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DATE: Sep. 19/13

## V2500-A5 SERIES PROPULSION SYSTEM SERVICE BULLETIN

This document transmits the Revision 1 of Service Bulletin V2500-ENG-72-0562.

### Document History

#### Service Bulletin Revision Status

Initial Issue Sep.22/08

### Service Bulletin Revision 1

Remove	Incorporate	Reason for change
All Pages of the Service Bulletin.	Pages 1 to 42 of the Service Bulletin	To update the Accomplishment Instructions. To attach the FAA AMOC letter.
All Pages of the Supplement.	Pages 1 to 34 of the Supplement (Parts Progression Charts)	To revise the Family Tree Charts.
All Pages of the Supplement.	Page 1 of the Supplement (Revision to Table of Limits)	No change.

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All Pages of the Supplement.	Page 1 and 2 of the Supplement (Prices and Availability)	No change.
All Pages of the Supplement.	Page 1 of the Supplement (Added Data)	No change.

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ENGINE – HIGH PRESSURE TURBINE (HPT) – V2500 SELECTONE PRODUCTION AND RETROFIT – HPT  
UPGRADE

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V15002 (A5 Standard, SelectOne Retrofit Standard).

(b) V2522-A5, V2524-A5, V2527M-A5 Engines from Serial No. V15002 onwards (SelectOne Production Standard).

(2) Airbus A320

(a) V2524-A5, V2527-A5, V2527E-A5 Engines prior to Serial No. V15002 (A5 Standard, SelectOne Retrofit Standard).

(b) V2524-A5, V2527-A5, V2527E-A5 Engines from Serial No. V15002 onwards (SelectOne Production Standard).

(3) Airbus A321

(a) V2530-A5, V2533-A5 Engines prior to Serial No. V15002 (A5 Standard, SelectOne Retrofit Standard).

(b) V2530-A5, V2533-A5 Engines from Serial No. V15002 onwards (SelectOne Production Standard).

B. Concurrent Requirements

- (1) The Service Bulletins that follow must be done before this one (Baseline/ Minimum Standard for SelectOne HP turbine Modification):

Reference 1, Service Bulletin No. V2500-ENG-72-0145;

Reference 2, Service Bulletin No. V2500-ENG-72-0238;

Reference 3, Service Bulletin No. V2500-ENG-72-0239;

Reference 4, Service Bulletin No. V2500-ENG-72-0327 (2nd Stage Retaining Plate Only);

Reference 5, Service Bulletin No. V2500-ENG-72-0364;

Reference 6, Service Bulletin No. V2500-ENG-72-0399;

Reference 7, Service Bulletin No. V2500-ENG-72-0511;

Reference 8, Service Bulletin No. V2500-ENG-72-0522 and

Reference 9, Service Bulletin No. V2500-ENG-72-0534.

- (2) The Service Bulletins that follow must be done at the same time as this one:

- (a) For A5 Standard, SelectOne Retrofit Standard engines:

Reference 10, Service Bulletin No. V2500-ENG-72-0560;

Reference 14, Service Bulletin No. V2500-ENG-72-0565;

Reference 17, Service Bulletin No. V2500-ENG-73-0203 and

Reference 18, Service Bulletin No. V2500-ENG-73-0207.

**NOTE:** The EEC software SCN20A/Z is the required standard for SelectOne Retrofit and Production engines and is planned for fleetwide incorporation in Q4 2008.

For customers receiving SelectOne engines prior incorporation of EEC software SCN20A/Z, the interim EEC software SCN20/Y, introduced by Service Bulletin ENG-73-0203, is the provided EEC software standard for these engines.

- (b) For SelectOne Production Standard engines:

Reference 10, Service Bulletin No. V2500-ENG-72-0560;

Reference 11, Service Bulletin No. V2500-ENG-72-0561;

Reference 12, Service Bulletin No. V2500-ENG-72-0563;

Reference 13, Service Bulletin No. V2500-ENG-72-0564;

Reference 17, Service Bulletin No. V2500-ENG-73-0203 and

Reference 18, Service Bulletin No. V2500-ENG-73-0207.

### C. Reason

- (1) Condition

For Delivered V2500-A5 Engines converted to V2500-A5 SelectOne:

This Service Bulletin allows retrofit of V2500-A5 Engines and introduces V2500-A5 SelectOne High Pressure Turbine (HPT) Kit, PN 2A4243.

Provide an upgraded High Pressure Turbine (HPT) relative to the V2500-A5 for the V2500 SelectOne upgrade that meets the following requirements.

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Increases HPT refurbishment interval by 20% for the 27K engine.

Achieves production scrap rate requirement.

Decreases outer diameter leakage by 1.0% relative to V12556.

### (2) Background

The V2500 SelectOne is a committed programme to enhance the V2500 engine for improved time on wing, efficiency and durability. The package features consist of enhancements and modifications on the HPC, HPT, LPT modules and complementary EEC software.

### (3) Objective

Redesign the V2500-A5 HPT to achieve the SelectOne upgrade requirements as follows:

1st vane with re-distributed cooling.

2nd vane with modified internal cooling and additional platform cooling.

1st blade with advanced coating and revised film cooling.

2nd blade re-staggered.

Improved outer diameter static hardware sealing.

Improved durability of 1st Stage Blade Outer Air Seal (BOAS)

### (4) Substantiation

The changes introduced by this Service Bulletin were the subject of satisfactory engineering analysis, extensive engine testing and flight test. This Service Bulletin complies with the applicable engine certification basis.

### (5) Effects of Bulletin on:

Removal/Installation: None.

Disassembly/Assembly: None.

Cleaning: None.

Inspection/Check: None.

Repair: None.

Testing: None.

## (6) Supplemental Information

None.

**D. Description**

Introduce the V2500-A5 SelectOne upgrade with new High Pressure Turbine (HPT) with improved features.

**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.

The authorising IAE documents are ECs 07SEL01P and 07SEL02P.

R Revision 1 of this Service Bulletin has been FAA approved as an Alternate Means  
R Of Compliance (AMOC) to Airworthiness Directive (AD) 2011-25-08.

**G. Manpower**

## (1) In Service

Not Applicable.

## (2) At Overhaul

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

(a) To accomplish Modification Instructions using new parts:

(i) To remove existing Nozzle Group Assembly and Rotor and Stator Assembly

3 hrs 10 mins

- (ii) To accomplish Modification Instructions using new parts  
15 hrs 22 mins
- (iii) To install modified Nozzle Group Assembly and Rotor and Stator Assembly  
6 hrs 35 mins
- (iv) To test engine  
5 hrs 0 mins
- (v) Total Manhours using new parts  
30 hrs 7 mins
- (b) To accomplish Modification Instructions using re-worked parts:
  - (i) To remove existing Nozzle Group Assembly and Rotor and Stator Assembly  
3 hrs 10 mins
  - (ii) To accomplish Modification Instructions using re-worked parts  
30 hrs 8 mins
  - (iii) To install modified Nozzle Group Assembly and Rotor and Stator Assembly  
6 hrs 35 mins
  - (iv) To test engine  
5 hrs 0 mins
  - (v) Total Manhours using re-worked parts  
44 hrs 53 mins

#### H. Weight and Balance

- (1) Weight Change  
+ 2.9 lb (+ 1.32 kg)
- (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) IAE V2500 Service Bulletin V2500-ENG-72-0145 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 2 Turbine Rotor Hub With Increased Front Snap Diameter - Category Code 7 - Mod.ENG-72-0145).
- (2) IAE V2500 Service Bulletin V2500-ENG-72-0238 (Engine - HP Turbine Rotor And Stator Assembly - Provide A New Stage 1 Turbine Hub - Category Code 8 - Mod.ENG-72-0238).
- (3) IAE V2500 Service Bulletin V2500-ENG-72-0239 (Engine - Diffuser And Combustor Group - Provide New Diffuser Group Adapters And Tube Assemblies - Category Code 8 - Mod.ENG-72-0239).
- (4) IAE V2500 Service Bulletin V2500-ENG-72-0327 (Engine - High Pressure Turbine Rotor And Stator Assembly - Introduce New Rotating Parts With Potential For Increased Cyclic Life).
- (5) IAE V2500 Service Bulletin V2500-ENG-72-0364 (Engine - High Pressure Turbine - Provide New Stage 2 High Pressure Turbine Duct Segments).
- (6) IAE V2500 Service Bulletin V2500-ENG-72-0399 (Engine - Provide A New 2nd Stage Turbine Rotor Blade Retention Configuration).
- R (7) IAE V2500 Service Bulletin V2500-ENG-72-0483 (Engine - New First Stage  
R Duct Segments And HPT Vane Support).
- (8) IAE V2500 Service Bulletin V2500-ENG-72-0511 (Engine - New 1st Stage Rotor Assembly With Metering Plugs Removed And New 1st Stage HPT Seal).
- (9) IAE V2500 Service Bulletin V2500-ENG-72-0522 (Engine - Provide New Second Stage Vane With Increased Cooling Air).
- (10) IAE V2500 Service Bulletin V2500-ENG-72-0534 (Engine - Provide New Second Stage Turbine Air Seal).
- (11) IAE V2500 Service Bulletin V2500-ENG-72-0560 (Engine - High Pressure (HP) Compressor - V2500 SelectOne Retrofit and Production - HP Compressor Upgrade).

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- (12) IAE V2500 Service Bulletin V2500-ENG-72-0561 (Engine - High Pressure (HP) Compressor - V2500 SelectOne Production - HP Compressor Upgrade).
- (13) IAE V2500 Service Bulletin V2500-ENG-72-0563 (Engine - LP Turbine - Introduction Of Turbine Vanes Stage 3).
- (14) IAE V2500 Service Bulletin V2500-ENG-72-0564 (Engine - High Pressure (HP) Compressor - V2500 SelectOne Production - Introduction Of Redesigned Variable Stator Vane (VSV) System).
- (15) IAE V2500 Service Bulletin V2500-ENG-72-0565 (Engine - Provide The Requirements For Modification To The V2500 SelectOne Retrofit Standard)
- (16) IAE V2500 Service Bulletin V2500-ENG-72-0575 (Engine - Rotor And Stator Assembly - Provide New 2nd Stage High Pressure Turbine (HPT) Restaggered Blades).
- (17) IAE V2500 Service Bulletin V2500-ENG-72-0576 (Engine - Turbine Nozzle - Provide A New High Pressure Turbine (HPT) 1st Stage Vane Assembly).
- (18) IAE V2500 Service Bulletin V2500-ENG-73-0203 (Engine - Fuel And Control - Provide A New Electronic Engine Control (EEC) With SCN20/Y Software).
- R (19) IAE V2500 Service Bulletin V2500-ENG-73-0207 (Engine - Fuel And Control -  
R Provide A New Data Entry Plug Kit Assembly With New Variants For The EEC  
R SCN20/Y Software).
- R (20) IAE V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-00-44, 72-00-45,  
R 72-44-00 and 72-45-00 series.
- R (21) V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA, S-V2500-2IA,  
R S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB,  
R S-V2500-6IA, S-V2500-6IB, S-V2500-7IA and S-V2500-7IB), Chapter/Section  
R 72-44-00 and 72-45-00.
- R (22) IAE V2500 Illustrated Parts Catalogues (S-V2500-2SA, S-V2500-2SB,  
R S-V2500-5SA, S-V2500-5SB, S-V2500-6SA, S-V2500-6SB, S-V2500-7SA,  
R S-V2500-7SB), Chapter/Section 72-44-00 and 72-45-00.
- R (23) IAE Standard Practices/Procedures Manual, Chapter/Section 70-09-00 and  
R 70-10-00.
- R (24) Airbus Aircraft Modifications No. 37868 and 38554.
- R (25) Internal Reference No. - EC 07SEL01P, EC 07SEL02P, EC 09VA007, EC 09VA027,  
R IEN 09VC017 and EA13VC056.
- R (26) ATA Locator - 72-40-00.

**L. Other Publications Affected**

- (1) V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-24 Cleaning, Inspection and Repair, to add the new parts.
- (2) V2500 Engine Illustrated Parts Catalog (S-V2500-2SA, S-V2500-2SB, S-V2500-5SA, S-V2500-5SB, S-V2500-6SA, S-V2500-6SB, S-V2500-7SA, S-V2500-7SB), Chapter/Section 72-44-00 and 72-45-00 series, to add the new parts.
- (3) V2500 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 72-44-00 and 72-45-00 series, to add the new parts.

**M. Interchangeability of Parts**

Old and new parts are not interchangeable.

Old and new parts must be replaced in complete sets only.

**N. Information in the Appendix**

Alternate Accomplishment Instructions (No)

Progression Charts (Yes)

Revision to Table of Limits (Yes)

Inspection Procedures (No)

Supplement (Yes)

Added Data (Yes)

## 2. Material Information

### A. Material - Price and Availability

1. Part prices were not available at the time of Service Bulletin publication. Contact IAE's Spare Parts Sales Department for firm quotations.
- R 2. There is a kit, PN 2A4243 to do this Service Bulletin. Contact IAE's Spare Parts Sales Department for firm quotations.
3. Part availability information is provided in material data Instructions - Disposition.

### B. Industry Support Program

Not Applicable.

### C. The material data that follows is for each engine.

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

SelectOne Production Standard Engines:

FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-001	72-44-00 2A4210	1	Turbine Nozzle Group	-	2A3915	(1)(E)(N)(R)
01-010	72-44-10 2A4085	1	Support Assy - HPT Stg 1	-	2A3896	(2)(B)(C)(R)
01-025	2A4088-01	1	Seal Assy - Brush Stg 1	-		(D)(R)
01-033	2A4161	3	Lock - Support Seal Stg 1	-		(D)
01-035	NAS1398C3A4	6	Rivet - Blind Stg 1	-		(D)
01-240	72-44-20 2A4081	40	Vane Assy - HPT Stg 1	-	2A4201	(2)(C)(N)(P)(R)
01-240	OR 2A4271	40	Vane Assy - HPT Stg 1	-	2A4201	(2)(B)(C)(R)
01-485	2A4126	40	Seal - HPT Stg 1	-		(2)(B)(R)
01-010	72-44-50 2A4086	1	TOBI Duct Assy - HPT Stg 1	-	2A3914-01	(1)(B)(C)(R)
01-001	72-45-00 2A4220	1	Rotor and Stator Assy	-	2A4310	(2)(C)(N)(P)(R)

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-001	OR 2A4250	1	Rotor and Stator Assy	-	2A4310	(1)(C)(F)(R)
01-010	72-45-10 2A9921	1	Turbine Rotor - HPT Stg 1	-	2A9421	(1)(C)(F)(I)
01-010	72-45-14 2A9721	64	Blade - HPT Stg 1	-	2A9321	(2)(B)(C)(R)
01-005	72-45-20 2A4087	1	Case and Vane Assy - HPT Stg 1	-	2A4050	(1)(C)(F)(I)
01-010	72-45-22 2A4130	19	Support - HPT Stg 1	-	2A1706	(2)(B)(C)(I)
01-060	2A4129	19	Seal - HPT Stg 1	-	2A1705	(2)(B)(C)(R)
01-010	72-45-23 2A4136	1	Gasket	-	2A3155	(2)(B)(C)(I)
01-010		1	Gasket	-	2A2275	(G)
01-010		1	Gasket	-	2A3156	(G)
01-020	2A4131	2	Band Segment	-	2A1707	(2)(B)(C)(I)
01-040	2A4133	1	Band Segment	-	2A1708	(2)(B)(C)(I)
01-060	2A4169	38	Duct Segment	-	2A3886-01	(2)(B)(C)(I)
01-062		1	Cover	-	2A3888	(C)
01-080	2A4106	38	Seal	-	2A1701	(2)(B)(C)(R)
02-050	72-45-24 2A4262	17	Ring Segment - HPT Stg 2 Vane Cluster	-	2A6102	(2)(B)(C)(I)
02-115	2A4127	1	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-130	2A4182	2	Vane Assy - HPT Stg 2	-	2A4272	(2)(C)(D)(I)
02-190	2A4127	19	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-197	2A4145	38	Seal - Feather - HPT Stg 2	-		(2)(B)(I)
02-200	2A4128	19	Seal - HPT Stg 2	-		(2)(B)(I)
02-200		17	Seal - HPT Stg 2	-	2A2336	(C)
02-205	2A4163	1	Gasket	-		(2)(B)(I)
02-260	2A4162	2	Ring Segment, 2nd Vane Cluster (Boro)	-	2A4072	(2)(B)(C)(R)
02-265	2A4128	1	Seal - HPT Stg 2	-		(2)(B)(R)
02-312	2A4127	1	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-350	2A4182	1	Vane - HPT Stg 2	-	2A4272	(2)(C)(D)(R)
02-420	2A4282	1	Vane Assy - HPT Stg 2	-	2A4082	(2)(C)(D)(R)
01-010	72-45-30 2A4222	1	Turbine Rotor - HPT Stg 2	-	2A4232	(2)(C)(N)(P)(I)

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A4232	(1)(C)(N)(I)
01-010	OR 2A4522	1	Turbine Rotor - HPT Stg 2	-	2A4222	(2)(E)(F)(I)
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A2822-001	(1)(E)(N)(I)
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A2522-001	(1)(E)(N)(I)
01-010	72-45-32 2A4122	72	Blade Assy - HPT Stg 2	-	2A9002	(2)(C)(N)(P)(R)
01-010	OR 2A4422	72	Blade Assy - HPT Stg 2	-	2A9002	(2)(B)(C)(R)

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

For Modification of V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5 Delivered Engines And SelectOne Retrofit Standard Engines:

FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-001	72-44-00 2A4210	1	Turbine Nozzle Group	-	2A3915	(1)(E)(N)(R)
01-001	OR 2A4210-001	1	Turbine Nozzle Group	-	2A3915	(1)(E)(N)(R)
01-001	OR 2A4210-001	1	Turbine Nozzle Group	-	2A8600	(1)(E)(N)(R)
01-001	OR 2A4210-001	1	Turbine Nozzle Group	-	2A8600-005	(1)(E)(N)(R)
01-001	OR 2A4210-001	1	Turbine Nozzle Group	-	2A8600-006	(1)(E)(N)(R)
01-001	OR 2A4210-001	1	Turbine Nozzle Group	-	2A8600-007	(1)(E)(N)(R)
01-010	72-44-10 2A4085	1	Support Assy - HPT Stg 1	-	2A3896	(2)(B)(C)(R)

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-025	2A4088-01	1	Seal Assy - Brush Stg 1	-		(D)(R)
01-033	2A4161	3	Lock - Support Seal Stg 1	-		(D)
01-035	NAS1398C3A4	6	Rivet - Blind Stg 1	-		(D)
01-240	72-44-20 2A4081	40	Vane Assy - HPT Stg 1	-	2A4201	(2)(C)(N)(P)(R)
01-240	OR 2A4271	40	Vane Assy - HPT Stg 1	-	2A4201	(2)(B)(C)(R)
01-485	2A4126 72-44-50	40	Seal - HPT Stg 1	-		(2)(B)(I)
01-010	2A4086	1	TOBI Duct Assy - HPT Stg 1	-	2A3914-01	(1)(B)(C)(R)
01-010	OR 2A3914-001	1	TOBI Duct Assy	-	2A3914-01	(1)(C)(N)(R)
01-010	OR 2A3487-001	1	TOBI Duct Assy	-	2A3487-01	(1)(E)(N)(R)
01-001	72-45-00 2A4220	1	Rotor and Stator Assy	-	2A4310	(2)(C)(N)(P)(R)
01-001	OR 2A4250	1	Rotor and Stator Assy	-	2A4310	(1)(C)(F)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A4200-014	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A4200-015	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A4200-016	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A7000-016	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A7000-017	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A7000-018	(1)(E)(N)(R)
01-001	OR 2A4250-001	1	Rotor and Stator Assy	-	2A7000-019	(1)(E)(N)(R)
	OR					

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-001	2A4250-001	1	Rotor and Stator Assy	-	2A7000-020	(1)(E)(N)(R)
	OR					
01-001	2A4250-001	1	Rotor and Stator Assy	-	2A9300-005	(1)(E)(N)(R)
	OR					
01-001	2A4250-001	1	Rotor and Stator Assy	-	2A9300-006	(1)(E)(N)(R)
	OR					
01-001	2A4250-001	1	Rotor and Stator Assy	-	2A9300-007	(1)(E)(N)(R)
	OR					
01-001	2A4250-001	1	Rotor and Stator Assy	-	2A9800-001	(1)(E)(N)(R)
	OR					
01-010	72-45-10 2A9921	1	Turbine Rotor - HPT Stg 1	-	2A9421	(1)(C)(F)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9421	(1)(C)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9031-011	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9521-004	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9521-005	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9521-006	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9621-003	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9621-004	(1)(E)(N)(I)
	OR					
01-010	2A9921-001	1	Turbine Rotor - HPT Stg 1	-	2A9621-005	(1)(E)(N)(I)
	OR					
01-010	72-45-14 2A9721	64	Blade - HPT Stg 1	-	2A9321	(2)(B)(C)(R)
	OR					
01-005	72-45-20 2A4087	1	Case and Vane Assy - HPT Stg 1	-	2A4050	(1)(C)(F)(I)
	OR					

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A4050	(1)(C)(N)(I)
	OR					
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A3219-003	(1)(E)(N)(I)
	OR					
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A3416-005	(1)(E)(N)(I)
	OR					
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A3469-003	(1)(E)(N)(I)
	OR					
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A3469-004	(1)(E)(N)(I)
	OR					
01-005	2A4087-001	1	Case and Vane Assy - HPT Stg 1	-	2A3475-002	(1)(E)(N)(I)
	72-45-22					
01-010	2A4130	19	Support - HPT Stg 1	-	2A1706	(2)(B)(C)(R)
01-060	2A4129	19	Seal - HPT Stg 1	-	2A1705	(2)(B)(C)(R)
	72-45-23					
01-010	2A4136	1	Gasket	-	2A3155	(2)(B)(C)(I)
01-010		1	Gasket	-	2A2275	(G)
01-010		1	Gasket	-	2A3156	(G)
01-020	2A4131	2	Band Segment	-	2A1707	(2)(B)(C)(I)
01-040	2A4133	1	Band Segment	-	2A1708	(2)(B)(C)(I)
01-060	2A4169	38	Duct Segment	-	2A3886-01	(2)(B)(C)(I)
01-062		1	Cover	-	2A3888	(C)
01-080	2A4106	38	Seal	-	2A1701	(2)(B)(C)(I)
	72-45-24					
02-050	2A4262	17	Ring Segment - HPT Stg 2 Vane Cluster	-	2A6102	(2)(B)(C)(I)
02-115	2A4127	1	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-130	2A4182	2	Vane Assy - HPT Stg 2	-	2A4272	(2)(C)(D)(I)
02-190	2A4127	19	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-197	2A4145	38	Seal - Feather - HPT Stg 2	-		(2)(B)(I)
02-200	2A4128	19	Seal - HPT Stg 2	-		(2)(B)(I)
02-200		38	Seal - HPT Stg 2	-	2A2336	(C)
02-205	2A4163	1	Gasket	-		(B)
02-260	2A4162	2	Ring Segment, 2nd Vane Cluster	-	2A4072	(2)(B)(C)(R)
02-265	2A4128	1	Seal - HPT Stg 2	-		(2)(B)
02-312	2A4127	1	Seal - HPT Stg 2	-	2A2335-01	(2)(B)(C)(I)
02-350	2A4182	1	Vane - HPT Stg 2	-	2A4272	(2)(C)(D)(I)

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FIG- ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR - DISP
02-420	2A4282	1	Vane Assy - HPT Stg 2	-	2A4082	(2)(C)(D)(R)
01-010	72-45-30 2A4222	1	Turbine Rotor - HPT Stg 2	-	2A4232	(2)(C)(N)(P)(I)
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A4232	(1)(C)(N)(I)
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A2822-001	(1)(E)(N)(I)
01-010	OR 2A4522-001	1	Turbine Rotor - HPT Stg 2	-	2A2522-001	(1)(E)(N)(I)
01-010	72-45-32 2A4122	72	Blade Assy - HPT Stg 2	-	2A9002	(2)(C)(N)(P)(R)
01-010	OR 2A4422	72	Blade Assy - HPT Stg 2	-	2A9002	(2)(B)(C)(R)

#### E. 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.
- (2) The new part is a replacement part only, and cannot be obtained by modification of the old part.

