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DATE: Dec. 1/05

V2500-A1/A5 SERIES PROPULSION SYSTEM SERVICE BULLETIN

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This document transmits Revision 2 to Service Bulletin EV2500-72-0435 and Revision 2 to the Supplement

Document History

Service Bulletin Revision Status		Supplement Revision Status	
Initial Issue	Feb.25/03	Initial Issue	Feb.25/03
Revision 1	May 29/03	Revision 1	May 29/03

Bulletin Revision 2

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 58 of the Service Bulletin	To add two part numbers (5W0154 and 5W0196) in Accomplishment Instructions.

Supplement Revision 2

Remove	Incorporate	Reason for change
All pages	Page 1	To add two part numbers (5W0154 and 5W0196) in Accomplishment Instructions.

V2500-ENG-72-0435

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise Publication Services, Rolls-Royce plc, Derby, England
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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 2 to the Bulletin and Revision 2 to the Supplement are as follows:

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R	1	2	Dec.1/05
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	Supplement		
R	1	2	Dec.1/05

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International Aero Engines

SERVICE BULLETIN

ENGINE – LP COMPRESSOR – INTRODUCTION OF FAN CASE, PANEL AND BRACKET SCALLOPED FOR NO.4 SCAVENGE TUBE REROUTE

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1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5 and V2527M-A5 Engines prior to Serial No.V11450*

(2) Airbus A320

(a) V2500-A1 Engines prior to Serial No.V0362

(b) V2527-A5 and V2527E-A5 Engines prior to Serial No.V11450*

(3) Airbus A321

(a) V2530-A5 and V2533-A5 Engines prior to Serial No.V11450*

* The Serial Number data shown is of a preliminary nature and is provided for advanced planning only. A future revision to this Service Bulletin will confirm final Serial Number effectivity.

B. Reason

(1) Problem

Oil loss from the No.4 Bearing Compartment has resulted in oil ignition and caused heat distress damage to HPT and LPT hardware.

(2) Background

It is reported that service engines experienced more than 10 oil loss events of the No.4 Bearing Compartment. The No.4 Compartment is scavenged using a blow down design and is not evacuated by a scavenge pump. The current configuration can allow oil to be trapped in the lowest section of the external scavenge line. Under certain sub idle conditions, the trapped oil prevents proper scavenging of the compartment, allowing the compartment to flood. Once the compartment floods, oil can leak past the carbon seals during sub idle operation as the pressure outside the compartment is insufficient to force the oil out the scavenge line. The No.4 rerouted Bearing Compartment Scavenge line is redesigned in order to provide sufficient scavenge margin under all conditions. The redesign work for modification of external No.4 Bearing Compartment Scavenge line revealed the interface between the new designed No.4 Bearing Compartment Scavenge Tube and the existing Fan Case, the No.6 Strut Fairing Panel and the Panel Supporting Bracket.

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(3) Objective

This Service Bulletin is to introduce scalloped profile on the Fan Case and the associating hardware for implementation of No.4 Scavenge Tube reroute.

(4) Substantiation

Analytically substantiated.

(5) Effect of Bulletin on Workshop procedures:

(a) Removal/Installation

Affected (See Supplemental Information)

(b) Disassembly/Assembly

Affected (See Supplemental Information)

(c) Cleaning

Not affected

(d) Inspection/Check

Not affected

(e) Repair

Not affected

(f) Testing

Not affected

(6) Supplemental Information

(a) The removal and installation of the Post Service Bulletin configuration requires instructions for removing and installing additional Bracket, and the revised procedures for removing and installing the Bolts, Washers and Nuts which attach the No.6 Strut Fairing Panel to the Panel Supporting Bracket.

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C. Description

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

(a) The profiles of the Fan Case, the No.6 Strut Fairing Panel and the Panel Supporting Bracket are changed to make scalloped contours to avoid interference with new No.4 Bearing Scavenge Tube. Refer to Figure 1.

(b) The part numbers and quantity of the attaching parts (Bolts, Nuts and Washers) associating the No.6 Strut Fairing Panel and the Panel Supporting Bracket are changed. Refer to Figure 2 and Figure 3.

(c) The new Bracket 5A1884 and attaching parts are added. Refer to Figure 3.

(d) The Module Assembly numbers (Module Identification numbers) of the LPC/Intermediate Module are changed.

(2) Existing Fan Case, No.6 Strut Fairing Panel and Panel Supporting Bracket can be reworked. Refer to Figure 13 to 15.

(3) For relationship with other Service Bulletins, see 1.K. References and Figure 4 to 10 Family Tree.

D. Compliance

Category Code 3

(1) For V2500-A1 engines

Accomplish by July 2006.

Category Code 4

(1) For V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5 and V2533-A5 engines

Accomplish by October 2011.

E. Approval

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

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F. Manpower

Estimated Man-hours to incorporate the full intent of this Service Bulletin:

(1) In service

Not Applicable.

(2) At overhaul - Scheduled removal

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

(a)	To attach tooling template and scribe profile	20 minutes
(b)	To machine profile	45 minutes
(c)	Inspect, visual and dimensional	30 minutes
(d)	Crack test using flourescent penetrant	60 minutes
(e)	Re-ident part	15 minutes
TOTAL		2 hours 50 minutes

NOTE: The total time given is for one component part and requires multiplying by three to achieve total time for the Fan Case, No.6 Strut Fairing Panel and Panel Supporting Bracket.

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G. Tooling Price and Availability

The following toooling is required to accomplish this Service Bulletin when reworking the existing Fan Case, No.6 Strut Fairing Panel and Panel Supporting Bracket.

Tool Number	Qty	Description	Function	Availability
IAE 3J12860	1	Guide, Scalloping Fan Case, Intermediate	Protect of Fan Case	1)
IAE 3J12861	1	Gage, Go/No-Go Fan Case, Intermediate	Dimension check	1)
IAE 3J12862	1	Template, Scalloping Fan Case, Intermediate	Mark of worked area	1)
IAE 3J12863	1	Template, Scalloping No.6 Strut Fairing Panel, Intermediate	Mark of worked area	1)
IAE 3J12864	1	Gage, Go/No-Go No.6 Strut Fairing Panel, Intermediate	Dimension check	1)
IAE 3J12865	1	Guide, Scalloping No.6 Strut Fairing Panel, Intermediate	Protect of Panel	1)
IAE 3J12866	1	Template, Scalloping Panel Supporting Bracket, Intermediate	Mark of worked area	1)
IAE 3J12867	1	Gage, Go/No-Go Panel Supporting Bracket, Intermediate	Dimension check	1)
IAE 3J12868	1	Guide, Scalloping Panel Supporting Bracket, Intermediate	Protect of Bracket	1)

1) Indicates that Tool Design Aperture Card is currently available from IAE for use in the local manufacture of the Fixture.

H. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

None.

(3) Datum

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

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I. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

J. Software Accomplishment Summary

Not applicable.

K. References

(1) SERVICE INFORMATION LETTER NO. 190

SUBJECT: No.4 Bearing Compartment Oil Loss

(2) Engineering Change No. 02VJ013

(3) V2500 Engine Illustrated Parts Catalog (A1/A5), Chapter/Section 72-32-00, 72-32-03 and 72-32-85

(4) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-32, Removal-02, Config-01 or Config-02

(5) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-32, Removal-03, Config-01 or Config-02

(6) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-40, Removal-02, Config-01 or Config-02

(7) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-60, Removal-02, Config-01 or Config-02

(8) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-32-00, Disassembly-02, Config-01 or Config-02

(9) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-32-00, Disassembly-05, Config-01 or Config-02

(10) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-32, Installation-01, Config-01 or Config-02

(11) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-32, Installation-03, Config-01 or Config-02

(12) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-32, Installation-04, Config-01 or Config-02

(13) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-40, Installation-09, Config-01 or Config-02

(14) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-00-60, Installation-03, Config-01 or Config-02

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(15) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-32-00, Assembly-11, Config-01 or Config-02

(16) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 72-32-00, Assembly-14, Config-01 or Config-02

(17) V2500 Engine Manual (EM) (E-V2500-1IA), Chapter/Section 71-00-00, Testing-00, Config-01 or Config-02

(18) V2500 Standard Practices/Processes Manual (SPM) (SPP-V2500-1IA), Chapter/Section 70-09-00 Marking of Parts

(19) V2500 Standard Practices/Processes Manual (SPM) (SPP-V2500-1IA), Chapter/Section 70-23-05 Local Application of Fluorescent Penetrant Inspection

(20) ATA Locator - 72-32-00

L. Other Publications Affected

(1) V2500 Engine Illustrated Parts Catalog (A1/A5), Chapter/Section 72-32-00, 72-32-03 and 72-32-85 will be revised.

(2) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Cleaning-01, Config-01 will be revised.

(3) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Cleaning-09, Config-01 will be revised.

(4) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Inspection/Check-01, Config-01 will be revised.

(5) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Inspection/Check-09, Config-01 will be revised.

(6) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Repair 001 (VRS1901), Repair 002 (VRS1902) and Repair 003 (VRS1903) will be revised.

(7) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-03, Repair 030 (VRS1711) will be revised.

(8) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-85, Cleaning-01, Config-01 will be revised.

(9) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-85, Inspection-01, Config-01, Config-02, Config-03 and Config-04 will be revised.

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(10) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-85, Repair 001 (VRS1403), Repair 002 (VRS1411), Repair 003 (VRS1412), Repair 004 (VRS1952), Repair 005 (VRS1405), Repair 007 (VRS1955), Repair 008 (VRS1956), Repair 010 (VRS1958), Repair 012 (VRS1418), Repair 013 (VRS1419), Repair 014 (VRS1959), Repair 016 (VRS1554), Repair 017 (VRS1556), Repair 018 (VRS1557), Repair 019 (VRS1819), Repair 020 (VRS1820), Repair 021 (VRS1559), Repair 022 (VRS1538), Repair 023 (VRS1555), Repair 024 (VRS1539), Repair 025 (VRS1540), Repair 026 (VRS1560), Repair 031 (VRS1833), Repair 036 (VRS1840), Repair 037 (VRS1821), Repair 038 (VRS1841), Repair 039 (VRS1823), Repair 040 (VRS1822), Repair 041 (VRS1842), Repair 042 (VRS1805), Repair 044 (VRS1818), Repair 046 (VRS1712) and Repair 047 (VRS1413) will be revised.

(11) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-00-32, Removal-05, Config-01 and Config-02 will be revised.

(12) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-00-32, Installation-01, Config-01 and Config-02 will be revised.

(13) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-00, Disassembly-02, Config-01 and Config-02 will be revised.

(14) V2500 Engine Manual (EM)(E-V2500-1IA), Chapter/Section 72-32-00, Assembly-02, Config-01 and Config-02 will be revised.

M. Interchangeability of Parts

Affected - Refer to Section 2 Material Information.

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2. Material Information

A. Industry Support Information

None.

B. Kits necessary for this Service Bulletin

None.

C. Parts affected by this Service Bulletin

V2500-A1 Engines

72-32-00

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01001	5W0175	1	Module, Case LPC/Intermediate	-	5W0160	(F)(D) (2D)
01001	5W0176	1	Module, Case LPC/Intermediate	-	5W0165	(D)(3D)
01001	5W0177	1	Module, Case LPC/Intermediate	-	5W0164	(D)(3D)
01001	5W0178	1	Module, Case LPC/Intermediate	-	5W0163	(D)(3D)
01001	5W0179	1	Module, Case LPC/Intermediate	-	5W0162	(D)(3D)
01001	5W0180	1	Module, Case LPC/Intermediate	-	5W0161	(D)(3D)
01535	AS21113	68	Bolt	-	AS21113	(A)(I)
01543	5A1884	1	Bracket	-	-	(B)(K)
01548	AS21118	2	Bolt	-	-	(A)(J)

V2500-A1 Engines

72-32-03

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02100	5A1885	1	Panel, Fairing No.6 Strut	-	5A1838	(B)(D) (S1)(2D)
02100	5A1898	1	Panel, Fairing No.6 Strut	-	5A2184	(D)(S1) (3D)
02110	4W0002	2	Nut	-	4W0002	(A)(G) (S1)

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02120	MS9321-10	2	Washer	-	MS9321-10	(A)(G) (S1)
02130	-	-	Bolt	-	4W0166	(C)(H) (S1)(1D)
02500	5A1886	1	Bracket, Supporting Panel	-	5A1749	(B)(D) (S1)(2D)
02520	4W1246	2	Bolt	-	4W0166	(A)(C)

V2500-A1 Engines

72-32-85

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01100	5W0184	1	Case, Fan	-	5W0100	(D)(3D)
01100	5W0185	1	Case, Fan	-	5W0070	(D)(3D)
01100	5W0186	1	Case, Fan	-	5W0093	(D)(3D)
01100	5W0187	1	Case, Fan	-	5W0069	(D)(3D)
01100	5W0188	1	Case, Fan	-	5W0094	(D)(3D)
01100	5W0189	1	Case, Fan	-	5W0081	(D)(3D)
01100	5W0190	1	Case, Fan	-	5W0072	(D)(3D)
01100	5W0191	1	Case, Fan	-	5W0124	(D)(3D)
01100	5W0192	1	Case, Fan	-	5W0168	(D)(3D)
01100	5W0193	1	Case, Fan	-	5W0171	(D)(F) (2D)
03100	5A2189	1	Plate, Module Identification	-	5A2189	(A)

V2500-A5 Engines

72-32-00

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01001	5W0181	1	Module, Case LPC/Intermediate	-	5W0155	(F)(D) (2D)
01001	5W0182	1	Module, Case LPC/Intermediate	-	5W0167	(D)(3D)
01001	5W0183	1	Module, Case LPC/Intermediate	-	5W0166	(D)(3D)
01535	AS21113	68	Bolt	-	AS21113	(A)(I)
01543	5A1884	1	Bracket	-	-	(B)(K)
01548	AS21118	2	Bolt	-	-	(A)(J)

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V2500-A5 Engines

72-32-03

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02100	5A1885	1	Panel, Fairing No.6 Strut	-	5A1838	(B)(D)(S1)(2D)
02110	4W0002	2	Nut	-	4W0002	(A)(G)(S1)
02120	MS9321-10	2	Washer	-	MS9321-10	(A)(G)(S1)
02130	-	-	Bolt	-	4W0166	(C)(H)(S1)(1D)
02500	5A1886	1	Bracket, Supporting Panel	-	5A1749	(B)(D)(S1)(2D)
02520	4W1246	2	Bolt	-	4W0166	(A)(C)

V2500-A5 Engines

72-32-85

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01100	5W0194	1	Case, Fan	-	5W0144	(D)(3D)
01100	5W0195	1	Case, Fan	-	5W0149	(D)(3D)
01100	5W0196	1	Case, Fan	-	5W0154	(D)(3D)
01100	5W0197	1	Case, Fan	-	5W0169	(D)(3D)
01100	5W0198	1	Case, Fan	-	5W0172	(F)(D)(2D)
03100	5A2189	1	Plate, Module Identification	-	5A2189	(A)

D. Instruction Disposition Codes:

(A) New parts are currently available.

(B) New parts will be available in March 2003.

(C) Old parts will continue to be available.

(D) Old parts are no longer available.

(E) New and Old parts are not spareable.

(F) Part is a nonprovisioned item.

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(G) Quantity reduced from 3 to 2.

(H) Quantity reduced from 1 to 0.

(I) Quantity reduced from 70 to 68.

(J) Quantity increased from 0 to 2.

(K) Additional item.

(S1) New parts coded (S1) must replace old parts coded (S1) as a complete set.

(1D) Old part can be used up on other applications.

(2D) New part can be obtained by rework and reidentification of old part.

(3D) New part can only be obtained by rework and reidentification of old part.

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3. Accomplishment Instructions

A. Disassembly Instructions

For V2500-A1

(1) Identify the parts and the area to be reworked, and thus the parts to be removed. Refer to Figure 11.

NOTE: The area to be reworked is around the Fan Case v-groove at 6 o'clock position. You have only to remove the parts necessary to access the area to be reworked.

(2) Remove only the parts necessary to access the area to be reworked.

Harnesses and Tubes:

Refer to EM 72-00-60, Removal-02, Config-01, EM 72-00-40, Removal-02, Config-01, EM 72-00-32, Removal-02, Config-01, EM72-00-32, Removal-03, Config-01 and EM 72-32-00, Disassembly-05, Config-01.

Open Latch Indicator:

Refer to EM 72-00-32, Removal-05, Config-01.

Bifurcation Panel:

Refer to EM 72-00-32, Removal-05, Config-01.

(3) Remove the Panel Corner Fillers and the Corner Strut Fillers from the Fan Frame Assembly at 6 o'clock position. Refer to EM 72-32-00, Disassembly-02, Config-01.

(4) Remove the No.6 Strut Fairing Panel and the Panel Supporting Bracket from the Fan Frame and the Fan Case. Refer to EM 72-32-00, Disassembly-02, Config-01.

B. Disassembly Instructions

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5 and V2533-A5

(1) Identify the parts and the area to be reworked, and thus the parts to be removed. Refer to Figure 11.

NOTE: The area to be reworked is around the Fan Case v-groove at 6 o'clock position. You have only to remove the parts necessary to access the area to be reworked.

(2) Remove only the parts necessary to access the area to be reworked.

