

PLEASE DISCARD THE ORIGINAL REVISION LETTER AND REPLACE
WITH THIS REVISION LETTER

Subject: Transmittal of Revision 1 To Service Bulletin Number
V25000-ENG-72-0368.

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Aug.8/00
Revision 1	Sep.5/00

Reason For Issuance Of Revision:

- (1) To add aircraft MD-90 to effevtivity.
- (2) To correct effectivity page 2.

Effect on Prior Compliance:

None.

List of Effective Pages:

<u>Bulletin Page No.</u>	<u>Rev. No.</u>	<u>Effective Date</u>
1 and 2	1	Sep.5/00
3 to 9	Basic	Aug.8/00

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Transmittal

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International Aero Engines SERVICE BULLETIN

ENGINE - PROVIDE NEW 2ND STAGE HIGH PRESSURE TURBINE (HPT) VANES

MODEL APPLICATION

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

7

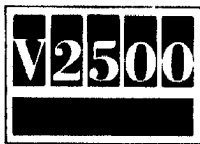
Internal Reference No.

96VB039

Aug.8/00
Revision 1 Sep.5/00

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ENGINE - PROVIDE NEW 2ND STAGE HIGH PRESSURE TURBINE (HPT) VANES

1. Planning Information

A. Effectivity

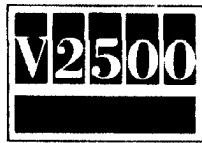
- (1) Aircraft: Airbus A319, A320, A321
McDonnell Douglas MD-90
- (2) Engine:
 - (a) V2522-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (b) V2524-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (c) V2527-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (d) V2527E-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (e) V2527M-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (f) V2530-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (g) V2533-A5 Engines Before Serial No. V10813, except engines V10807, V10809, and V10811.
 - (h) V2525-D5 Engines Before Serial No. V20286.
 - (i) V2528-D5 Engines Before Serial No. V20286.

B. Concurrent Requirements

None.

C. Reason

- (1) Condition:
Existing vane castings feature excess material.
- (2) Background:
Excess material was originally thought to be required in earlier development programs.
- (3) Objective:
Provide new second stage HPT Vanes with new castings which eliminate excess material.
- (4) Substantiation
This change has no affect on the physical or structural configuration of the final part.



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(5) Effects of Bulletin on Workshop Procedures:

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

(6) Supplemental Information

Old and New Vanes are directly and completely interchangeable.

D. Description

Provide new cast 2nd Stage HPT Vanes.

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:

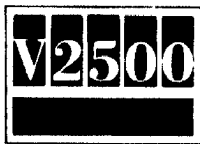
<u>Venue</u>	<u>Estimated Manhours</u>
(1) In service	Not applicable
(2) At overhaul	No additional time required

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.

I. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.
The following tools are required to accomplish the Service Bulletin.



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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) The V2500 Engine Illustrated Parts Catalog, (S-V2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, S-V2500-7IB), Chapter/Section 72-45-24.
- (2) The V2500 Engine Manual, 72-45-20, Assembly and 72-45-24, Cleaning, Inspection and Repair.
- (3) The v2500 Standard Practices/Processes Manual, 70-00-00.
- (4) The V2500 Overhaul Processes and Consumables Index.
- (5) IAE V2500 Service Bulletins:
V2500-ENG-70-0428 - Engine - HP Turbine Rotor and Stator Assembly - To Announce The Availability of New Stage 2 Turbine Vanes.
V2500-ENG-72-0237 - Engine - HP Turbine Rotor and Stator Assembly - Provide New Stage 2 HPT Vanes.
V2500-ENG-72-0259 - Engine - HP Turbine Rotor and Stator Assembly - Provide New Stage 2 High Pressure Turbine Vanes.

M. Other Publications Affected

- (1) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-24, Cleaning to add the new part number.
- (2) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-24, Cleaning to add the new part number.
- (3) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-24, Inspection to add the new part number.
- (4) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-24, Inspection to add the new part number.
- (5) The V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-24, Repair to add the new part number.
- (6) The V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-24, Repair to add the new part number.