##### Spare Parts Availability

- (A) The new part is available.
- (B) The new part will be available approximately September 2008.
- (C) The old part will continue to be supplied.
- (D) The new part will be available approximately February 2009.
- (E) The old part is not available.
- (F) The new part will be supplied on a full manufacturing lead time quotation basis only.
- (G) The old part is an option of PN 2A3155.
- (N) The new part is not available.
- (P) The new part is applicable to Engine Serial Nos. V15001 and 15002 only.

##### Cleaning, Inspection and Repair Information

(I) The cleaning, inspection and repair requirements are the same for the old and new part. The applicable engine manuals will be revised.

(R) The cleaning, inspection and repair requirements are different for the old and new part. The applicable engine manuals will be revised to include the new requirements.

#### F. Tooling – Price and Availability

Special tools are required to accomplish this Service Bulletin.

Tool No.	Name	Manufacturer
1P16549	Orientation Adapter	P&W
1P16563	Holding Plate	P&W

#### G. Reidentified Parts

Reidentified Parts Data		
New PN	Keyword	Old PN
2A4210-001	Turbine Nozzle Group	2A3915
2A4210-001	Turbine Nozzle Group	2A8600
2A4210-001	Turbine Nozzle Group	2A8600-005
2A4210-001	Turbine Nozzle Group	2A8600-006
2A4210-001	Turbine Nozzle Group	2A8600-007
2A3914-001	TOBI Duct Assy	2A3914-01
2A3487-001	TOBI Duct Assy	2A3487-01
2A4250-001	Rotor and Stator Assy	2A4310
2A4250-001	Rotor and Stator Assy	2A4200-014
2A4250-001	Rotor and Stator Assy	2A4200-015
2A4250-001	Rotor and Stator Assy	2A4200-016
2A4250-001	Rotor and Stator Assy	2A7000-016
2A4250-001	Rotor and Stator Assy	2A7000-017
2A4250-001	Rotor and Stator Assy	2A7000-018
2A4250-001	Rotor and Stator Assy	2A7000-019
2A4250-001	Rotor and Stator Assy	2A7000-020
2A4250-001	Rotor and Stator Assy	2A9300-005
2A4250-001	Rotor and Stator Assy	2A9300-006

New PN	Keyword	Old PN
2A4250-001	Rotor and Stator Assy	2A9300-007
2A4250-001	Rotor and Stator Assy	2A9800-001
2A9921-001	Turbine Rotor - HPT Stg 1	2A9421
2A9921-001	Turbine Rotor - HPT Stg 1	2A9031-011
2A9921-001	Turbine Rotor - HPT Stg 1	2A9521-004
2A9921-001	Turbine Rotor - HPT Stg 1	2A9521-005
2A9921-001	Turbine Rotor - HPT Stg 1	2A9521-006
2A9921-001	Turbine Rotor - HPT Stg 1	2A9621-003
2A9921-001	Turbine Rotor - HPT Stg 1	2A9621-004
2A9921-001	Turbine Rotor - HPT Stg 1	2A9621-005
2A4087-001	Case and Vane Assy - HPT Stg 1	2A4050
2A4087-001	Case and Vane Assy - HPT Stg 1	2A3219-003
2A4087-001	Case and Vane Assy - HPT Stg 1	2A3416-005
2A4087-001	Case and Vane Assy - HPT Stg 1	2A3469-003
2A4087-001	Case and Vane Assy - HPT Stg 1	2A3469-004
2A4087-001	Case and Vane Assy - HPT Stg 1	2A3475-002

#### H. Other Material Information Data

Not Applicable.

### 3. Accomplishment Instructions

#### A. Modification of High Pressure Turbine (HPT) To Provide New And Improved Features For A5 Engines

**NOTE:** The following Service Bulletins must be completed prior to incorporating this Service Bulletin: Reference 1, Service Bulletin No. V2500-ENG-72-0145; Reference 2, Service Bulletin No. V2500-ENG-72-0238; Reference 3, Service Bulletin No. V2500-ENG-72-0239; Reference 4, Service Bulletin No. V2500-ENG-72-0327; Reference 5, Service Bulletin No. V2500-ENG-72-0364; Reference 6, Service Bulletin No. V2500-ENG-72-0399; Reference 7, Service Bulletin No. V2500-ENG-72-0511; Reference 8, Service Bulletin No. V2500-ENG-72-0522 and Reference 9, Service Bulletin No. V2500-ENG-72-0534.

This Service Bulletin must be done at the same time as Reference 10, Service Bulletin No. V2500-ENG-72-0560, Reference 14, Service Bulletin No. V2500-ENG-73-0203 and Reference 15, Service Bulletin No. V2500-ENG-73-0207.

R **NOTE:** The EEC software Standard SCN20A/Z or later is required for V2500-A5  
R SelectOne Retrofit and V2500-A5 SelectOne Production Engines.

R **NOTE:** Later approved parts are only those IAE OEM released later parts that  
R are fully interchangeable with the part specified in this Service  
R Bulletin or one way forward interchangeable with the part specified in  
R this Service Bulletin. Later approved parts must also meet the  
R requirements of their issuing SB.

#### (1) Prerequisites

##### (a) Recommended sequence of modification for A5 Delivered Engines

- (i) IAE V2500 Service Bulletin V2500-ENG-72-0145 (Engine - HP Turbine Rotor And Stator Assembly - Provide New Stage 2 Turbine Rotor Hub With Increased Front Snap Diameter - Category Code 7 - Mod. ENG-72-0145).
- (ii) IAE V2500 Service Bulletin V2500-ENG-72-0238 (Engine - HP Turbine Rotor And Stator Assembly - Provide A New Stage 1 Turbine Hub - Category Code 8 - Mod. ENG-72-0238).
- (iii) IAE V2500 Service Bulletin V2500-ENG-72-0239 (Engine - Diffuser And Combustor Group - Provide New Diffuser Group Adapters And Tube Assemblies - Category Code 8 - Mod. ENG-72-0239).

- (iv) IAE V2500 Service Bulletin V2500-ENG-72-0327 (Engine - High Pressure Turbine Rotor And Stator Assembly - Introduce New Rotating Parts With Potential For Increased Cyclic Life).

NOTE: 2nd Stage Retaining Plate only.

- (v) IAE V2500 Service Bulletin V2500-ENG-72-0364 (Engine - High Pressure Turbine - Provide New Stage 2 High Pressure Turbine Duct Segments).
- (vi) IAE V2500 Service Bulletin V2500-ENG-72-0399 (Engine - Provide A New 2nd Stage Turbine Rotor Blade Retention Configuration).
- (vii) IAE V2500 Service Bulletin V2500-ENG-72-0511 (Engine - New 1st Stage Rotor Assembly With Metering Plugs Removed And New 1st Stage Hpt Seal).
- (viii) IAE V2500 Service Bulletin V2500-ENG-72-0522 (Engine - Provide New Second Stage Vane With Increased Cooling Air).
- (ix) IAE V2500 Service Bulletin V2500-ENG-72-0534 (Engine - Provide New Second Stage Turbine Air Seal).

- R (b) Clean, repair and inspect in accordance with Reference 20, Engine  
R Manual, Task 72-45-24-100 and/or Reference 23, Standard Practices  
Manual, Chapter/Section 70-10-00.

(2) Disassembly Instructions

- R (a) Remove the Nozzle Group Assembly in accordance with Reference 20,  
Engine Manual, Task 72-44-00-01-001 and replace with the new Nozzle  
Group Assembly, PN 2A4210 or modify in accordance with Section 4.A,  
Modification Instructions.
- R (b) Remove the Rotor and Stator Assembly in accordance with Reference 20,  
Engine Manual, Task 72-45-00-030-001 and replace with the new Rotor  
and Stator Assembly, PN 2A4250 or modify in accordance with Section  
4.B, Modification Instructions.

(3) Assembly Instructions

- R (a) Assemble the Nozzle Group Assembly in accordance with Reference 20,  
Engine Manual, Task 72-00-44-420-001-001 or Task 72-00-44-420-001-002.
- R (b) Assemble the Rotor and Stator Assembly in accordance with Reference  
20, Engine Manual, Task 72-00-45-420-001-B01 or Task  
72-00-45-420-001-B02.

## (4) Modification Instructions

**NOTE:** The Stage 1 HPT Cooling Duct Assembly PN 2A4086 has new air flow requirements. Overhaul and Repair shops which will be air flowing the 2A4086 HPT Cooling Duct need to have the IAE 2P16021 Airflow Master calibrated to the 2A4086 standards. Contact the following for quotation and instructions for re-calibration of the IAE 2P16021 Airflow Master:

Pratt and Whitney  
New Business Office M/S 165-09  
400 Main Street  
East Hartford, CT 06108  
U.S.A.

## (a) Modify the Turbine Nozzle Group Assembly as follows:

- R (i) Remove and discard the HPT Support in accordance with Reference 20, Engine Manual, Task 72-44-00-01-001. See Figure 2.
- R (ii) Replace the HPT Support Assembly with PN 2A4085, or later  
R approved parts.
- R (iii) Remove and discard the 1st Stage Vane Assembly (40) in  
accordance with Reference 20, Engine Manual, Task  
72-44-20-01-240.
- (iv) Replace the 1st Stage Vane Assembly with PN 2A4271.
- R (1) Add 40 Seals, PN 2A4126 in accordance with Reference 20,  
Engine Manual, Task 72-44-20-01-485.
- R (v) Remove the Duct (TOBI) in accordance with Reference 20, Engine  
Manual, Task 72-44-50-01-010.
- (vi) Replace the Duct (TOBI) with PN 2A4086 or modify the Duct  
(TOBI) as follows:
- R (1) Clean in accordance with Reference 20, Engine Manual, Task  
72-44-50-100.
- R (2) Inspect in accordance with Reference 20, Engine Manual,  
Task 72-44-50-200.
- R (3) Repair in accordance with Reference 20, Engine Manual,  
Task 72-44-50-300.
- R (4) For PN 2A3487-01, add 3 machine holes 0.213 to 0.223 in.  
R (5,41 to 5,66 mm) at Location AV as shown in Figure 3.

- R (5) Flow test passages collectively in direction shown in Figure 5 and in accordance with Reference 20, Engine Manual, Task 72-44-50-300-010 with:
- R Flow = 1.108 and Minimum Pressure Ratio = 1.519 Maximum Pressure Ratio = 1.558
- R To achieve the required flow, it is permissible to cut back trailing edges of all vanes as shown in Figure 5, View N, or add plugs as necessary as shown in Figure 5, Sect M-M. Dimension AZ in Figure 5, between trailing edge of adjacent cutback vanes must be alike within 0.060 in. (1,524 mm). Refer to 72-44-50 Repair, VRS3177.
- R (6) Mark the 1st Stage HPT Duct Assy with the new part number in accordance with Reference 23, V2500-A5 Standard Practices Manual, Chapter/Section 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in. (0,152 mm) max.
- R See Figure 3 for the area to mark the part. Reidentify the part as shown in Table I.

Table I: Reidentified Parts Data

New PN	Keyword	Old PN
2A3914-001	T0BI Duct Assy	2A3914-01
2A3487-001	T0BI Duct Assy	2A3487-01

- R (vii) Assemble the Stage 1 Turbine Nozzle Assembly in accordance with Reference 20, Engine Manual, Task 72-44-00-440-001-C00 or Task 72-44-00-440-001-B00 except for the following:
- Replace:
- SBE 72-0159, New Combustion Chamber Assemblies
- SBE 72-0151, New Stage 1 HPT Vane Seals
- With:
- SBE 72-0562

(viii) Install the Stage 1 HPT Vane Seals in the slots of the Stage 1 Vane Assemblies (72-44-00-0-990-029, Figure 1002A).

(1) Install the 1st Stage HPT Vane Seal in the slots that are located on the left side of the Stage 1 HPT Vane Assemblies (72-44-20, 01-240).

A Install Stage 1 HPT Vane Seal (01-485).

R 1 Use COMAT 01-573 Paraffin Wax to hold the seals in position.

B Make sure all seals are installed.

(ix) Install the Stage 1 HPT Vane Assemblies in the Stage 1 HPT Support Assembly (72-44-00-990-018, Figure 1002) or (72-44-00-990-028, Figure 1002A).

(1) Install Stage 1 HPT Vane Assembly from the vane set.

NOTE: When installing the Vane Assembly into the HPT Support, be careful not to damage the brush seal.

A Install this Vane Assembly in the Stage 1 HPT Support Assembly with the leading edge up.

R (x) Mark the Nozzle Group Assembly in accordance with Reference 23,  
R V2500-A5 Standard Practices Manual, Chapter/Section  
R 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in.  
(0,152 mm) max.

See Figure 2 for the area to mark the part. Reidentify the part as shown in Table II.

Table II: Reidentified Parts Data

New PN	Keyword	Old PN
2A4210-001	Nozzle Group Assy	2A3915
2A4210-001	Nozzle Group Assy	2A8600
2A4210-001	Nozzle Group Assy	2A8600-005
2A4210-001	Nozzle Group Assy	2A8600-006
2A4210-001	Nozzle Group Assy	2A8600-007

(b) Modify the HPT Rotor and Stator Assembly in accordance with Reference 20, Engine Manual, Task 72-45-00-01-001. See Figure 6A.

(i) Remove and discard the Case and Vane Assembly in accordance with Reference 20, Engine Manual, Task 72-45-20-01-005.

(ii) Replace the Case and Vane Assembly with PN 2A4087.

- R (iii) Remove and discard the 1st Stage Rotor Assembly in accordance with Reference 20, Engine Manual, Task 72-45-10-01-010.
- (iv) Replace the 1st Stage Rotor Assembly with PN 2A9921 or modify as follows:
- R (1) Remove and discard the 1st Stage Blade (64) in accordance with Reference 20, Engine Manual, Task 72-45-14-01-010.
- (2) Replace the 1st Stage Blade (64) with PN 2A9721.
- A 1st Stage Hub, PN 2A2801 or PN 2A5001 is required to do this modification. Reference ATA 72-45-11-01-011.
- B 1st Stage Hub, PN 2A2201 is not permitted for SelectOne engine models.
- C 1st Air Seal, PN 2A3923 is required to do this modification. Reference ATA 72-45-12-01-020.
- D 1st Air Seal, PN 2A1350 or PN 2A3423 is required to do this modification. Reference ATA 72-45-12-01-040.
- R (3) Assemble the 1st Stage Rotor Assembly in accordance with Reference 20, Engine Manual, Task 72-45-10-440-001-D00 or Task 72-45-10-440-001-C00.
- NOTE: SB 72-0238, 1st Hub and up, and SB 72-0511 must be incorporated.
- NOTE: Engines that have incorporated SB 72-0511 do not have metering plugs in the Stage 1 HP Turbine Hub.
- R (4) Mark the 1st Stage Rotor Assembly in accordance with Reference 23, V2500-A5 Standard Practices Manual, Chapter/Section 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in. (0,152 mm) max.
- R
- R
- R

See Figure 8 for the area to mark the part. Reidentify the part as shown in Table III.

Table III: Reidentified Parts Data

New PN	Keyword	Old PN
2A9921-001	Rotor Assy, 1st Stage	2A9031-011
2A9921-001	Rotor Assy, 1st Stage	2A9521-004
2A9921-001	Rotor Assy, 1st Stage	2A9521-005

New PN	Keyword	Old PN
2A9921-001	Rotor Assy, 1st Stage	2A9521-006
2A9921-001	Rotor Assy, 1st Stage	2A9621-003
2A9921-001	Rotor Assy, 1st Stage	2A9621-004
2A9921-001	Rotor Assy, 1st Stage	2A9621-005
2A9921-001	Rotor Assy, 1st Stage	2A9421

R

(v) Remove and discard the 2nd Stage Rotor Assembly in accordance with Reference 20, Engine Manual, Task 72-45-30-01-010.

(vi) Replace the 2nd Stage Rotor Assembly with PN 2A4522 or modify as follows:

R

(1) Remove and discard the 2nd Stage Blade (72) in accordance with Reference 20, Engine Manual, Task 72-45-32-01-010.

(2) Replace the 2nd Stage Blade (72) with PN 2A4422.

A 2nd Hub, PN 2A3002 or PN 2A4802 are required for this modification.

B 2nd Hub, PN 2A2302 is not permitted for SelectOne engine models.

C 2nd Stage Retaining Plate, PN 2A3426 or PN 2A3437 are required for this modification.

D 2nd Stage Retaining Plate, PN 2A2097 is not permitted for SelectOne engine models.

R

(3) Assemble the 2nd Stage Rotor Assembly in accordance with Reference 20, Engine Manual, Task 72-45-30-440-001-D00 or Task 72-45-30-440-001-C00 except for the following:

SBE 72-0562, New Stage 2 HPT Blade SelectOne

NOTE: SB 72-0145 or SB 72-0327 must be incorporated.

Moment Weight the Stage 2 HPT Blades (72-45-32, 01-010). Reference 72-45-30-990-054 (Figure 1010).

A Check blades for correct configuration SelectOne. Blades must have mistake proof tab on shelves (pressure side) below platform.

- B** Install and attach IAE 1P16016 Moment Weight Blade Adapter 1 off to the lever arm on the moment weighing equipment.
- C** Zero the moment weight equipment.
- R** **D** Install the blade root on the dowel pin in the locator assembly. Lift the clamp and move the blade root to the side of the blade adapter.
- R** **NOTE:** The blade must touch the dowel pin and the root must be seated on the pin.
- E** Release the pressure on the clamp and adjust the slide support so the blade will locate square on the face of the locator and tighten the cap screw.
- F** Moment weigh the blade.
- G** Remove the blade from the blade adapter.
- R** **H** Mark the moment weight on the concave side of the blade airfoil. Use COMAT 06-073 ink in accordance with Reference 23, Standard Practices Manual, Task 70-09-01-400-501.
- I** Repeat the moment weight procedure for each of the blades in the assembly.
- R** **(4)** Mark the 2nd Stage Rotor Assembly in accordance with Reference 23, V2500-A5 Standard Practices Manual, Chapter/Section 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in. (0,152 mm) max.

See Figure 9 for the area to mark the part. Reidentify the part as shown in Table IV.

Table IV: Reidentified Parts Data

New PN	Keyword	Old PN
2A4522-001	Rotor Assy, 2nd Stage	2A2822-001
2A4522-001	Rotor Assy, 2nd Stage	2A2522-001
2A4522-001	Rotor Assy, 2nd Stage	2A4232

- (vii) 1-2 Seal, PN 2A4157 is required to do this modification. Replace as required per SB 72-0534.

R

- (viii) Assemble the HPT Rotor and Stator Assembly in accordance with Reference 20, Engine Manual, Task 72-45-00-430-001-D00 or Task 72-45-00-430-001-C00.

SBE 72-0562: New HPT Hardware SelectOne

Note Chapter 5 HPT Parts Must Include The Following:

HPT Stage 1 Hub incorporates SB 72-0238 or Post SB

HPT Stage 1 Air Seal Inner incorporates SB 72-0511 or Post SB

HPT Stage 2 Air Seal incorporates SB 72-0534 or Post SB

HPT Stage 2 Hub incorporates SB 72-0145 or Post SB

HPT Stage 2 Retaining Plate incorporates SB 72-0237 (For Stage 2 Retaining Plates Only)

R  
R  
R

- (ix) Mark the HPT Rotor and Stator Assembly in accordance with Reference 23, V2500-A5 Standard Practices Manual, Chapter/Section 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in. (0,152 mm) max.

See Figure 6B for the area to mark the part. Reidentify the part as shown in Table V.

Table V: Reidentified Parts Data

New PN	Keyword	Old PN
2A4250-001	HPT Rotor and Stator Assy	2A4200-014
2A4250-001	HPT Rotor and Stator Assy	2A4200-015
2A4250-001	HPT Rotor and Stator Assy	2A4200-016
2A4250-001	HPT Rotor and Stator Assy	2A7000-016
2A4250-001	HPT Rotor and Stator Assy	2A7000-017
2A4250-001	HPT Rotor and Stator Assy	2A7000-018
2A4250-001	HPT Rotor and Stator Assy	2A7000-019
2A4250-001	HPT Rotor and Stator Assy	2A7000-020
2A4250-001	HPT Rotor and Stator Assy	2A9300-005
2A4250-001	HPT Rotor and Stator Assy	2A9300-006
2A4250-001	HPT Rotor and Stator Assy	2A9300-007
2A4250-001	HPT Rotor and Stator Assy	2A9800-001

New PN	Keyword	Old PN
2A4250-001	HPT Rotor and Stator Assy	2A4310

- R (c) Modify the HPT Case and Vane Assembly (ATA 72-45-20-01-005):
- R (i) Disassemble the HPT Case and Vane Assembly (ATA 72-45-20-040-001-C00).
- (ii) Remove, discard and replace the Ring Segment and Vane Cluster.
- (1) Remove 2nd Vane Cluster and Ring Segments (17) Standard (ATA 72-45-24-02-050) and replace with PN 2A4262.
- (2) Remove 2nd Vane Cluster (2) (ATA 72-45-24-02-260) and replace with PN 2A4162.
- (iii) Remove and discard the Duct Support (19). Reference ATA 72-45-22-01-010.
- (iv) Replace Duct Support (19) with PN 2A4130.
- (v) Remove and discard the HPT Seal (38). Reference ATA 72-45-23-01-060.
- R (vi) Replace the HPT Seal (38) with PN 2A4169 or later approved parts.
- R (vii) Remove and discard the Gasket. Reference ATA 72-45-24-02-010.
- (viii) Replace the Gasket with PN 2A4136.
- (ix) Remove and discard the Band Segment.
- (x) Replace the Band Segment 2 (ATA 72-45-23-01-020) with PN 2A4131.
- (xi) Replace the Band Segment 1 (ATA 72-45-23-01-040) with PN 2A4133.
- (xii) Remove and discard the HPT Seal (19). Reference ATA 72-45-22-01-060.
- (xiii) Replace the HPT Seal (19) with PN 2A4129.
- (xiv) Remove and discard the HPT Seal (38). Reference ATA 72-45-23-01-080.
- (xv) Replace the HPT Seal (38) with PN 2A4106.

(xvi) Remove and discard the HPT Seal (19). Reference ATA 72-45-24-02-200.

(xvii) Replace the HPT Seal (19) with PN 2A4128.

R

(xviii) Add the HPT Gasket, Reference ATA 72-45-24-02-205, PN 2A4163.

(xix) Discard the HPT Seal (19). Reference ATA 72-45-24-02-190.

(xx) Add the HPT Seal (19). Reference ATA 72-45-24-02-190, PN 2A4127.

(xxi) Add the HPT Seal (38). Reference ATA 72-45-24-02-197, PN 2A4145.

R

(xxii) Assemble the HPT Case and Vane Assembly in accordance with Reference 20, Engine Manual, Task 72-45-20-440-002-C00 or Task 72-45-20-440-002-B00 except for the following:

(1) Install the seals in the Stage 2 HPT Ring Segment and Vane Cluster Assembly slots, Reference 72-45-20-990-071 (Fig 1003).

R

A Install the seals in accordance with the following procedures. Use COMAT 01-573 Paraffin Wax to hold seals in position. Remove excess wax at all locations.

1 Install seal (72-45-24, 02-190) into the slot with the longer leg parallel to the outer vane platform and the short leg in the slot adjacent to the anti-rotation lug on the vane, on the right side of the vane.

2 Install seal (72-45-24, 02-200) into the slot that remains on the outer vane platform, opposite seal (72-45-24, 02-190), on the right side of the vane.

3 Install seal (72-45-24, 02-197) 19 off in between clustered vanes. Install remaining 19 seals into the slot parallel to outer vane platform on right side of the vane.

4 Install seal (72-45-24, 02-220) into the slot of the ring segment.

5 Install seal (72-45-24, 02-180) into the slot of the outer vane platform with the short leg of the seal to the ring segment.

