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V2500-A1 SERIES PROPULSION SYSTEM SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0450 and the Initial Issue of the Supplement

Bulletin Initial Issue

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Supplement Initial Issue

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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin are as follows:

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Printed in Great Britain



ENGINE – HP COMPRESSOR DISCS (STAGES 3–8) – INTRODUCTION OF A REVISED STAGE 3–8 DISC ASSEMBLY

1. Planning Information

A. Effectivity

Airbus A320

V2500–A1 Engines prior to Serial No.V0362.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

For logistical reasons there is a requirement to change the source of manufacture for the HP Compressor Stage 3–8 disc assembly.

(2) Evidence

(See Problem).

(3) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis.

(4) Objective

Incorporation of this Service Bulletin (Modification) is designed to satisfy manufacture requirements.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

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(d) Repair Schemes

Affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The change of the manufacturing source has resulted in the following changes:

(a) The material for the stage 6, 7 and 8 discs has been changed from Titanium 5331s to Titanium 6246.

(b) A single blend radius of 35mm has been introduced onto the Stage 4 disc profile.

(c) The profile under the rim on the forward side of the stage 8 disc has increased in thickness.

(d) The diaphragm radius at the rear of the stage 8 disc is increased from 5,00 mm to 10,00 mm.

(e) In order to optimise manufacture, various non-life related manufacturing easements have been introduced.

(f) The spacer thickness between Stages 3 and 4 discs has been increased to commonise the weld process.

(2) For effect on declared life see Time Limits Manual, 5-10-01.

E. Compliance

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

F. Approval

The part number transactions shown in section 2. Material Information of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA Approved for the engine model listed.



G. Manpower

(1) In service

Not Applicable.

(2) At overhaul

Not affected.

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

H. Material Price and Availability

Modification kit not required; parts supplied as single line items.

For prices and availability of future spares see supplement to this bulletin.

I. Tooling Price and Availability

Special tools are not required.

J. Industry Support Information

Not applicable.

K. Weight and Balance

(1) Weight Change

Plus 2.3 lb (plus 1.02 Kg).

(2) Moment Arm

13.4 in (340 mm) rearwards of datum.

(3) Datum

Engine Front Mount Centreline (Power Plant Station PPS100).

L. Electrical Load Data

Not affected.

M. Software Accomplishment Summary

Not applicable.



N. References

- (1) IAE Engineering Change Number 02VR017.
- (2) Engine Manual, 72-41-10, Config-01, Disassembly and Assembly.
- (3) ATA Locator 72-41-11.

O. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC), SV2500, Chapter/Section 72-41-11 will be revised.
- (2) Engine Manual, 72-41-10, Config-01, Disassembly and Assembly.
- (3) Time Limits Manual, 05-10-01.

P. Interchangeability of Parts

Not affected.



2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts to be reworked:

None.

C. New production parts:

All Engines

72-41-11

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01200	6A8236	1	.Disc, assy of Stage 3-8	-	6A7401	(A)(B) (S1)

D. Instruction Disposition Codes:

(A) New part will be made available from February 2003.

(B) Old part becomes redundant upon embodiment of this modification.

(S1) Old and new parts are freely and fully interchangeable.



3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

For the correct Assembly Instructions refer to Engine Manual, 72-41-10, Config-01, Disassembly and Assembly.

C. Recording Instructions

A record of accomplishment is required.



