



Date: May 12/00

Subject: Transmittal of Revision 1 To Service Bulletin Number
V25000-ENG-72-0364.

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Feb.23/00
Revision 1	May 12/00

Reason For Issuance Of Revision:

- (1) Incorporate intent of EC 98VC016N.
- (2) Delete Concurrence Requirements.
- (3) To Add dimensions to Illustrations.
- (4) Editorial corrections.
- (5) To Update Material Information.
- (6) To Update Family Trees.

Effect on Prior Compliance:

None.

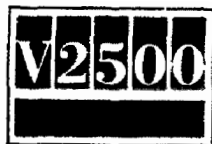
List of Effective Pages:

<u>Bulletin Page No.</u>	<u>Rev. No.</u>	<u>Effective Date</u>
1 to 19	1	May 12/00

V2500-ENG-72-0364

Transmittal

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International Aero Engines SERVICE BULLETIN

ENGINE - HIGH PRESSURE TURBINE - PROVIDE NEW STAGE 2 HIGH PRESSURE
TURBINE DUCT SEGMENTS

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

72-45-00

Compliance Category Code

Internal Reference No.

I 7

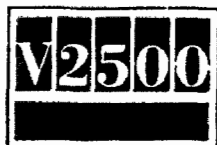
98VC016, 98VC016N

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SERVICE BULLETIN

ENGINE - HIGH PRESSURE TURBINE - PROVIDE NEW STAGE 2 HIGH PRESSURE
TURBINE DUCT SEGMENTS

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A319, A320, A321
McDonnell Douglas MD-90
- (2) Engine: V2500-A1 Engines Before Serial No. V0362.
V2522-A5 Engines Before Serial No. V10760, Except V10737, V10739,
V10741, V10743, V10745, V10751, V10755, V10757, and V10759.
V2524-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2527-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2527E-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2527M-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2530-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2533-A5 Engine Serial No. V10760, Except V10737, V10739, V10741,
V10743, V10745, V10751, V10755, V10757, and V10759.
V2525-D5 Engines before Serial No. V20284.
V2528-D5 Engines before Serial No. V20284.

B. Concurrent Requirements

None.

C. Reason

- (1) Condition:
Ceramic spalling of the second stage High Pressure Turbine (HPT)
Duct Segments can cause downstream damage.
- (2) Background:
There are potential causes for HPT Stage 2 Duct Segment ceramic
liberation. These include segment to segment contact, ceramic
damage incurred at assembly grind, excessive ceramic thickness.
Ceramic liberation has resulted in many instances of LPT airfoil
damage.
- (3) Objective:
Provide new second stage HPT Duct Segments incorporating a
decreased thickness of ceramic coating. The segments are also
decreased in size which requires increasing the quantity of
segments.

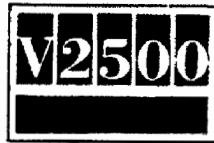
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Not subject to the EAR per 15 C.F.R. Chapter I, Part 734.3(b)(3).

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(4) Substantiation

This ceramic outer Air Seal design has been successfully demonstrated in the first stage of the V2500-A5/D5, as well as, other engine models.

(5) Effects of Bulletin on Workshop Procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Affected
Cleaning	Affected
Inspection/Check	Affected
Repair	Affected
Testing	Not affected

(6) Supplemental Information

None.

D. Description

- (1) Install new Stage 2 Duct Assemblies which incorporate the thinner ceramic Duct Segments.

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 7

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.



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I. Tooling - Price and Availability

The following tools are required to accomplish the Service Bulletin.

<u>Tool No.</u>	<u>Qty</u>	<u>Description</u>	<u>Function</u>	<u>Avail</u>
1P16466	1	Ring, Orientation - Case & Vane Assy, HPT 2nd Duct Assy.	Positions Case and Vane Assy.	(1)

(1) Indicates that tool design aperture card is current available from IAE.

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-70-0450 (Information - Engine - HP Turbine Rotor And Stator Assembly - To Announce The Availability Of A New Turbine Case And Vane Assembly)

V2500-ENG-72-0002 (Engine- Stage 1 Turbine Nozzle Assembly And HP Turbine Rotor And Stator Assembly - Incorporation Of Offset Supports)

V2500-ENG-72-0085 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 2 Duct Segments Incorporating Revised Coating Requirements)

V2500-ENG-72-0092 (Engine - HP Turbine - Provide A Turbine Case And Vane Assembly That Will Allow Individual First Stage Duct Replacement)

V2500-ENG-72-0108 (Engine - HP Turbine Rotor And Stator Assembly - Incorporate New Stage 1 Duct Segments With Improved Ceramic Coating)

V2500-ENG-72-0122 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 2 HPT Vane Assemblies, Stage 2 Air Sealing Ring Segment Assemblies And Stage 2 HPT Seals)

V2500-ENG-72-0236 (Engine - HP Turbine Rotor And Stator Assembly - Provide A New Orifice Plate With An Increased Opening Size)

V2500-ENG-72-0237 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 2 HPT Vanes)

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V2500-ENG-72-0310 (Engine - High Pressure Turbine - Provide New Stage 1 And 2 High Pressure Turbine Duct Segments)