6 Turn over the Case and Vane Assembly.

- 7 Support front of I.D. of Stage 2 Vane Platform with wood blocks or fixture IAE 1P16568.
- 8 Remove fixture IAE 1P16026.
- (2) Install 2nd Stage Duct Segments and Supports, Start with Reference 72-45-20-440-101.
- (3) Turn over case supporting the rear of "N" Flange being careful not to damage the air seal (72-45-27-01-060).
- (4) Install the Stage 1 HPT Band Segments, Stage 1 HPT Duct Segment Assemblies and Stage 1 HPT Duct Supports, Reference 72-45-20-990-077 (Figure 1009) and Reference 72-45-20-990-078 (Figure 1010).
  - A Install the Gasket (72-45-24, 02-010) in the inner groove of the Stage 2 Ring Segment and Vane Cluster Assemblies, Reference 72-45-20-990-007 (Figure 1009).
  - B Install IAE 1P16563 on Front Inner Flange of Stage 2 HPT Vane Assembly.
    - 1 Install the Stage 1 HPT Band Segment (72-45-23, 01-040) in the groove of the vane assemblies with the large outer diameter down.
    - 2 Align and position the center of the band segment with the first bolt hole to the right side of the top vertical centerline and align with the anti-rotation lug on the vane assembly.
    - 3 Install the two Stage 1 HPT Band Segments (72-45-23, 01-020) in the groove of the vane assemblies. Make sure the band segments do not go over each other.
- (5) Install the Stage 1 HPT Duct Segment Assemblies (72-45-23, 01-060).
  - A Install Duct Segment Number 1 in the groove of the vane assembly on the innerdiameter of the band segment.
  - B Position this Duct Segment to the first bolt hole to the right side of the top vertical centerline.
  - C Install Duct Segment Number 2 in a clockwise direction adjacent to the Number 1 Duct Segment.

D Install one IAE 1P16549 Orientation Adapter 19 off on the inner flange of the case assembly adjacent to the Number 1 and 2 Duct Segments.

1 Put the locator of the adapter in the bolt hole.

NOTE: The Orientation Adapter shows the relative position of the Duct Segments to the bolt hole in the case.

2 If necessary, align the two installed Duct Segments with the adapter.

E Repeat the above procedures to Install the Duct Segments that remain, by number, in a clockwise direction.

F Install and position a 0.018 in. (0,457 Nm) Feeler Gage in the lower one-quarter area between each of the Duct Segments. This will keep the minimum requirement of Dimension C.

(6) Install Stage 1 HPT Duct Seal (72-45-23, 01-080) between each of the duct segments.

R (7) Install Seal (72-45-24-02-205) in front of Stage 1 Duct Segment.

(8) Install Stage 1 HPT Duct Support Seal (72-45-22, 01-060) in the recess slot located on the right side of each duct support. Put the short side of the seal in the slot, Reference 72-45-20-990-078 (Figure 1010).

R A Use COMAT 01-573 Praffin Wax to hold the seal in position.

B Remove excess wax at all locations.

(9) Install Stage 1 HPT Duct Supports (72-45-22, 01-010).

R A Apply COMAT 10-094 Anti-seize Compound to the threads of Bolts (72-45-22, 01-100).

- B Remove on adapter IAE 1P16549 at top vertical centerline. Install the Number 1 Duct Support in the inner flange of the case assembly and position the support at the top vertical centerline.
- 1 Align the counterbore hole in the support with the hole in the inner diameter flange of the case assembly located to the right side of the top vertical centerline.
  - 2 Engage the lug of the Number 1 and 2 Duct Segments and the Band Segment in the slot of the support. Engage the support outer diameter lug in the inner flange slot of the case assembly.
  - 3 If necessary, hit the support lightly on the flat surface to seat the support.
  - 4 Install the bolt in the support finger tight.

C Remove Adapter IAE 1P16549 one at a time.

- 1 Repeat the above procedure to install the duct supports that remain, by number, in clockwise direction.
- 2 Align and carefully engage the Stage 1 HPT Duct Support Seal on the last installed support with the seal slot on the support you install.

R

D Torque the bolts 180 degrees apart 62.0 to 72.0 lbfin (7,005 to 8,135 Nm). Use the IAE 1P17772 Socket 1 off.

E Measure the distance at Dimension D.

NOTE: This is the distance from the front flange of the case assembly to the inner diameter front surface of each Stage 1 Duct Support.

- 1 Measure the distance at Dimension D at 19 locations. Use the IAE 1P17756 Parallel Measuring Bar 1 off and a depth micrometer.
- 2 Subtract the depth gage measurement from the dimension given on the Parallel Measuring Bar.
- 3 The distance at all locations must be between 2.335 to 2.369 in. (59,31 to 60,17 Nm).

R

F Remove all Feeler Gages.

G Check the clearance at Dimension C. This dimension must be 0.016 in. (0.406 Nm) minimum at 38 positions.

H Remove IP 16563 Holding Plate.

(xxiii) Mark the HPT Case and Vane Assembly in accordance with Reference 23, V2500-A5 Standard Practices Manual, Chapter/Section 70-09-00-400-501, Vibration Peen Manual or Mechanical 0.006 in. (0,152 mm) max.

See Figure 7 for the area to mark the part. Reidentify the part as shown in Table VI.

Table VI: Reidentified Parts Data

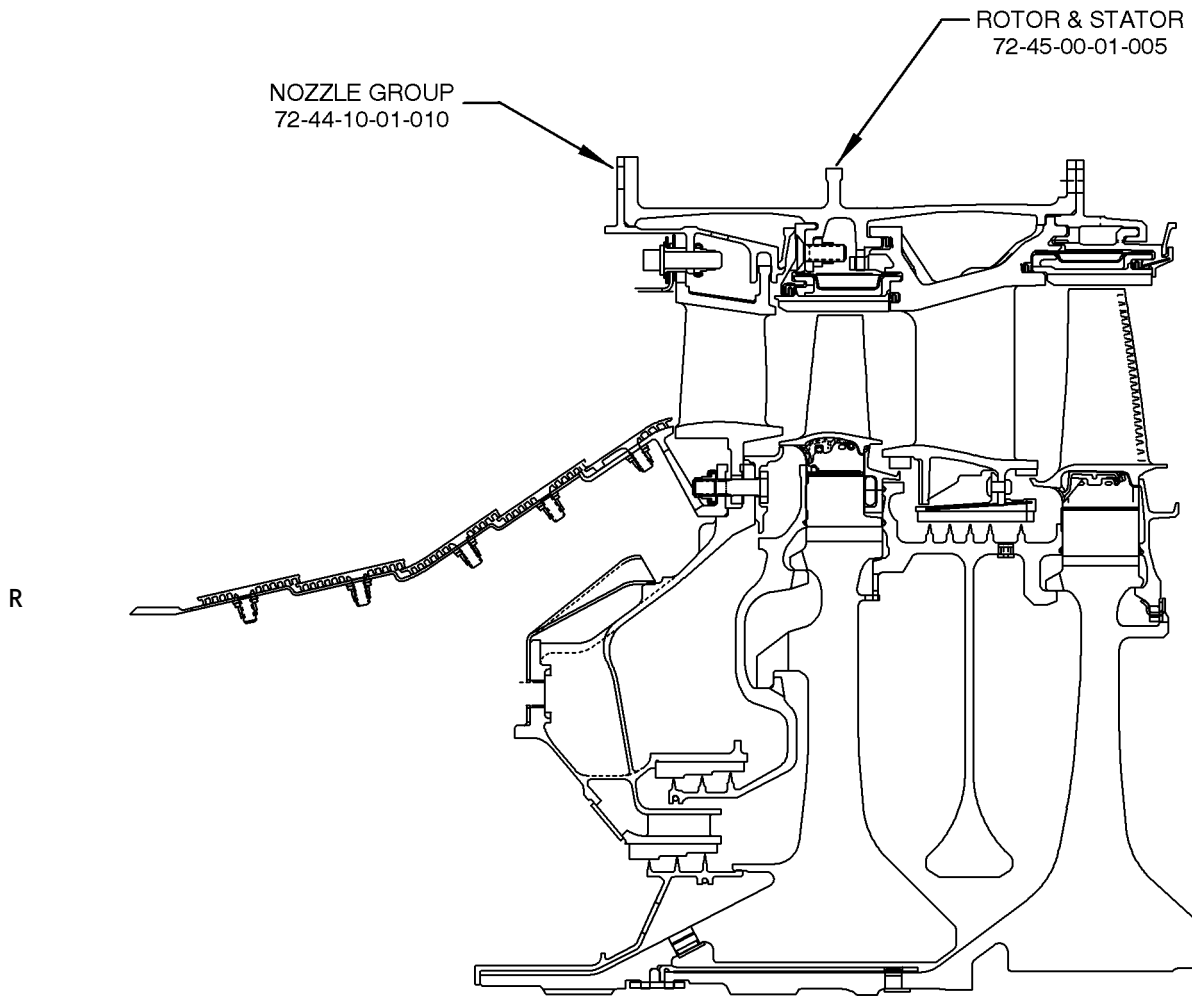
New PN	Keyword	Old PN
2A4087-001	HPT Case and Vane Assy	2A3219-003
2A4087-001	HPT Case and Vane Assy	2A3469-005
2A4087-001	HPT Case and Vane Assy	2A3469-003
2A4087-001	HPT Case and Vane Assy	2A3469-004
2A4087-001	HPT Case and Vane Assy	2A3475-002
2A4087-001	HPT Case and Vane Assy	2A4050

(5) Test Instructions

(a) Test

(6) Recording Instructions

(a) A record of accomplishment is required.



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NOZZLE GROUP ASSEMBLY AND ROTOR AND STATOR ASSEMBLY  
FIGURE 1

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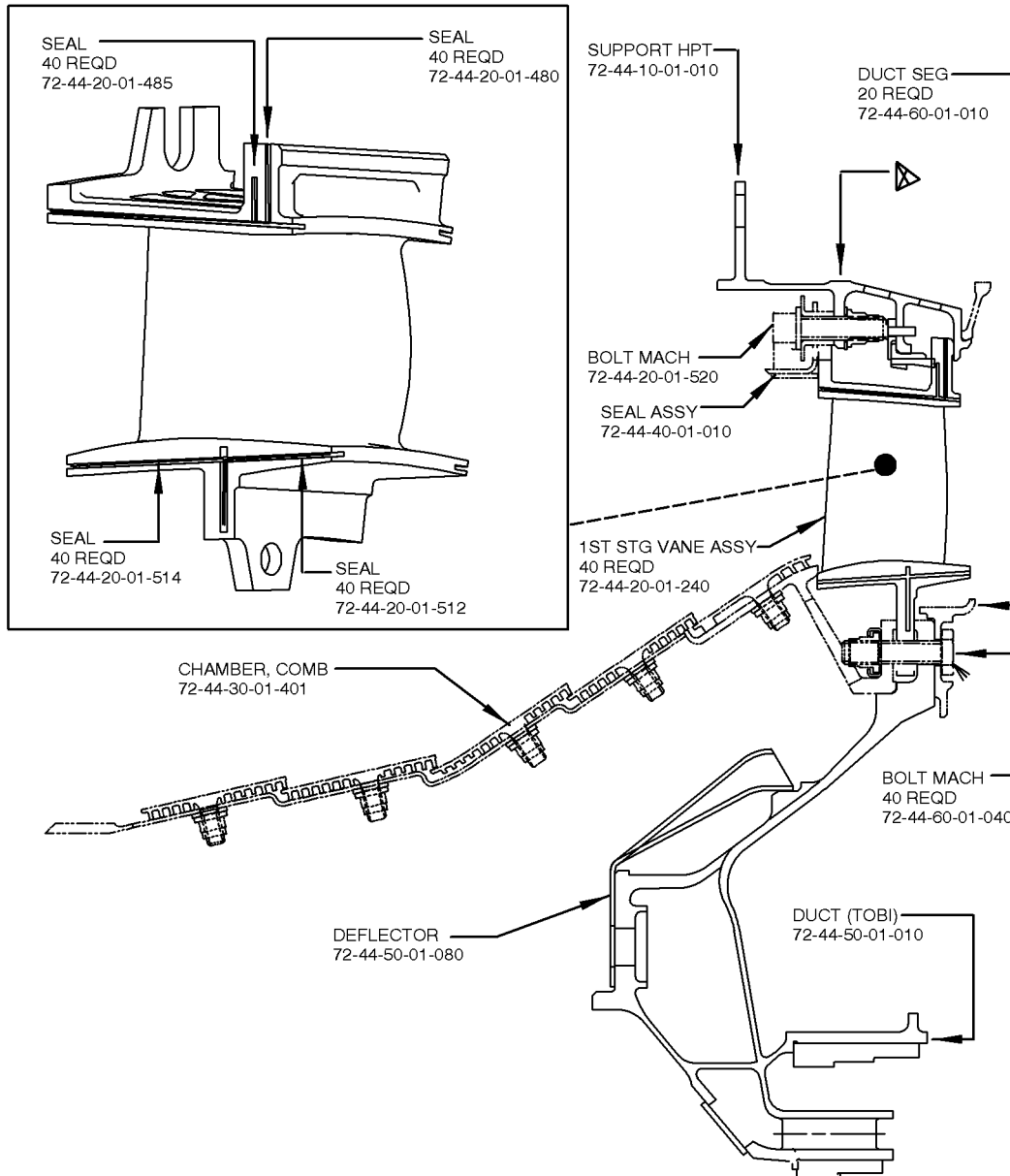
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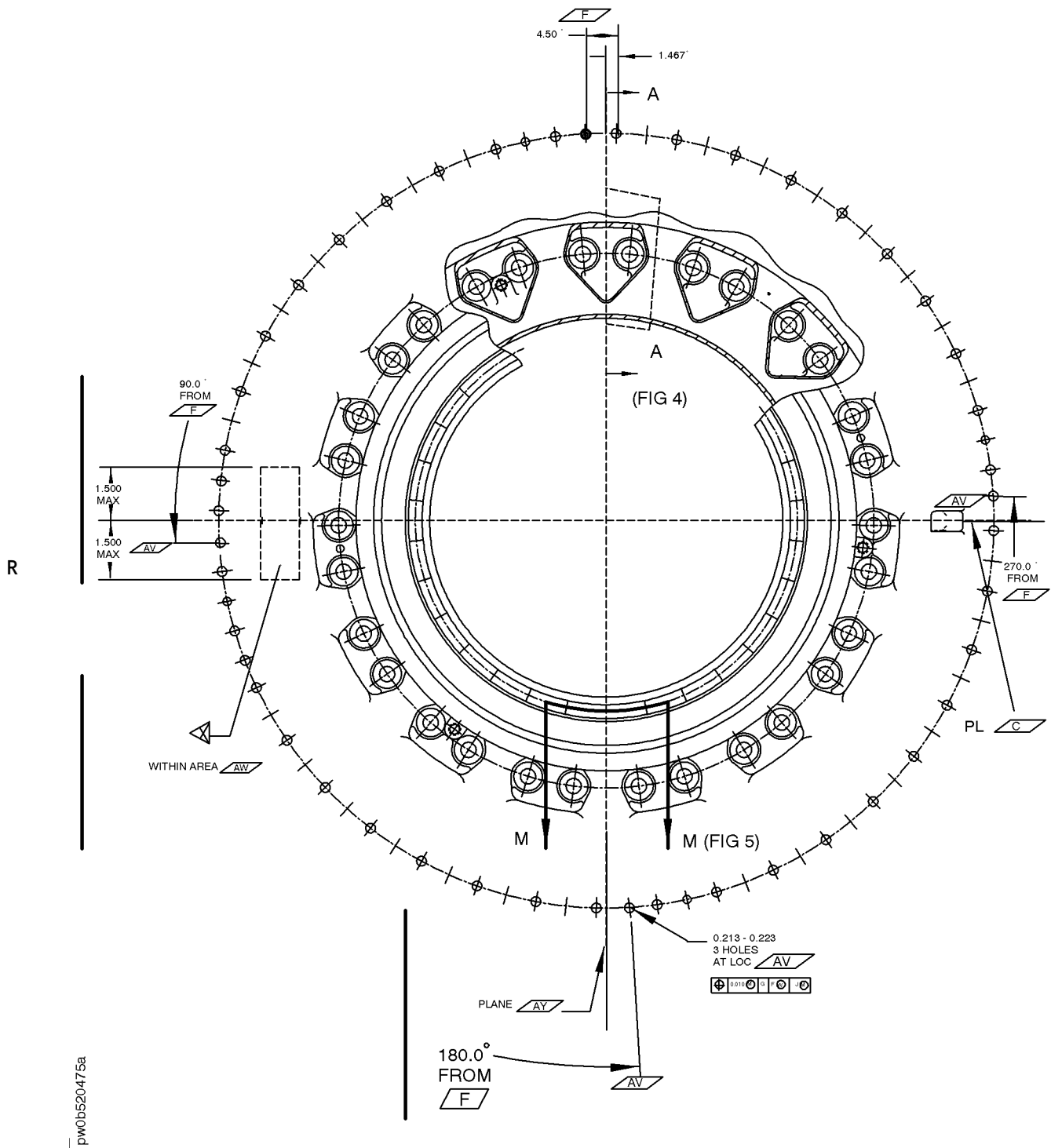
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NOZZLE GROUP  
FIGURE 2



DUCT (TOBI) RE-OP - FORWARD LOOKING REAR  
FIGURE 3

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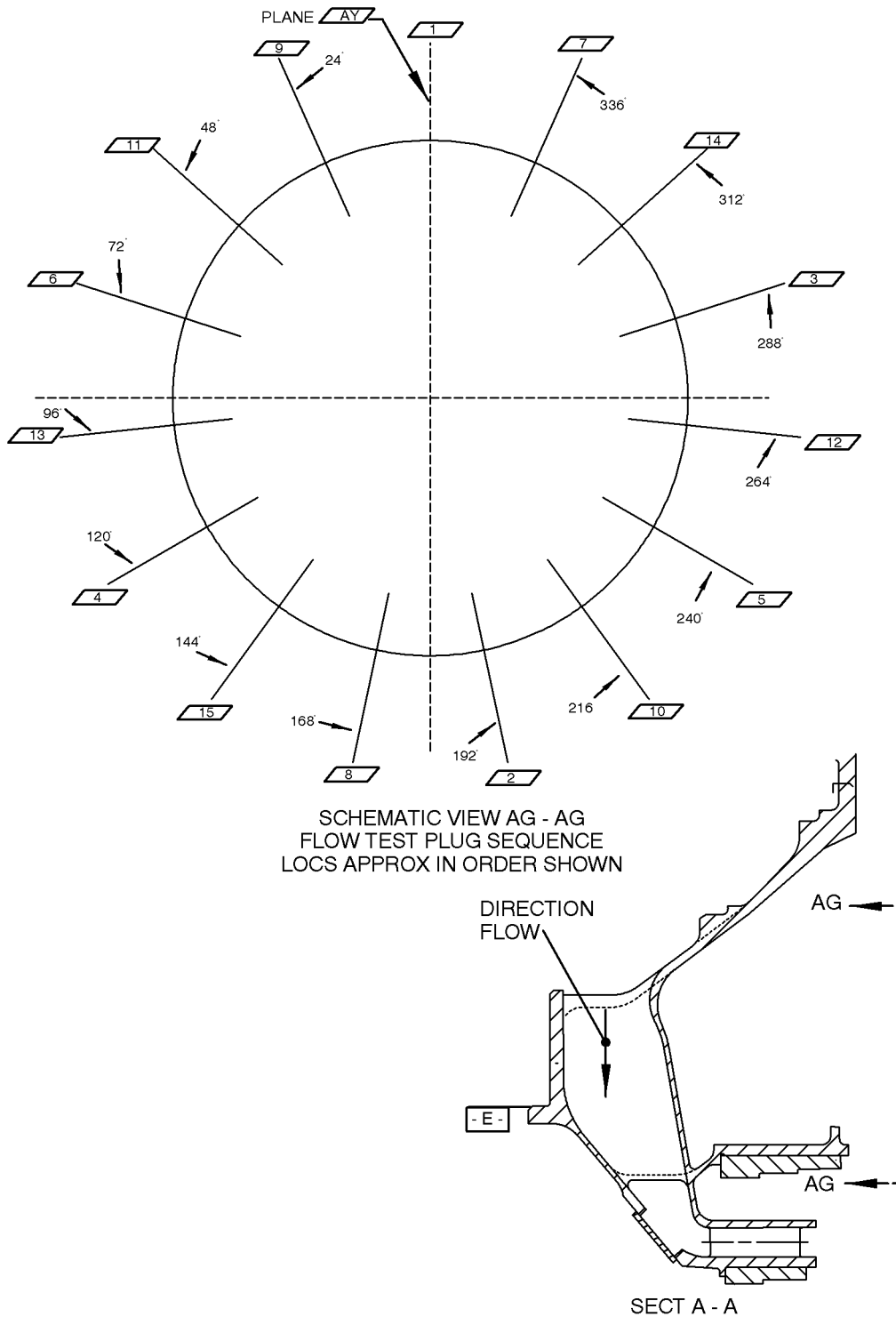
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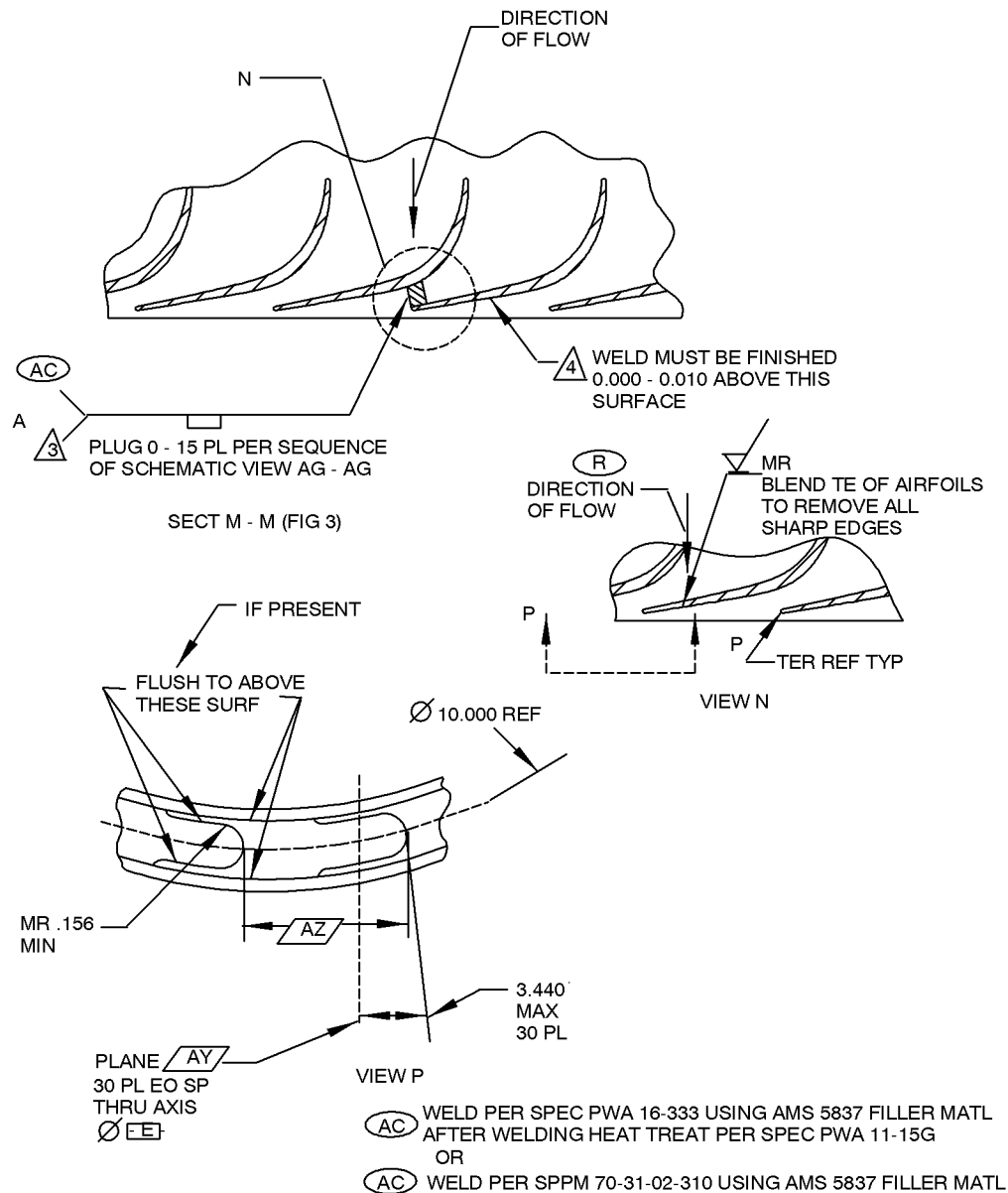
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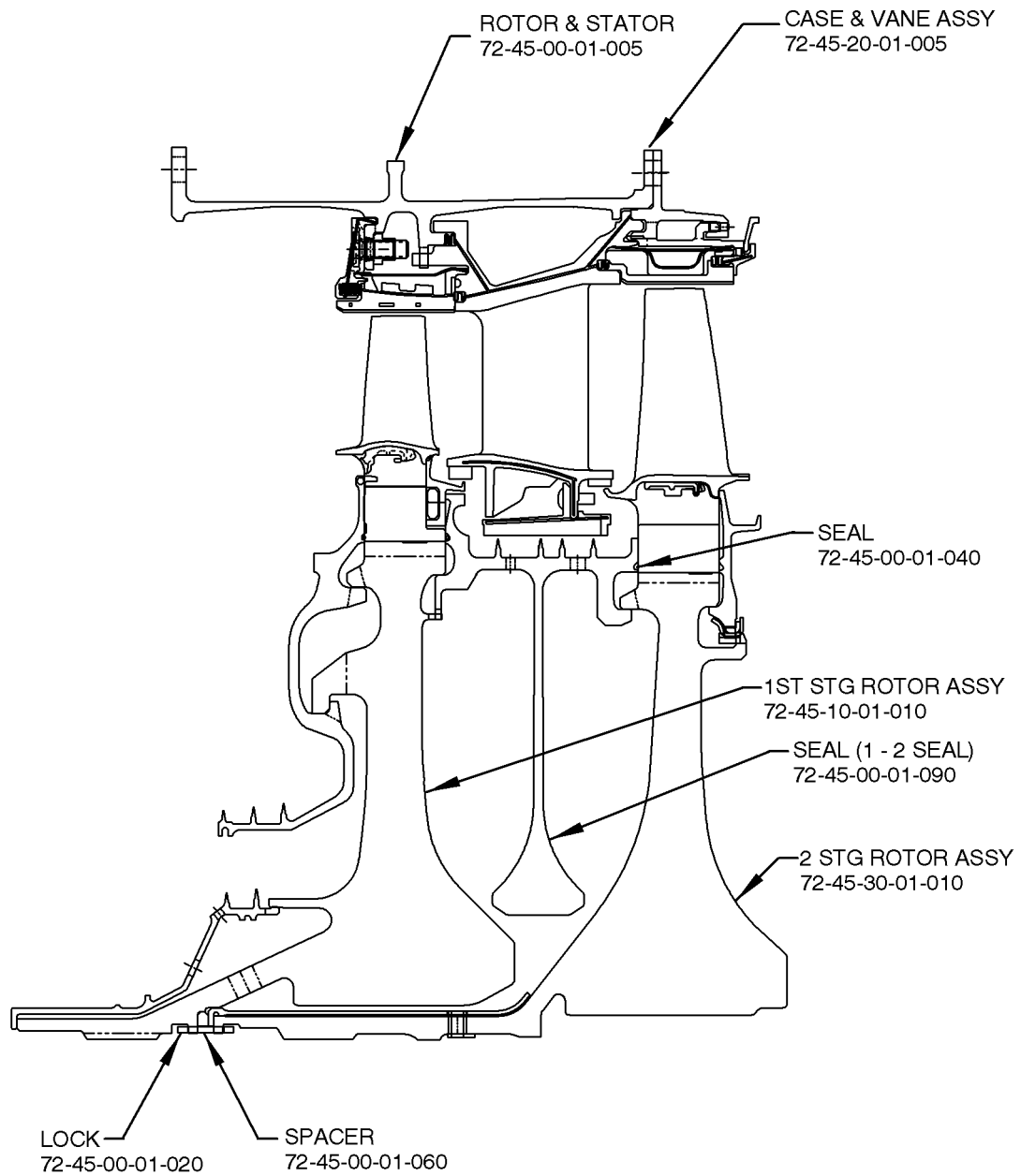
Page 35