Harnesses and Tubes:

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Refer to EM 72-00-60, Removal-02, Config-02, EM 72-00-40, Removal-02, Config-02, EM 72-00-32, Removal-02, Config-02, EM 72-00-32, Removal-03, Config-02 and EM 72-32-00, Disassembly-05, Config-02.

Open Latch Indicator:

Refer to EM 72-00-32, Removal-05, Config-02.

Bifurcation Panel:

Refer to EM 72-00-32, Removal-05, Config-02.

(3) Remove the Panel Corner Fillers and the Corner Strut Fillers from the Fan Frame Assembly at 6 o'clock position. Refer to EM 72-32-00, Disassembly-02, Config-02.

(4) Remove the No.6 Strut Fairing Panel and the Panel Supporting Bracket from the Fan Frame and the Fan Case. Refer to EM 72-32-00, Disassembly-02, Config-02.

C. Rework Instructions

For V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5 and V2533-A5

(1) Tools:

Refer to paragraph 1.G.

(2) Consumable Materials:

CoMat 06-064 - Fluorescent penetrant

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(3) Do a modification of Fan Case and re-identify as follows:

CAUTION

1. TITANIUM COMPONENT. SILICON CARBIDE TYPE WHEELS, STONE AND ABRASIVE PAPERS ARE TO BE USED FOR THIS REWORK.

2. TITANIUM COMPONENT. ALUMINIUM OXIDE MUST NOT BE USED.

3. TITANIUM COMPONENT. THE MATERIAL WILL OXIDIZE AND CRACK IF MECHANICAL CUTTERS ARE USED HEAVILY. THIS WILL HAVE OCCURRED IF THE COMPONENT SHOWS DARK STRAW TO BLUE DISCOLOURATION.

4. BE CAREFUL THAT THE GUIDE IS NOT DAMAGED BY CUTTING PROCESS.

PROCEDURE	RELATED DATA
(a) Install a protective cover to prevent any unwanted material that may go into the Engine, if necessary	
(b) Install the Template on to the Fan Case V-groove at the 6 o'clock position	Refer to Figure 11 and 16. Use IAE 3J12862 Template, Scalloping
(c) Mark the area to be removed along the profile of the template	Refer to Figure 16. Use a scribing tool
NOTE: The profile of the Template is the nominal dimension of the area to be removed.	
(d) Remove the Template from the Fan Case	
(e) Install the Guide on to the Rear Fan Case V-groove at the 6 o'clock position	Refer to Figure 17. Use IAE 3J12860 Guide, Scalloping
(f) Remove the material along the line which was marked in step C.(3)(c)	Refer to Figure 13
(g) Remove the Guide from the Fan Case	
(h) Remove all the burrs and sharp edges	

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(i) Install the Gage on to the Fan Case V-groove at the 6 o'clock position	Refer to Figure 18. Use IAE 3J12861, Gage Go/No-Go
(j) Dimensionally examine the reworked area. The area to be reworked must be between the minimum dimension line and the maximum dimension line on the Gage	Refer to Figure 13 and 18
(k) Remove the Gage from the Fan Case	
(l) Visually inspect the reworked area	Nicks, dents, pits, scratches and galls are not permitted
(m) Do a local penetrant crack test on the affected area	Refer to SPM, TASK 70-23-05-230-501. Use CoMat 06-064 fluorescent penetrant with penetrant crack test equipment. Cracks are not permitted
(n) Cancel the existing part number and re-identify with a new part number which is followed by the letters 'Fan Case' adjacent to the existing part number	Refer to Figure 13 Use the Vibro-peen method

Existing	Re-number
5W0069	5W0187
5W0070	5W0185
5W0072	5W0190
5W0081	5W0189
5W0093	5W0186
5W0094	5W0188
5W0100	5W0184
5W0124	5W0191
5W0168	5W0192
5W0171	5W0193
5W0144	5W0194
5W0149	5W0195
5W0169	5W0197
5W0172	5W0198
5W0154	5W0196

R

(o) Remove the mask on the Engine, if installed.

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(4) Do a modification of No.6 Strut Fairing Panel and re-identify as follows:

CAUTION

1. TITANIUM COMPONENT. SILICON CARBIDE TYPE WHEELS, STONE AND ABRASIVE PAPERS ARE TO BE USED FOR THIS REWORK.

2. TITANIUM COMPONENT. ALUMINIUM OXIDE MUST NOT BE USED.

3. TITANIUM COMPONENT. THE MATERIAL WILL OXIDIZE AND CRACK IF MECHANICAL CUTTERS ARE USED HEAVILY. THIS WILL HAVE OCCURRED IF THE COMPONENT SHOWS DARK STRAW TO BLUE DISCOLOURATION.

4. BE CAREFUL THAT THE GUIDE IS NOT DAMAGED BY CUTTING PROCESS.

PROCEDURE	RELATED DATA
(a) Install the Template on to the Panel	Refer to Figure 19. Use IAE 3J12863 Template, Scalloping
(b) Mark the area to be removed along the profile of the Template	Refer to Figure 19. Use a scribing tool
NOTE: The profile of the Template is the nominal dimension of the area to be removed.	
(c) Remove the Template from the Panel	
(d) Install the Guide on to the Panel	Refer to Figure 20. Use IAE 3J12865 Guide, Scalloping
(e) Remove the material along the line which was marked in step C.(4)(b)	Refer to Figure 14
NOTE: The profile of the Guide is the maximum dimension of the area to be removed.	
(f) Remove the Guide from the Panel	
(g) Remove all the burrs and sharp edges	

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(h) Install the Gage on to the Panel	Refer to Figure 21. Use IAE 3J12864, Gage Go/No-Go
(i) Dimensionally examine the reworked area. The area to be reworked must be between the minimum dimension line and the maximum dimension line on the Gage	Refer to Figure 14 and 21
(j) Remove the Gage from the Panel	
(k) Do the rework in accordance with	SBE 72-0346, if the Panel is 5A0352
(l) Visually inspect the reworked area	Nicks, dents, pits, scratches and galls are not permitted
(m) Do a local penetrant crack test on the affected area	Refer to SPM, TASK 70-23-05-230-501. Use CoMat 06-064 fluorescent penetrant with penetrant crack test equipment. Cracks are not permitted
(n) Cancel the existing part number and re-identify with a new part number that is marked adjacent to the existing part number	Refer to Figure 14 Use the Vibro-peen method Existing: 5A1838, 5A2184 Re-number: 5A1885, 5A1898

(5) Do a modification of Panel Supporting Bracket and re-identify as follows:

CAUTION BE CAREFUL THAT THE GUIDE IS NOT DAMAGED BY CUTTING PROCESS.

PROCEDURE	RELATED DATA
(a) Install the Template on to the Bracket	Refer to Figure 22. Use IAE 3J12866 Template, Scalloping

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(b)	Mark the area to be removed along the profile of the Template	Refer to Figure 22. Use a scribing tool

NOTE: The profile of the Template is the minimum dimension of the area to be removed.

(c)	Remove the Template from the Bracket	
(d)	Install the Guide on to the Bracket	Refer to Figure 23. Use IAE 3J12868 Guide, Scalloping
(e)	Remove the material along the line which was marked in step C.(5)(b)	Refer to Figure 15

NOTE: The profile of the Guide is the maximum dimension of the area to be removed.

(f)	Remove the Guide from the Bracket	
(g)	Remove all the burrs and sharp edges	
(h)	Install the Gage on to the Bracket	Refer to Figure 24. Use IAE 3J12867, Gage Go/No-Go
(i)	Dimensionally examine the reworked area. The area to be reworked must be between the minimum dimension line and the maximum dimension line on the Gage	Refer to Figure 15 and 24
(j)	Remove the Gage from the Bracket	
(k)	Do the rework in accordance with SBE 72-0246, if the Bracket is 5A0046	
(l)	Visually inspect the reworked area	Nicks, dents, pits, scratches and galls are not permitted
(m)	Do a local penetrant crack test on the affected area	Refer to SPM, TASK 70-23-05-230-501. Use CoMat 06-064 fluorescent penetrant with penetrant crack test equipment. Cracks are not permitted

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(n) Cancel the existing part number and re-identify with a new part number that is marked adjacent to the existing part number

Refer to Figure 15
Use the Vibro-peen method

Existing	Re-number
5A1749	5A1886

(6) Re-identify new LPC/Intermediate Module as follows:

PROCEDURE	RELATED DATA
(a) Prepare the new module identification plate	
(b) Remove the two Bolts and existing module identification plate from Fan Case	
(c) Make a mark of the new module identification number on to the new 5A2189 module identification plate (72-32-85, 03-100)	Refer to SPM 70-09-00, Marking of parts

Existing	Re-number
5W0160	5W0175
5W0161	5W0180
5W0162	5W0179
5W0163	5W0178
5W0164	5W0177
5W0165	5W0176
5W0155	5W0181
5W0167	5W0182
5W0166	5W0183

(d) Install the new 5A2189 module identification plate (72-32-85, 03-100) with the existing two Bolts to Fan Case

(e) Torque the Bolts to 36 to 45 lbfin (4,00 to 5,00 Nm)

D. Assembly Instructions

For V2500-A1

(1) Install the new 5A1884 Bracket (72-32-00, 01-543) with new two Bolts (72-32-00, 01-548) on to the Fan Case. Refer to Figure 12 and 26.

(a) Install the new 5A1884 Bracket (72-32-00, 01-543) with new two Bolts (72-32-00, 01-548) on to the Fan Case. Torque the Bolts to 180 to 220 lbfin (20,00 to 25,00 Nm).

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(2) Apply Jointing Compound to the Mating Faces on the new 5A1886 Panel Supporting Brackets (72-32-03, 02-500). Refer to EM, 72-32-00, Assembly-14, Config-01.

(3) Install the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) on to the Fan Frame Assembly and the Fan Case. Refer to Figure 11, 25 and 27.

(a) Attach the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500) to the Fan Case.

(i) Put the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500) onto the Fan Case at the 6 o'clock position.

(ii) Safety with the two existing Washers (72-32-03, 02-530), new 4W1246 Bolts (72-32-03, 02-520) and existing Nuts (72-32-03, 02-510). Torque the Bolts to 85 to 105 lbfin (10,00 to 12,00 Nm).

(b) Attach the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) to the Fan Frame and the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500).

(i) Put the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) onto the Fan Frame Assembly and the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500).

(ii) Install the two Bolts (72-32-03, 02-132), Washers (72-32-03, 02-120) and Nuts (72-32-03, 02-110) to attach the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) to the 5A1886 Panel Supporting Bracket (72-32-03, 02-500). Tighten the Bolts lightly.

(iii) Pre SBE 72-0051: Install the four Washers (72-32-03, 02-140) and Bolts (72-32-03, 02-150) to attach the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) to the Fan Frame Assembly. Tighten the Bolts lightly.

(iv) SBE 72-0051: Install the drain pipe (72-32-03, 02-080), the four Washers (72-32-03, 02-140) and Bolts (72-32-03, 02-150) to attach the new 5A1885 or 5A1898 No.6 Strut Fairing Panel (72-32-03, 02-100) to the Fan Frame Assembly. Tighten the Bolts lightly.

(v) Torque the Bolts (72-32-03, 02-132) to 85 to 105 lbfin (10,00 to 12,00 Nm).

(vi) Torque the Bolts (72-32-03, 02-150) to 85 to 105 lbfin (10,00 to 12,00 Nm).

(vii) Safety the Bolts with lockwire.

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(4) Apply Sealant to the Mating Faces on the Corner Fillers. Refer to EM, 72-32-00, Assembly-14, Config-01.

(5) Install the Corner Strut Fillers and the Panel Corner Fillers on to the Struts and the Strut Fairing Panels. Refer to EM, 72-32-00, Assembly-14, Config-01.

(6) Fill the Recesses in the Corner Strut Fillers with Sealant. Refer to EM, 72-32-00, Assembly-14, Config-01.

(7) Install the parts that were removed in step (2) of paragraph A

Bifurcation Panel:

Refer to EM, 72-00-32, Installation-01, Config-01.

Open Latch Indicator:

Refer to EM, 72-00-32, Installation-01, Config-01.

Harnesses and Tubes:

Refer to EM 72-00-32, Installation-03, Config-01, EM 72-00-32, Installation-04, Config-01, EM 72-00-40, Installation-09, Config-01, EM 72-00-60, Installation-03, Config-01 and EM 72-32-00, Assembly-11, Config-01.

E. Assembly Instructions

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5 and V2533-A5

(1) Install the new 5A1884 Bracket (72-32-00, 01-543) with new two Bolts (72-32-00, 01-548) on to the Fan Case. Refer to Figure 12 and 26.

(a) Install the new 5A1884 Bracket (72-32-00, 01-543) with new two Bolts (72-32-00, 01-548) on to the Fan Case. Torque the Bolts to 180 to 220 lbfin (20,00 to 25,00 Nm).

(2) Apply Jointing Compound to the Mating Faces on the 5A1886 Panel Supporting Brackets (72-32-03, 02-500). Refer to EM, 72-32-00, Assembly-14, Config-02.

(3) Install the new 5A1885 No.6 Strut Fairing Panel (72-32-03, 02-100) onto the Fan Frame Assembly and the Fan Case. Refer to Figure 11, 25 and 28.

(a) Attach the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500) to the Fan Case.

(i) Put the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500) onto the Fan Case at the 6 o'clock position.

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(ii) Safety with the two existing Washers (72-32-03, 02-530), new 4W1246 Bolts (72-32-03, 02-520) and existing Nuts (72-32-03, 02-510). Torque the Bolts to 85 to 105 lbfin (10,00 to 12,00 Nm).

(b) Attach the new 5A1885 No.6 Strut Fairing Panel (72-32-03, 02-100) to the Fan Frame and the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500).

(i) Put the new 5A1885 No.6 Strut Fairing Panel (72-32-03, 02-100) onto the Fan Frame Assembly and the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500).

(ii) Install the two Bolts (72-32-03, 02-132), Washers (72-32-03, 02-120) and Nuts (72-32-03, 02-110) to attach the new 5A1885 No.6 Strut Fairing Panel (72-32-03, 02-100) to the new 5A1886 Panel Supporting Bracket (72-32-03, 02-500). Tighten the Bolts lightly.

(iii) Install the drain pipe (72-32-03, 02-080), the four Washers (72-32-03, 02-140) and Bolts (72-32-03, 02-150) to attach the new 5A1885 No.6 Strut Fairing Panel (72-32-03, 02-100) to the Fan Frame Assembly. Tighten the Bolts lightly.

(iv) Torque the Bolts (72-32-03, 02-132) to 85 to 105 lbfin (10,00 to 12,00 Nm).

(v) Torque the Bolts (72-32-03, 02-150) to 85 to 105 lbfin (10,00 to 12,00 Nm).

(vi) Safety the Bolts with lockwire.

(4) Apply Sealant to the Mating Faces on the Corner Fillers. Refer to EM, 72-32-00, Assembly-14, Config-02.

(5) Install the Corner Strut Fillers and the Panel Corner Fillers on to the Struts and the Strut Fairing Panels. Refer to EM, 72-32-00, Assembly-14, Config-02.

(6) Fill the Recesses in the Corner Strut Fillers with Sealant. Refer to EM, 72-32-00, Assembly-14, Config-02.

(7) Install the parts that were removed in step (2) of paragraph B

Bifurcation Panel:

Refer to EM, 72-00-32, Installation-01, Config-02.

Open Latch Indicator:

Refer to EM, 72-00-32, Installation-01, Config-02.

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Harnesses and Tubes:

Refer to EM 72-00-32, Installation-03, Config-012, EM 72-00-32, Installation-04, Config-02, EM 72-00-40, Installation-09, Config-02, EM 72-00-60, Installation-03, Config-02 and EM 72-32-00, Assembly-11, Config-02.

F. Recording Instructions

For V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5 and V2533-A5

A record of accomplishment is required.