V2500-ENG-72-0339 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 1 Hptp Duct Segments, Band Segments, Supports, Seals And Bolts)

V2500-ENG-72-0365 (Engine - Provide Pretrenched Second Stage HPT Air Sealing Ring Segments)

- (2) The V2500-A1 Engine Illustrated Parts Catalog (S-V2500-1IA), Chapter/Section 72-45-20, 72-45-25, 72-45-30 to add new part number.
- (3) The 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 72-45-20, 72-45-25, 72-45-30 to add new part number..
- (4) The V2500-D5 Engine Illustrated Parts Catalog (S-V2500-3IA, S-V2500-3IB), Chapter/Section 72-45-20, 72-45-25, 72-45-30 to add new part number..
- (5) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-20, Assembly-01.
- (6) The V2500-D5 Engine Engine Manual (E-V2500-3IA), Chapter/Section 72-45-20, Assembly-01.
- (7) The V2500 Standard Practices/Processes Manual (SPP-V2500-1IA), 70-09-00 Marking of Parts.

M. Other Publications Affected

- (1) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-25, Cleaning, to add the new part number.
- (2) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-25, Inspection, to add the new part number.
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-25, Repair, to add the new part number.
- (4) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-25, Cleaning, to add the new part number.
- (5) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-25, Inspection, to add the new part number.
- (6) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-25, Repair, to add the new part number.



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2. Accomplishment Instructions

A. Rework Instructions

- (1) Do a modification of the 2A1653 or 2A2270 Stage 2 HPT Support Assembly (1 off). See Reference (1), Chapter/Section 72-45-26, Figure/Item No. 01-020. See Figures X and Y.

Procedure

Supplementary Information

- | | | | | | | | |
|--|---|-----------------|------------------------|--------|--------|--------|--------|
| (a) Drill Hole. | Refer to Figure 2 (Sheet1) Section A-A | | | | | | |
| (b) Select (Class 1-4, P3, P5) Pin Part Number 2A1268 (1 off) to obtain a 0.0005T - 0.0015T (0.0.013T - 0.038T) Fit. | Refer to Figure 2 Sheet 2). | | | | | | |
| (c) Install the Pin Part Number 2A1268 (1 off) in the 2 HPT Support Assembly. | Refer to Figure 2 (Sheet2).
Note: 1 Pin is required for each Duct Segment | | | | | | |
| (d) Mark the new part number adjacent to the existing part number. Use the vibration peen method. | <table border="0"><tr><td style="text-align: center;"><u>Existing</u></td><td style="text-align: center;"><u>New Part Number</u></td></tr><tr><td style="text-align: center;">2A1653</td><td style="text-align: center;">2A3408</td></tr><tr><td style="text-align: center;">2A2270</td><td style="text-align: center;">2A3407</td></tr></table>
Use the procedure specified in Reference (6), Chapter/Section 70-09-00, Marking of Parts. See Figure Z. | <u>Existing</u> | <u>New Part Number</u> | 2A1653 | 2A3408 | 2A2270 | 2A3407 |
| <u>Existing</u> | <u>New Part Number</u> | | | | | | |
| 2A1653 | 2A3408 | | | | | | |
| 2A2270 | 2A3407 | | | | | | |

B. Installation Instructions

- (1) Assemble the following by the procedure specified in Reference (2) or (3), Chapter/Section 72-45-20 Assembly-01. See Figure 1.
- (a) Stage 2 High Pressure Turbine Duct Segments (38 off), 2A3392 (V2500-A1) or 2A3393 (V2500-A5/D5).
NOTE: This configuration requires 38 Duct Segments.
- (b) Seal (38 off) 2A3447.
NOTE: This configuration requires 38 Seals.
- (c) Support Assembly (19 off), 2A3407 (V2500-A1) or 2A3408 (V2500-A5/D5).
- (d) Band Segments 2A3411-01 (2 off) and 2A3413-01 (1 off) (V2500-A1) or 2A3412-01 (2 off) and 2A3414-01 (1 off) (V2500-A5/D5).
- (2) Do not do the grind procedure specified in Reference (2) or (3), Chapter/Section 72-45-20, Assembly-01. See the applicable subtask for the particular engine model.
- NOTE:** The new Stage 2 High Pressure Turbine Duct Segments are finish machined at manufacture eliminating, the need to machine (grind) at assembly.



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- (3) Identify the new Case and Vane Assembly by the procedure specified in Reference (6) Chapter/Section 70-09-00, Marking of Parts, and as follows:

<u>Old Part Number</u>	<u>New Part Number</u>
2A3468	2A3415
2A3469	2A3416
2A3304	2A3304-001
2A3364	2A3364-001
2A3415-002	2A3415-005
2A3415-003	2A3415-004