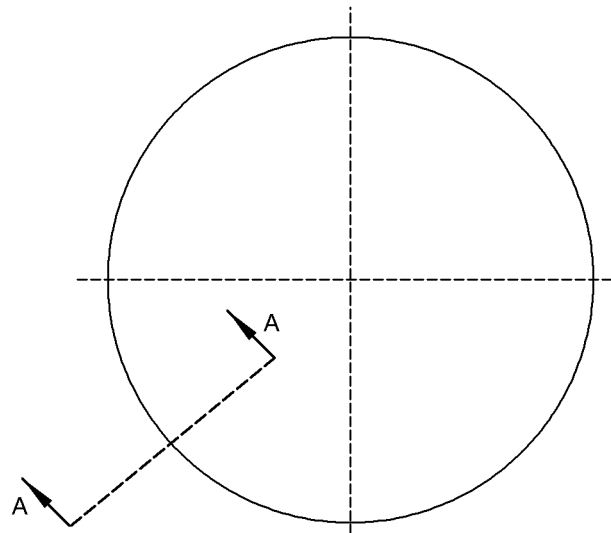
DUCT (TOBI) RE-OP  
FIGURE 4



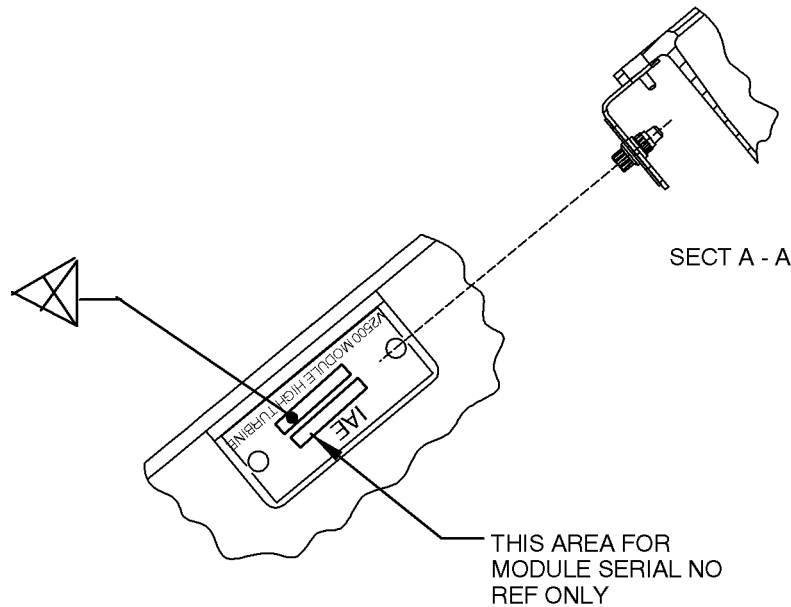
DUCT (TOBI) RE-OP  
FIGURE 5



HPT ROTOR AND STATOR  
FIGURE 6 (SHEET 1 OF 2)

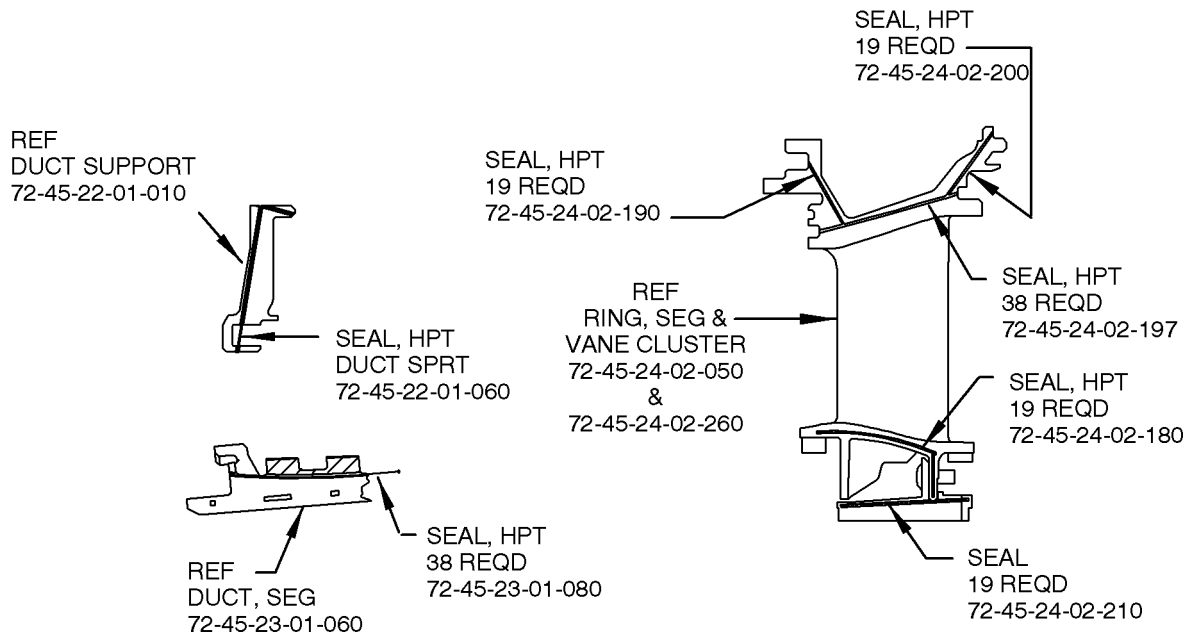
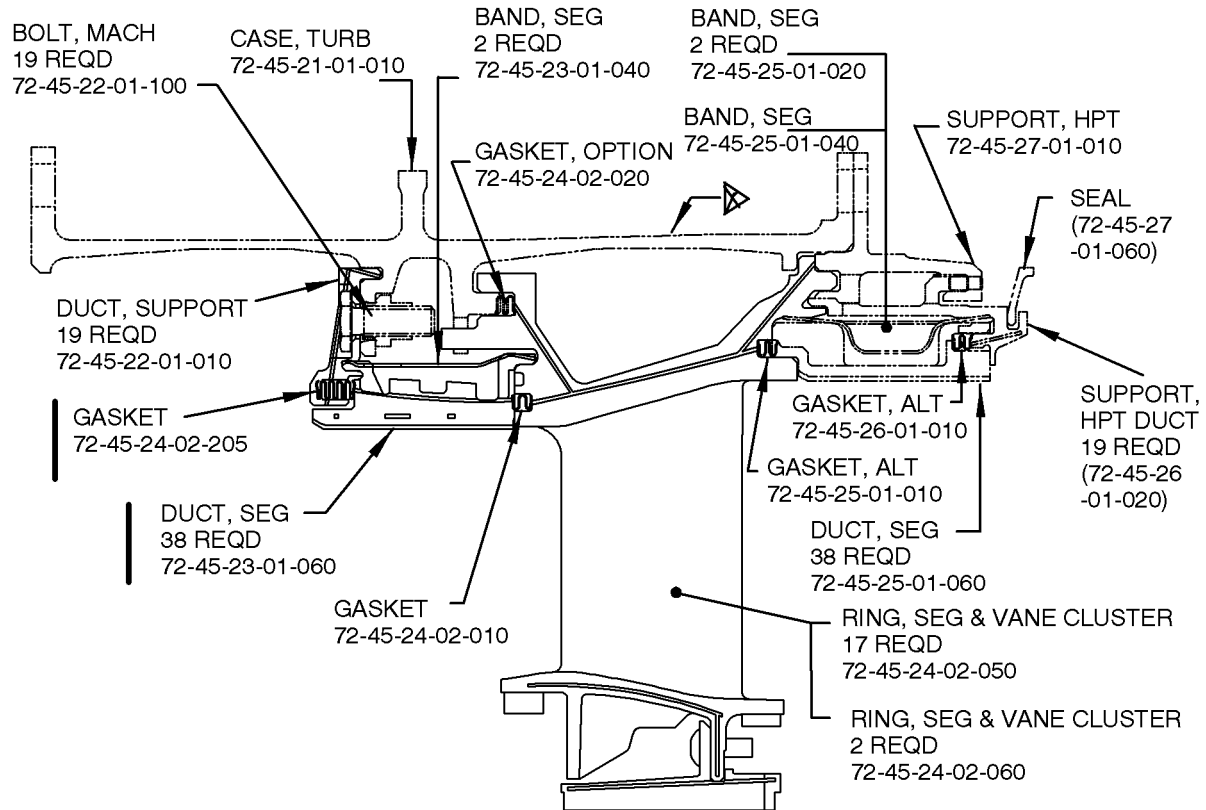


SCHEMATIC  
FORWARD LOOKING REAR

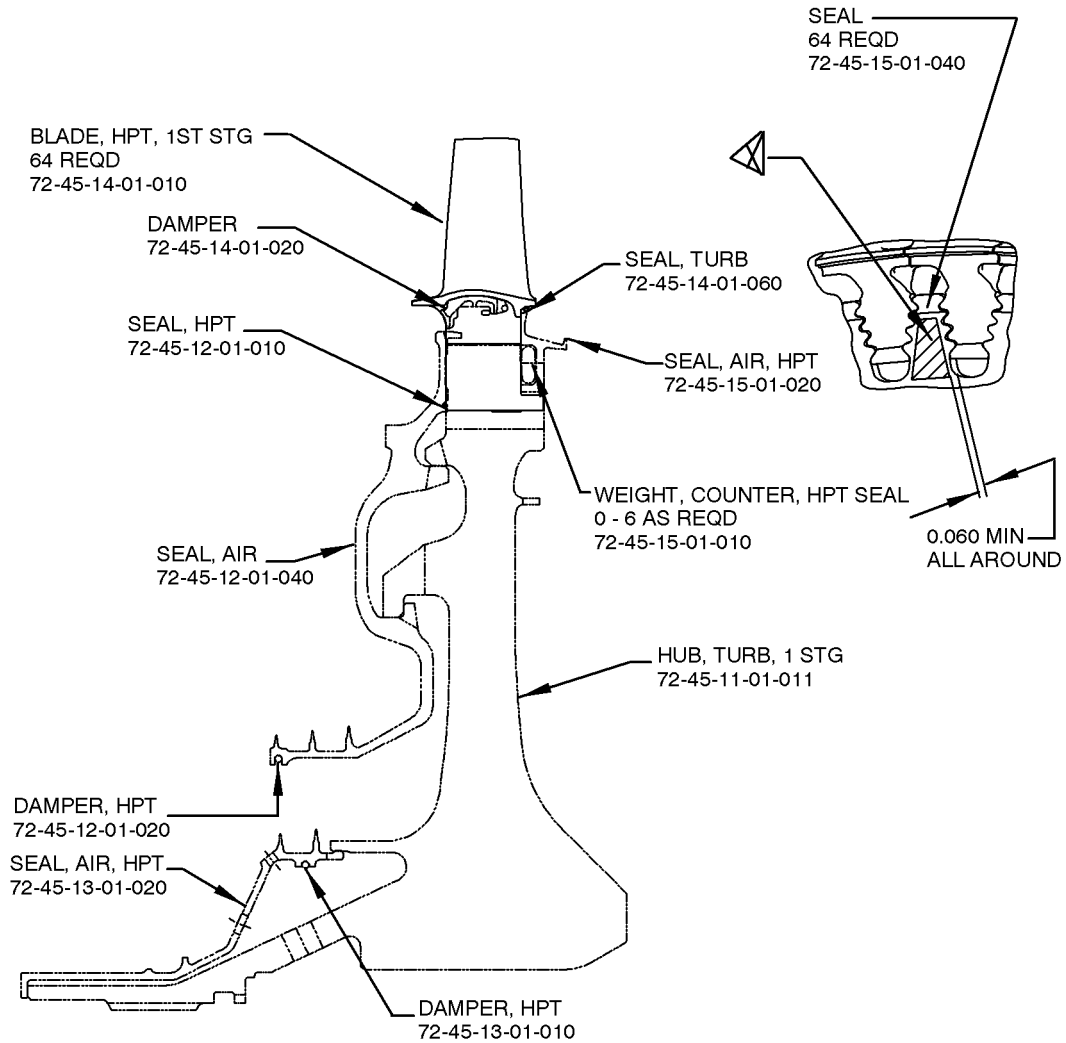


HPT ROTOR AND STATOR  
FIGURE 6 (SHEET 2 OF 2)

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HPT CASE AND VANE ASSEMBLY  
FIGURE 7



HPT 1ST STAGE TURBINE ROTOR  
FIGURE 8

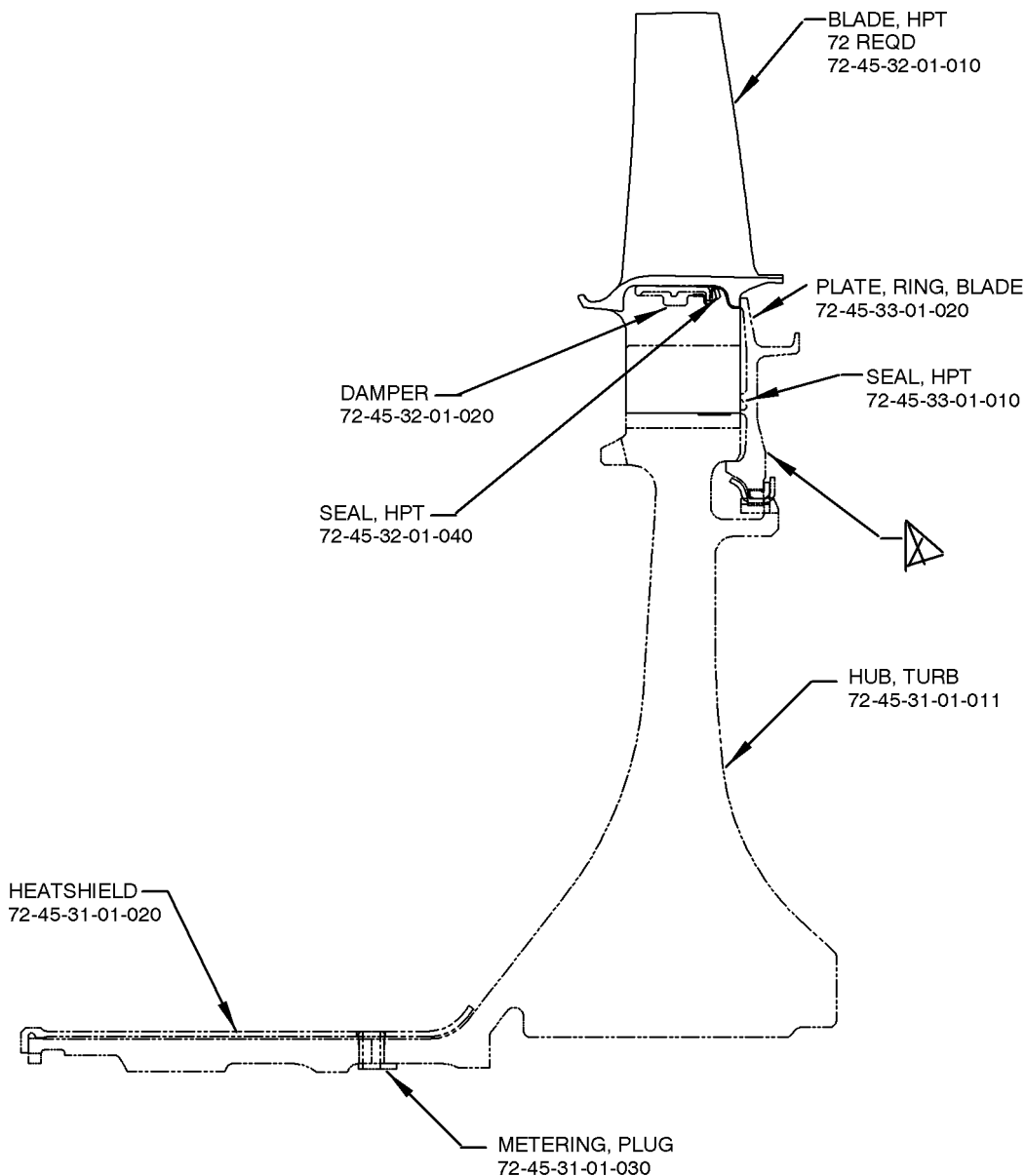
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HPT 2ND STAGE TURBINE ROTOR  
FIGURE 9

ENGINE – HIGH PRESSURE TURBINE (HPT) – V2500 SELECTONE PRODUCTION AND RETROFIT – HPT  
UPGRADE

Supplement – Parts Progression To Show the Changed Part in Relation to Other Parts

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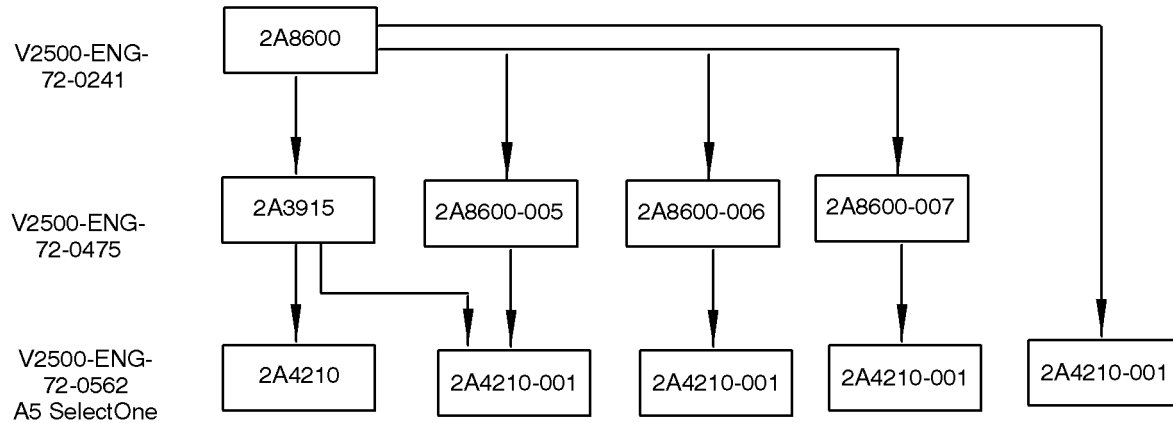
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MODIFICATIONS

PART NUMBER CHANGE



pw0b520396

FAMILY TREE – TURBINE NOZZLE GROUP REF. CATALOG SEQUENCE NO. 72-44-00 FIGURE 01  
ITEM 001  
CHART A

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MODIFICATIONS

PART NUMBER CHANGE

BASELINE

2A1664\*

V2500-ENG-72-0147

2A2703

V2500-ENG-72-0341

2A3367

V2500-ENG-72-0483

2A3896

V2500-ENG-72-0562  
A5 SelectOne

2A4085

pw0b520495

FAMILY TREE – FIRST STAGE HPT SUPPORT ASSEMBLY REF. CATALOG SEQUENCE NO. 72-44-10  
FIGURE 01 ITEM 010  
CHART B

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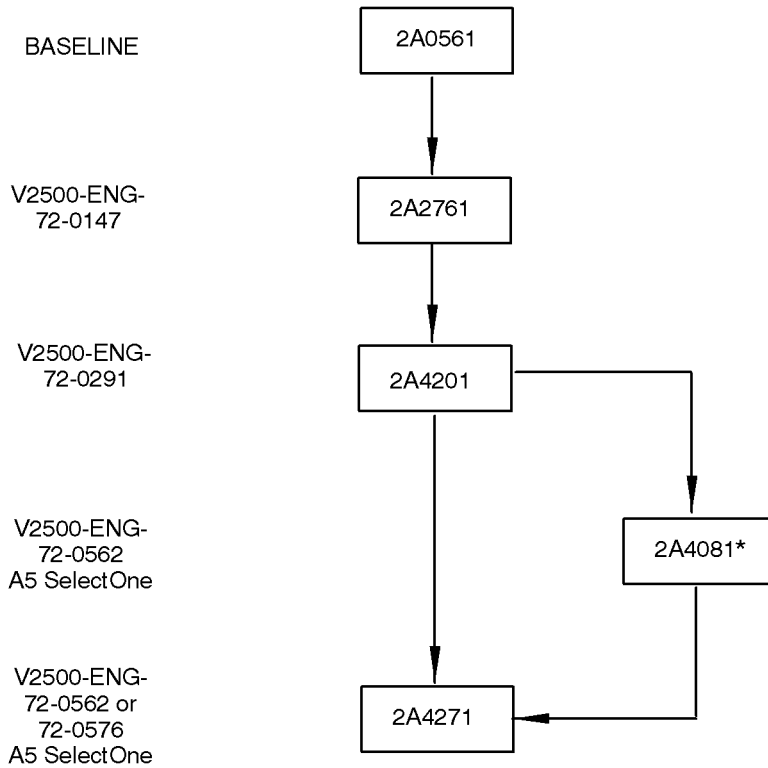
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MODIFICATIONS