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2. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

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 Engine to incorporate this Service Bulletin					
2A3475 (72-45-20)	1		Case and Vane Assy, Turbine	2A3416 (01-005)	(S1) (1D) (B) (C)
2A5602 (72-45-20)	17		.Ring Segment, Vane Cluster Assy	2A5102 (02-050)	(S1) (1D) (A) (D)
2A3572 (72-45-24)	34		..Vane Assy Of, HPT, 2 Stage Assy	2A3402 (02-130)	(S1) (A) (D)
2A5502 (72-45-20)	2		.Ring Segment, Vane Cluster Assy	2A5202 (02-260)	(S1) (1D) (A) (D)
2A3572 (72-45-24)	2		..Vane Assy Of, HPT, 2 Stage Assy	2A3402 (02-350)	(S1) (A) (D)
2A3282 (72-45-24)	2		..Vane Assy Of, HPT, 2 Stage Assy	2A3302 (02-420)	(S1) (A) (D)

C. Consumable Materials

None

D. Instructions/Disposition Code Statements:

(S1)Old and New Parts are freely and fully interchangeable

(1D)You can obtain the new part by modification of the old part and identification to the new part number.

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

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

(C) The old part no longer supplied.

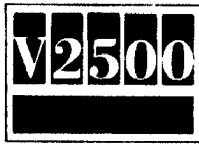
(D) The old part will be supplied until stock is depleted.

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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3. Accomplishment Instructions

- A. Replace the 2A3402 Stage 2 HPT Vane Assembly (2 off) with the 2A3572 Stage 2 HPT Vane Assembly when you assemble the new Stage 2 HPT Ring Segment and Vane Cluster Assembly by the procedure specified in Reference 2, Chapter/Section 72-45-24.

NOTE: Delivered engines may contain a mixture of Vane Assemblies. If a Case and Vane Assembly contains a mixture it is to be identified to the new number.

- B. Replace the 2A3302 and 2A3402 Stage 2 HPT Vane Assemblies (1 off) with the 2A3282 and 2A3572 Stage 2 HPT Vane Assemblies respectively when you assemble the new Stage 2 HPT Ring Segment and Vane Cluster Assembly by the procedure specified in Reference 2, Chapter/Section 72-45-24.

NOTE: Delivered engines may contain a mixture of Vane Assemblies. If a Case and Vane Assembly contains a mixture it is to be identified to the new number.

- C. Recording Instructions

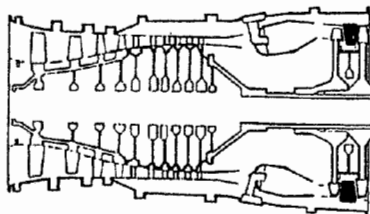
(1) A record of accomplishment is necessary.

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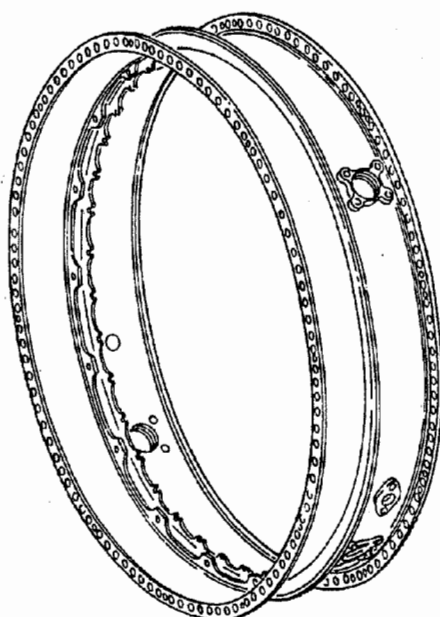
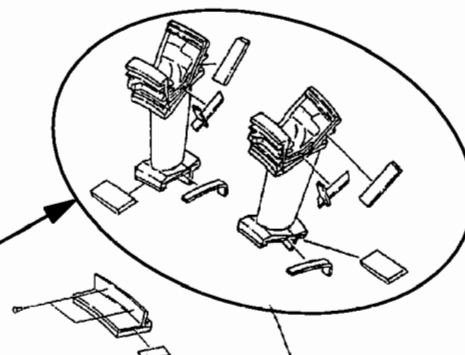
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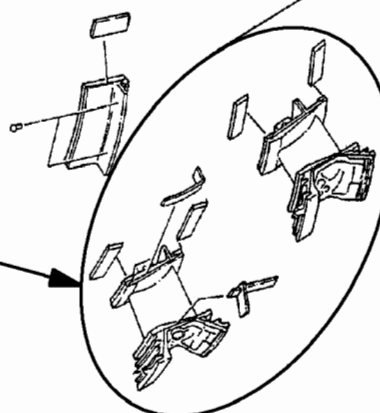


MODULE 40

INSTALL THE 2A3572
STAGE 2 HIGH PRESSURE
TURBINE VANE ASSEMBLY
(2 off)*



INSTALL THE 2A3572 AND
2A3282 STAGE 2 HIGH
PRESSURE TURBINE
VANE ASSEMBLIES (1 off)