C. Recording Instructions

D. A record of accomplishment is necessary.

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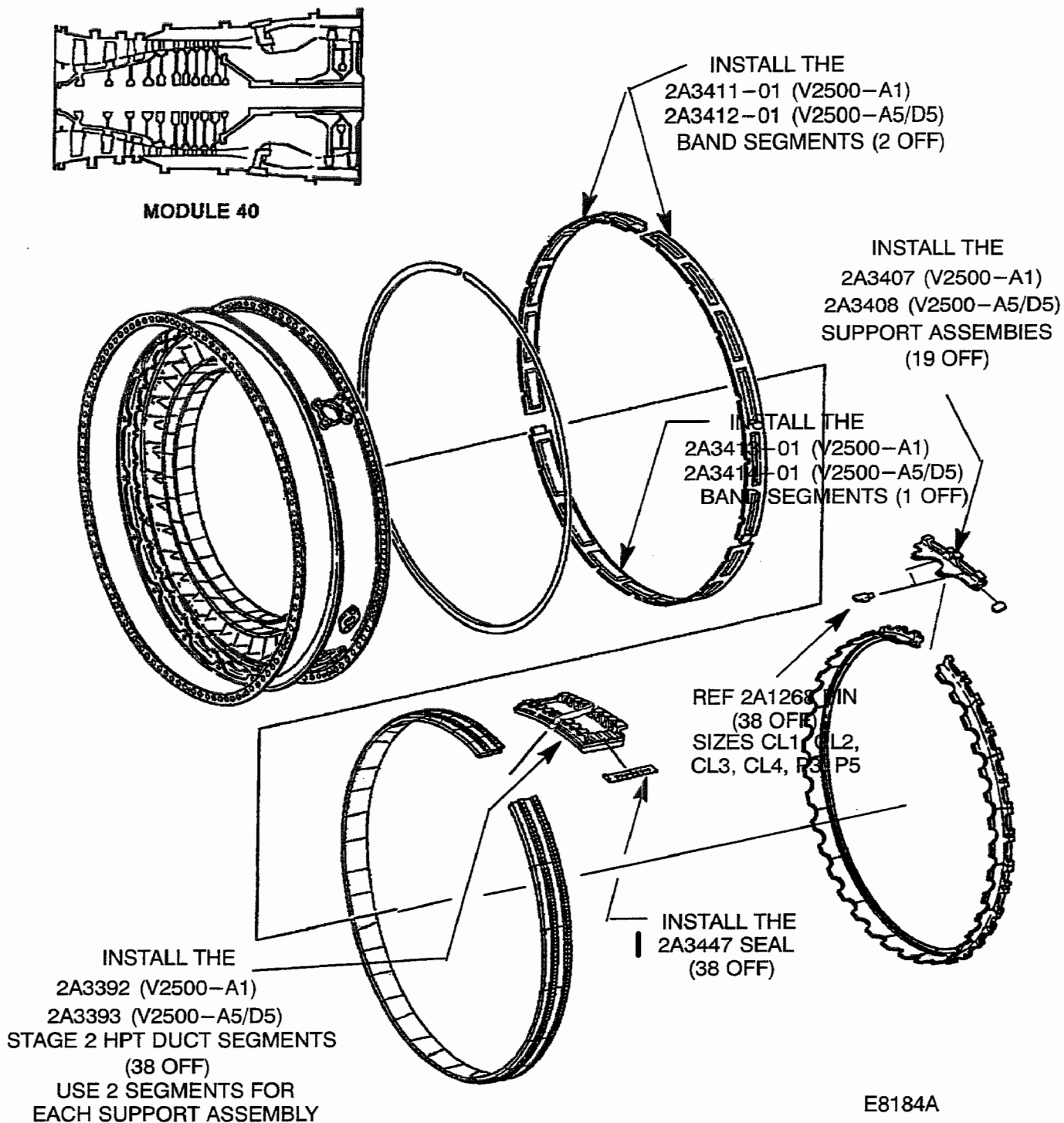
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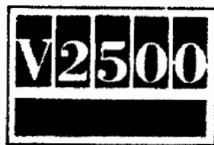