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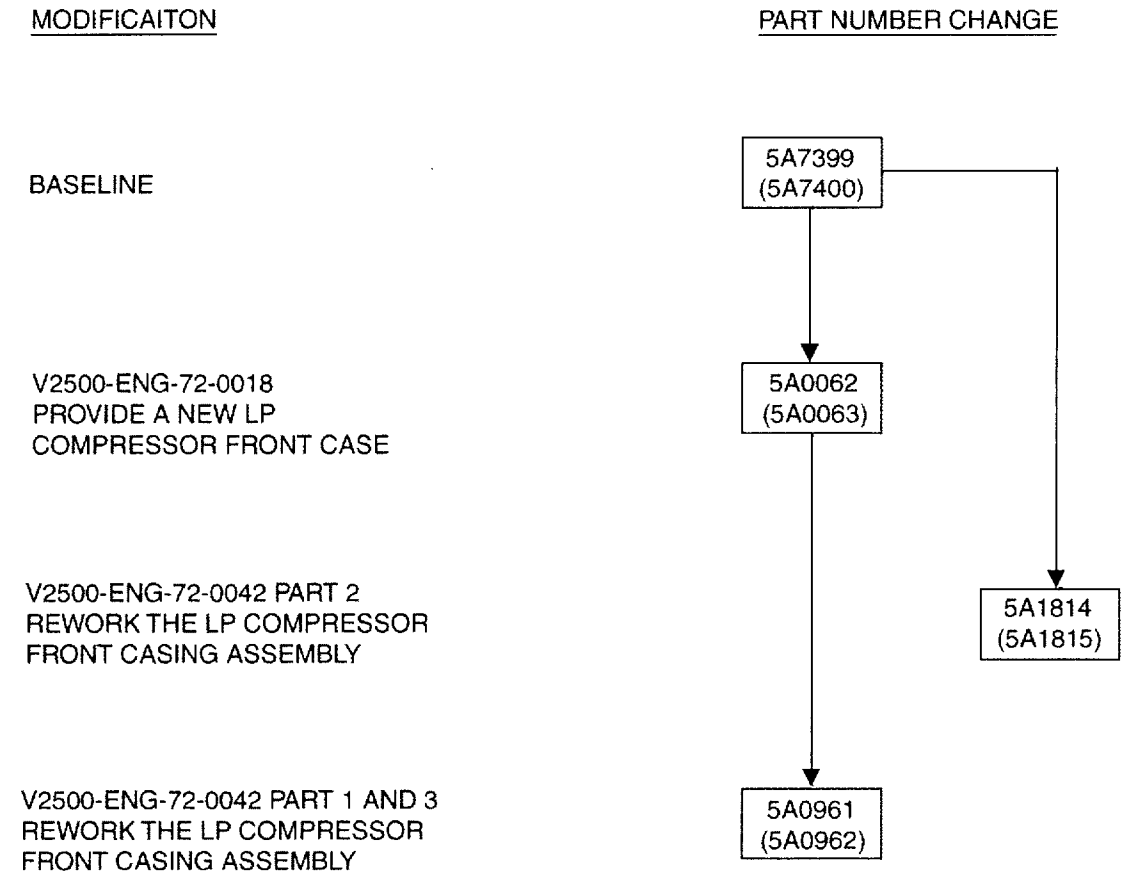

NOTE:Part Numbers in parenthesis show piece part numbers.

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Before and after alteration of Fan Case
Figure 1

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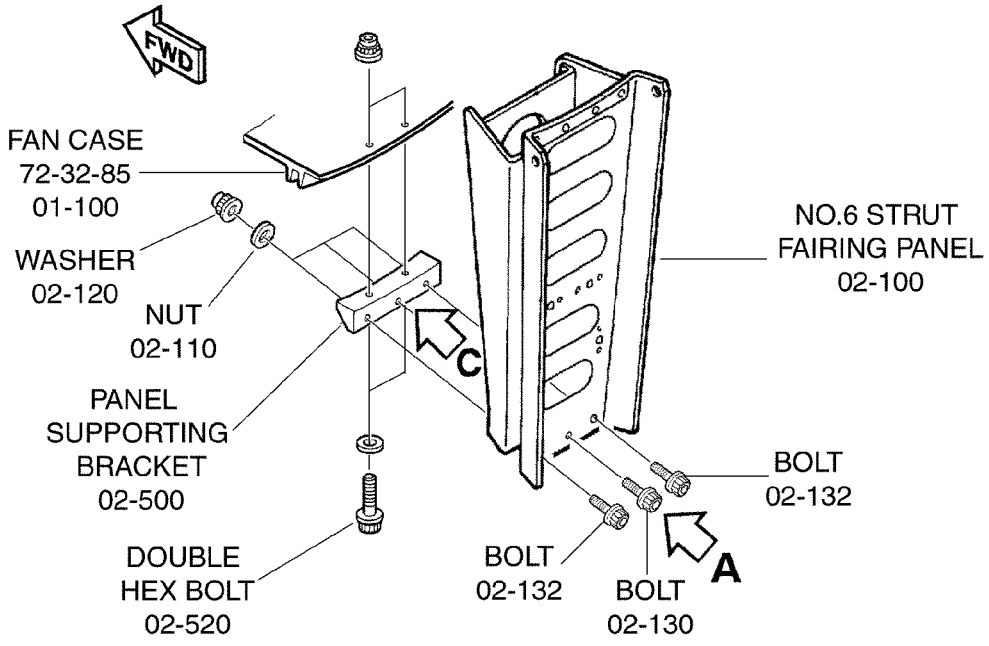
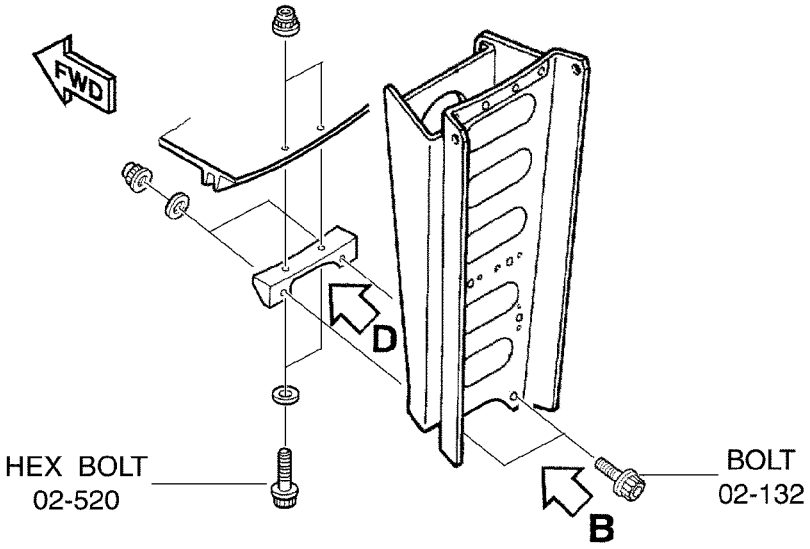


BEFORE ALTERATION



AFTER ALTERATION

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Before and after alteration of No.6 Strut Fairing Panel, Panel Supporting Bracket
Figure 2 (Sheet 1 of 3)

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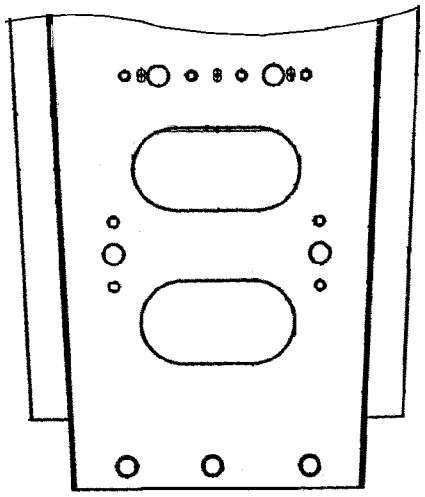
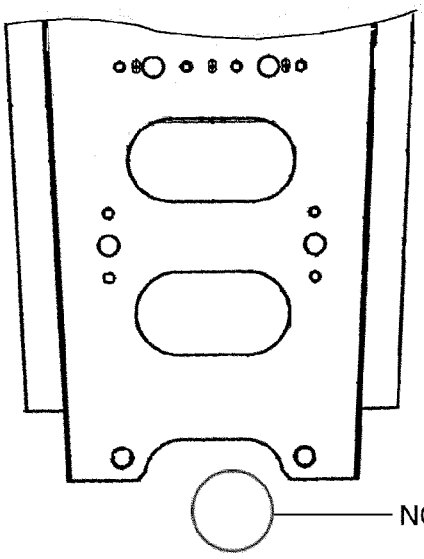


BEFORE ALTERATION

A



AFTER ALTERATION

B

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Before and after alteration of No.6 Strut Fairing Panel, Panel Supporting Bracket
Figure 2 (Sheet 2 of 3)

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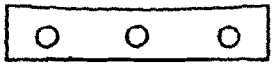
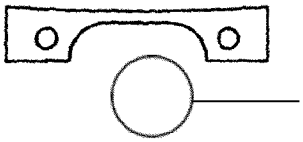


BEFORE ALTERATION

C



AFTER ALTERATION

D

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Before and after alteration of No.6 Strut Fairing Panel, Panel Supporting Bracket
Figure 2 (Sheet 3 of 3)

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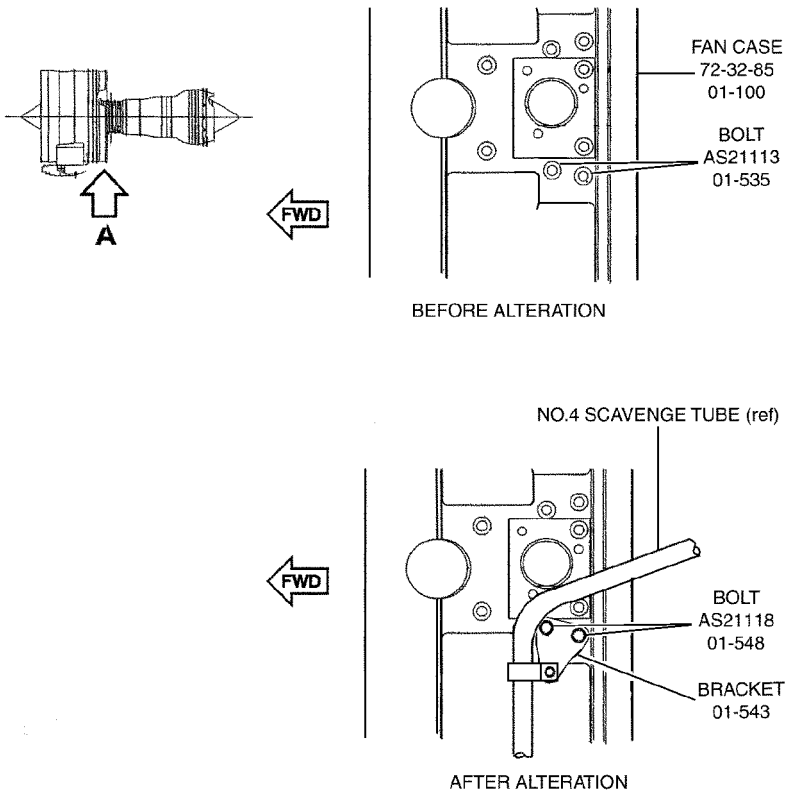

Before and after alteration of new Bracket and Bolts
Figure 3

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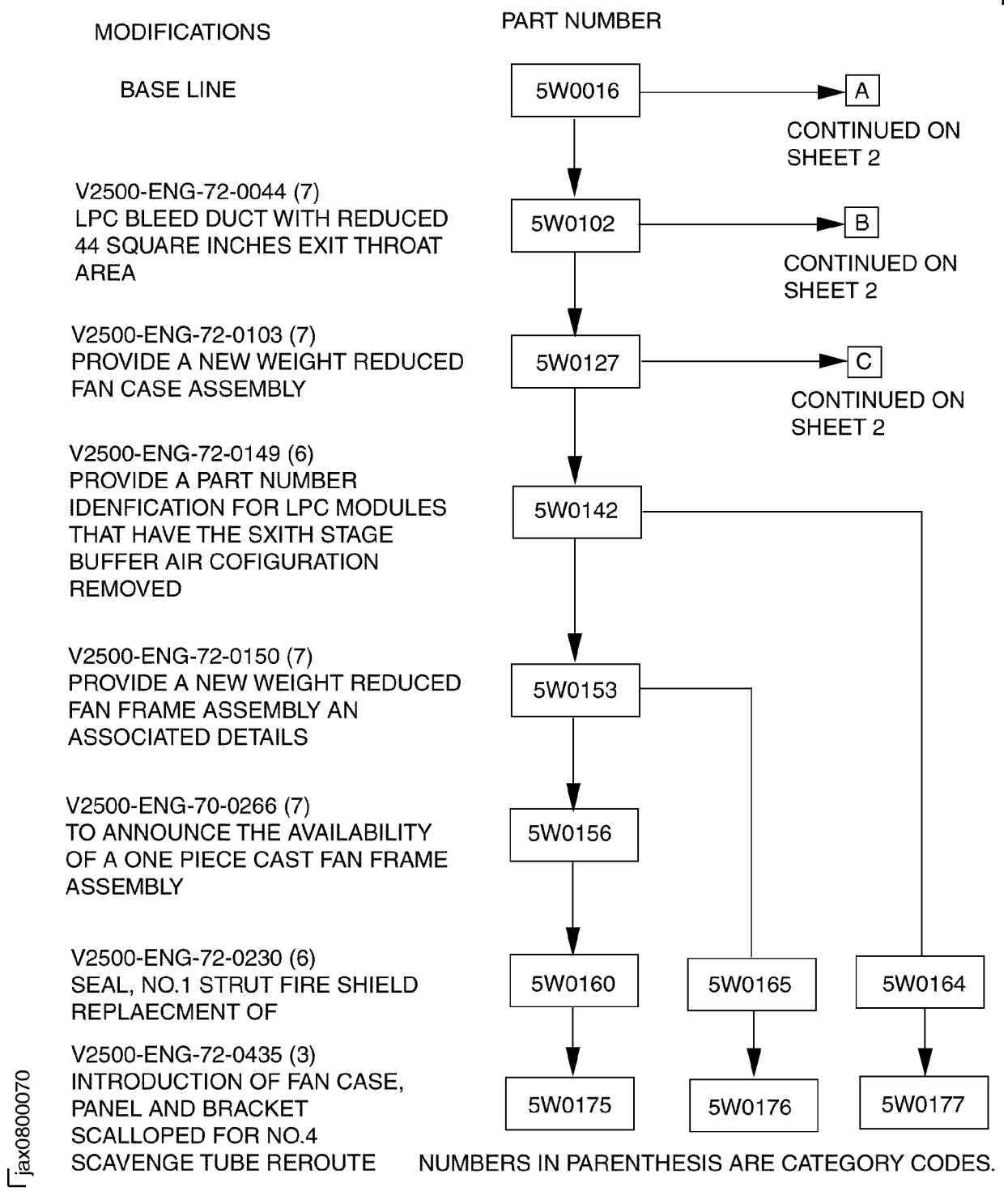

Family Tree - LPC/Intermediate Case Module for V2500-A1 (72-32-00, Fig 01 Item 001)
Figure 4 (Sheet 1 of 2)

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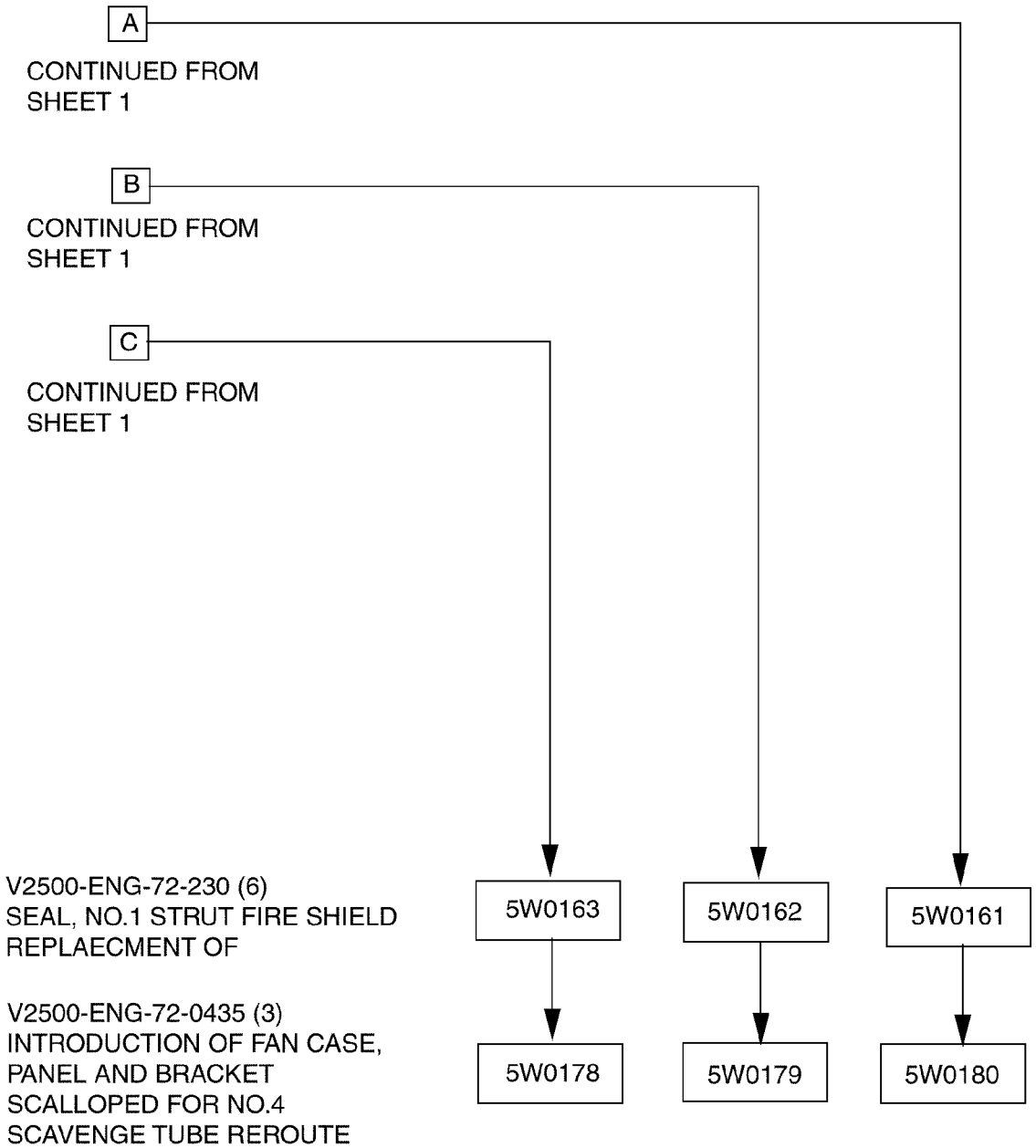