PART NUMBER CHANGE



\*Only in Engine V15001 AND V15002 Pre SB 72-0576

pw0b520520

FAMILY TREE – STAGE 1 HPT VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-44-20 FIGURE  
01 ITEM 240  
CHART C

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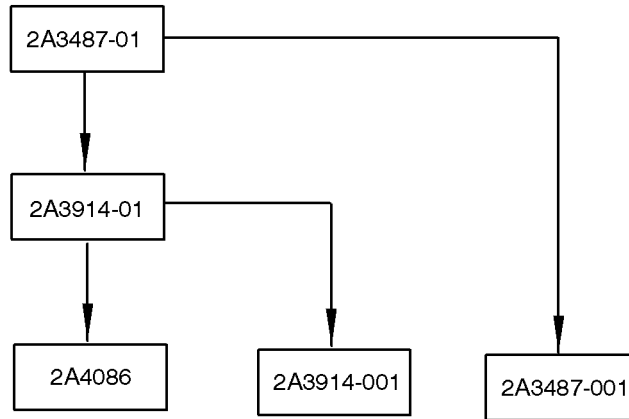
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## MODIFICATIONS

## PART NUMBER CHANGE

V2500-ENG-  
72-0381

V2500-ENG-  
72-0475

V2500-ENG-  
72-0562  
A5 SelectOne


pw0b520519

FAMILY TREE – HPT COOLING DUCT ASSEMBLY REF. CATALOG SEQUENCE NO. 72-44-50 FIGURE  
01 ITEM 010  
CHART D

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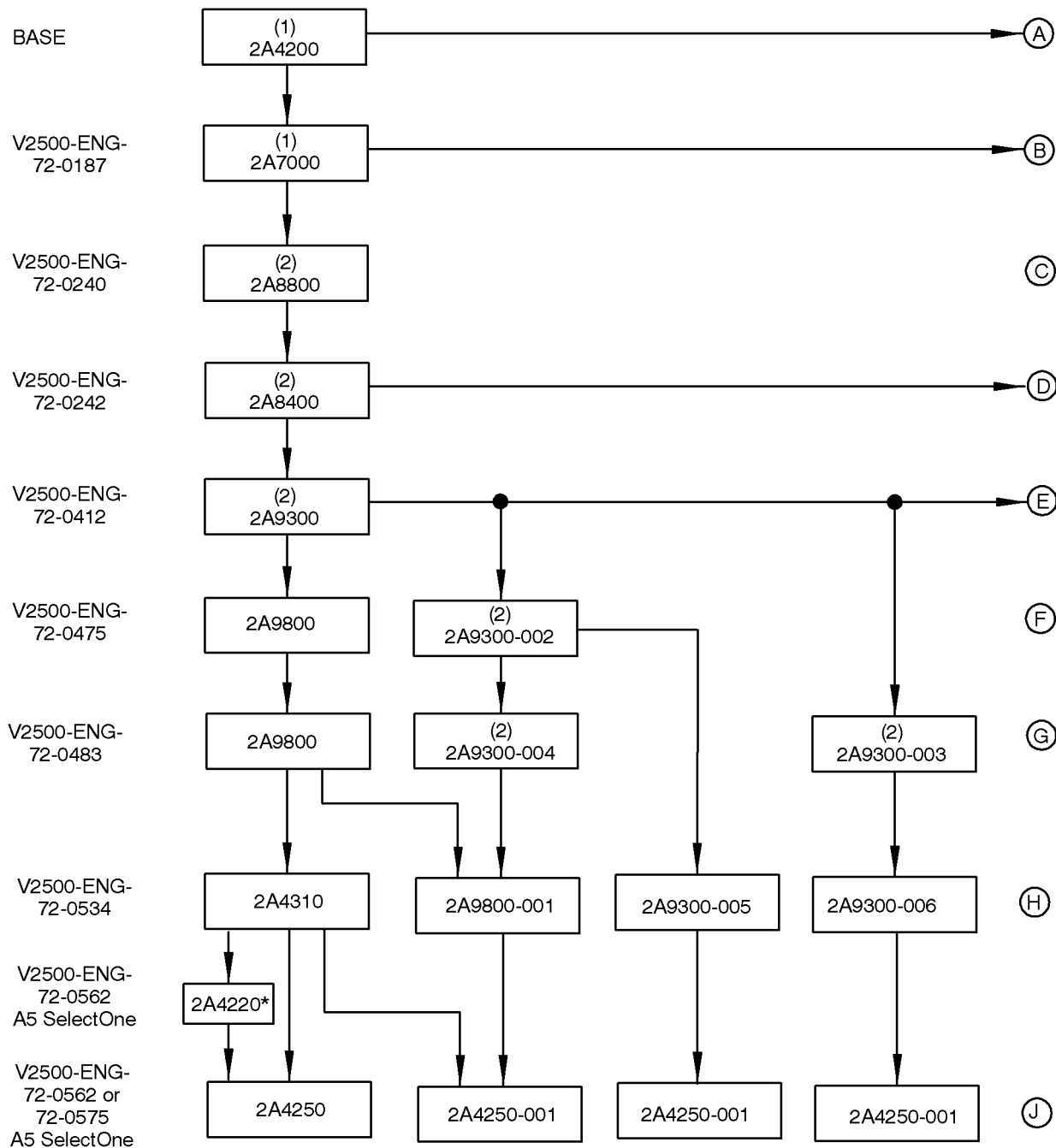
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MODIFICATIONS

PART NUMBER CHANGE



\*Only in A5 SelectOne Engine V15001 and V15002 Pre SB 72-0575

(1) NOT 33K RATED

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 1 OF 9)

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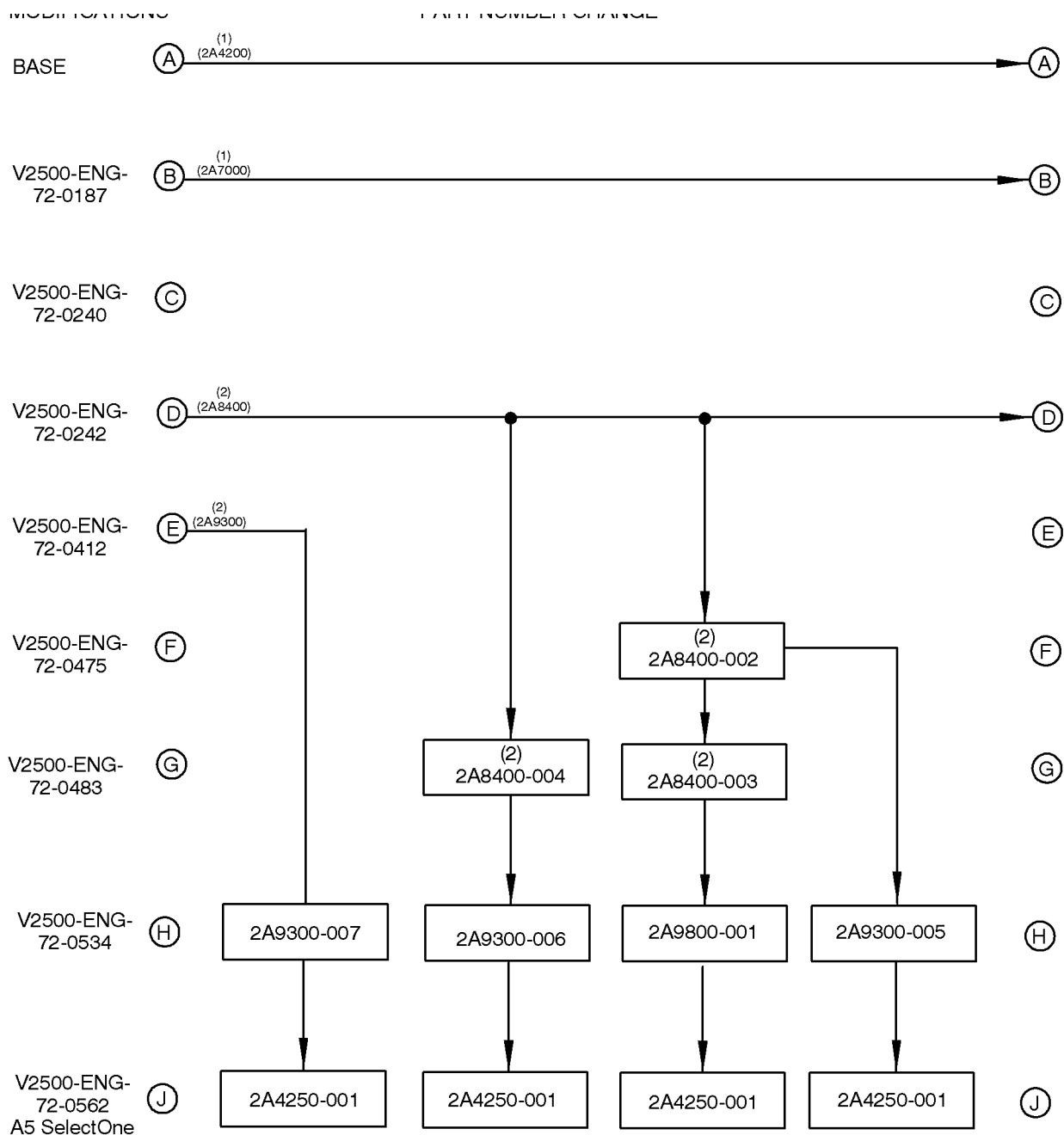
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pw0b520485



(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw0b520484

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 2 OF 9)

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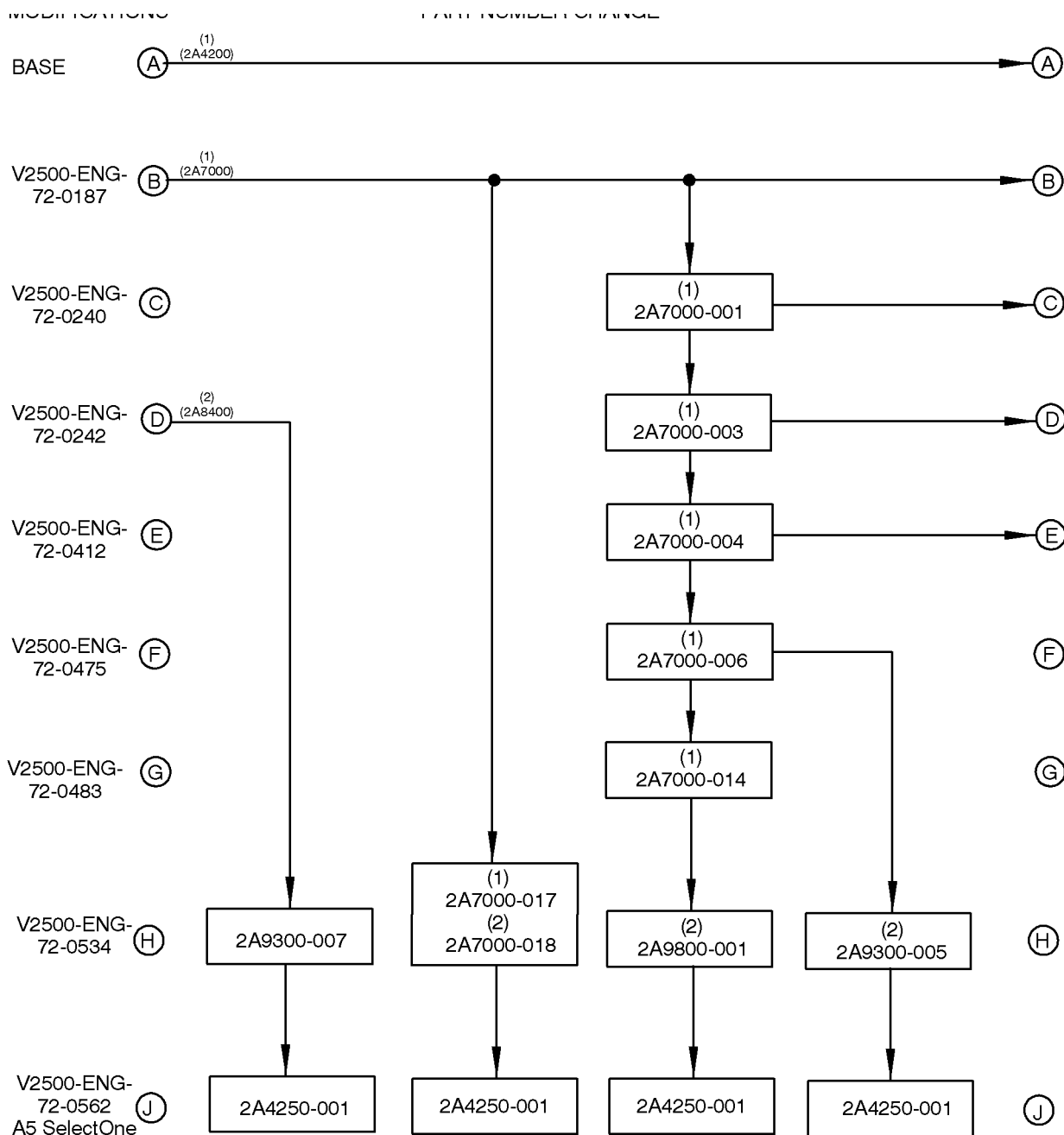
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(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw005120486

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 3 OF 9)

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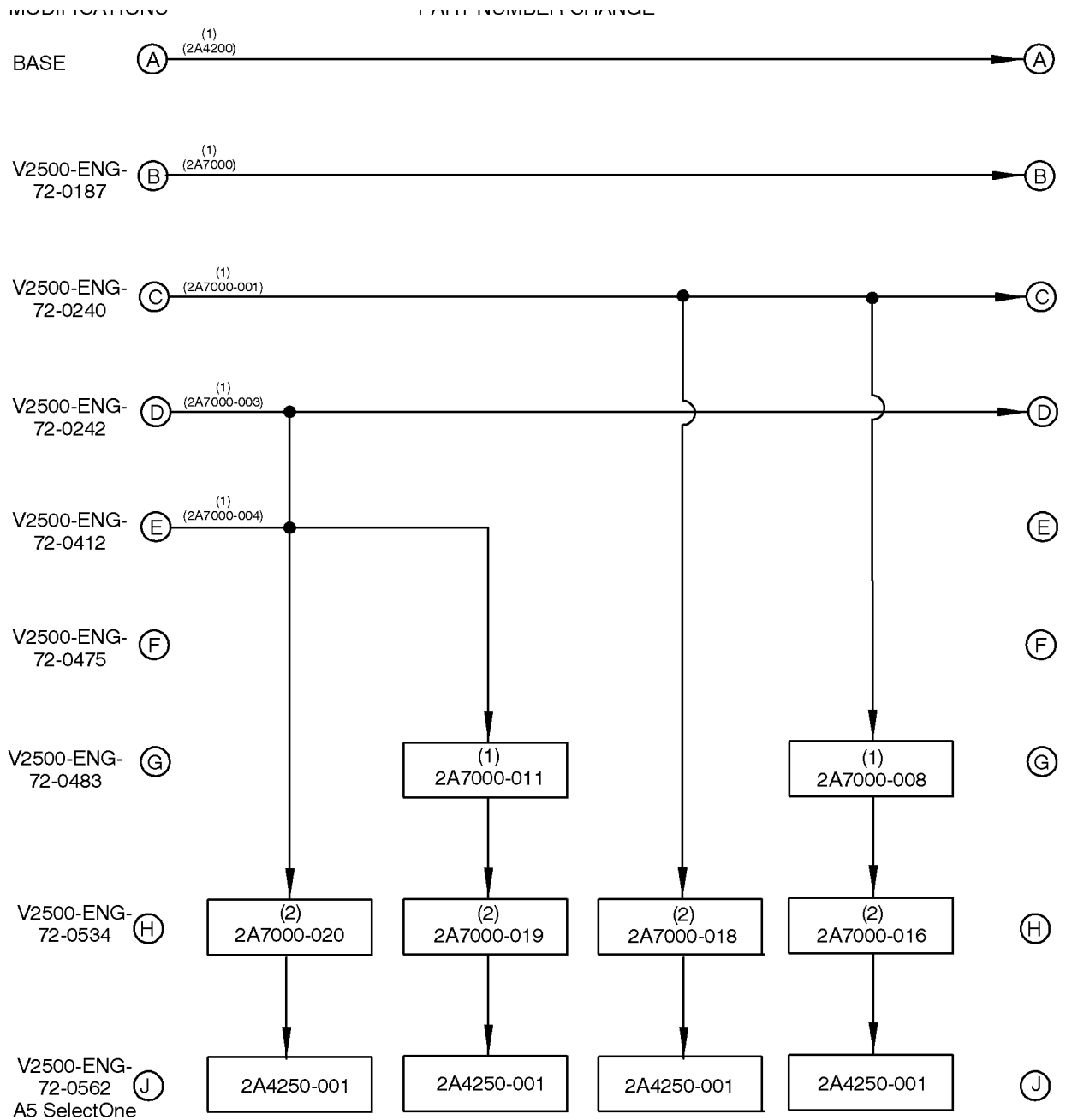
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(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw005120490

FAMILY TREE - ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 4 OF 9)

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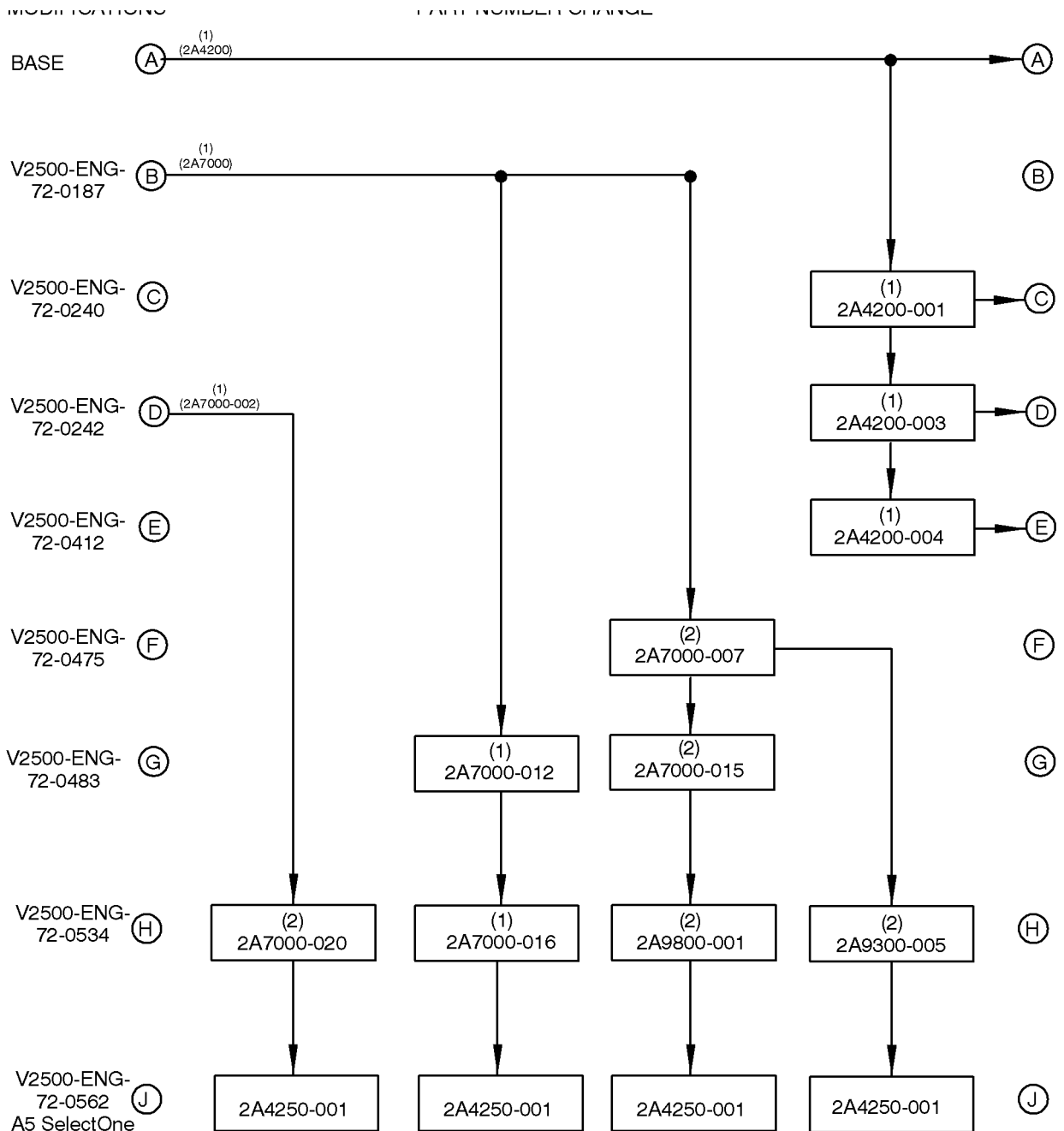
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(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw0b520488

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 6 OF 9)

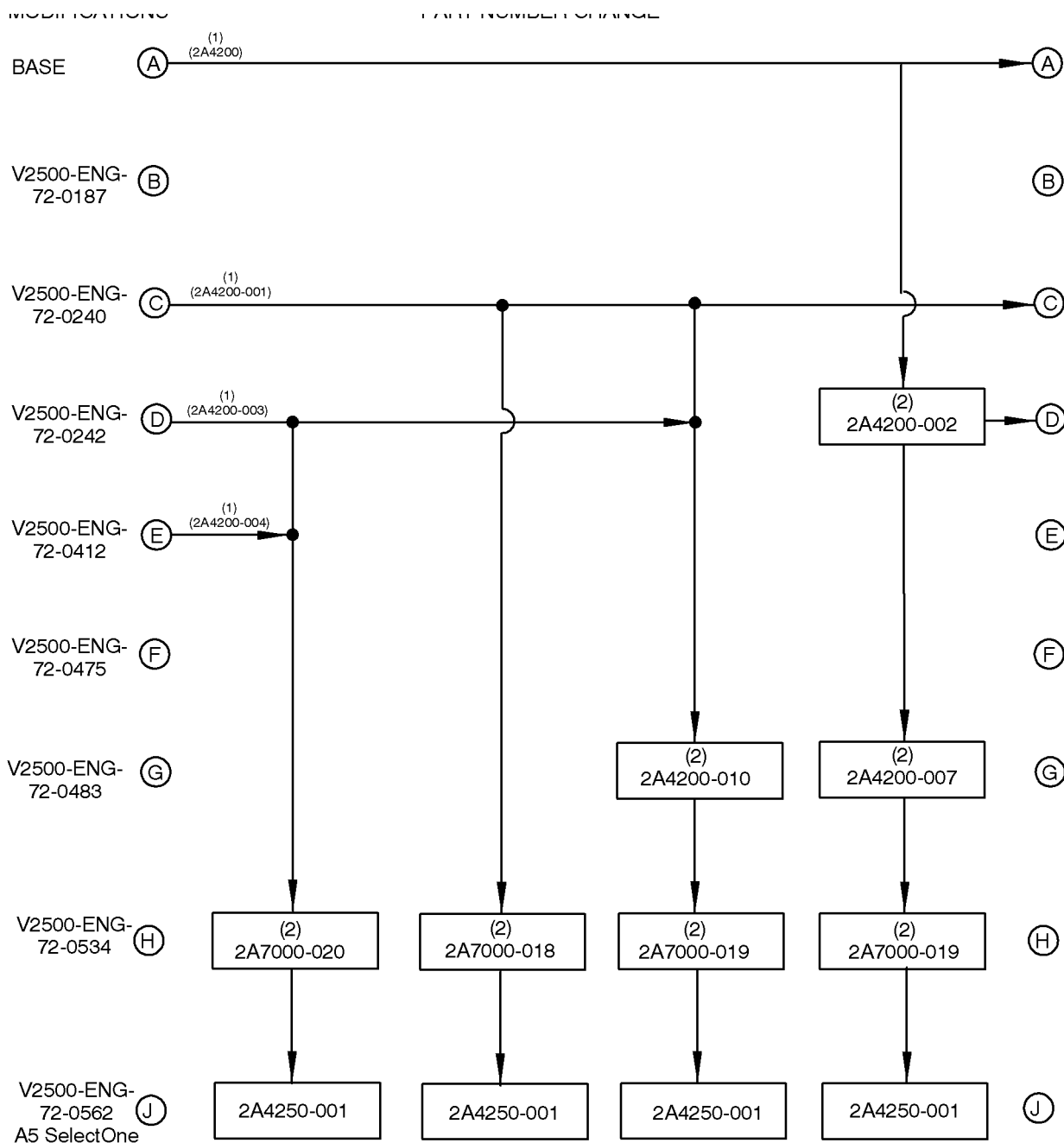
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(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw0b520492