International Aero Engines SERVICE BULLETIN

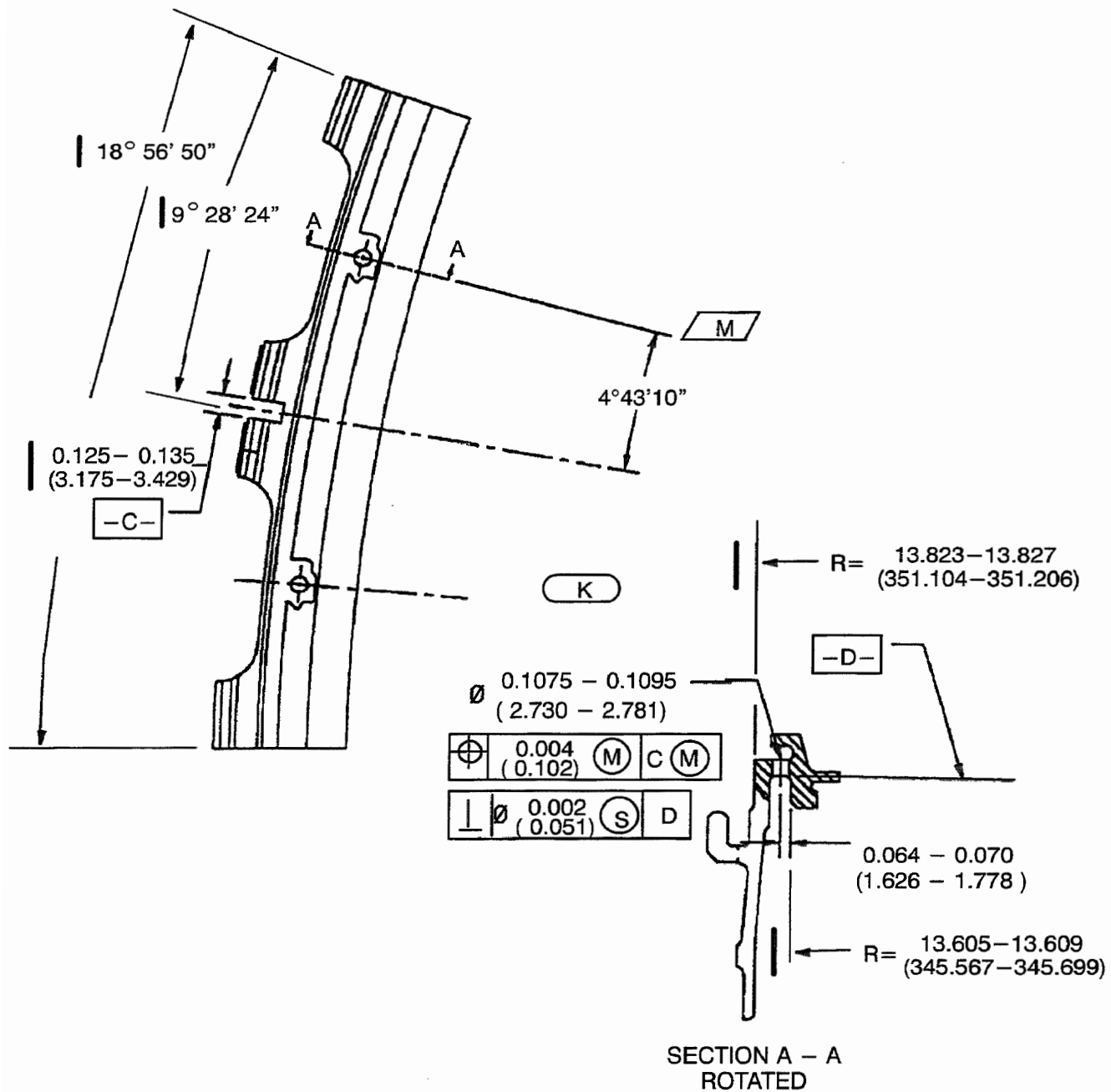
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Location of the Stage 2 High Pressure Turbine Duct Segments And Support
Figure 1



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K MAY BE FINISHED PRE SPEC PWA 97.3.

E8185A

Modification of the Stage 2 High Pressure Turbine Duct Assembly
Figure 2 (Sheet 1 of 2)

Feb.23/00

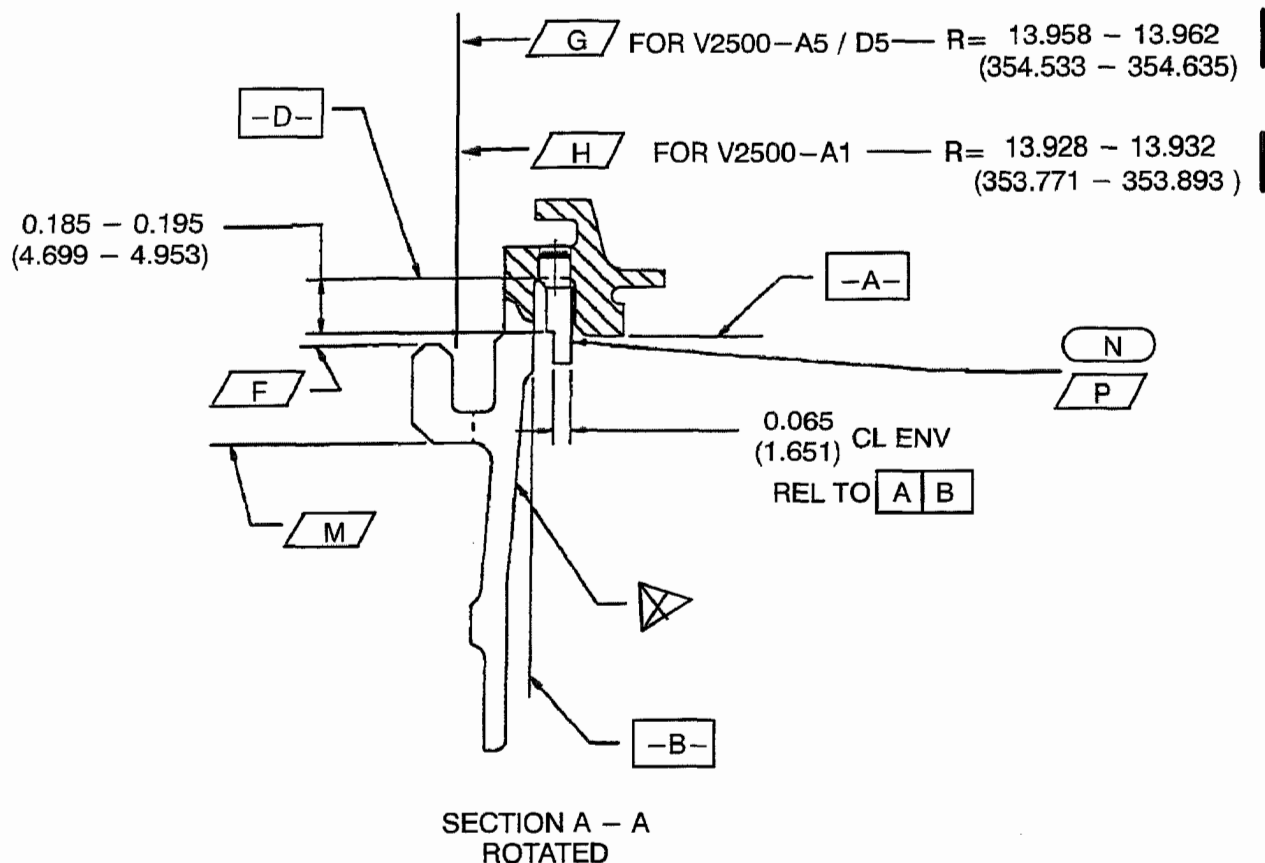
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UNLESS SPECIFIED DIFFERENTLY BREAK EDGES 0.003 – 0.015 (0.076 – 0.381).
SURFACE TEXTURE PER SPEC PWA 388, UNLESS SPECIFIED DIFFERENTLY ALL SURF ¹²⁵✓