Family Tree - LPC/Intermediate Case Module for V2500-A1 (72-32-00, Fig 01 Item 001)
Figure 4 (Sheet 2 of 2)

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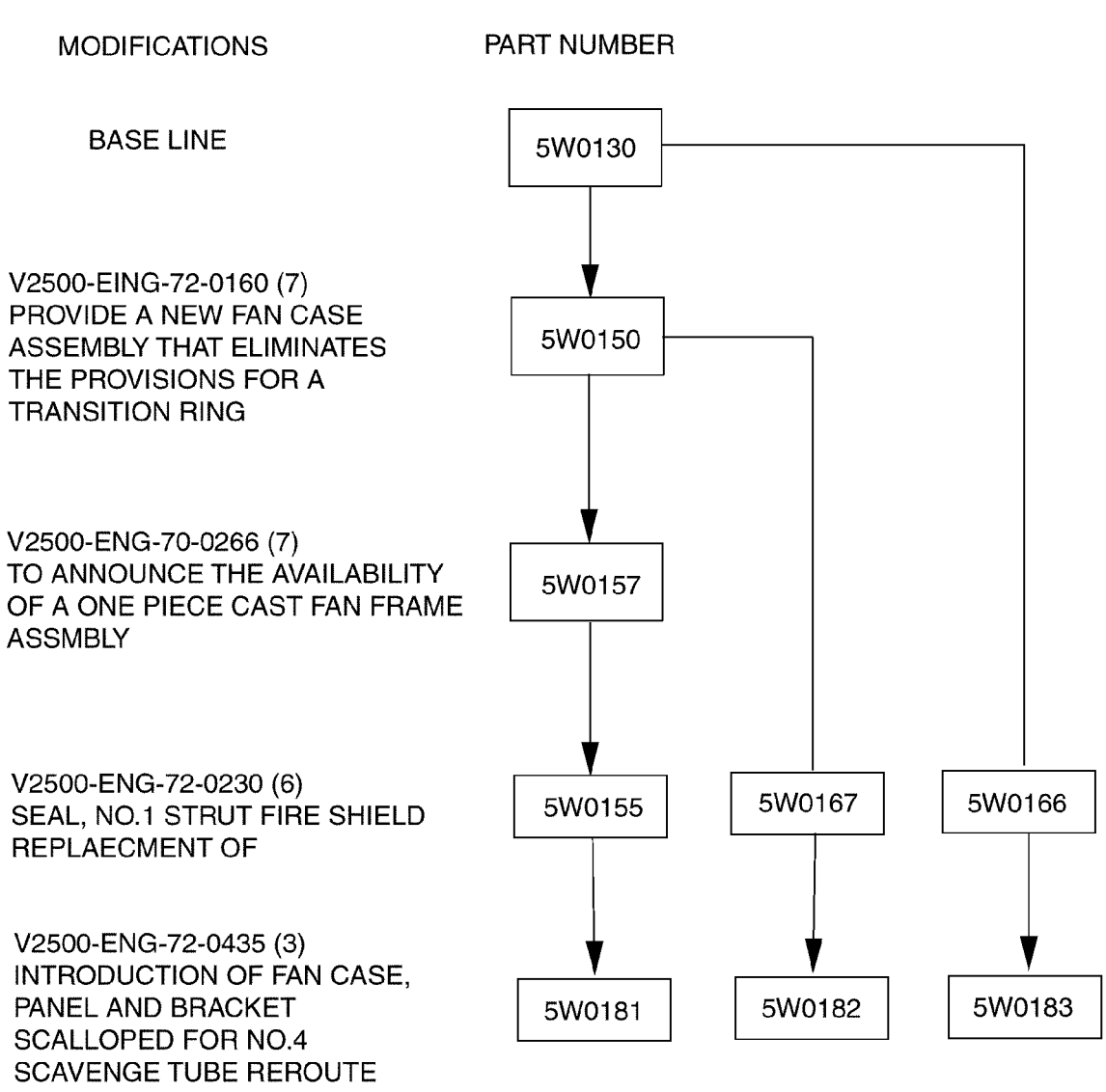

NUMBERS IN PARENTHESIS ARE CATEGORY CODES.

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Family Tree - LPC/Intermediate Case Module for V2500-A5 (72-32-00, Fig 01 Item 001)
Figure 5

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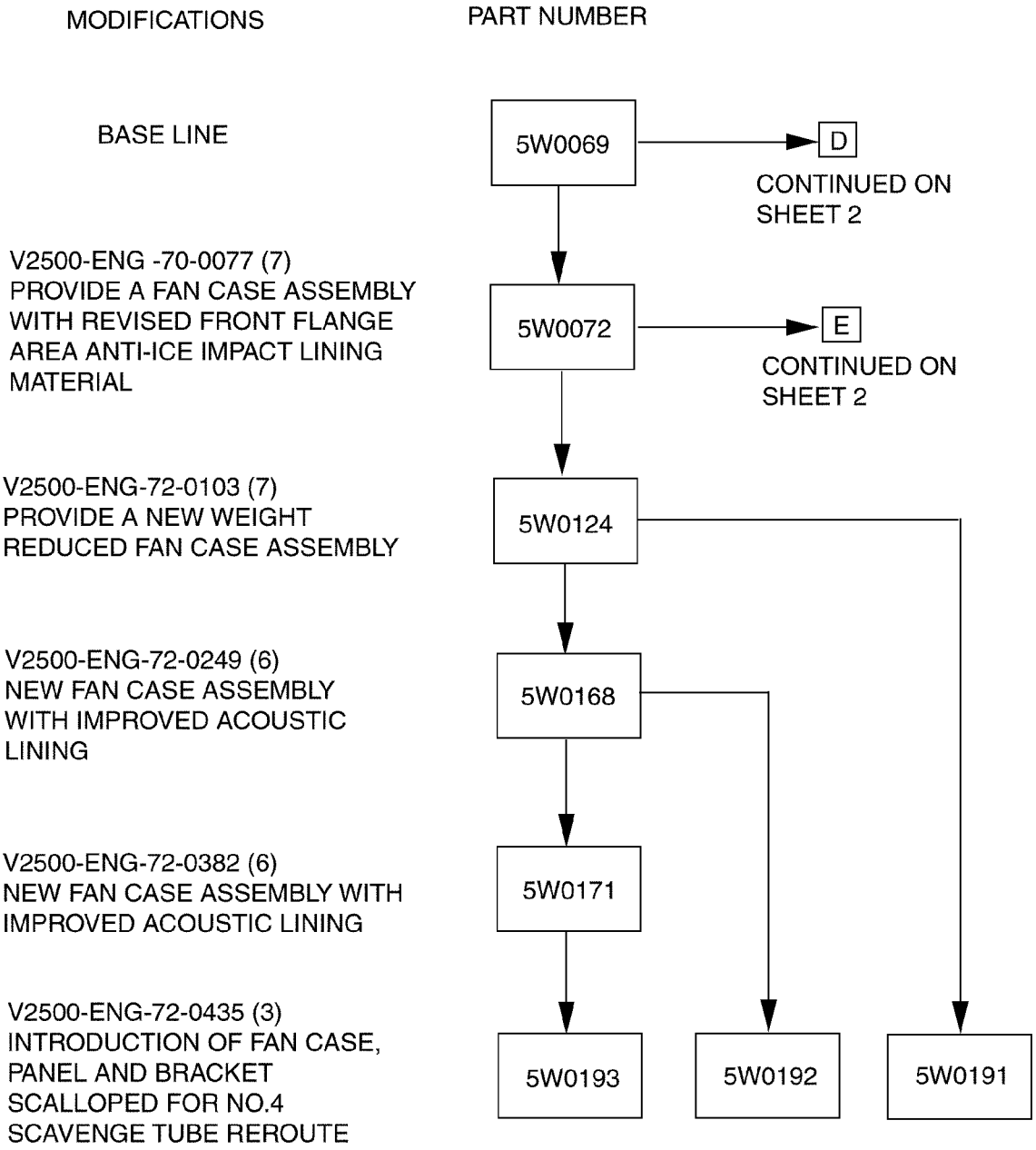

NUMBERS IN PARENTHESIS ARE CATEGORY CODES.

Family Tree - Fan Case for V2500-A1 (72-32-85, Fig 01 Item 100)
Figure 6 (Sheet 1 of 2)

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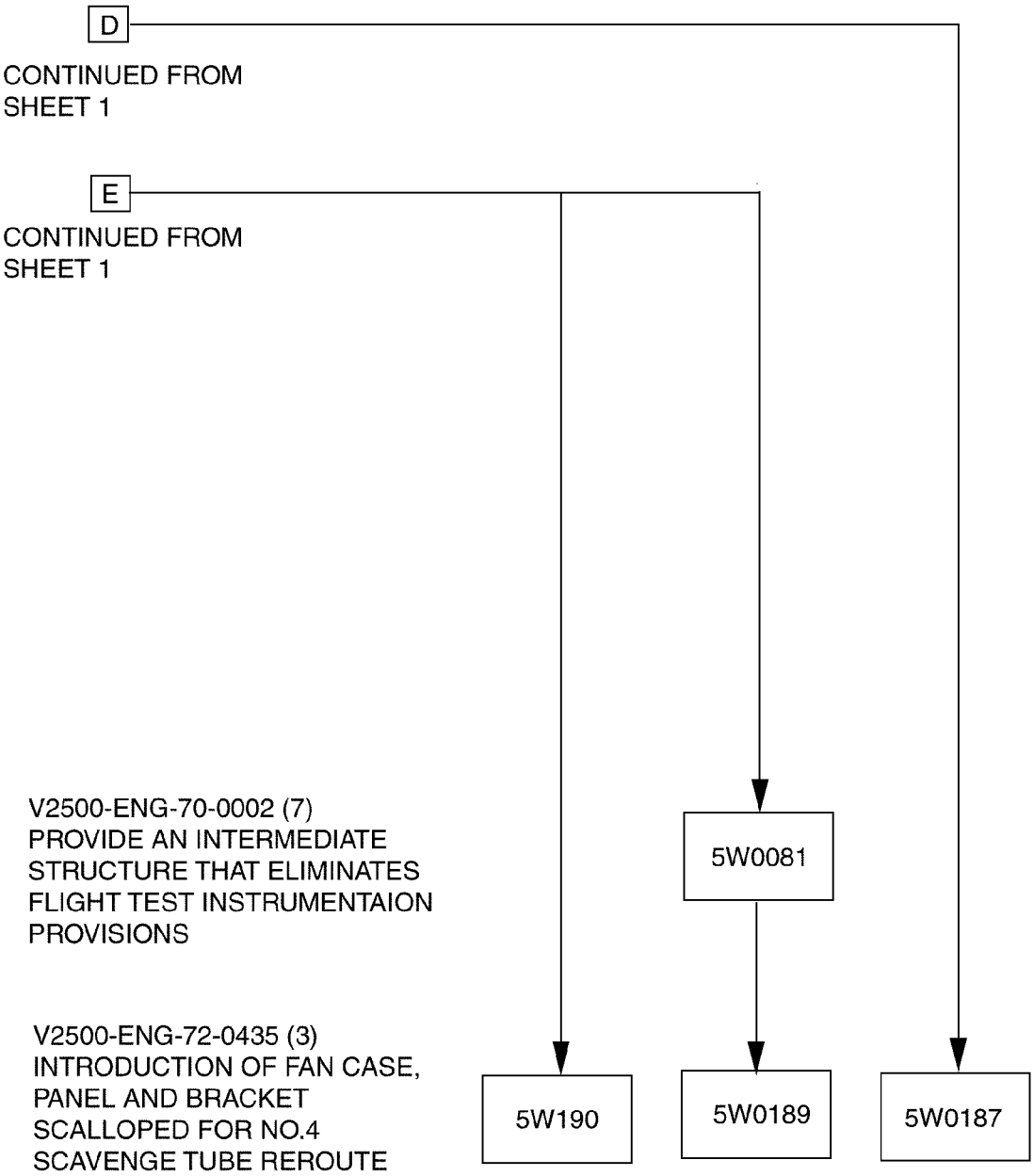

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Family Tree - Fan Case for V2500-A1 (72-32-85, Fig 01 Item 100)
Figure 6 (Sheet 2 of 2)

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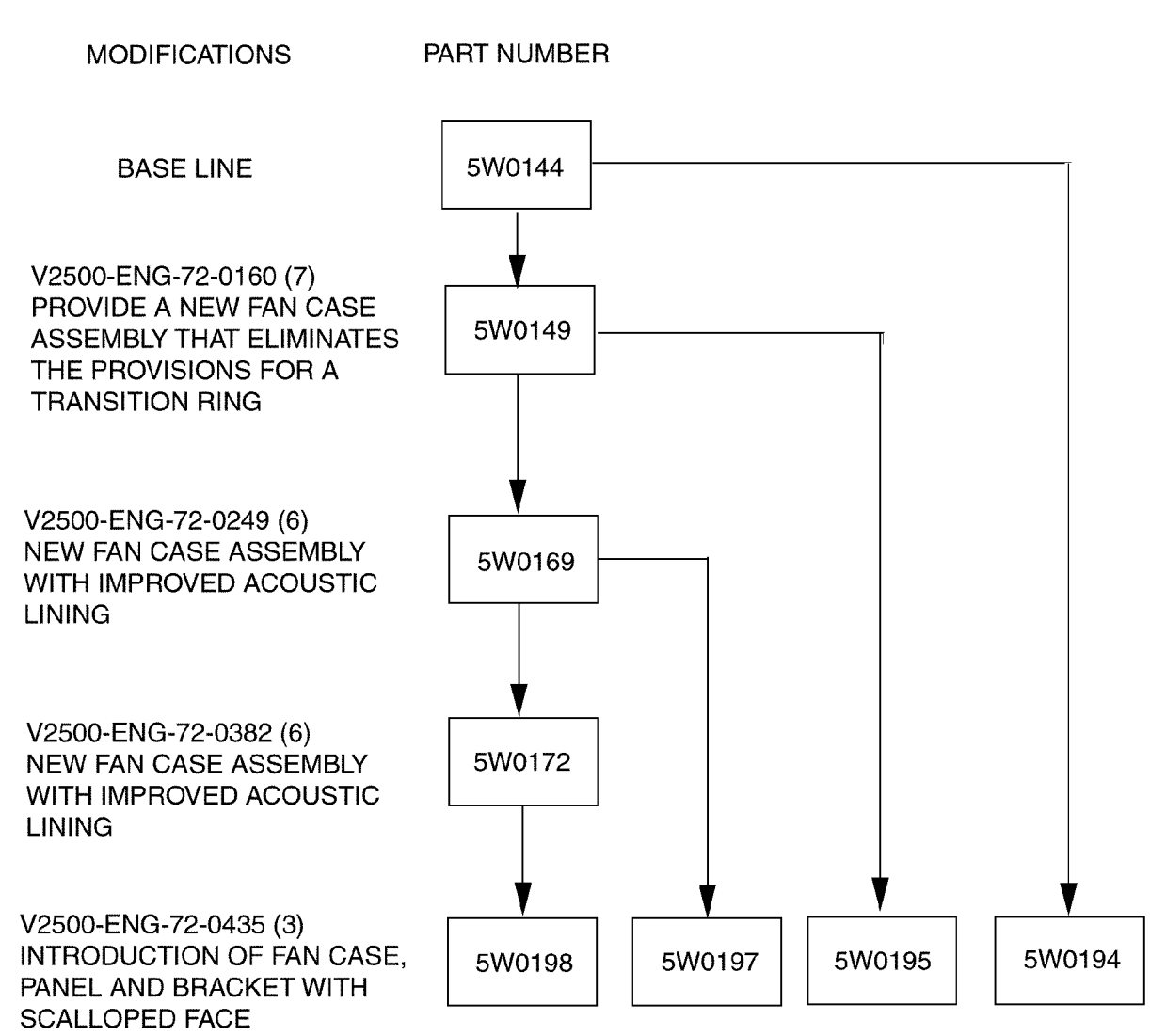

jax0800099

NUMBERS IN PARENTHESIS ARE CATEGORY CODES.