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 7 OF 9)

Sep.22/08

Sep. 19/13 Revision 1

# V2500-ENG-72-0562

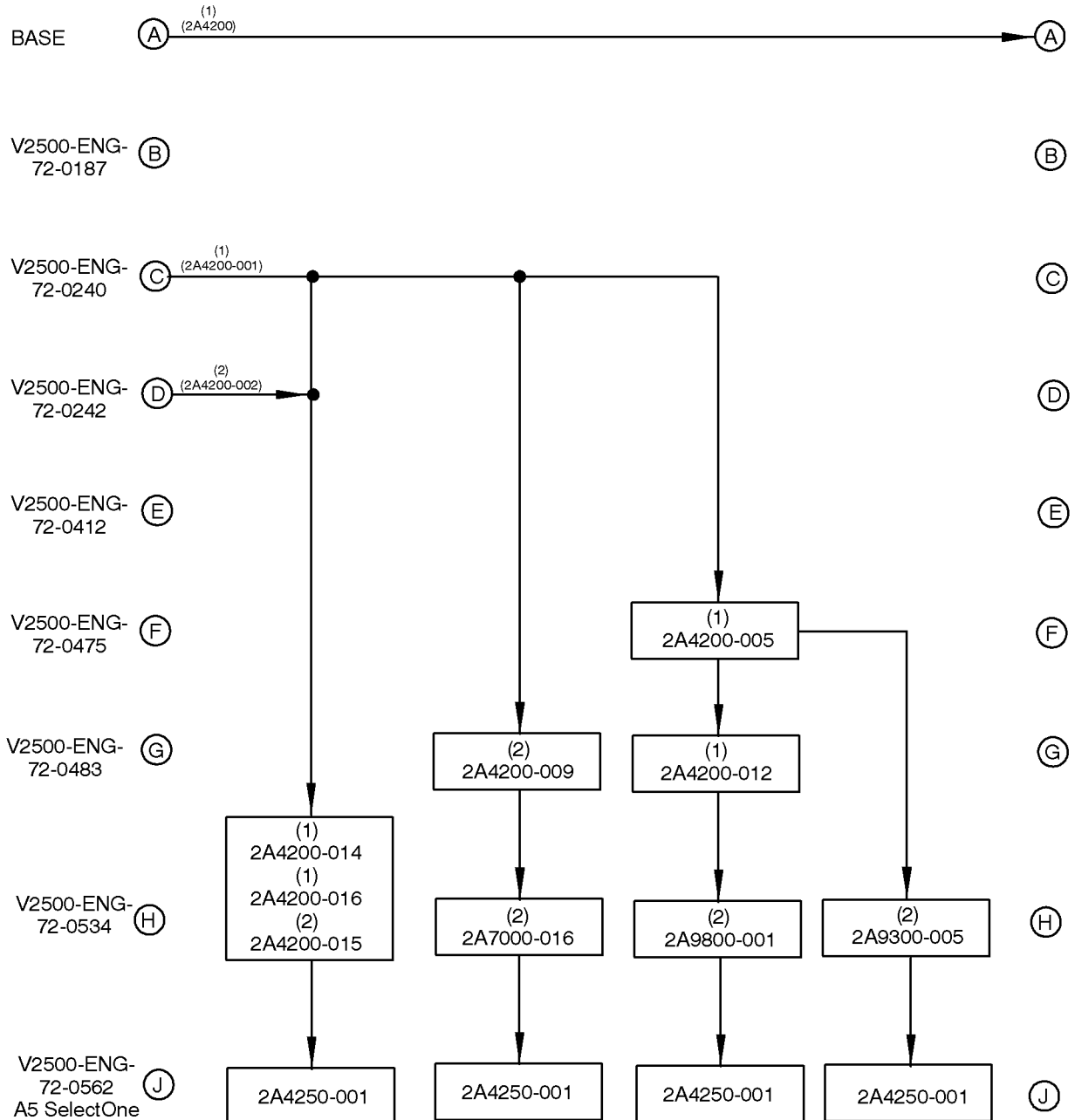
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MODIFICATIONS

PART NUMBER CHANGE



(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 8 OF 9)

Sep.22/08

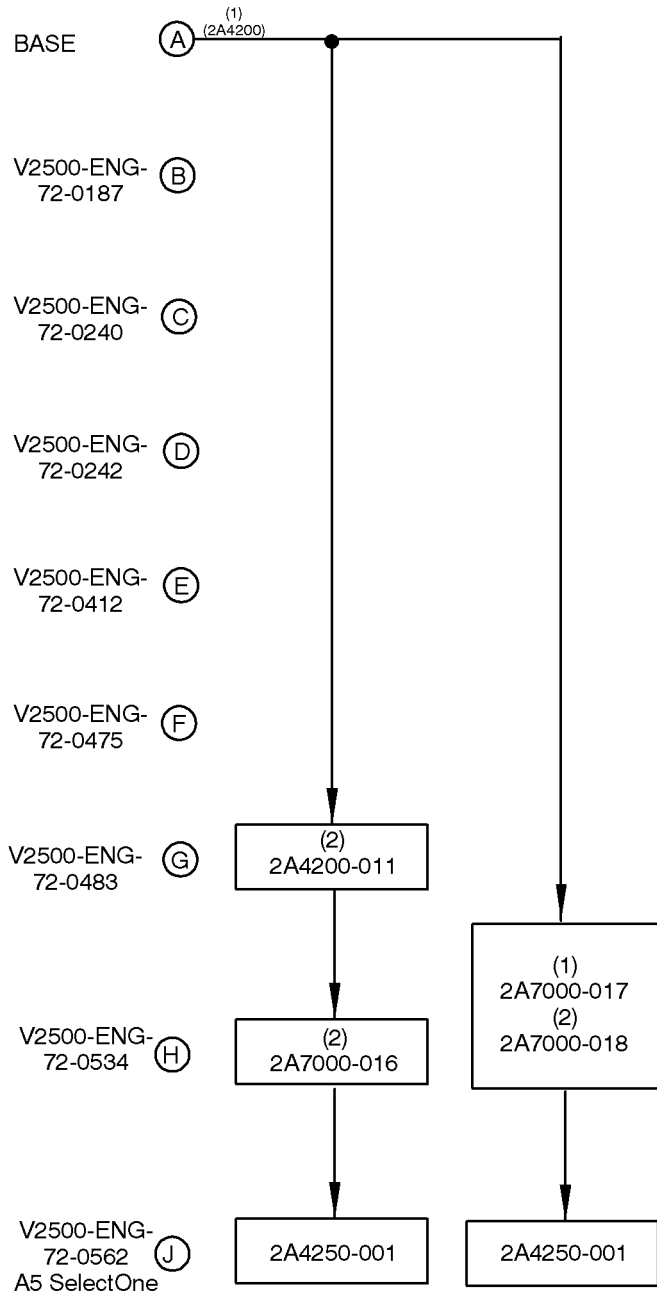
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MODIFICATIONS PART NUMBER CHANGE



(1) NOT 33K RATED.

(2) NOT 33K RATED IF THE HPT STAGE 1 ROTOR ASSEMBLY CONTAINS STAGE 1 HUB PN 2A2201 AND/OR ANY STAGE 1 BLADE PN 2A8701-002, 2A8701-001, 2A8521-004, 2A8521-002, 2A8321-004, 2A8321-003, 2A8321-002.

pw01520493

FAMILY TREE – ROTOR AND STATOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-00 FIGURE 01 ITEM 001  
CHART E (SHEET 9 OF 9)

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# V2500-ENG-72-0562

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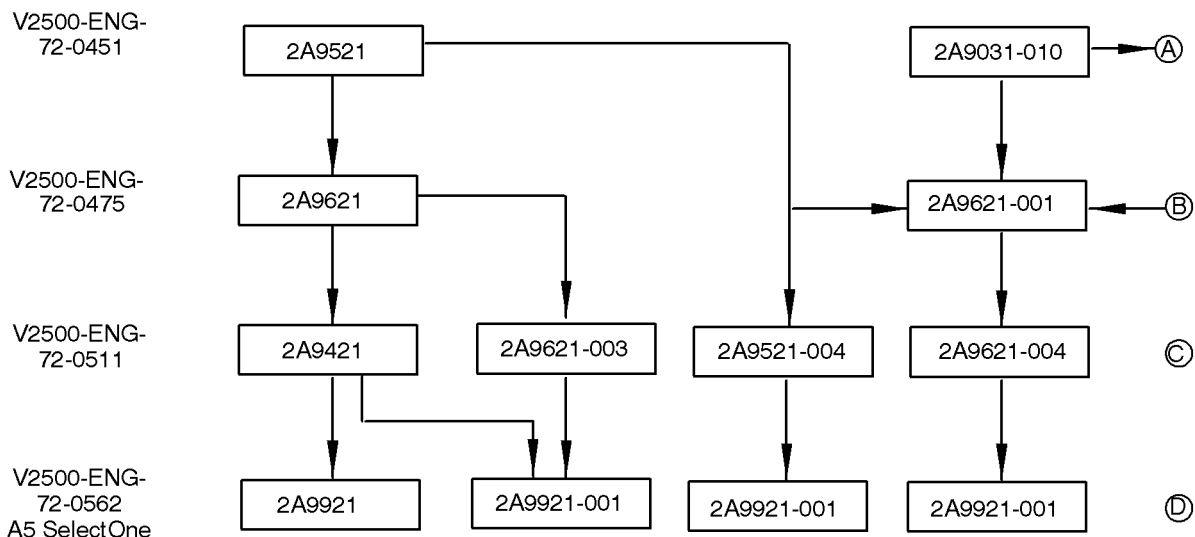
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MODIFICATION

PART NUMBER CHANGE



pw0b520504

FAMILY TREE - TURBINE ROTOR 1ST STAGE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-10  
FIGURE 01 ITEM 010  
CHART F (SHEET 1 OF 2)

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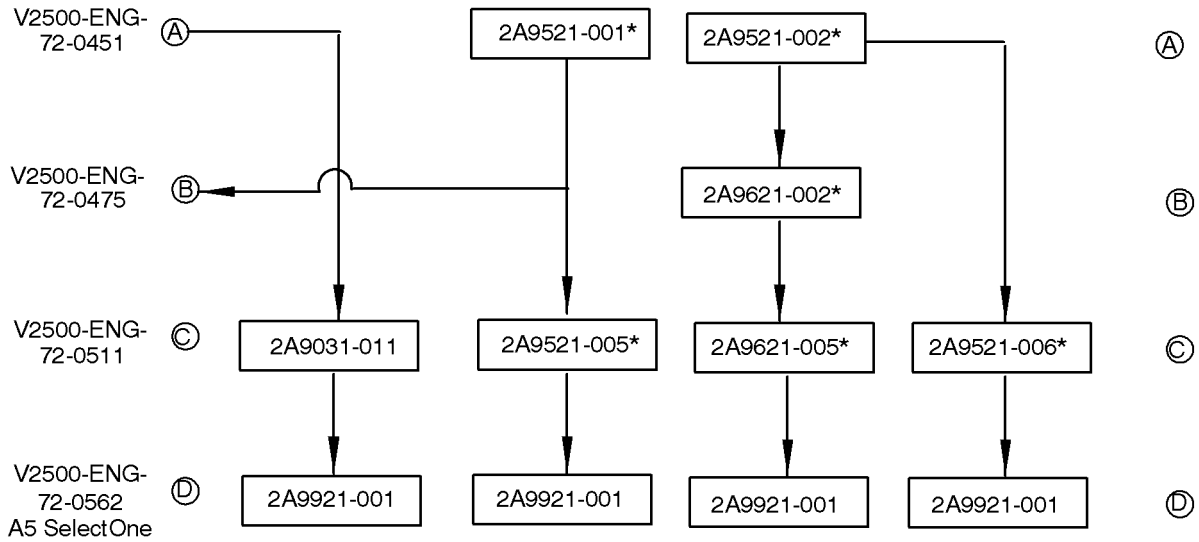
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**V2500-ENG-72-0562**

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MODIFICATION

PART NUMBER CHANGE



\*DO NOT USE IN MODEL V2533-A5

pw0b520505

FAMILY TREE - TURBINE ROTOR 1ST STAGE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-10  
FIGURE 01 ITEM 010  
CHART F (SHEET 2 OF 2)

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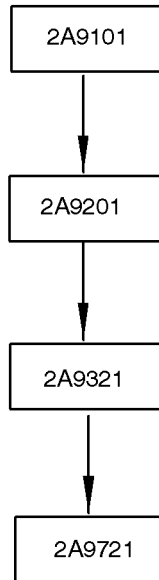
MODIFICATIONS

PART NUMBER CHANGE

V2500-ENG-  
72-0357

V2500-ENG-  
72-0361

V2500-ENG-  
72-0475

V2500-ENG-  
72-0562  
A5 SelectOne


pw0b520501

FAMILY TREE – HPT BLADE 1ST STAGE REF. CATALOG SEQUENCE NO. 72-45-14 FIGURE 01  
ITEM 010  
CHART G

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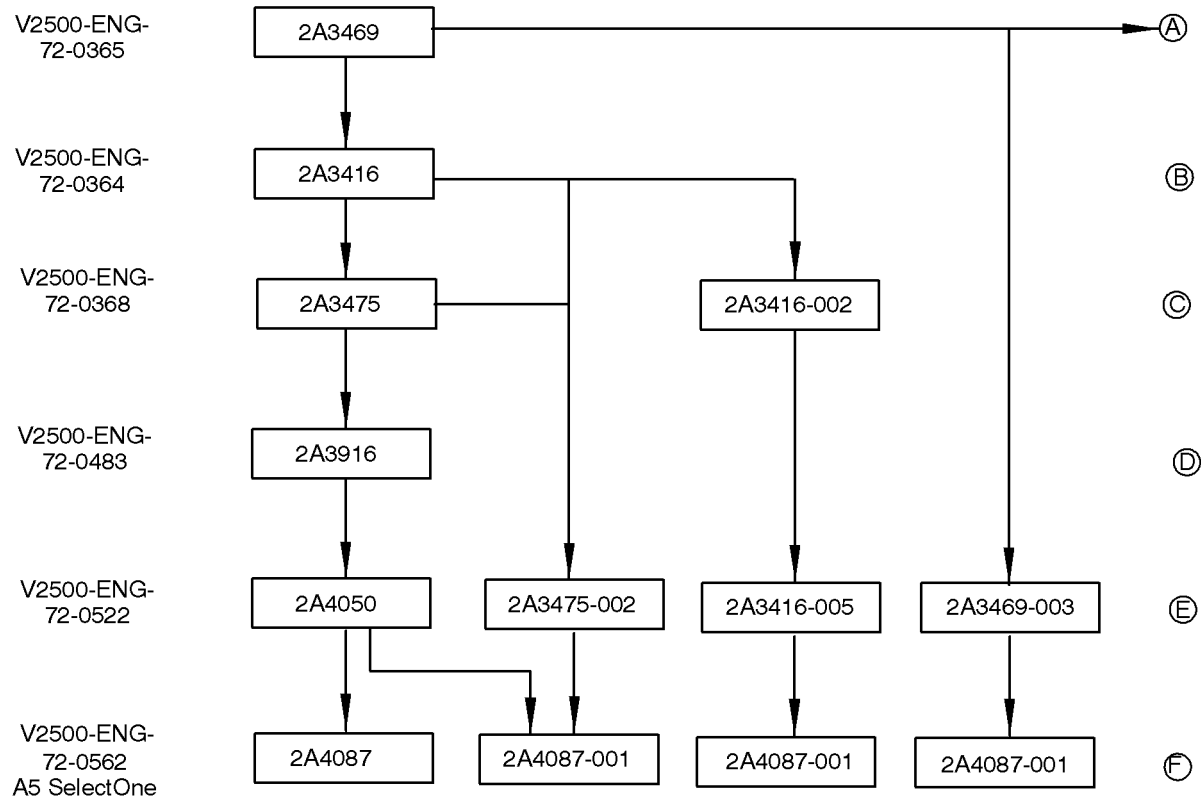
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MODIFICATION

PART NUMBER CHANGE



pw0b520391

FAMILY TREE – HPT CASE AND VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-20 FIGURE  
01 ITEM 005  
CHART H (SHEET 1 OF 5)

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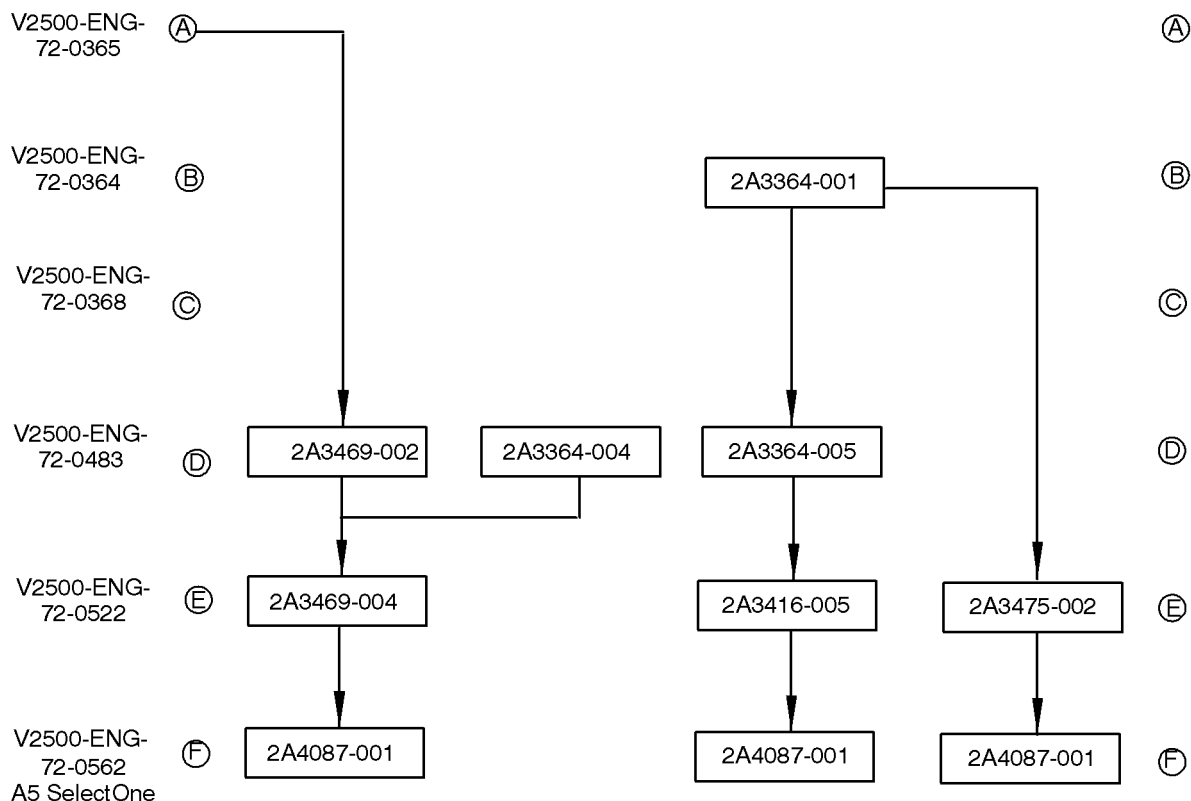
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MODIFICATION

PART NUMBER CHANGE



pw0b520392

FAMILY TREE – HPT CASE AND VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-20 FIGURE  
01 ITEM 005  
CHART H (SHEET 2 OF 5)

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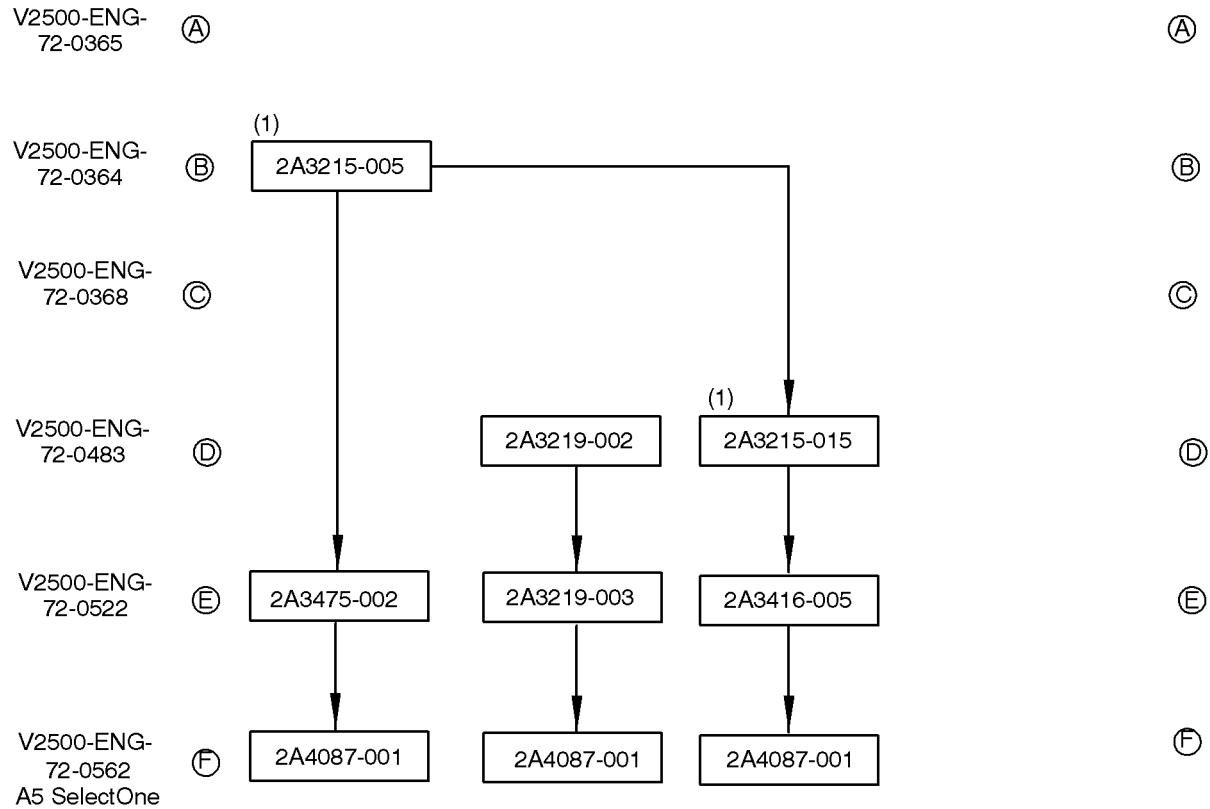
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MODIFICATION