✕ MARK IDENT PER SPEC PWA 310 , CLASS 40.

K MAY BE FINISHED PRE SPEC PWA 97.3.

UNLESS SPECIFIED DIFFERENTLY ALL DIM APPLY WHEN SURFACE **F** IS

	0.002 (0.051)
--	------------------

AND DIM **G** OR **H** IS WITHIN LIMITS SHOWN IN FREE
STATE OR CONSTRAINED. CONSTRAINT CONTACT ALLOWED
ONLY ON SURFACES **M**, **F** & RADIUS **H**.

N SELECT CLASS TO OBTAIN 0.0005T – 0.0015T (0.013T – 0.038T) FIT.

E8186A

Modification of the Stage 2 High Pressure Turbine Duct Assembly
Figure 2 (Sheet 2 of 2)

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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
------------------------------	-----	----------------------------	---------	------------------------------	-----------------------------

Applicability: For each V2500-A1 Engine to incorporate this Service Bulletin

2A3415 (72-45-20)	1		Case & Vane Assembly OR	2A3468 (01-005)	(S1)(B)(D)
2A3304-001 (72-45-20)	1		Case & Vane Assembly	2A3304 (01-005)	(S1)(B)(D)
2A3411-01 (72-45-25)	2		.Band Segment, HPT, 2 Stg, Assy Of	2A2271-01 (01-020)	(S1)(A)(E)
2A3413-01 (72-45-25)	1		.Band Segment, HPT, 2 Stg, Assy Of	2A2269-01 (01-040)	(S1)(A)(E)
(72-45-25)	19		.Duct Segment HPT, 2 Stg	2A3362 (01-060)	(S1)(E)
2A3392	38		.Duct Segment HPT, 2 Stg		(S1)(A)
(72-45-25)	19		.Seal-HPT Duct 2 Stg	2A0194 (01-080)	(S1)(S1)
2A3447	38		.Seal-HPT Duct 2 Stg		(S1)(A)
2A3407 (72-45-26)	19		.Support Assy HPT Duct	2A2270 (01-020)	(S1)(C)(E)
(72-45-26)	19		..Pin-Shoulder (Class 1-4, P3, P5)	2A1268 (01-042)	(S1)(F)
2A1268	38		..Pin-Shoulder (Class 1-4, P3, P5)		(S1)(A)

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New Part No. (ATA No.)	Qty	Est'd Unit Price(\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
------------------------------	-----	----------------------------	---------	------------------------------	-----------------------------

Applicability: For each V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525-D5, and V2528-D5 Engine to incorporate this Service Bulletin

2A3416 (72-45-20)	1		Case & Vane Assembly OR	2A3469 (01-005)	(S1)(B)(D)
2A3364-001 (72-45-20)	1		Case & Vane Assembly OR	2A3364 (01-005)	(S1)(B)(D)
2A3215-004 (72-45-20)	1		Case & Vane Assembly OR	2A3215-003 (01-005)	(S1)(B)(D)
2A3215-005 (72-45-20)	1		Case & Vane Assembly	2A3215-002 (01-005)	(S1)(B)(D)
2A3412-01 (72-45-25)	2		.Band Segment HPT, 2 Stg, Assy Of	2A1655-01 (01-020)	(S1)(A)(E)
2A3414-01 (72-45-25)	1		.Band Segment HPT, 2 Stg, Assy Of	2A1663-01 (01-040)	(S1)(A)(E)
(72-45-25)	19		.Duct Segment HPT, 2 Stg	2A3363 (01-060)	(S1)(E)
2A3393	38		.Duct Segment HPT, 2 Stg		(S1)(A)
(72-45-25)	19		.Seal-HPT Duct 2 Stg	2A2149 (01-080)	(S1)(E)
2A3447	38		.Seal-HPT Duct 2 Stg		(S1)(A)
2A3408 (72-45-26)	19		.Support Assy HPT Duct	2A1653 (01-020)	(S1)(A)(C)(E)
(72-45-26)	19		..Pin-Shoulder (Class 1-4, P3, P5)	2A1268 (01-042)	(S1)(F)
2A1268	38		..Pin-Shoulder (Class 1-4, P3, P5)		(S1)(A)

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C. Consumable Materials

Not applicable

D. Instructions/Disposition Code Statements:

(S1) New Parts coded (S1) must replace Old Parts coded (S1) in a COMPLETE SET per engine.