Family Tree - Fan Case for V2500-A5 (72-32-85, Fig 01 Item 100)
Figure 7

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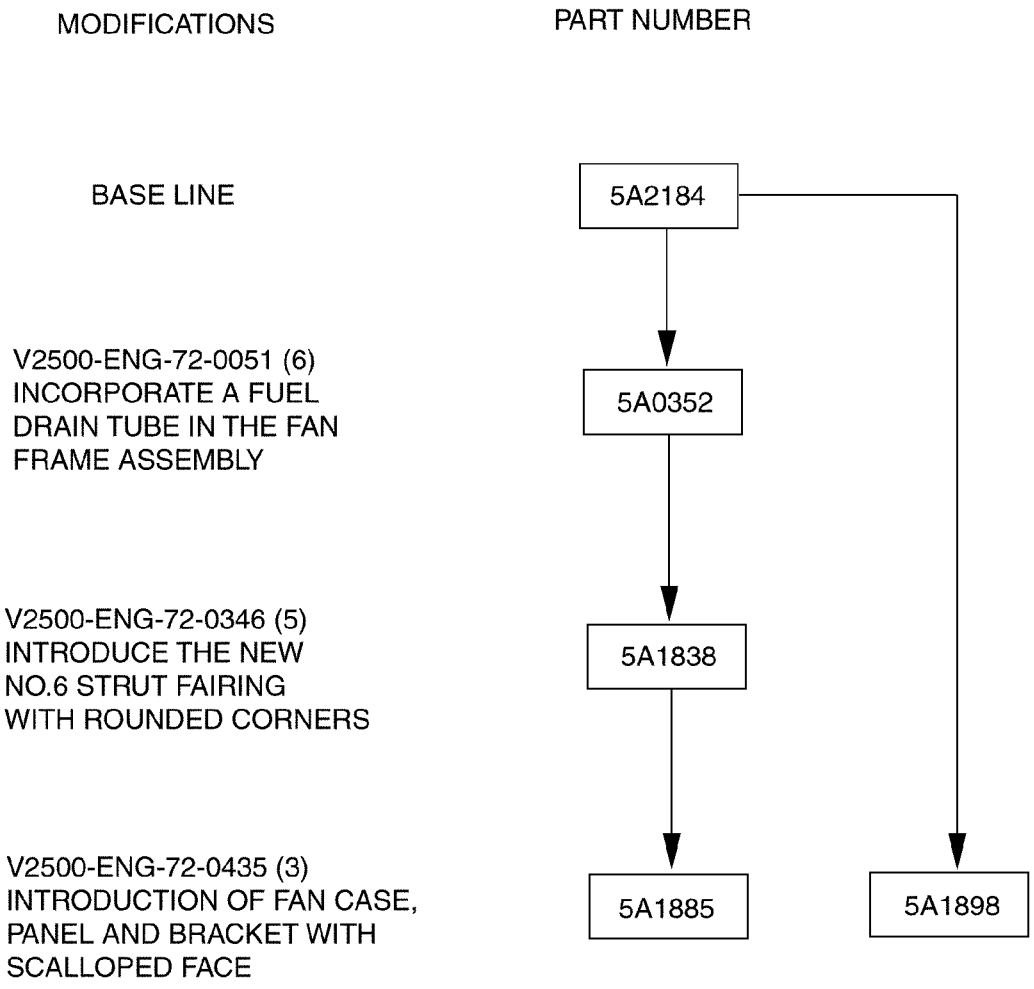

NUMBERS IN PARENTHESIS ARE CATEGORY CODES.

jax0800101

Family Tree - No.6 Strut Fairing Panel for V2500-A1 (72-32-03, Fig 02 Item 100)
Figure 8

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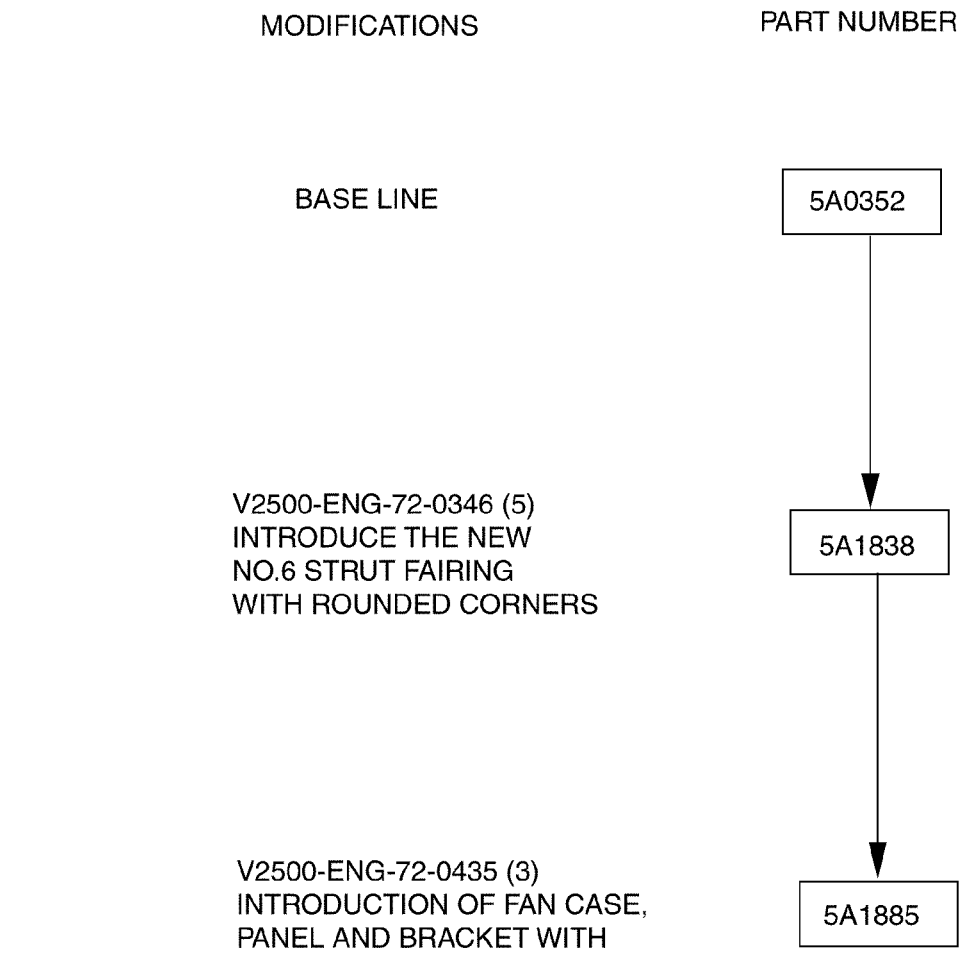

jax0800100

Family Tree - No.6 Strut Fairing Panel for V2500-A5 (72-32-03, Fig 02 Item 100)
Figure 9

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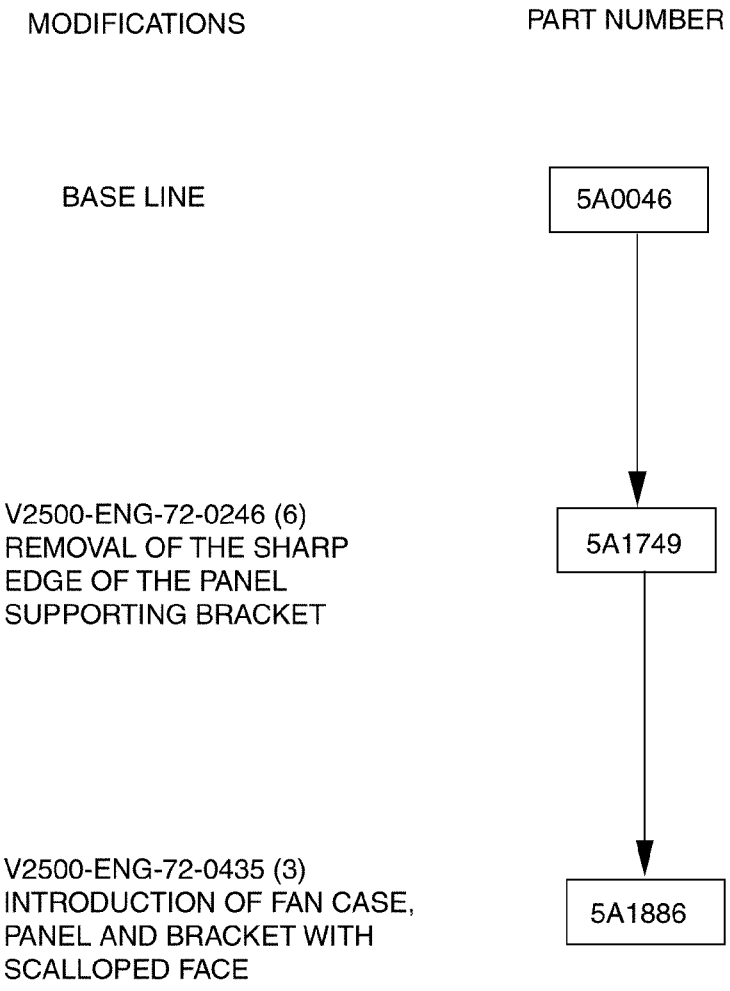

jax0800102

Family Tree - Panel Supporting Bracket for V2500-A1 and V2500-A5 (72-32-03, Fig 02 Item 500)
Figure 10

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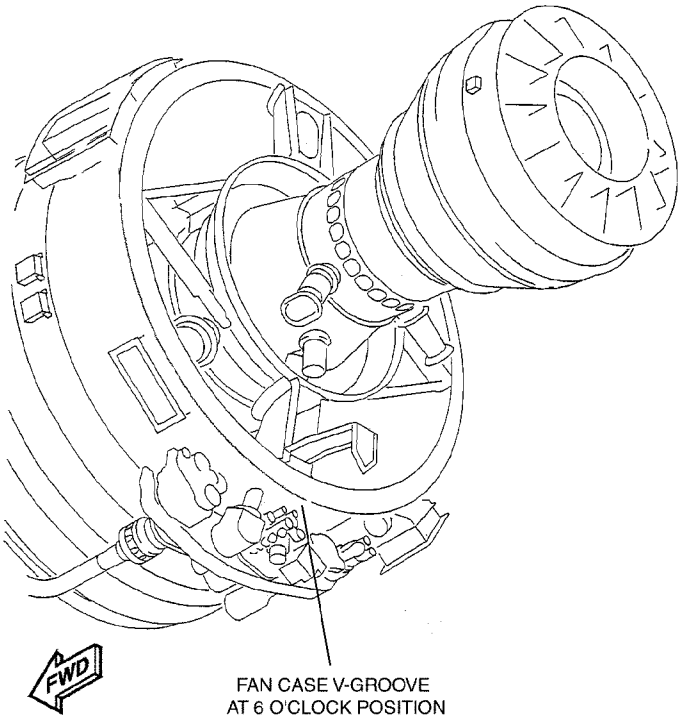

jax0800107

Location of Fan Case, No.6 Strut Fairing Panel and Panel Supporting Bracket
Figure 11 (Sheet 1 of 2)

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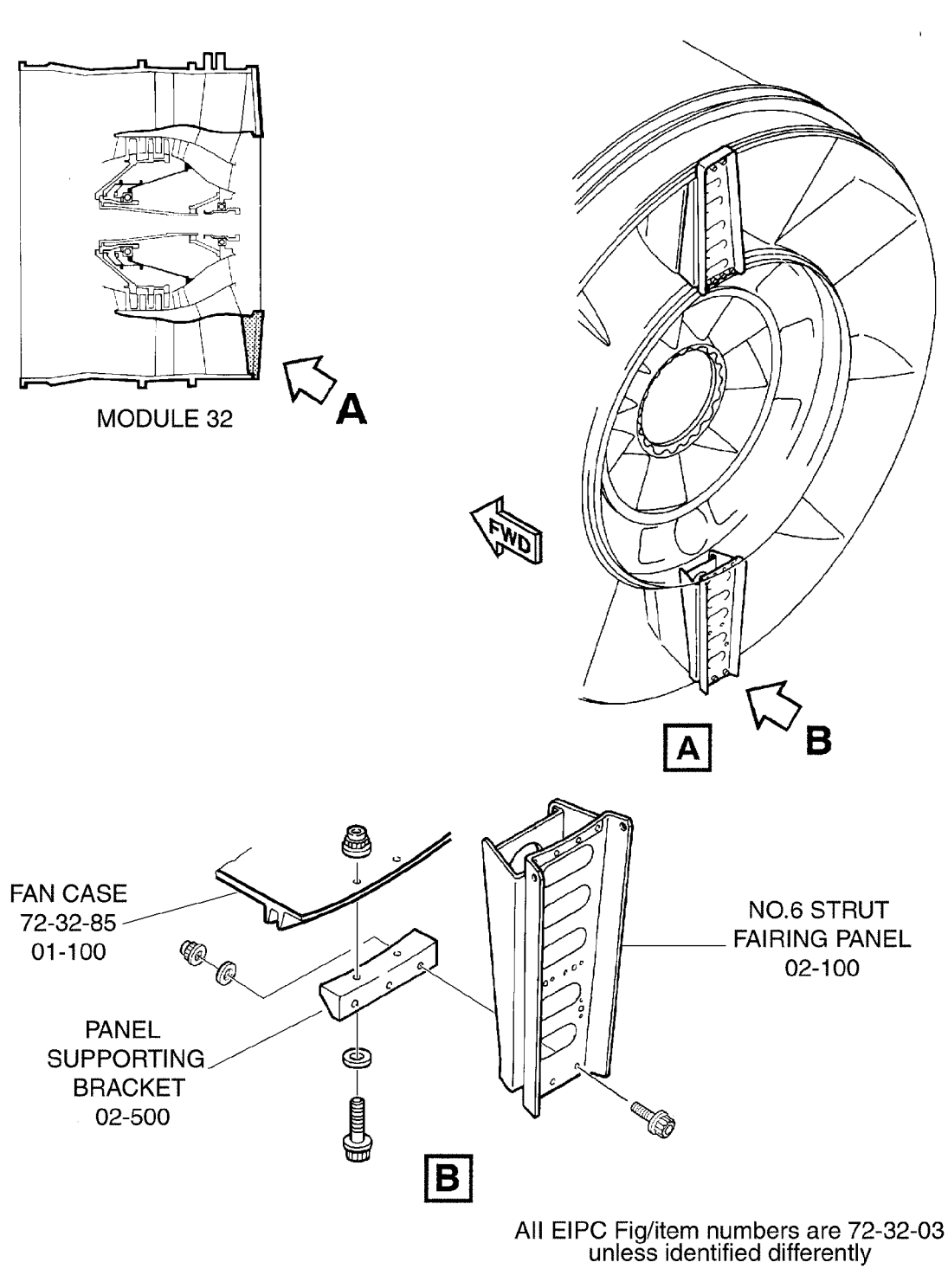

Location of Fan Case, No.6 Strut Fairing Panel and Panel Supporting Bracket
Figure 11 (Sheet 2 of 2)

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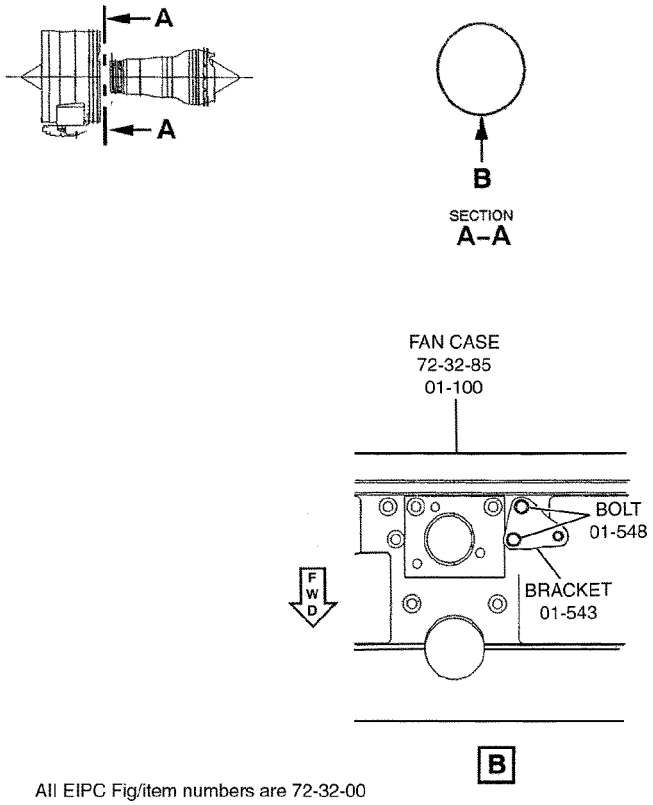

Location of new 5A1884 Bracket
Figure 12

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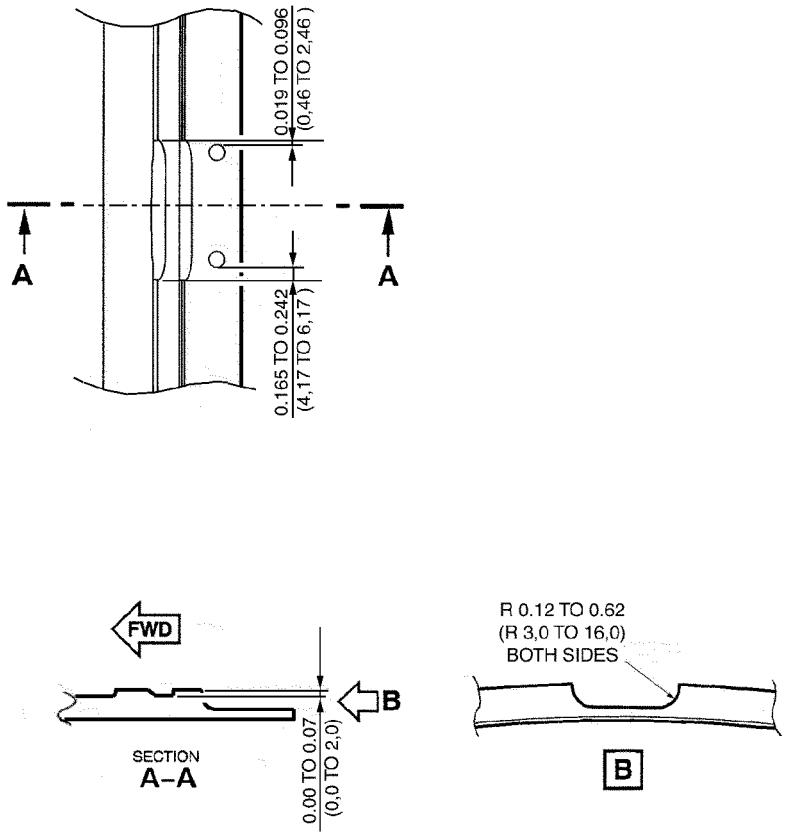

ALL DIMENSIONS ARE IN INCHES (MILLIMETRES).