Baseline

V2500-ENG-72-0035

HP Compressor Discs and
Blades-Stages 3 to 5 -
Anti-Frettagge Treatment

V2500-ENG-72-0130

HP Compressor Discs
Stage 3 to 8 Rotor Drum
Assembly with Spacers in
Triple Melt Titanium

V2500-ENG-72-0161

HP Compressor Discs and
Blades-Stage 7 & 8 Damper Wires
and Stage 6, 7 & 8 Blades with
Anti-Frettagge Coating

V2500-ENG-72-0178

HP Compressor Discs
Stage 3 to 8 Rotor Drum
Thicker Stage 6 Disk Hub
and Damping Wire Locating Lip

V2500-ENG-72-0254

HP Compressor Discs
Stage 3 to 8-Introduction of
HPC Drum with Revised
Disc Profiles

V2500-ENG-72-0304

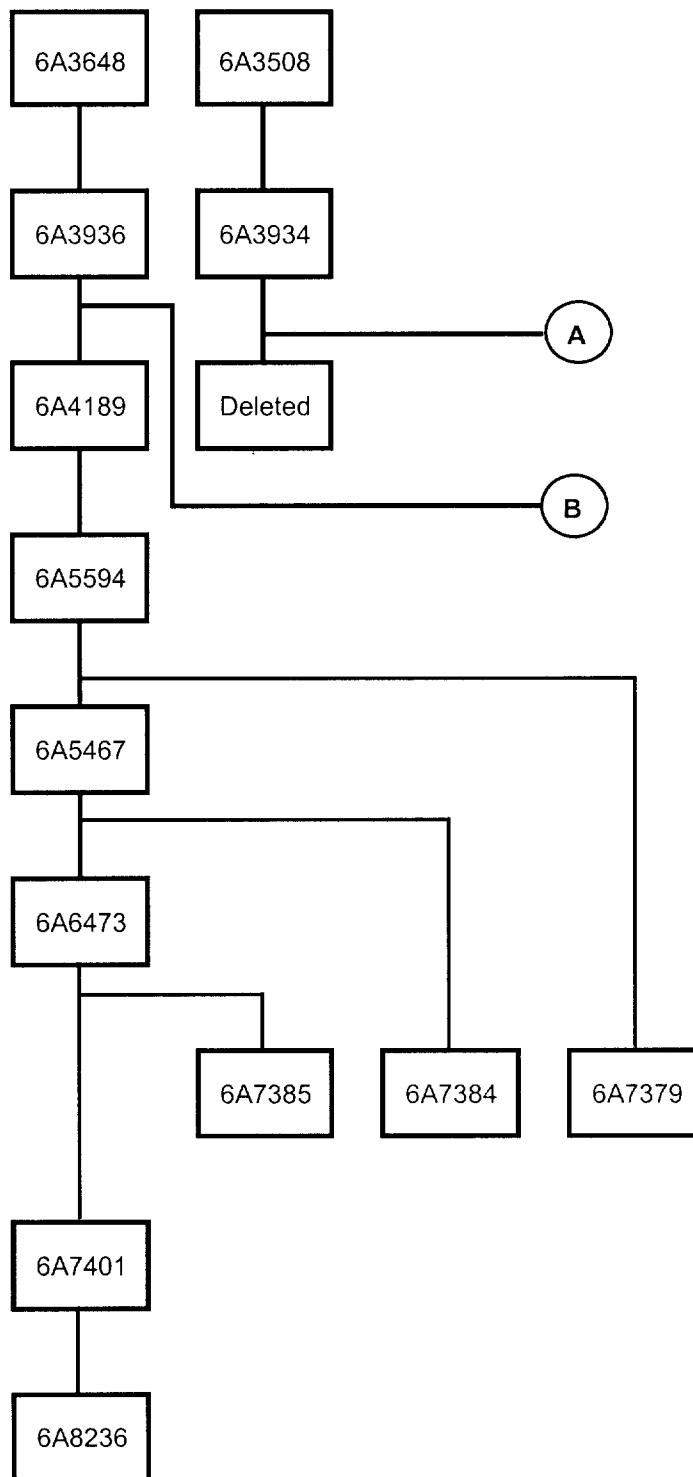
HP Compressor Discs
Stage 3 to 8-Intro of Reworked
Stage 3 to 8 Disc Assy with
Revised 'L' Shaped Sealing Wires