PART NUMBER CHANGE



(1) DO NOT USE IN MODEL V2533-A5 IF CASE AND VANE ASSEMBLY CONTAINS ANY RING SEGMENT AND VANE CLUSTER ASSEMBLY 2A2272, 2A2272-001, 2A2272-002, 2A2372, 2A2372-002, 2A3372, 2A3372-001, 2A3472, OR 2A3472-001.

pw0b520393

FAMILY TREE – HPT CASE AND VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-20 FIGURE  
01 ITEM 005  
CHART H (SHEET 3 OF 5)

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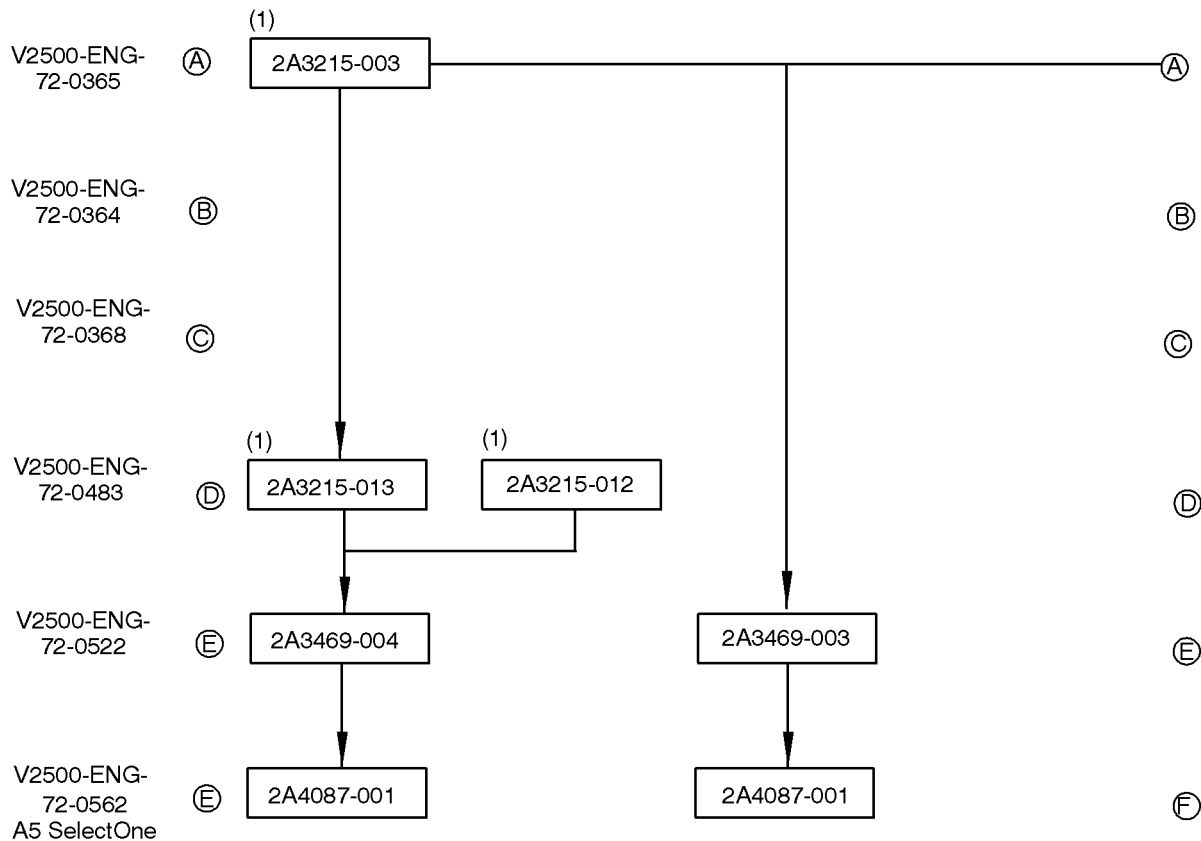
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MODIFICATION

PART NUMBER CHANGE



(1) DO NOT USE IN MODEL V2533-A5 IF CASE AND VANE ASSEMBLY CONTAINS ANY RING SEGMENT AND VANE CLUSTER ASSEMBLY 2A2272, 2A2272-001, 2A2272-002, 2A2372, 2A2372-002, 2A3372, 2A3372-001, 2A3472, OR 2A3472-001.

pw0b520394

FAMILY TREE – HPT CASE AND VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-20 FIGURE 01 ITEM 005  
CHART H (SHEET 4 OF 5)

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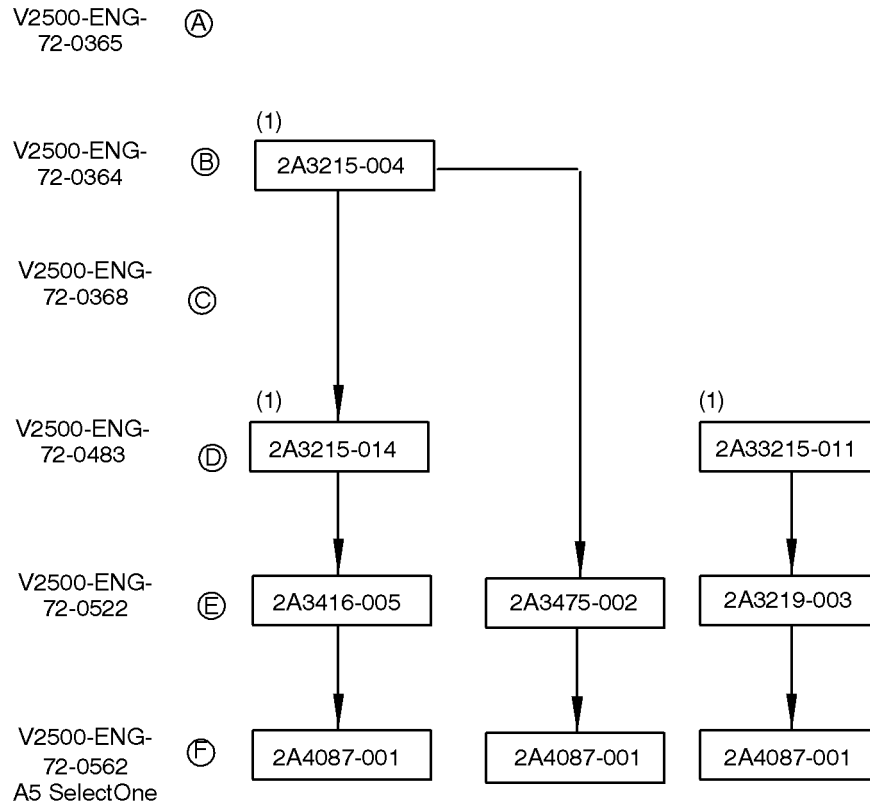
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## MODIFICATION

## PART NUMBER CHANGE



(1) DO NOT USE IN MODEL V2533-A5 IF CASE AND VANE ASSEMBLY CONTAINS ANY RING SEGMENT AND VANE CLUSTER ASSEMBLY 2A2272, 2A2272-001, 2A2272-002, 2A2372, 2A2372-002, 2A3372, 2A3372-001, 2A3472, OR 2A3472-001.

pw0b520395

FAMILY TREE – HPT CASE AND VANE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-20 FIGURE  
01 ITEM 005  
CHART H (SHEET 5 OF 5)

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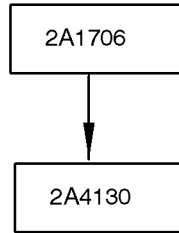
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MODIFICATIONS

PART NUMBER CHANGE

BASE

V2500-ENG-  
72-0562  
A5 SelectOne



pw0b520525

FAMILY TREE – DUCT SUPPORT – HPT STAGE 1 REF. CATALOG SEQUENCE NO. 72-45-22 FIGURE  
01 ITEM 010  
CHART J

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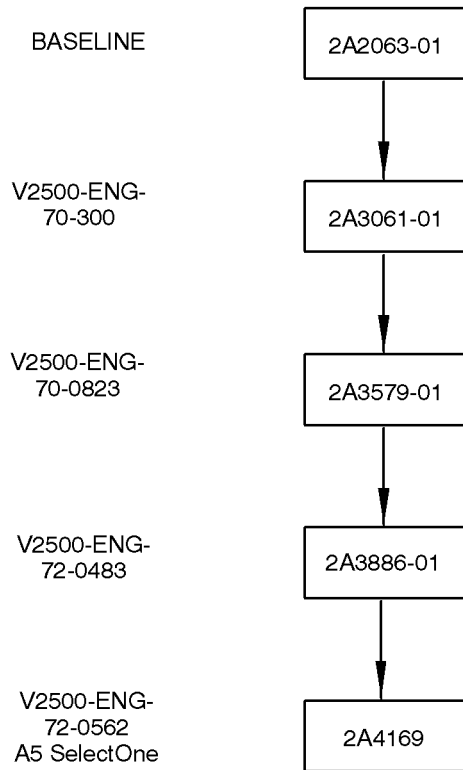
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## MODIFICATIONS

## PART NUMBER CHANGE



pw0b519390

FAMILY TREE – DUCT SEGMENT 1ST STAGE ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-23  
FIGURE 01 ITEM 060  
CHART K

Sep.22/08

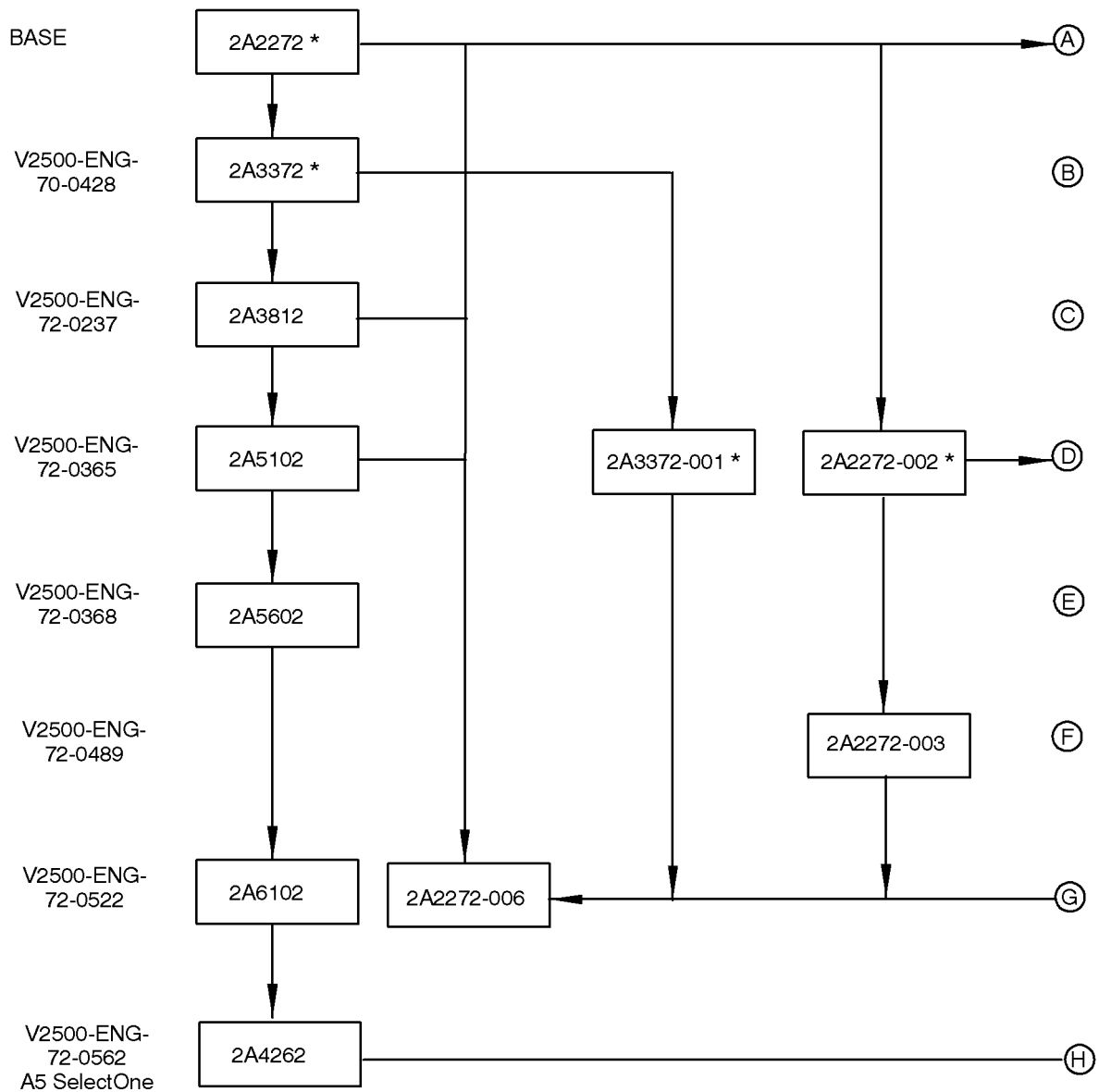
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pw0b520541

FAMILY TREE - RING SEGMENT AND VANE CLUSTER ASSEMBLY (NON-BOREScope) REF. CATALOG  
SEQUENCE NO. 72-45-24 FIGURE 02 ITEM 050  
CHART L (SHEET 1 OF 2)

Sep.22/08

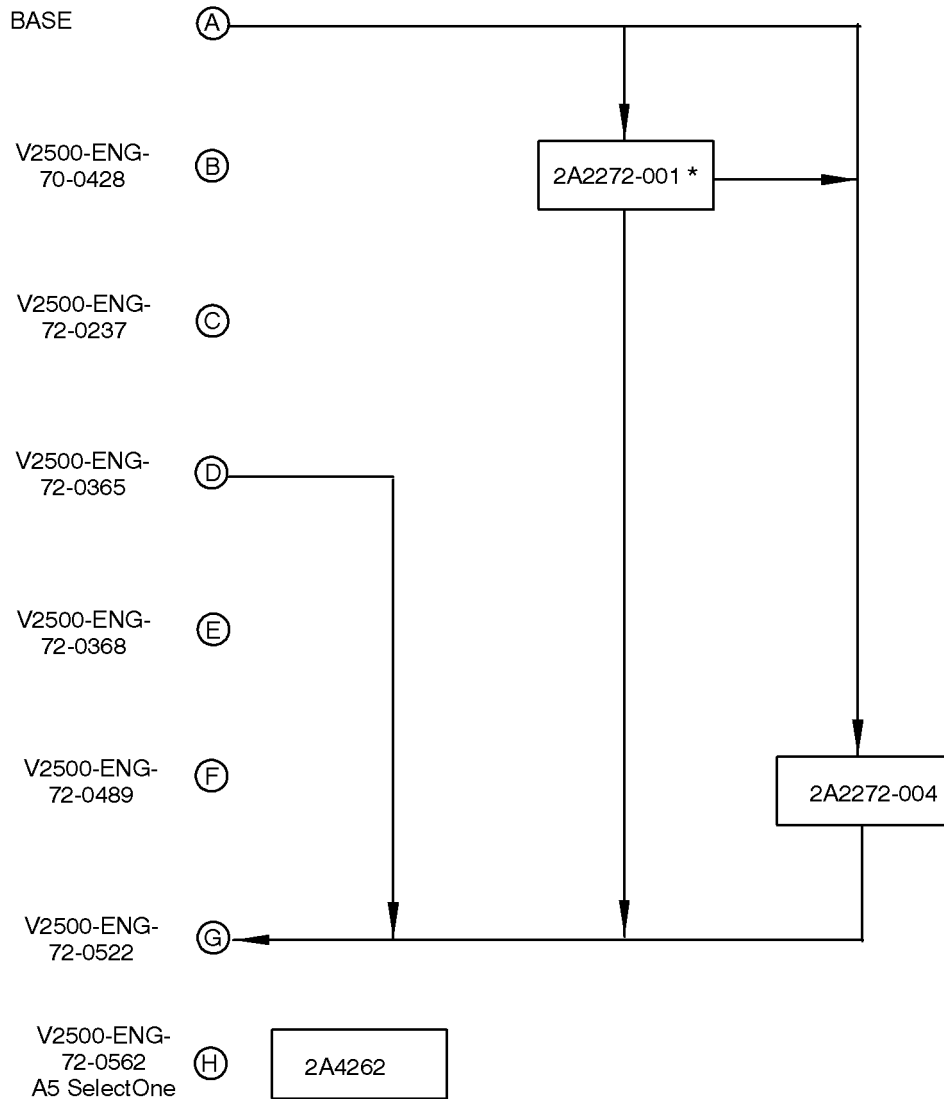
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pw0b520542

FAMILY TREE – RING SEGMENT AND VANE CLUSTER ASSEMBLY (NON-BOREScope) REF. CATALOG  
SEQUENCE NO. 72-45-24 FIGURE 02 ITEM 050  
CHART L (SHEET 2 OF 2)

Sep.22/08

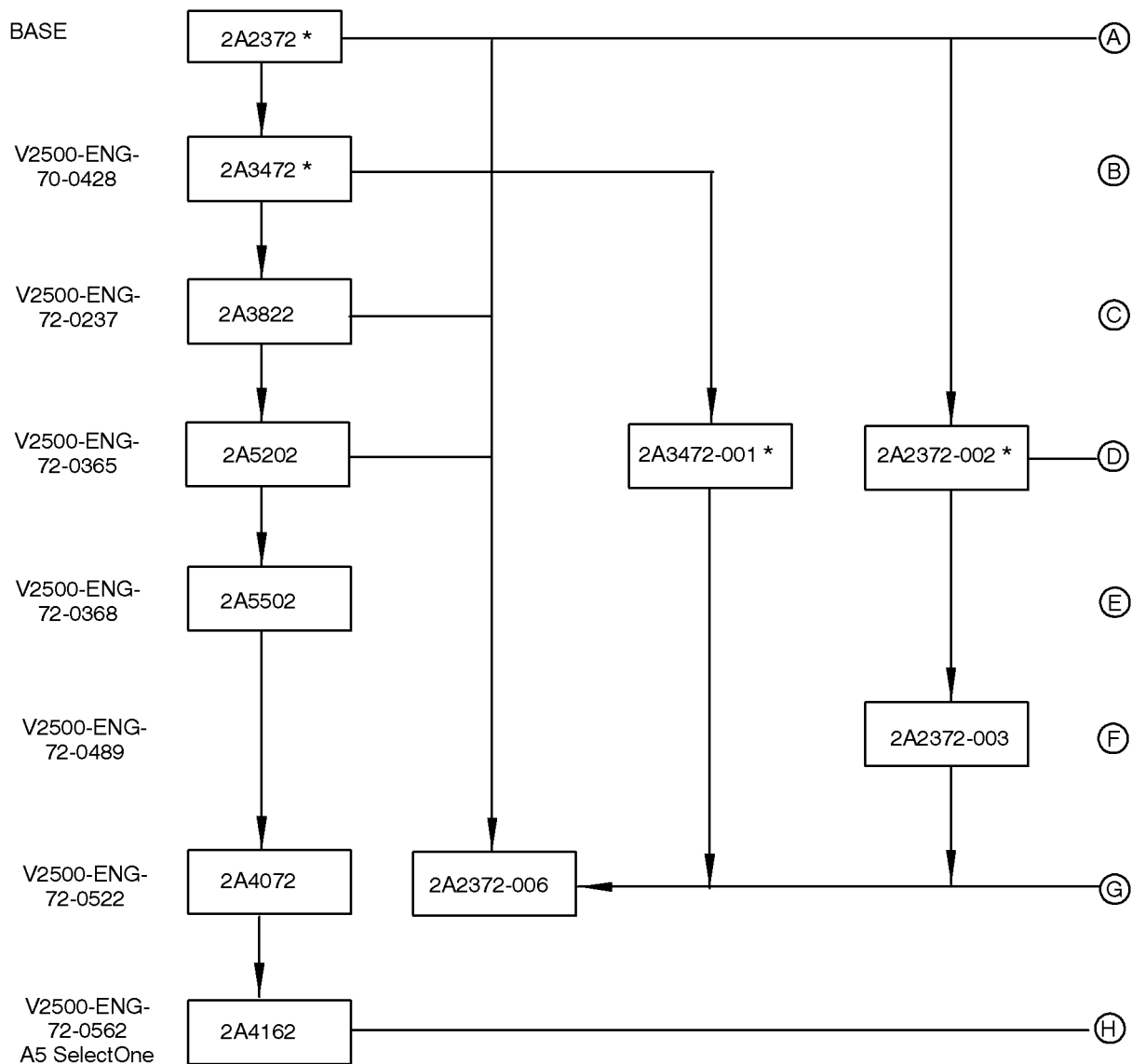
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\* DO NOT USE IN MODEL V2533-A5

pw0b520543

FAMILY TREE - RING SEGMENT AND VANE CLUSTER ASSEMBLY (BORESCOPE) REF. CATALOG  
SEQUENCE NO. 72-45-24 FIGURE 02 ITEM 260  
CHART M (SHEET 1 OF 2)

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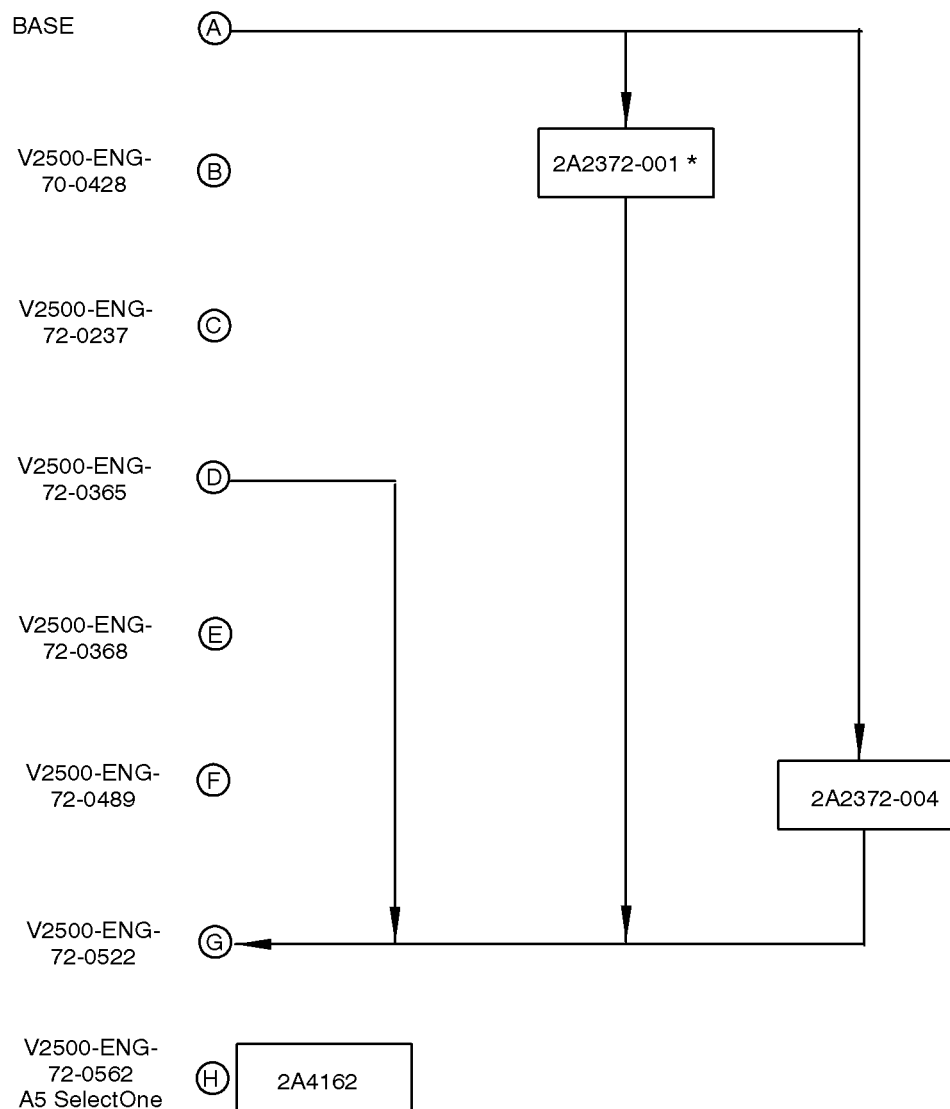
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\* DO NOT USE IN MODEL V2533-A5

pw0b520544

FAMILY TREE – RING SEGMENT AND VANE CLUSTER ASSEMBLY (BORESCOPE) REF. CATALOG  
SEQUENCE NO. 72-45-24 FIGURE 02 ITEM 260  
CHART M (SHEET 2 OF 2)