Rework and reidentification of Fan Case
Figure 13 (Sheet 1 of 2)

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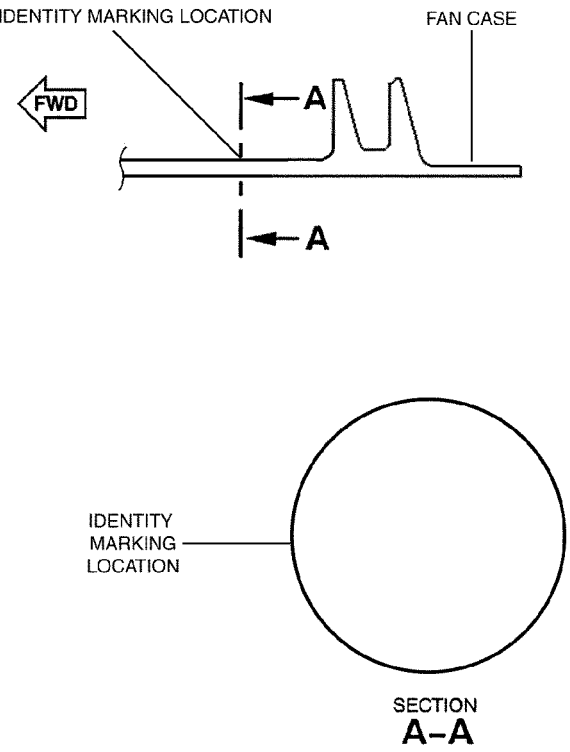

jax0800106

Rework and reidentification of Fan Case
Figure 13 (Sheet 2 of 2)

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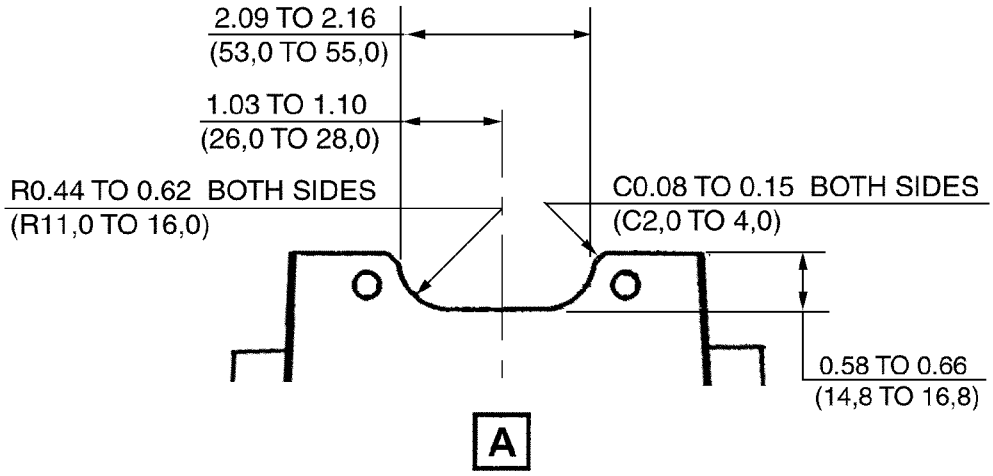

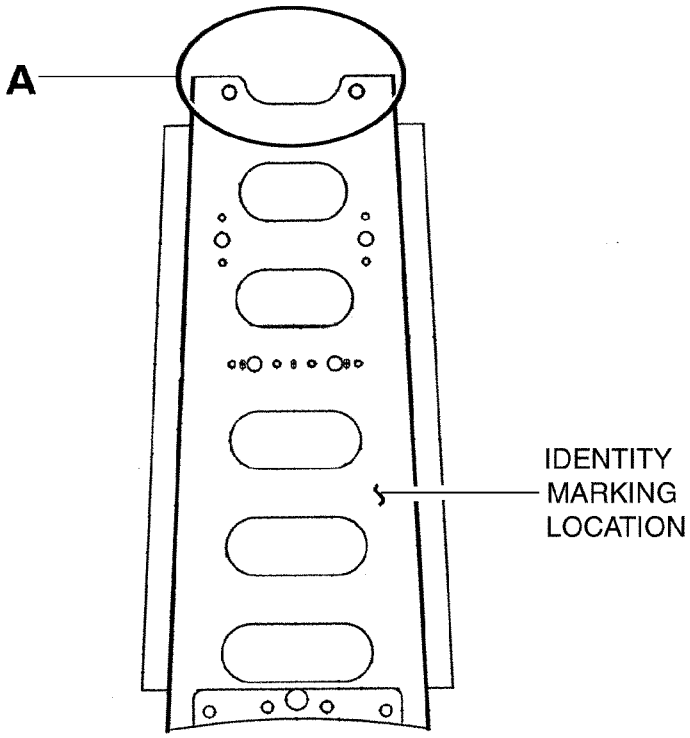

jax0800074

ALL DIMENSIONS ARE IN INCHES (MILLIMETRES).

Rework and reidentification of No.6 Strut Fairing Panel
Figure 14

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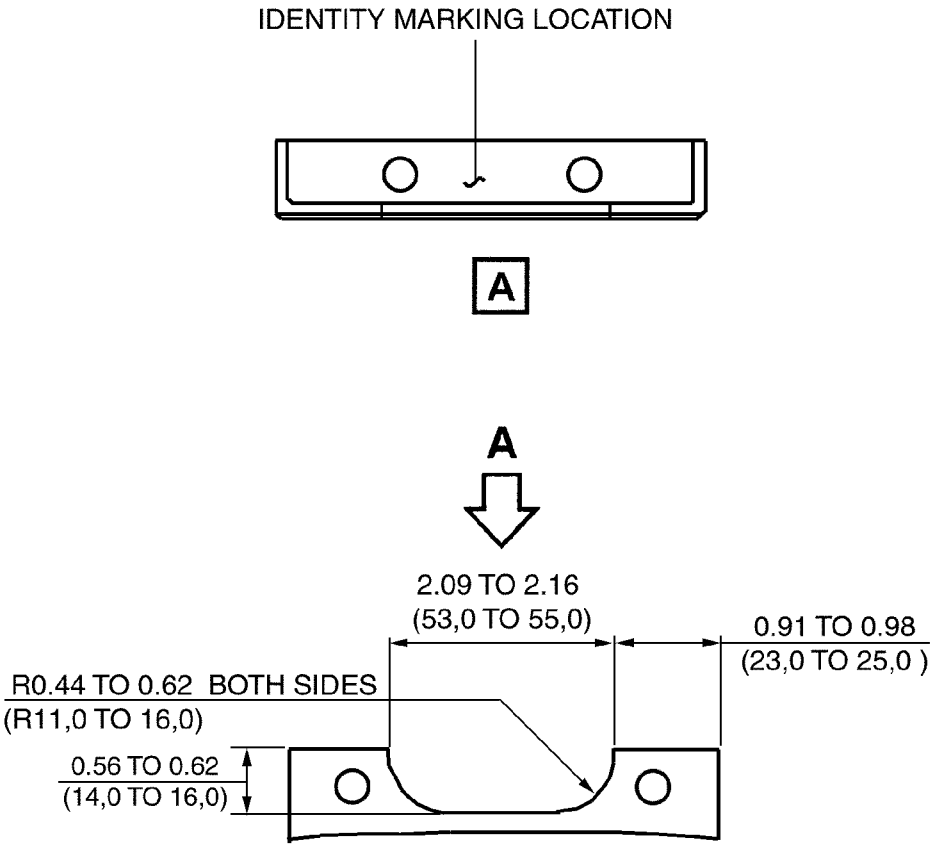

ALL DIMENSIONS ARE IN INCHES (MILLIMETRES).

jax0800076

Rework and reidentification of Panel Supporting Bracket
Figure 15

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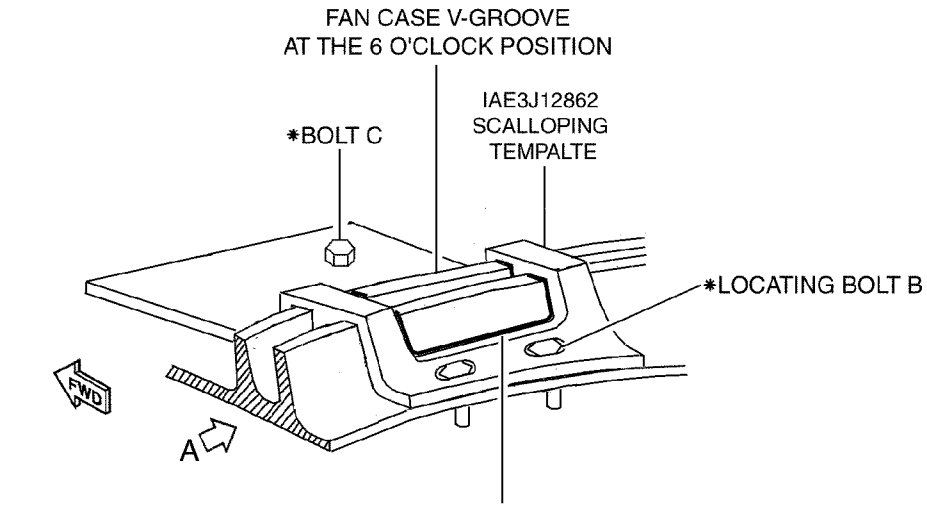

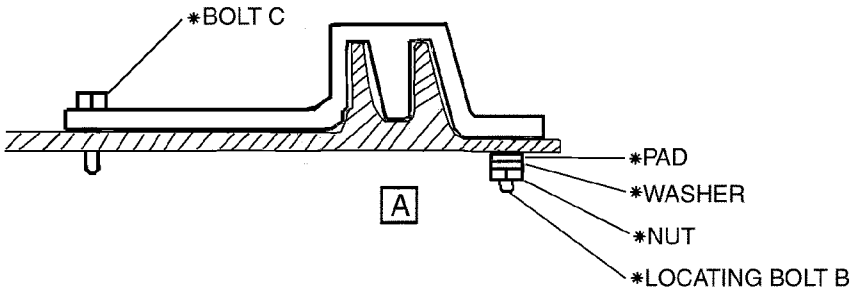

* PART OF THE IAE3J12862 SCALLOPING TEMPLATE

jax0800085

INSTALL THE BOLT C AFTER THE TWO LOCATING BOTLS B ARE TIGHTENED
TO LOCATE THE TEMPLATE AT THE CORRECT POSITION ON THE FAN CASE

Installation of IAE 3J12862 Scalloping Template
Figure 16

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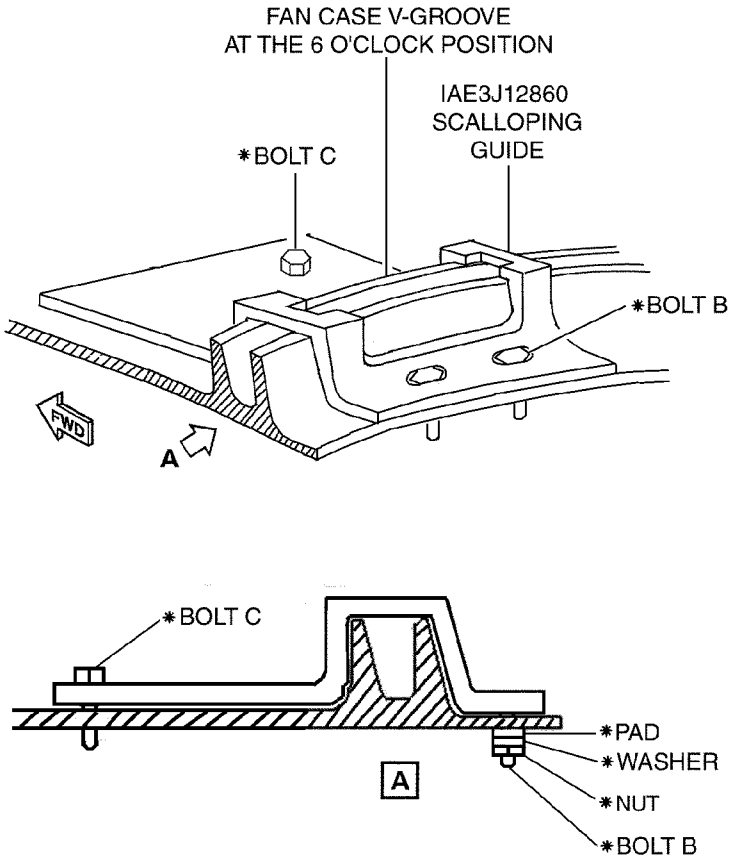

* PART OF THE IAE3J12860 SCALLOPING GUIDE

jax0800069

Installation of IAE 3J12860 Scalloping Guide
Figure 17

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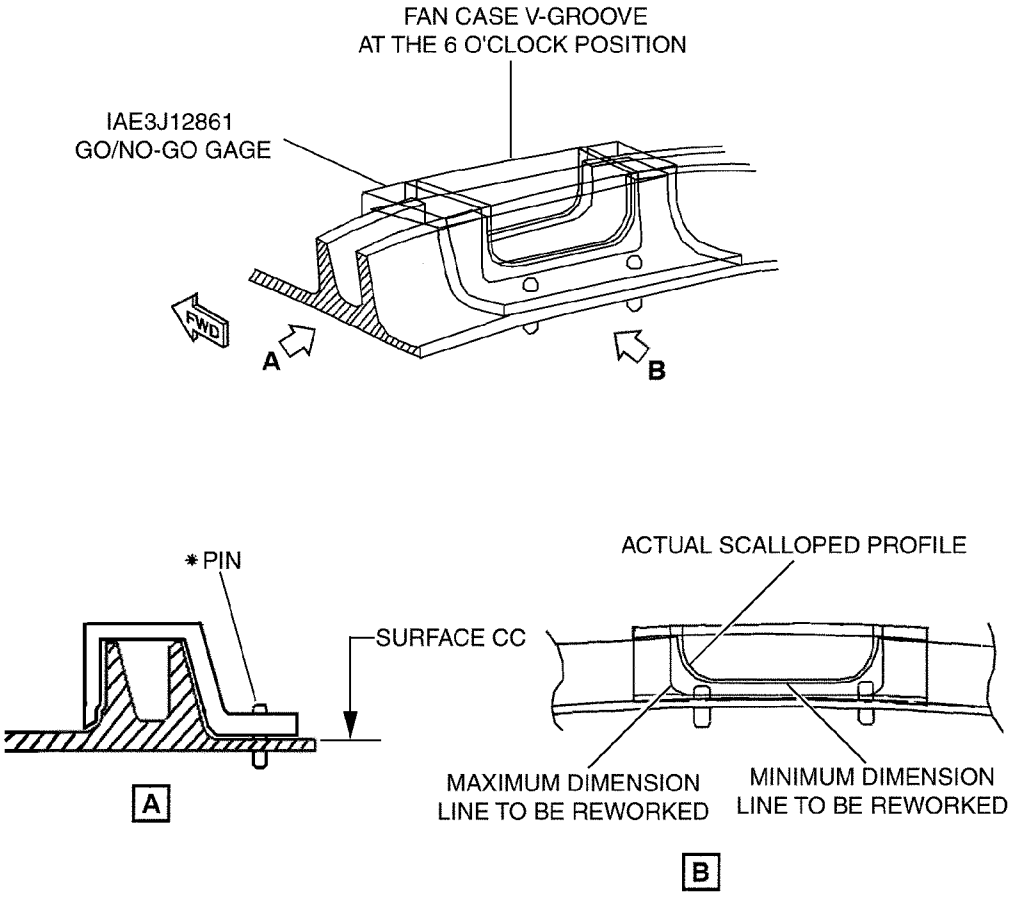