V2500-ENG-72-0300

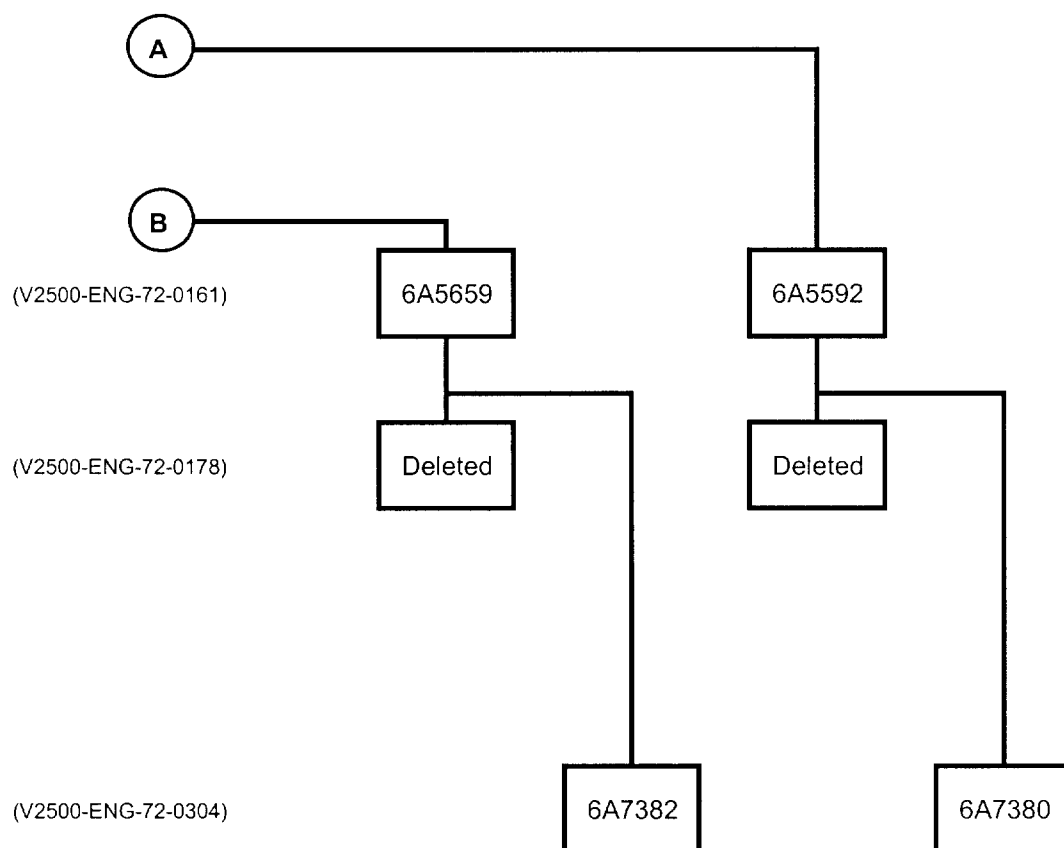
HP Compressor Discs
Stages 3 to 8-Intro of HP Comp
Disc Assy with Revised Location
Of Damper Wire Grooves

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HP Compressor Discs
Stages 3-8 - Intro of a
Revised Stage Disc Assy



Family Tree - HP Compressor Stage 3 - 8 Disc Assembly
Figure 1, Sheet 1 of 2



Family Tree - HP Compressor Stage 3 - 8 Disc Assembly
Figure 1, Sheet 2 of 2



ENGINE - HP COMPRESSOR DISCS (STAGES 3-8) - INTRODUCTION OF A REVISED STAGE 3-8 DISC ASSEMBLY

SUPPLEMENT - PRICES AND AVAILABILITY

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:

Not applicable, parts supplied as single line items.

2. New Production Parts:

Part No.	Description	Unit Price US Dollars
6A8236	Disc Assembly of, Stage 3 - 8	129,250.00

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Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