(A) The new part will be available approximately February 2000.

(B) The new part will be supplied on a quotation basis only.

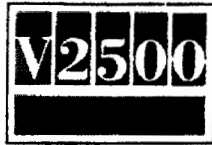
(C) The new part may also be obtained by rework.

(D) The old part is no longer available.

(E) The old part will continue to be supplied until supply is used up.

(F) The old part is being retained.

NOTE: The estimated unit prices, if 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

V2500-ENG-72-0002
ENGINE- STAGE 1 TURBINE
NOZZLE ASSEMBLY AND HP
TURBINE ROTOR AND STATOR
ASSEMBLY - INCORPORATION OF
OFFSET SUPPORTS

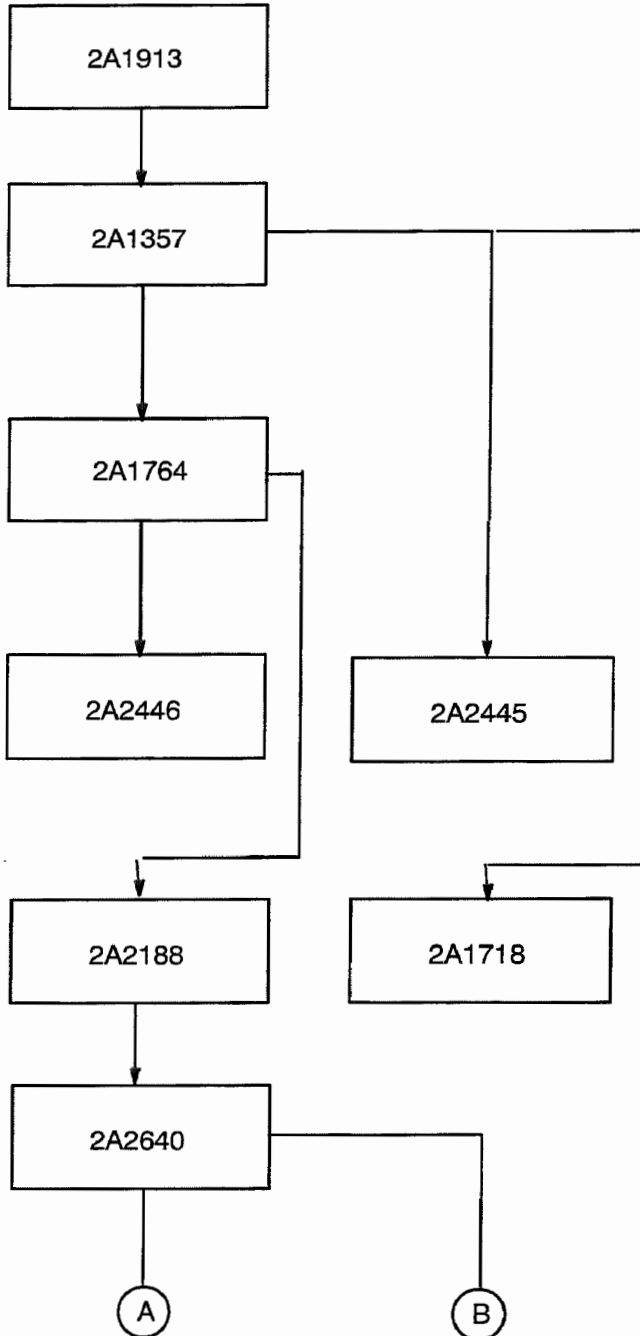
V2500-ENG-72-0092
ENGINE - HP TURBINE - PROVIDE
A TURBINE CASE AND VANE
ASSEMBLY THAT WILL ALLOW
INDIVIDUAL FIRST STAGE DUCT
REPLACEMENT

V2500-ENG-72-0122 PART 1
NEW STAGE 2 HPT AIR SEALING
RING SEGMENT ASSEMBLY AND
FEATHERSEALS

V2500-ENG-72-0122 PART 2
NEW STAGE 2 HPT AIR SEALING
RING SEGMENT ASSEMBLY VANE
COVERS AND FEATHERSEALS

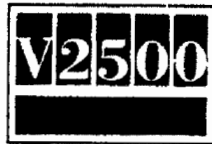
V2500-ENG-70-0450
INFORMATION ENGINE - HP
TURBINE ROTOR AND STATOR
ASSEMBLY - ANNOUNCE THE
AVAILABILITY OF A NEW TURBINE
CASE AND VANE ASSEMBLY