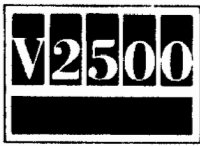
E8162

Location of the Stage 2 High Pressure Turbine (HPT) Vane Assemblies
Figure 1

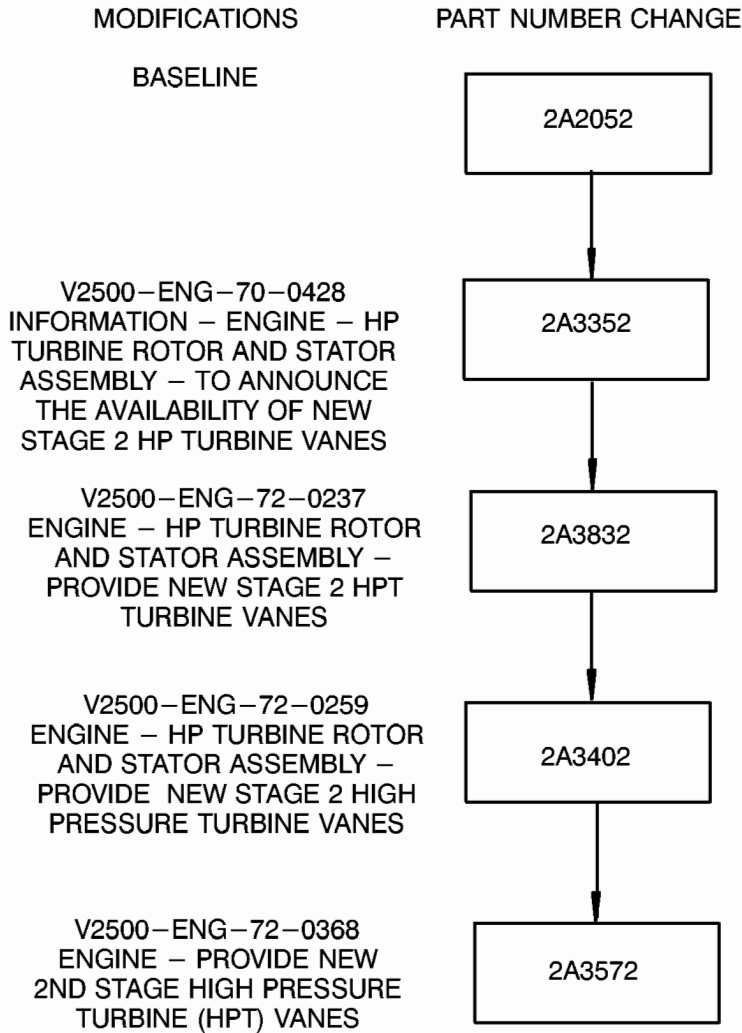
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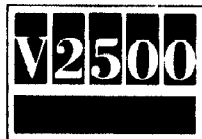
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Family Tree - Stage 2 High Pressure Turbine Vane Assembly
Ref. Catalog Sequence No 72-45-24. Fig. 02 Items 130 and 350
Figure 2

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MODIFICATIONS

BASELINE

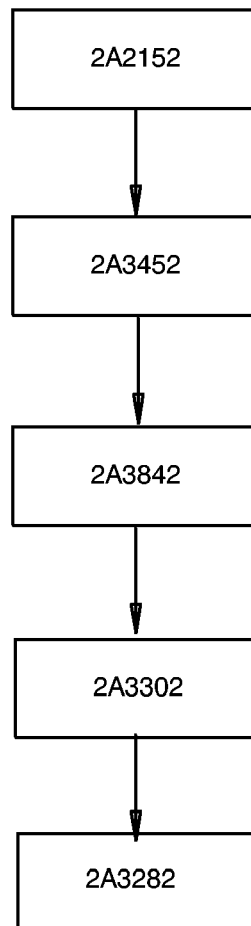
V2500-ENG-70-0428
INFORMATION - ENGINE - HP
TURBINE ROTOR AND STATOR
ASSEMBLY - TO ANNOUNCE
THE AVAILABILITY OF NEW
STAGE 2 HP TURBINE VANES

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

V2500-ENG-72-0259
ENGINE - HP TURBINE ROTOR
AND STATOR ASSEMBLY -
PROVIDE NEW STAGE 2 HIGH
PRESSURE TURBINE VANES

V2500-ENG-72-0368
ENGINE - PROVIDE NEW
2NDSTAGE HIGH PRESSURE
TURBINE (HPT) VANES

PART NUMBER CHANGE



Family Tree - Stage 2 High Pressure Turbine Vane Assembly
Ref. Catalog Sequence No 72-45-24. Fig. 02 Item 420
Figure 3

E8164

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