*PART OF THE IAE3J12861 GO/NO-GO GAGE

jax0800082

MAKE SURE THAT THERE IS NO SPACE BETWEEN
THE GAGE AND THE SURFACE CC OF THE FAN CASE FLANGE

Installation of IAE 3J12861 Go/No-Go Gage
Figure 18

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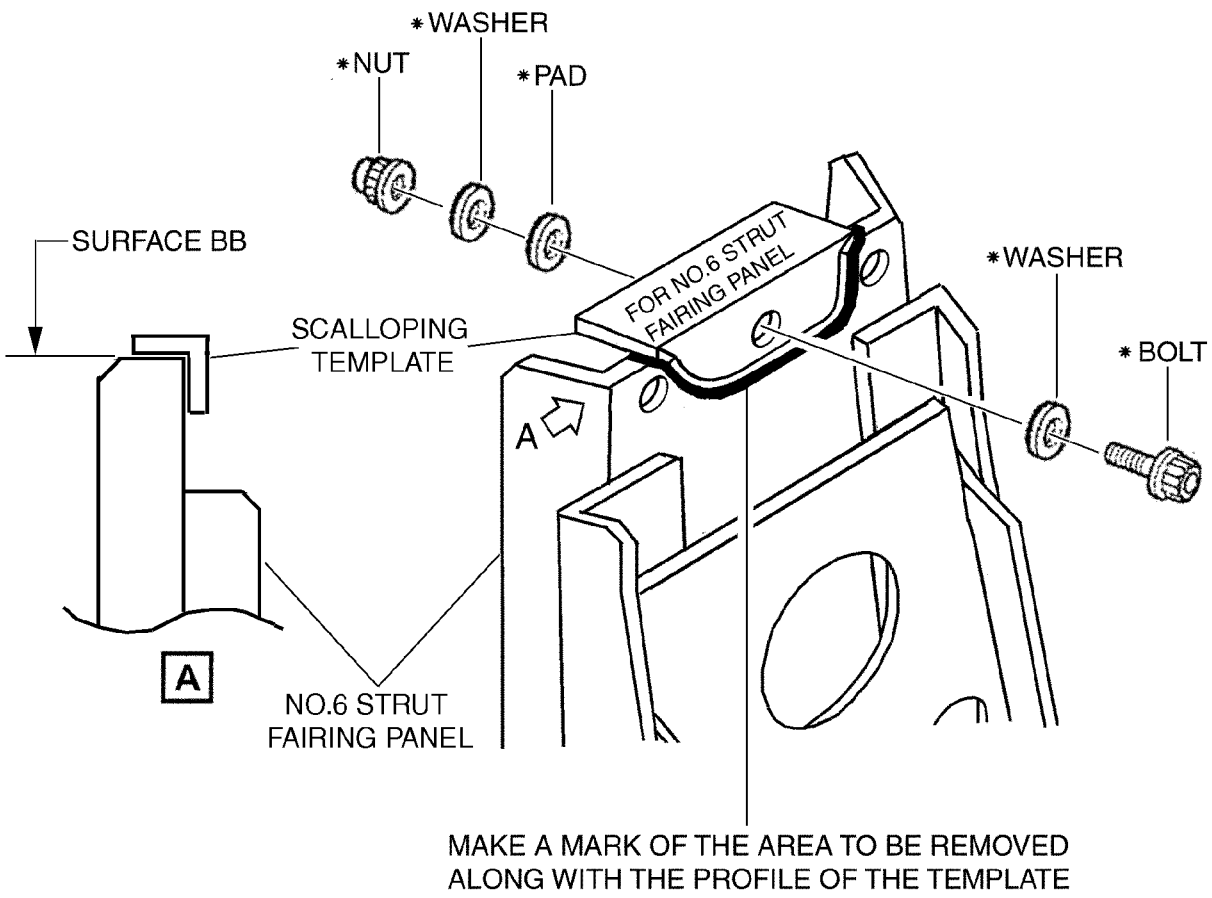

* PART OF THE IAE 3J12863 SCALLOPING TEMPLATE

MAKE SURE THAT THERE IS NO SPACE BETWEEN THE TEMPLATE AND THE SURFACE BB OF THE NO.6 STRUT FAIRING PANEL

jax0800091

Installation of IAE 3J12863 Scalloping Template
Figure 19

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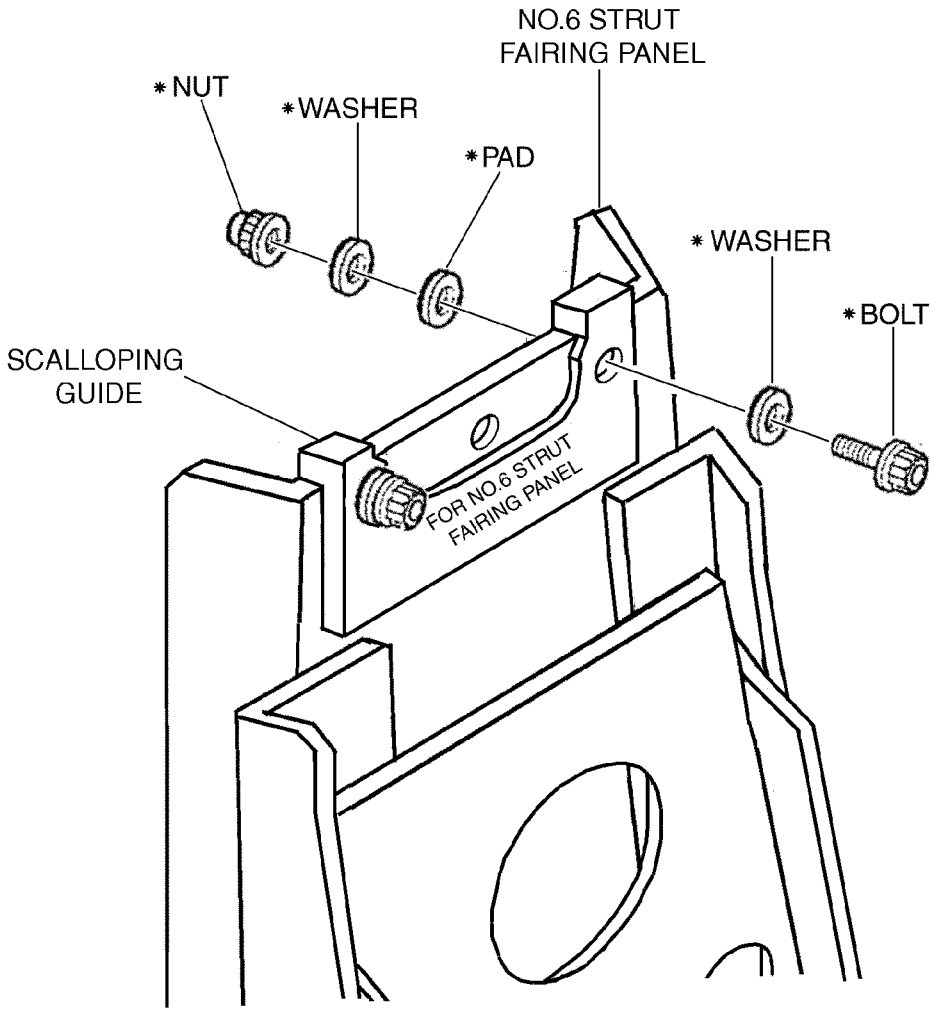

* PART OF THE IAE 3J12865 SCALLOPING GUIDE

jax0800096

Installation of IAE 3J12865 Scalloping Guide
Figure 20

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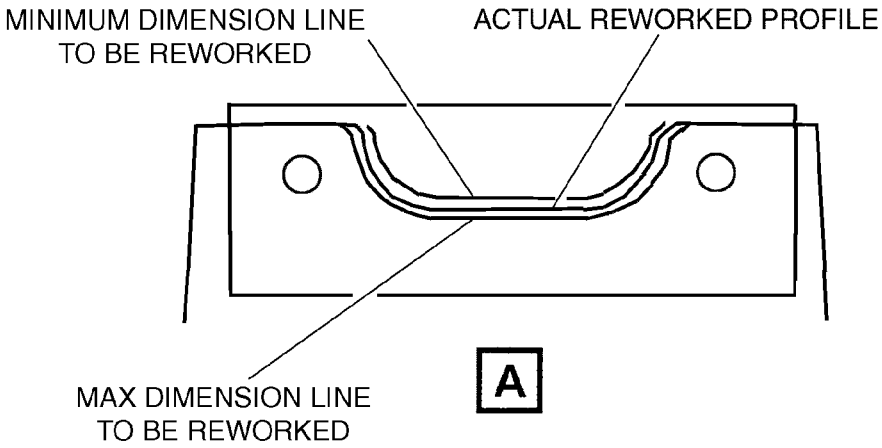

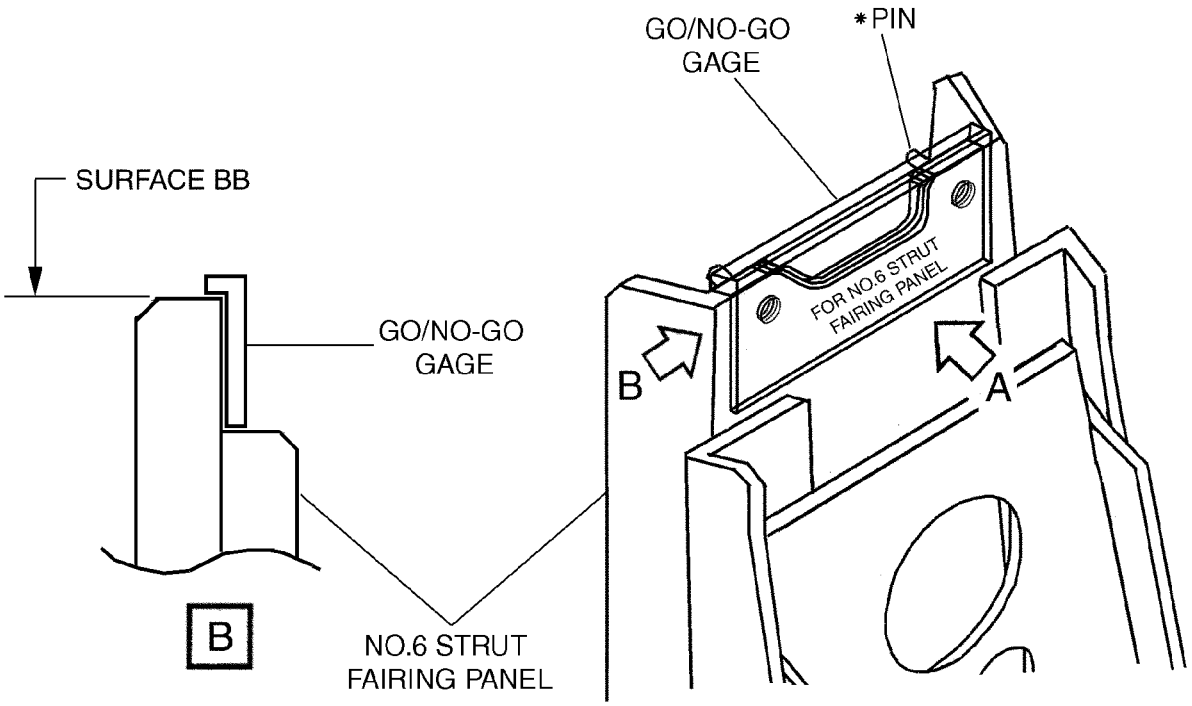

* PART OF THE IAE 3J12864 GO/NO-GO GAGE

MAKE SURE THAT THERE IS NO SPACE BETWEEN THE GO/NO-GO GAGE AND THE SURFACE BB OF THE NO.6 STRUT FAIRING PANEL

jax0800094

Installation of IAE 3J12864 Go/No-Go Gage
Figure 21

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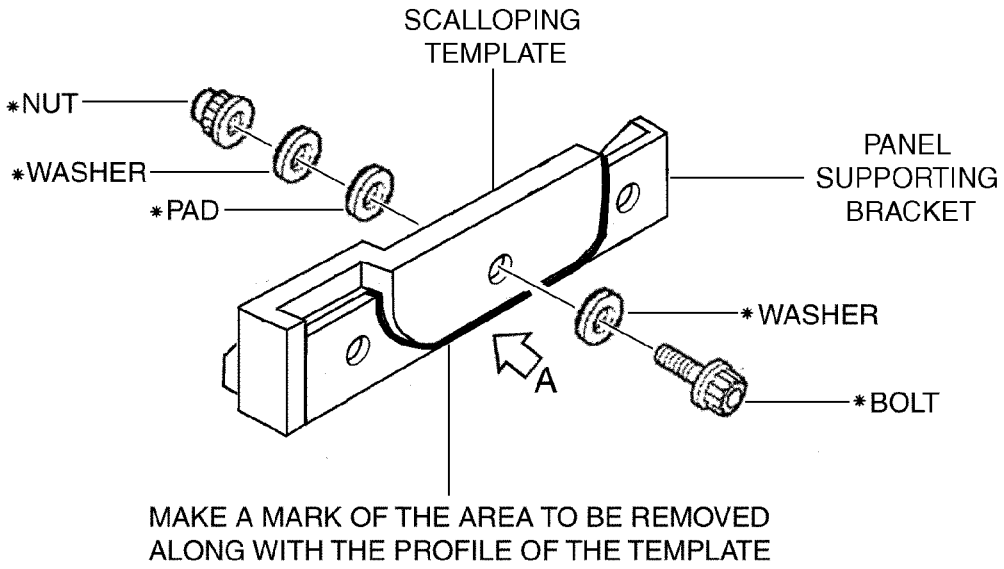

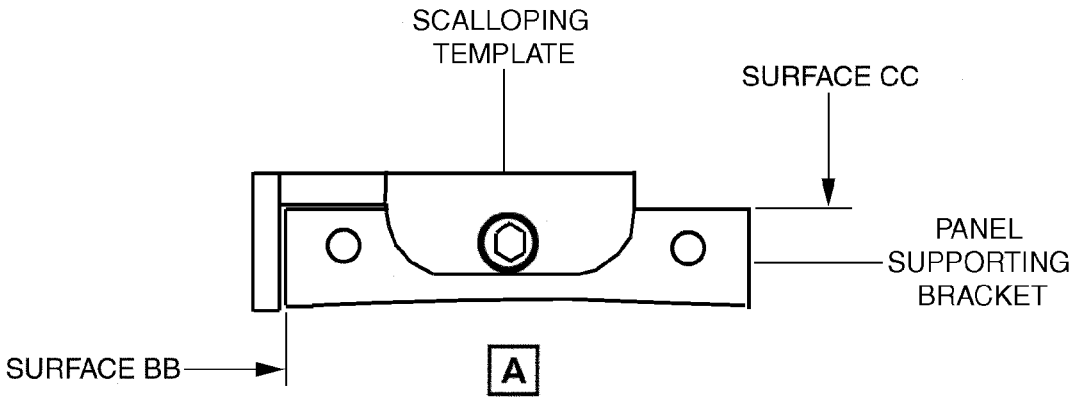

* PART OF THE IAE3J12866 SCALLOPING TEMPLATE

MAKE SURE THAT THERE IS NO SPACE BETWEEN THE TEMPLATE AND THE SURFACE BB OF THE BRACKET

MAKE SURE THAT THERE IS NO SPACE BETWEEN THE TEMPLATE AND THE SURFACE CC OF THE BRACKET

jax0800086

Installation of IAE 3J12866 Scalloping Template
Figure 22

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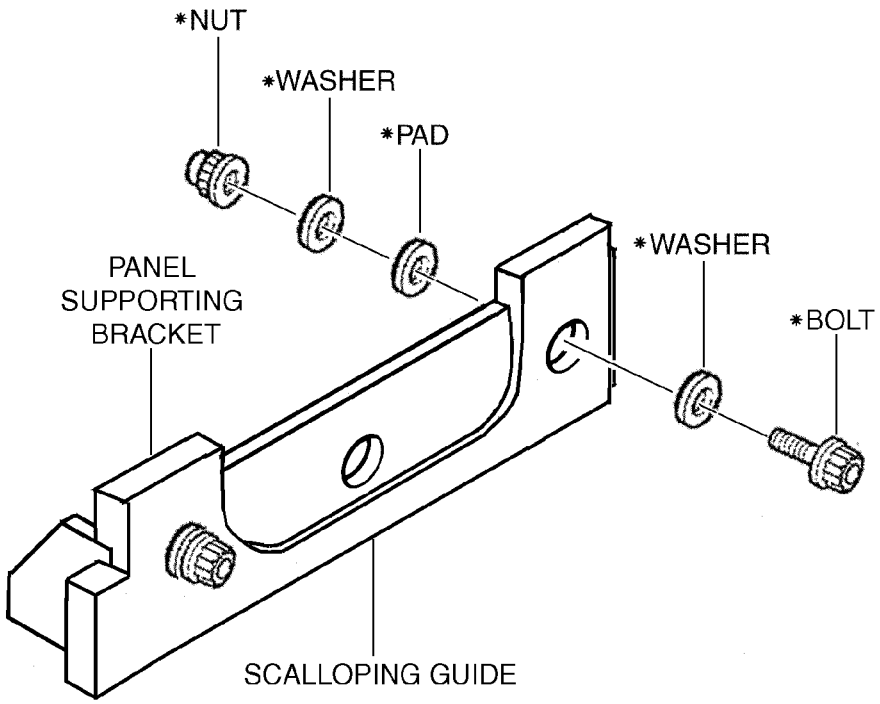