PART NUMBER CHANGE



E8187A

Family Tree - High Pressure Turbine Case And Vane Assembly (V2500-A1)
Ref. Catalog Sequence No. 72-45-20. Fig. 01 Item 005
Figure 3 (Sheet 1)



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SERVICE BULLETIN

MODIFICATIONS

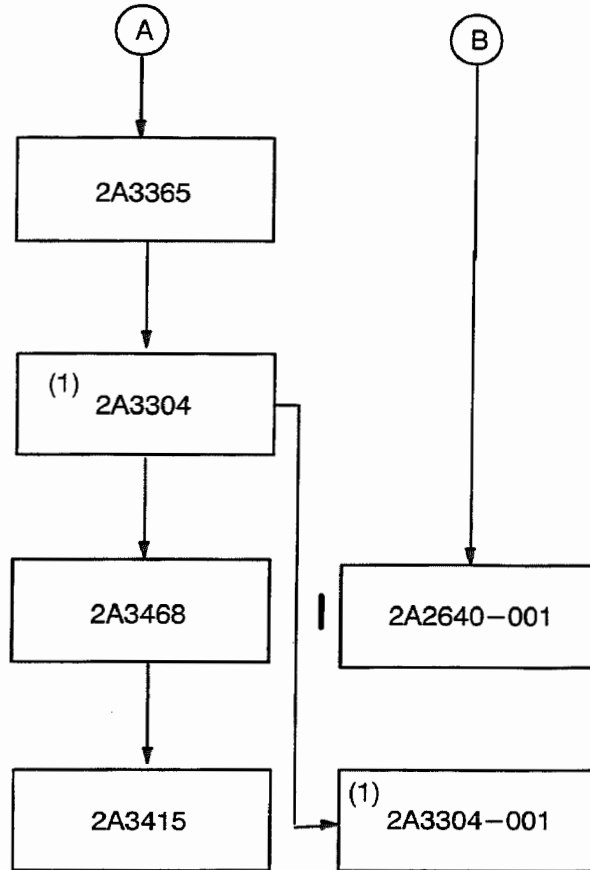
PART NUMBER CHANGE

V2500-ENG-72-0310
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW HIGH
PRESSURE TURBINE STAGE 1 AND
2 DUCT SEGMENTS

V2500-ENG-72-0339
ENGINE - HP TURBINE ROTOR AND
STATOR ASSEMBLY - PROVIDE NEW
STAGE 1 HPT DUCT SEGMENTS,
BAND SEGMENTS, SUPPORTS,
SEALS AND BOLTS

V2500-ENG-72-0365
PROVIDE PRETRENCHED SECOND
STAGE HPT AIR SEALING RING
SEGMENTS

V2500-ENG-72-0364
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW STAGE
2 HIGH PRESSURE TURBINE
DUCT SEGMENTS



(1) PHOENIX

E8188A

Family Tree - High Pressure Turbine Case And Vane Assembly (V2500-A1)
Ref. Catalog Sequence No. 72-45-20. Fig. 01 Item 005
Figure 3 (Sheet 2)

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MODIFICATIONS BASE LINE

V2500-ENG-72-0236
ENGINE- HP TURBINE ROTOR AND
STATOR ASSEMBLY - PROVIDE A
NEW ORIFICE PLATE WITH AN
INCREASED OVERSIZE

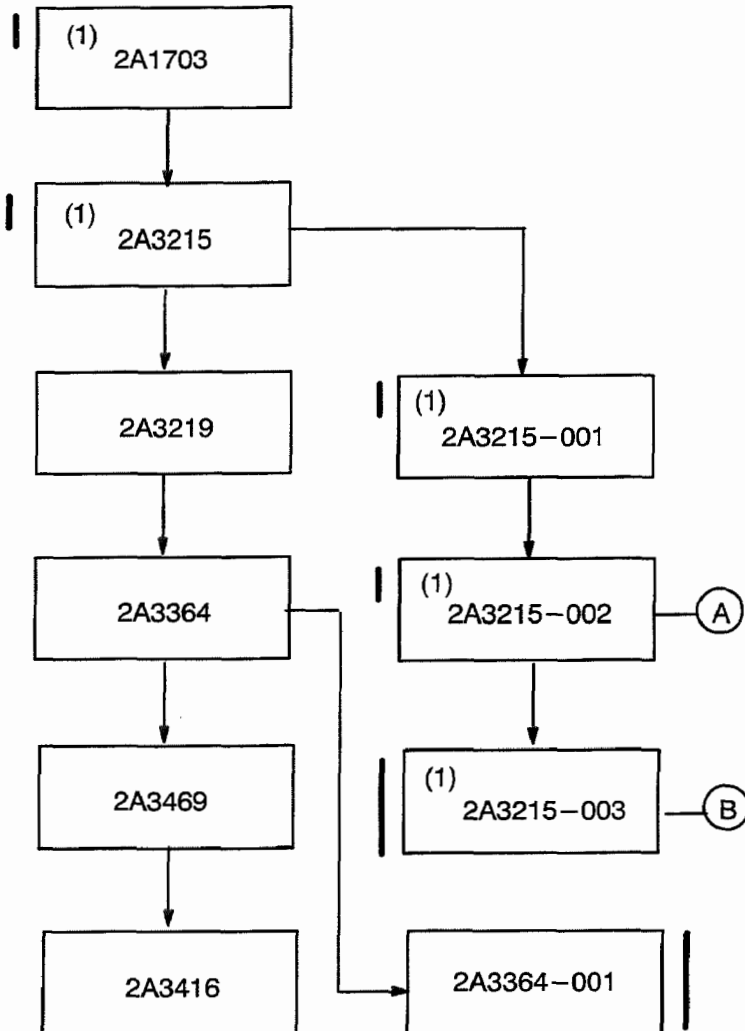
V2500-ENG-72-0237
ENGINE- HP TURBINE ROTOR AND
STATOR ASSEMBLY - PROVIDE A
NEW STAGE 2 HPT VANES

