



400 MAIN STREET, MAIL STOP 121-10
EAST HARTFORD, CT 06108, USA.
TELEPHONE:- 860 565 5515
FAX:- 860 565 0600

DATE: Aug. 2/05

P.O. BOX 31, DERBY
TELEGRAMS - 'ROYCAR' DERBY
TELEX - 37645
TELEPHONE:- 44 (0) 1332 242424
FAX:- 44 (0) 1332 249936

V2500-A1 SERIES PROPULSION SYSTEM SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0498 and the Initial Issue of the Supplement

Bulletin Initial Issue

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	Page 1 and 2 of the	Initial issue
	Summary	
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	Service Bulletin	

Supplement Initial Issue

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CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED

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LIST OF EFFECTIVE PAGES

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Printed in Great Britain

ENGINE - INTRODUCE PLUG AND WASHER FOR TURBINE EXHAUST CASE REPAIR (VRS3655) STRUTS
4, 7, 8, AND 10

SUMMARY

1. PLANNING

A. EFFECTIVITY

Engine V2500-A1 Serial Numbers All engines

B. CONCURRENT REQUIREMENTS

There are no concurrent requirements.

C. REASON/PROBLEM

Problem: Provide new plugs and washers for repair of turbine exhaust case. Past instances of fluid entrapment in the cavities of the instrumented struts on the turbine exhaust case have resulted in bulging or rupture of the strut during initial engine operation due expansion of the fluids. This repair will allow the installation of drain holes in the outer case wall to completely evacuate the cavities of struts number(s) 3, 4, 6, 7, 8, 10 and 11, and subsequently close the drain hole.

Substantiation: Satisfactory structural engineering review. Fit, function, and interchangeability of the turbine exhaust case is not affected. Assembly will be re-identified after repair incorporation to identify minor form revision. Similar repairs are accomplished on other engine models. References D and E on change 02VC021B were previously issued to perform the identical repair as one-time concessions (OTCS).

D. DESCRIPTION

Provide Plug and Washer part numbers to be used in the accomplishment of Repair VRS3655.

E. COMPLIANCE

8

Accomplish based upon experience with the prior configuration.

F. MANPOWER

(1) In Service - Not Applicable.

(2) At Overhaul - Not Applicable.

G. Total Necessary Man-hours - Not Applicable.

2. MATERIAL INFORMATION**Parts Prices**

A. The estimated price of new material to do this Service Bulletin using new replacement parts is \$214.80.

ENGINE – INTRODUCE PLUG AND WASHER FOR TURBINE EXHAUST CASE REPAIR (VRS3655) STRUTS
4, 7, 8, AND 10

1. Planning Information

A. Effectivity Data (For Airbus A320)

Engine Models Applicable

V2500-A1

Engine Serial No. – All engines

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason

- (1) Problem: Provide new plugs and washers for repair of turbine exhaust case. Past instances of fluid entrapment in the cavities of the instrumented struts on the turbine exhaust case have resulted in bulging or rupture of the strut during initial engine operation due expansion of the fluids. This repair will allow the installation of drain holes in the outer case wall to completely evacuate the cavities of struts number(s) 3, 4, 6, 7, 8, 10 and 11, and subsequently close the drain hole.
- (2) Substantiation: Satisfactory structural engineering review. Fit, function, and interchangeability of the turbine exhaust case is not affected. Assembly will be re-identified after repair incorporation to identify minor form revision. Similar repairs are accomplished on other engine models. References D and E on change 02VC021B were previously issued to perform the identical repair as one-time concessions (OTCS).
- (3) Effects of Bulletin on:
 - Removal/Installation: Not affected.
 - Disassembly/Assembly: Not affected.
 - Cleaning: Not affected.
 - Inspection/Check: Not affected.
 - Repair: Not affected.
 - Testing: Not affected.

(4) Supplemental Information

None.

D. Description

Provide Plug and Washer part numbers to be used in the accomplishment of Repair VRS3655.

E. Compliance

Category 8

Accomplish based upon experience with the prior configuration.

F. Approval Data

The part number changes and/or part modifications specified in the Accomplishment Instructions and Material Information sections of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

The compliance statement and the procedures described in 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 Applicable.

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

To embody modification please refer to repair 076 (VRS3655).
Accomplished based upon experience with the prior configuration.

H. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No Effect.

(3) Datum

Engine Front Mount Centerline (Power Plant Station (PPS) 100)

I. Electrical Load Data

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

J. Software Accomplishment Summary

Not Applicable.

K. References

1. V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA), Chapter/Section 72-50-50.
2. V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-50-53 Add Drain Holes on the Outer Case, Repair 076 (VRS3655).
3. V2500 Standard Practices/Processes Manual (E-V2500-1IA), Chapter/Section 70-09-00-400-501.
4. Internal Reference No. - 02VC021C.
5. ATA Locator - 72-50-00.

L. Other Publications Affected

1. V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA), Chapter/Section 72-50-53 to add the new part.
2. V2500 Engine Manuals (E-V2500-1IA), Chapter/Section 72-50-53 Cleaning, Inspection and Repair, to add the new part.

M. Interchangeability of Parts

Plugs and washers must be used in sets.

N. Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (No)

Revision to Table of Limits (No)

Inspection Procedures (No)

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2. Material Information

A. Industry Support Program

Not Applicable.

B. The material data that follows is for each engine.

72-50-53

For V2500-A1 Engines:

FIG- NUMBER	ITEM NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-001	4A8025-001	1	Case Assembly, Turbine Exhaust OR	-	4A8025	(1) (C)
01-001	4A8014-001	1	Case Assembly, Turbine Exhaust	-	4A8014	(1) (C)
21-700	768748	4	.Plug-Plain, .320 X .373 Flat	-		(3) (B)
21-710	768749	4	.Washer-Flat, .406 X .875 X .093	-		(3) (B)

C. Instructions/Disposition Code Statements:

Parts Modification Conditions

(1) The new part can be obtained by modification of the old part as specified in the Accomplishment Instructions.

(3) Service Repair Part for Repair VRS3655.

Spare Parts Availability

(B) The new part will be available approximately 15 November 2005.

(C) The old part will continue to be supplied.

D. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

E. Reidentified Parts

Reidentified Parts New PN	Data Keyword	Old PN
4A8025-001	Case Assembly, Turbine Exhaust OR	4A8025

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New PN	Keyword	Old PN
4A8014-001	Case Assembly, Turbine Exhaust	4A8014

F. Other Material Information Data

Not Applicable.

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3. Accomplishment Instructions

After accomplishing repair VRS3655, identify the Turbine Exhaust Case assemblies in accordance with the Reidentified Parts section of this Service Bulletin.

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Supplement

V2500 A1

1. Modification Kit

A. There is no kit provided to do this Service Bulletin.

2. Material Cost

NOTE: The prices 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 Catalog for current prices.

A. The estimated price of new material to do this Service Bulletin using new replacement parts is \$214.80.

B. There is no kit provided to do this Service Bulletin.

3. New Service Repair Parts

New Production Part Number	Description	Unit Price US Dollars
768748	Plug-Plain, .320 X .373 Flat	15.80
768749	Washer-Flat, .406 X .875 X .093	37.90

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