* PART OF THE IAE3J12868 SCALLOPING GUIDE

jax0800088

Installation of IAE 3J12868 Scalloping Guide
Figure 23

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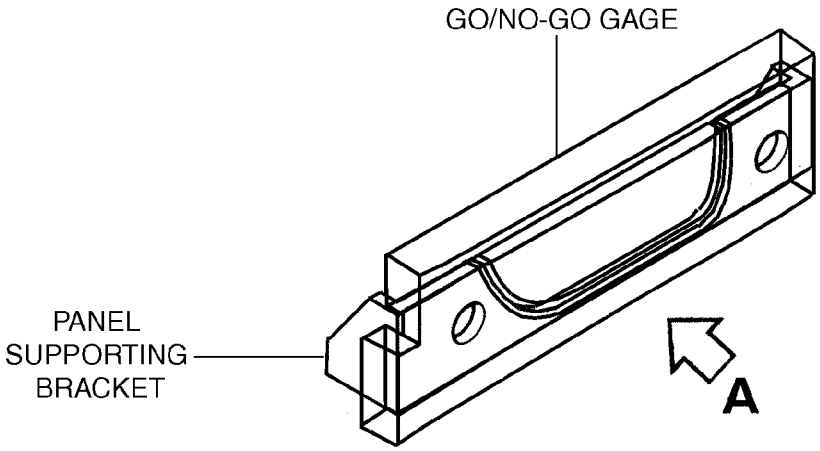

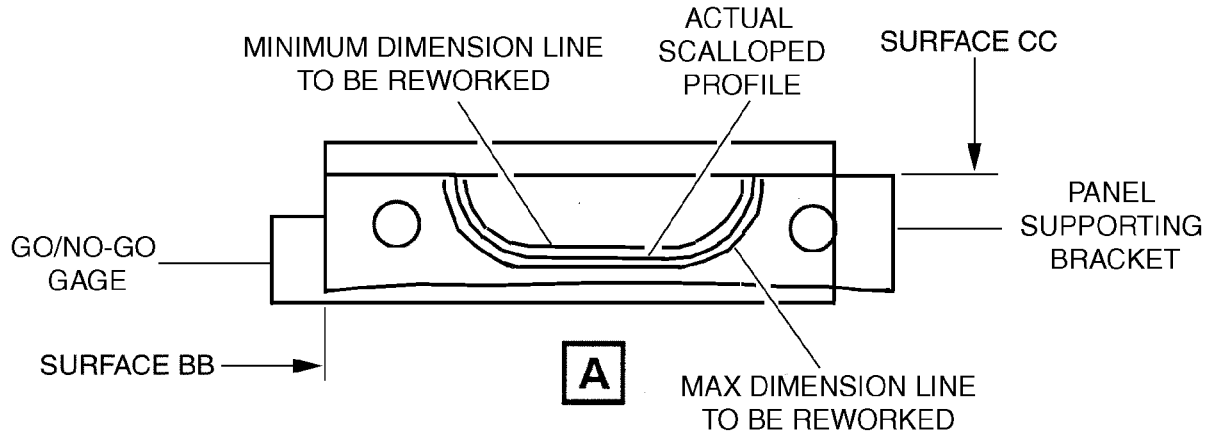

MAKE SURE THAT THERE IS NO SPACE BETWEEN
THE GAGE AND THE SURFACE CC OF THE BRACKET

MAKE SURE THAT THERE IS NO SPACE BETWEEN
THE GAGE AND THE SURFACE BB OF THE BRACKET

jax0800090

Installation of IAE 3J12867 Go/No-Go Gage
Figure 24

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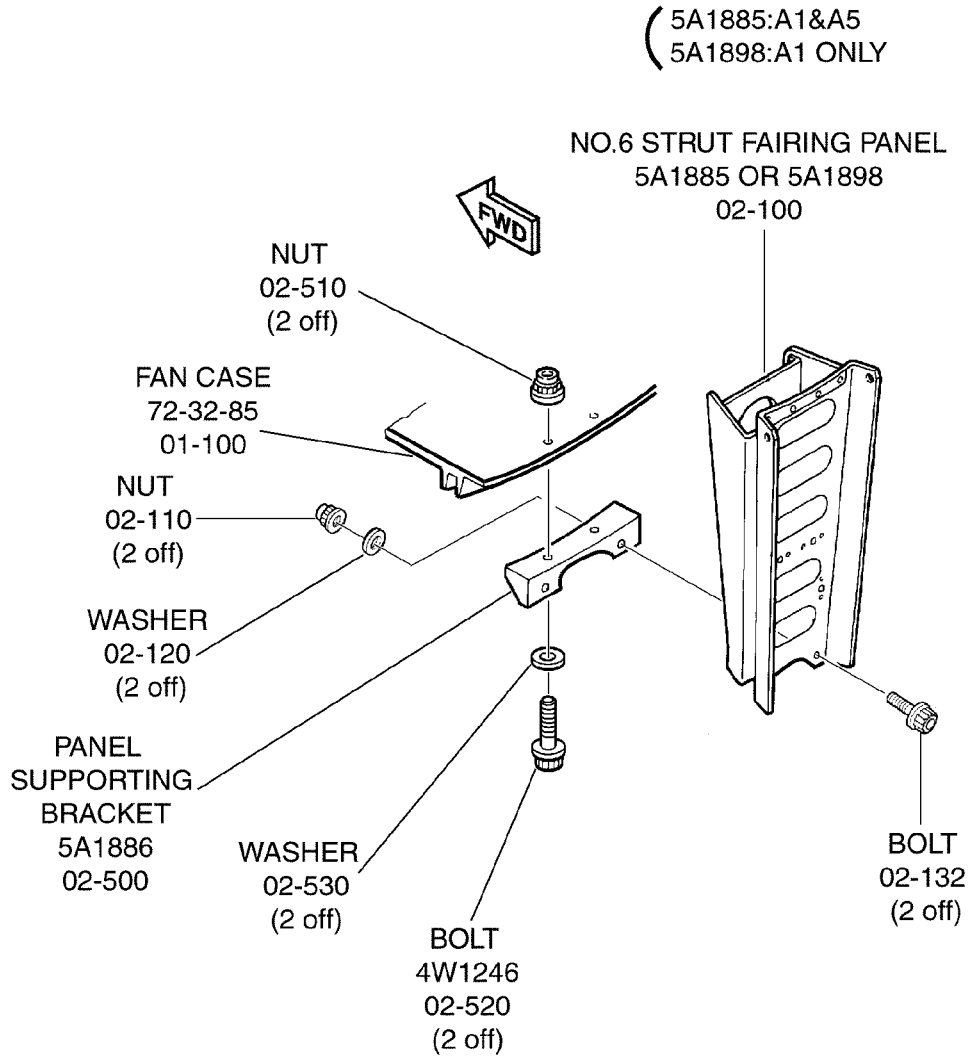

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jax0800105

Installation of new No.6 Strut Fairing Panel, Panel Supporting Bracket
Figure 25

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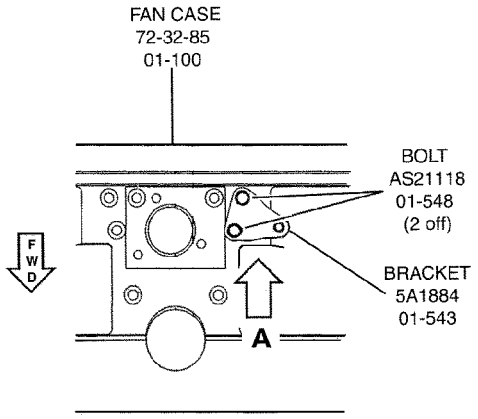

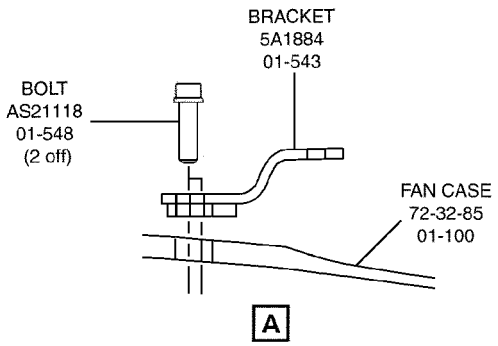

jax0800079

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Installation of new 5A1884 Bracket
Figure 26

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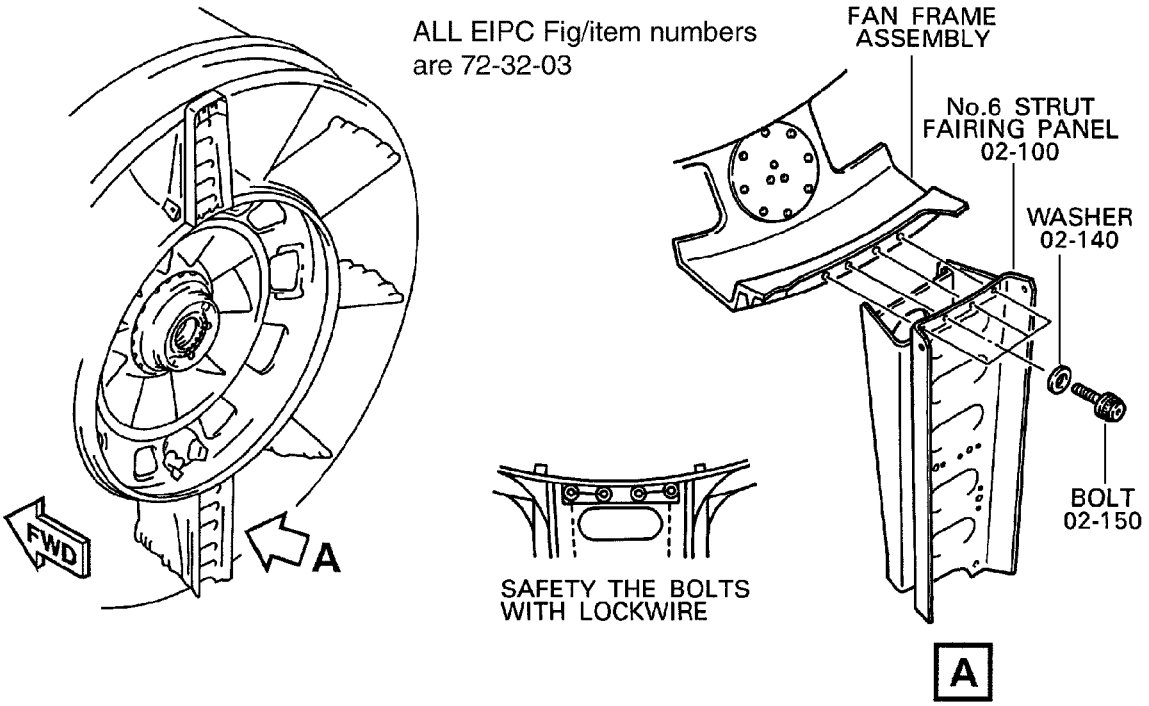

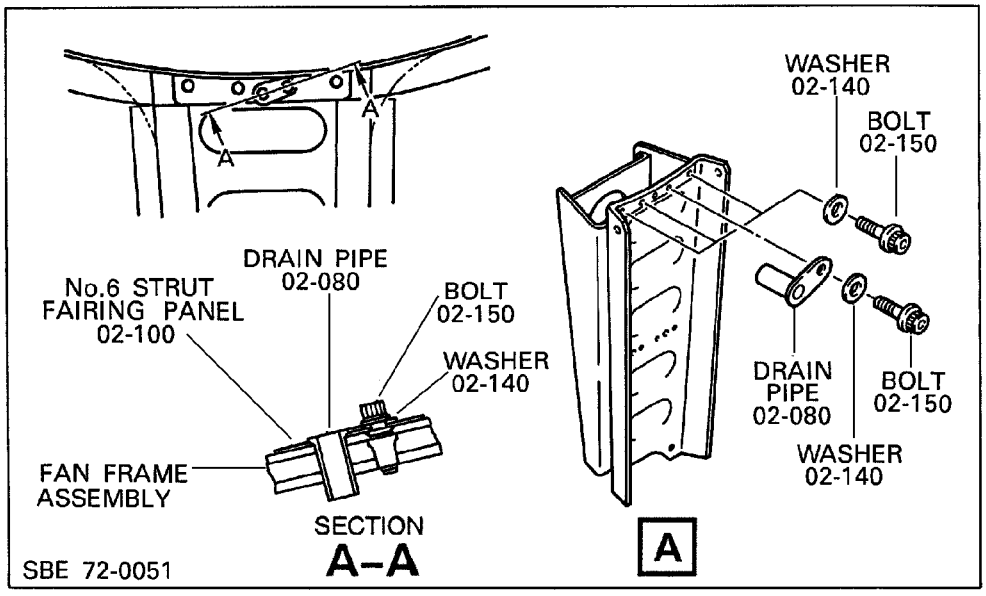

jax0800022

Installation of No.6 Strut Fairing Panel for A1
Figure 27

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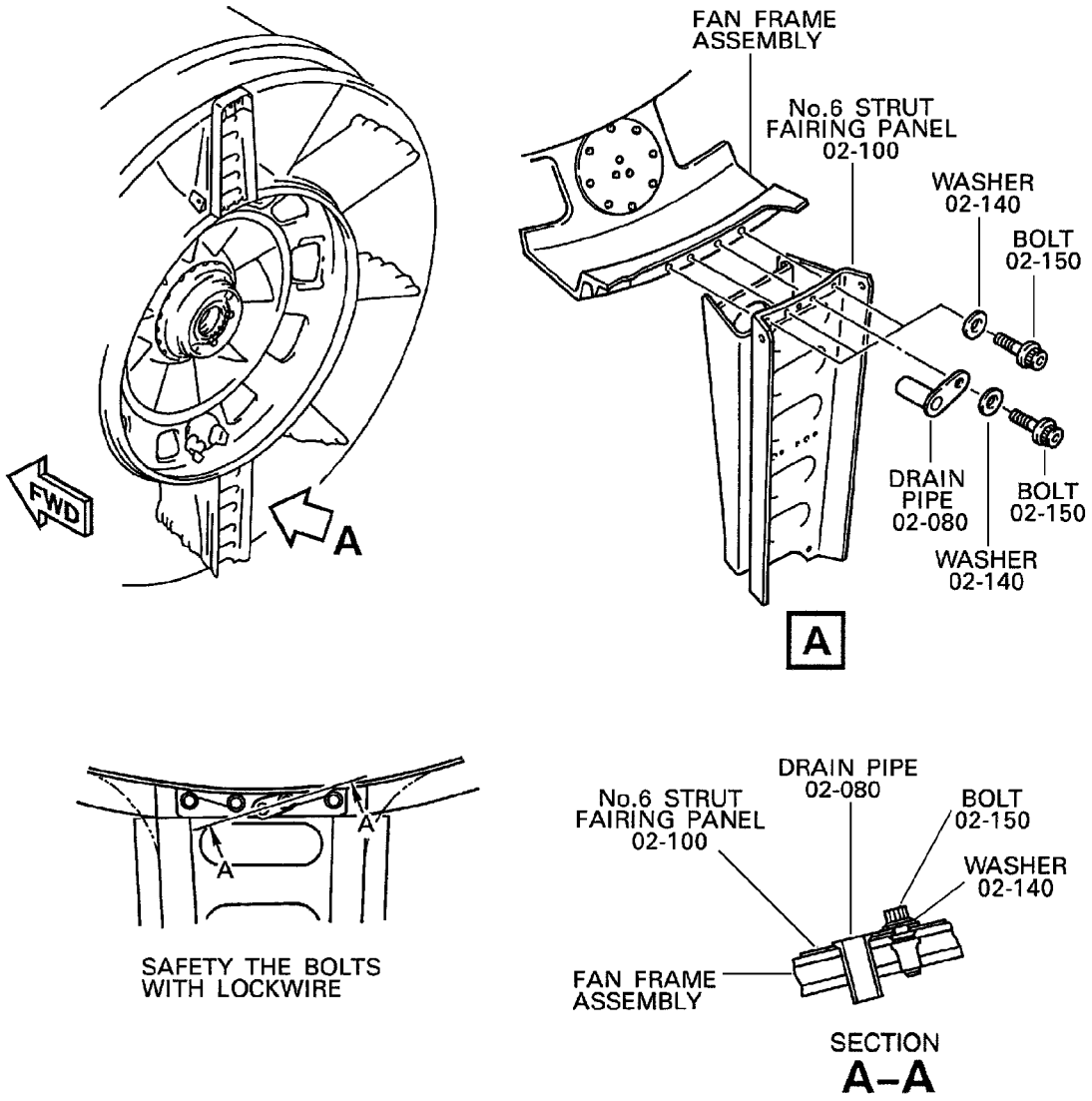

jax0800081

Installation of No.6 Strut Fairing Panel for A5
Figure 28

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International Aero Engines

SERVICE BULLETIN

ENGINE – LP COMPRESSOR – INTRODUCTION OF FAN CASE, PANEL AND BRACKET SCALLOPED FOR NO.4 SCAVENGE TUBE REROUTE

SUPPLEMENT – PRICES AND AVAILABILITY

Printed in Great Britain

The prices if shown are for estimating 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 catalogue for current prices.

1. Modification Kit

Modification kit is not required.

2. New Production:

Part No.	Qty	Unit Price US Dollars	Comments
5A1885	1	2578.00	Rework of 5A1838
5A1886	1	296.00	Rework of 5A1749
5W0193	1	Price on request	Rework of 5W0171
5W0198	1	Price on request	Rework of 5W0172
AS21118	2	13.80	New part
5A1884	1	200.00	New part
5A2189	1	33.50	

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