V2500-ENG-72-0310
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW HIGH
PRESSURE TURBINE STAGE 1 AND
2 DUCT SEGMENTS

V2500-ENG-72-0365
(98VC012) PRETRENCHED SECOND
STAGE HPT AIR SEALING RING SEG-
MENTS

V2500-ENG-72-0364
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW STAGE
2 HIGH PRESSURE TURBINE
DUCT SEGMENTS

PART NUMBER CHANGE



(A) AND (B) CONTINUED ON SHEET 2

(1) DO NOT USE IN V2533-A5 ENGINES

E8189A

Family Tree - High Pressure Turbine Case And Vane Assembly (All V2500-A5 and
V2500-D5 Engines) Ref. Catalog Sequence No. 72-45-20. Fig. 01 Item 005
Figure 4 (Sheet 1)



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MODIFICATIONS

PART NUMBER CHANGE

V2500-ENG-72-0364
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW STAGE
2 HIGH PRESSURE TURBINE
DUCT SEGMENTS

(A)



(1)
2A3215-005

(B)



(1)
2A3215-004

(A) AND (B) CONTINUED FROM SHEET 1

(1) DO NOT USE IN V2533-A5 ENGINES

E8205

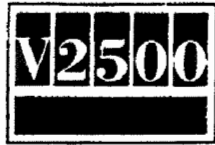
Family Tree - High Pressure Turbine Case And Vane Assembly (All V2500-A5 and
V2500-D5 Engines) Ref. Catalog Sequence No. 72-45-20. Fig. 01 Item 005
Figure 4 (Sheet 2)

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International Aero Engines SERVICE BULLETIN

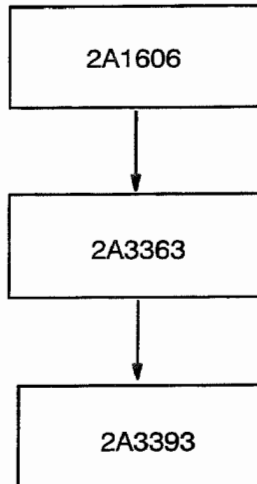
MODIFICATIONS

BASE LINE

V2500-ENG-72-0310
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW HIGH
PRESSURE TURBINE STAGE 1 AND
2 DUCT SEGMENTS

V2500-ENG-72-0364
ENGINE - HIGH PRESSURE TUR-
BINE - PROVIDE NEW STAGE 2
HIGH PRESSURE TURBINE DUCT
SEGMENTS

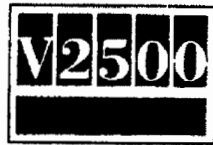
PART NUMBER CHANGE



Printed in Great Britain

E8190

Family Tree - Stage 2 High Pressure Turbine Duct Segment (All V2500-A5 and
V2500-D5 Engines) Ref. Catalog Sequence No. 72-45-25. Fig. 01 Item 060
Figure 5



International Aero Engines SERVICE BULLETIN

MODIFICATIONS

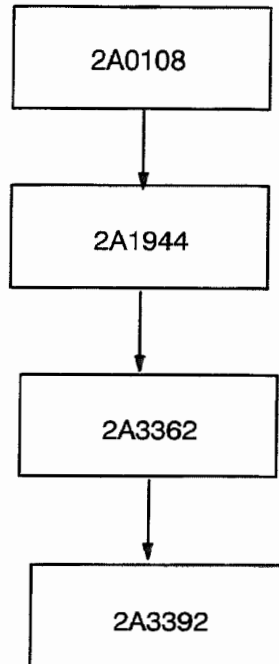
BASE LINE

V2500-ENG-72-0085
ENGINE- HP TURBINE ROTOR AND
STATOR ASSEMBLY - PROVIDE A NEW
STAGE 2 DUCT INCORPORATING RE-
VISED COATING REQUIREMENTS

V2500-ENG-72-0310
ENGINE - HIGH PRESSURE
TURBINE - PROVIDE NEW HIGH
PRESSURE TURBINE STAGE 1 AND
2 DUCT SEGMENTS

V2500-ENG-72-0364
ENGINE - HIGH PRESSURE TUR-
BINE - PROVIDE NEW STAGE 2
HIGH PRESSURE TURBINE DUCT
SEGMENTS

PART NUMBER CHANGE



E8191

Family Tree - Stage 2 High Pressure Turbine Duct Segment (V2500-A1) Ref. Catalog
Sequence No. 72-45-25. Fig. 01 Item 060
Figure 6

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