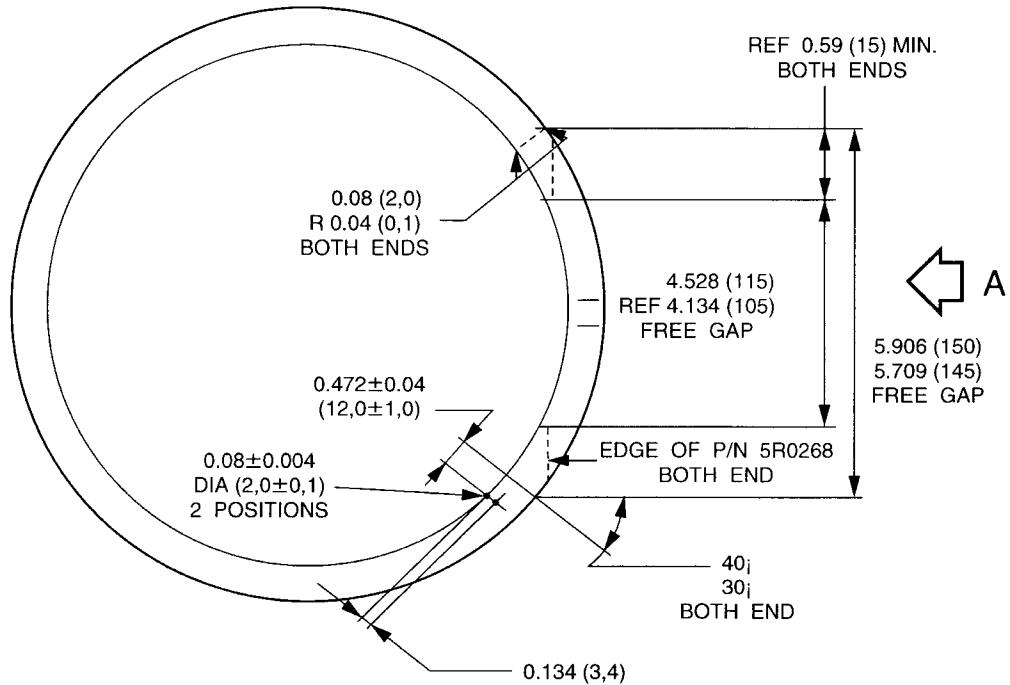




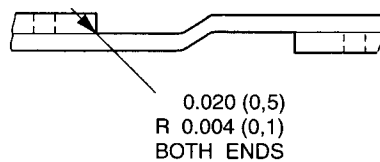
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UNLESS OTHERWISE SPECIFIED:  
 DIMENSIONS ARE IN INCHES (MILLIMETERS).  
 TOLERANCE ON DIMENSIONS ± 0.010 (0,25)  
 BREAK SHARP EDGES 0.004 (0,1) TO 0.02 (0,5)  
 AFTER REWORKING.



A

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View of rework of the Retaining Spiral Ring  
 Figure 2

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