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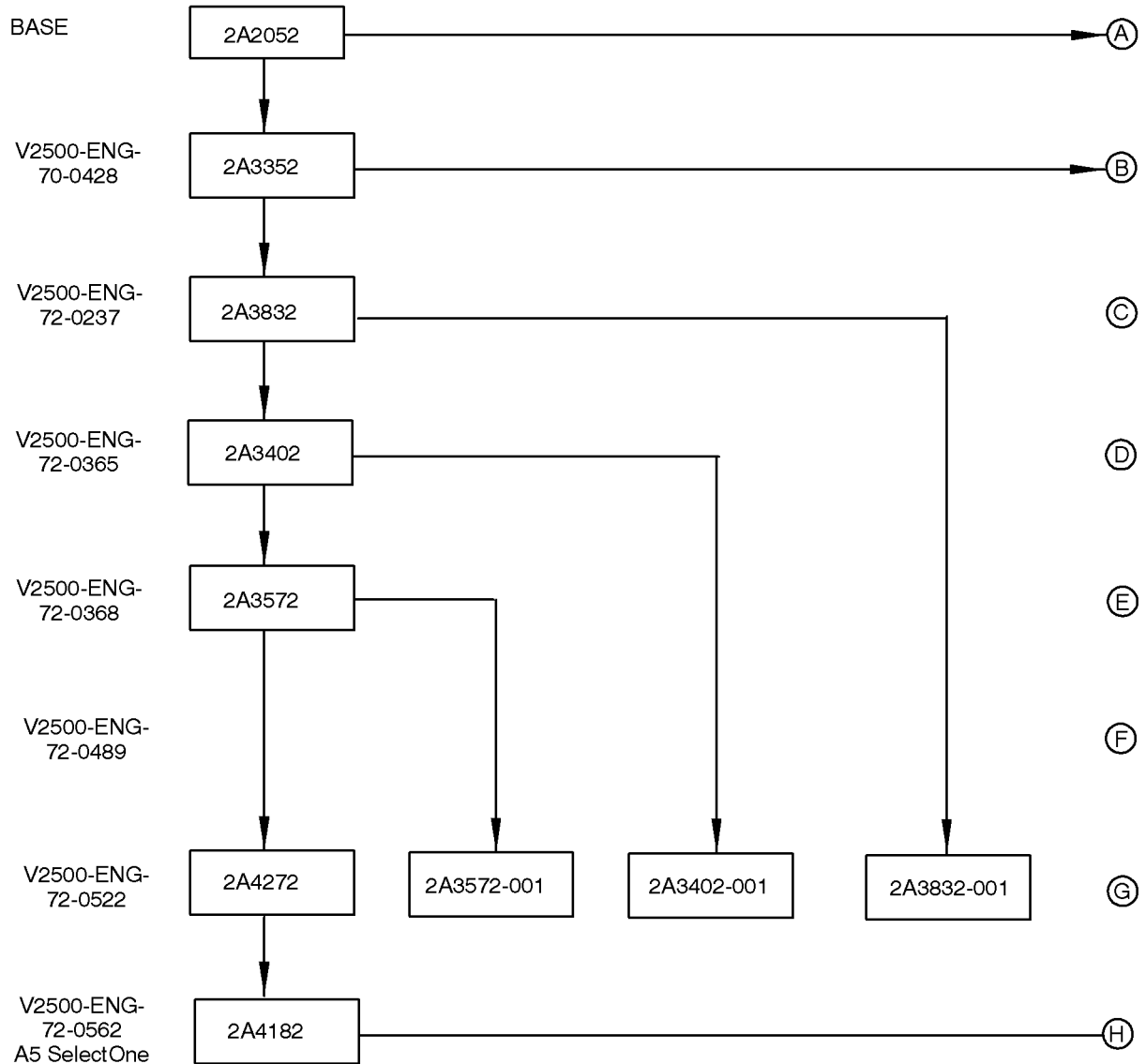
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MODIFICATIONS

PART NUMBER CHANGE



pw0b520549

FAMILY TREE - HPT STAGE 2 VANE ASSEMBLY (NON-BORESCOPE) REF. CATALOG SEQUENCE NO.  
72-45-24 FIGURE 02 ITEM 130 AND 350  
CHART N (SHEET 1 OF 2)

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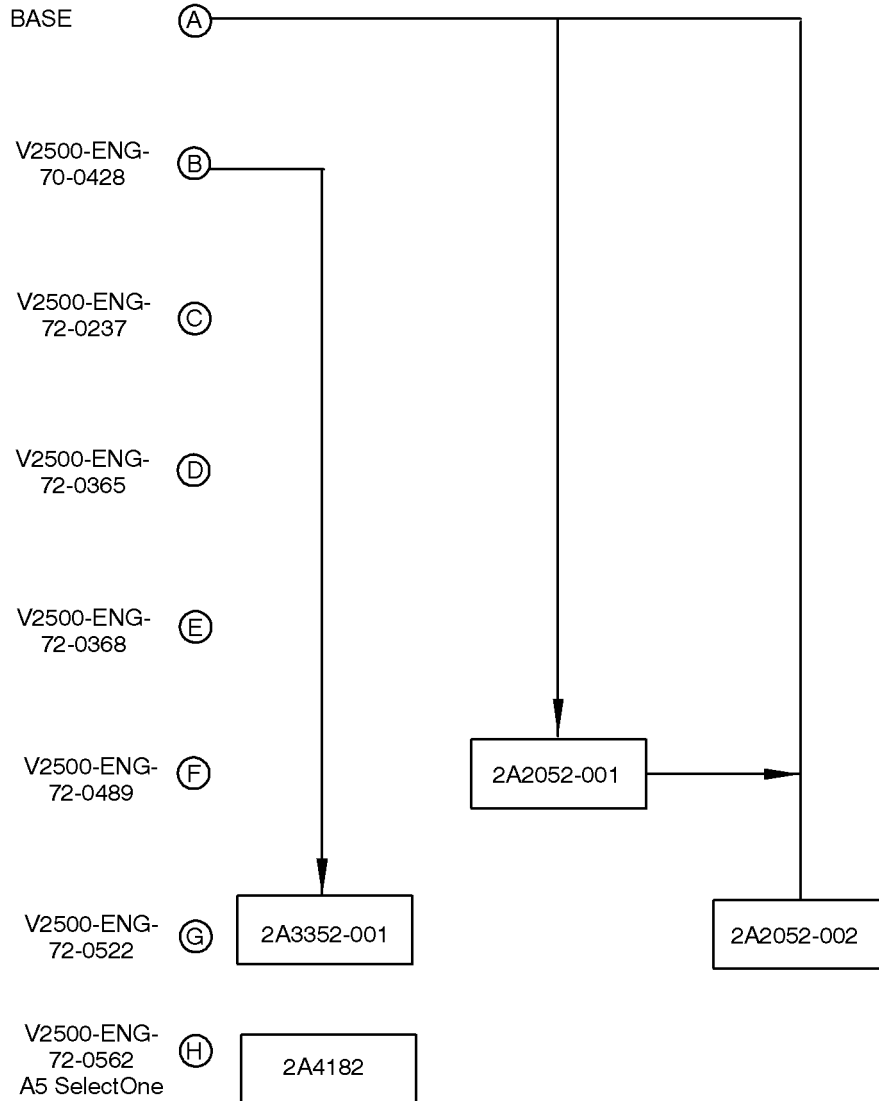
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pw0b520546

FAMILY TREE – HPT STAGE 2 VANE ASSEMBLY (NON-BORESCOPE) REF. CATALOG SEQUENCE NO.  
72-45-24 FIGURE 02 ITEM 130 AND 350  
CHART N (SHEET 2 OF 2)

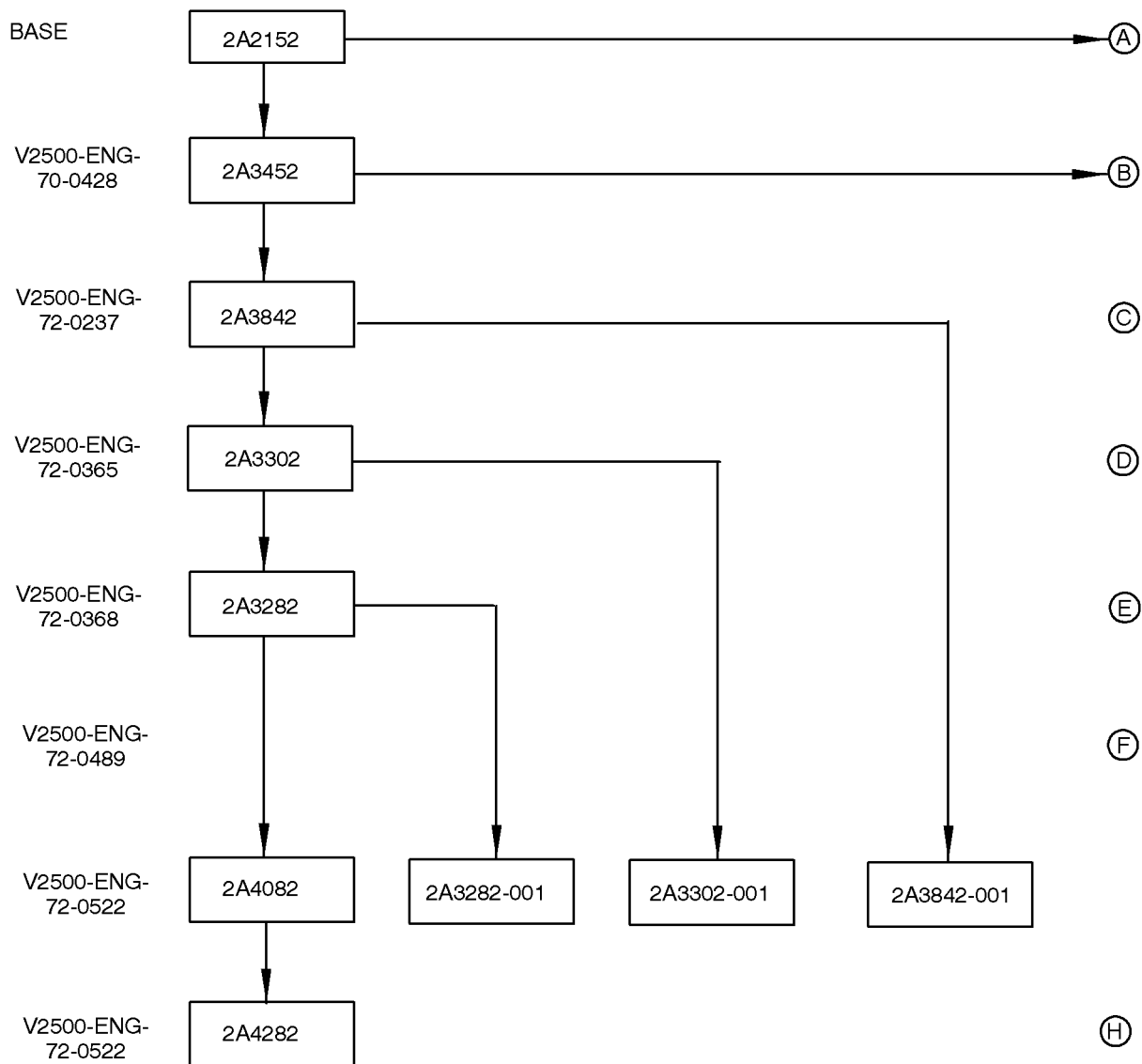
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pw06520547

FAMILY TREE - HPT STAGE 2 VANE ASSEMBLY (BORESCOPE) REF. CATALOG SEQUENCE NO.  
72-45-24 FIGURE 02 ITEM 240  
CHART P (SHEET 1 OF 2)

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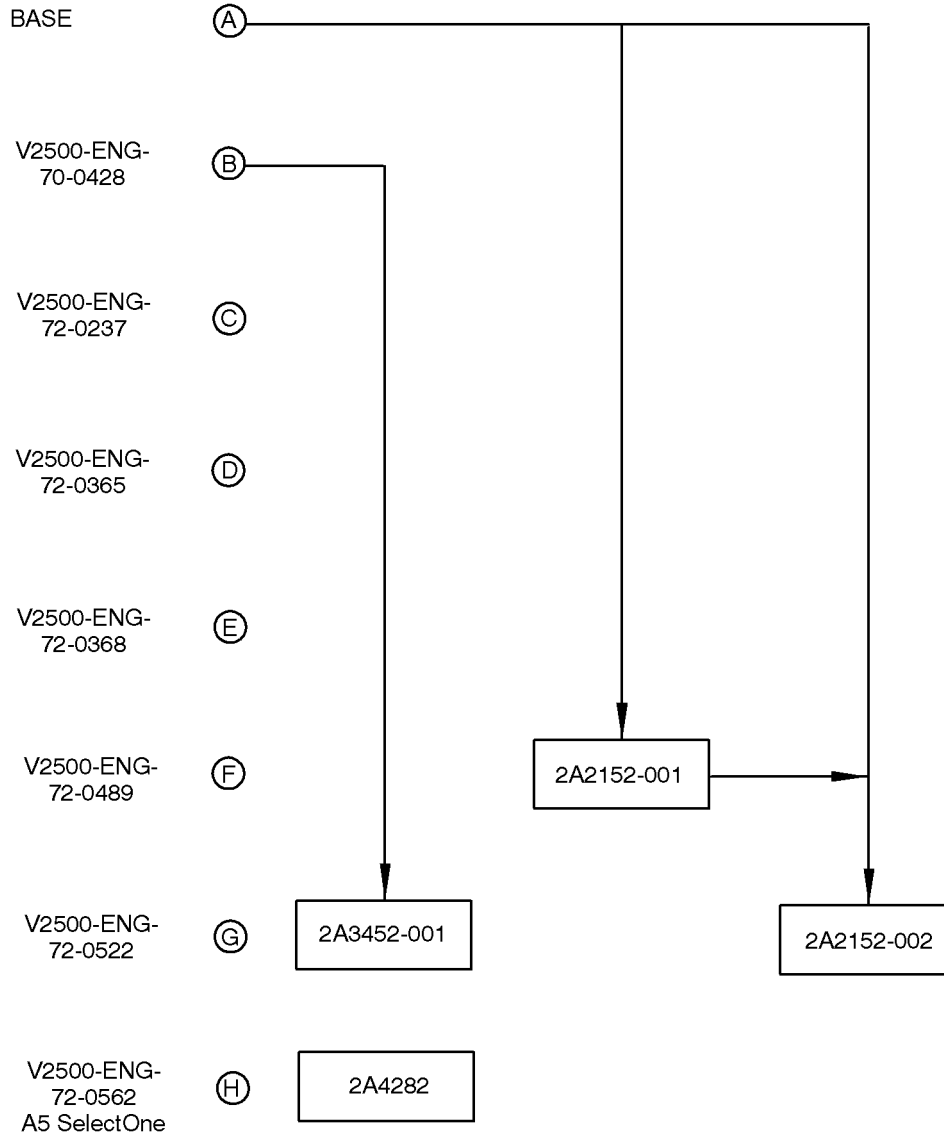
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pw0b520548

FAMILY TREE – HPT STAGE 2 VANE ASSEMBLY (BORESCOPE) REF. CATALOG SEQUENCE NO.  
72-45-24 FIGURE 02 ITEM 420  
CHART P (SHEET 2 OF 2)

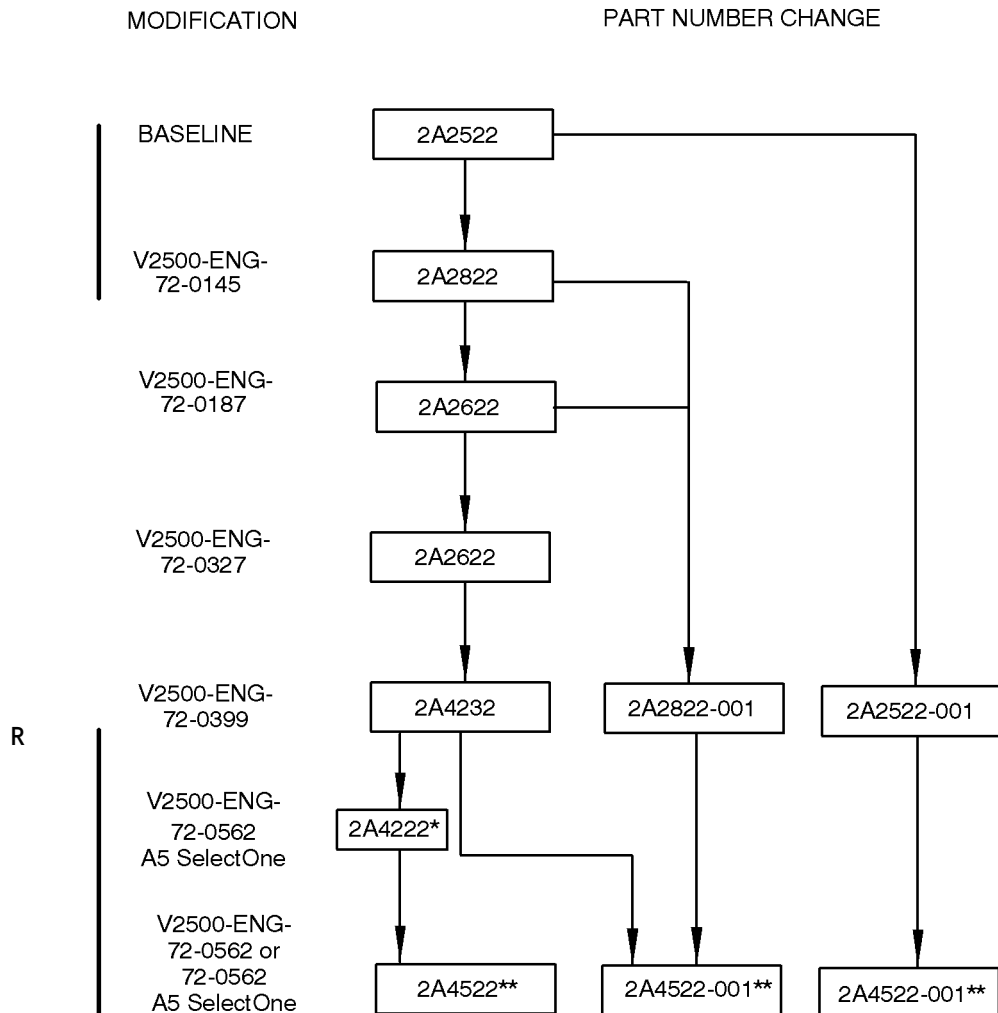
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\*Only in Engine V15001 and V15002 Pre SB 72-0575

**\*\*These assembly part numbers must have a 2A4802 or 2A3002 stage 2 hub installed**

pw0b520507a

FAMILY TREE - STAGE 2 HPT ROTOR ASSEMBLY REF. CATALOG SEQUENCE NO. 72-45-30 FIGURE  
01 ITEM 010  
CHART Q

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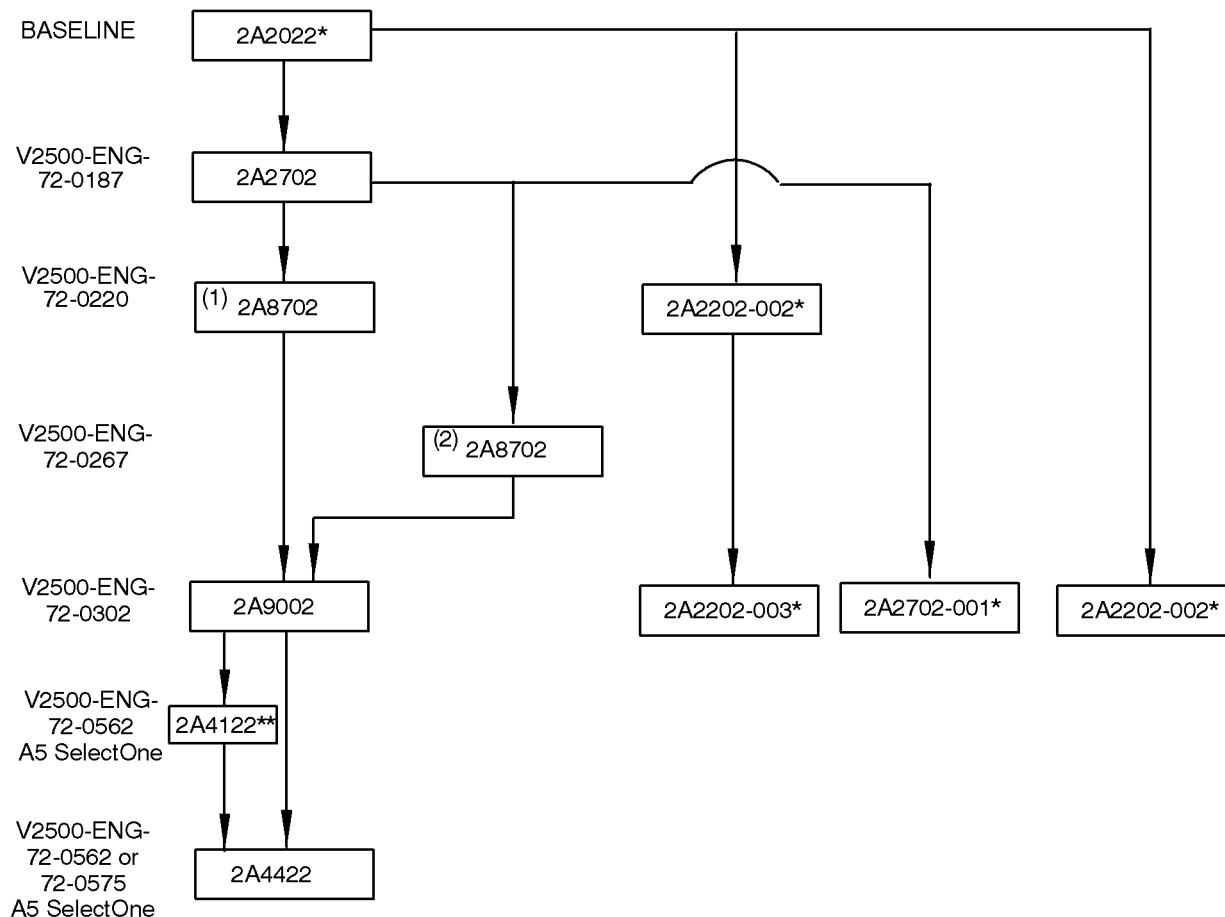
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MODIFICATION

PART NUMBER CHANGE



\*\*Only in Engine V15001 and V15002 Pre SB 72-0575

\* DO NOT USE IN V2533-A5 ENGINES

(1) FOR MODELS V2522-A5, V2524-A5, V2527-A5, V2528E-A5, V2527M-A5, V2530-A5

(2) FOR MODEL V2533-A5

pw0b520518

FAMILY TREE – STAGE 2 HPT BLADE REF. CATALOG SEQUENCE NO. 75-45-32 FIGURE 01 ITEM 010  
CHART R

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APPENDIX 1
Supplement – Revision to Table of Limits

Engine Manual(s), Chapter/Section 05-10-01, A1/A5 Revision 73, dated August 1, 2008 is scheduled to incorporate the Part Service Life Limits related to this Service Bulletin and will take precedence over the Service Bulletin. The listed parts are allowed A5 SelectOne, other Life Limited HPT Rotors are not allowed in A5 SelectOne.

Revision to Table of Limits life cycles is as follows:

CL	REF	AFFECTED PARTS	PART # / CL	MODEL	REPLACE IF EITHER LIMIT EXCEED	
					CYCLE MAX	HRS MAX
W	1600	HUB – TURBINE, 1 STG	2A5001	V2500-A5	20,000	
W	1600	HUB – TURBINE, 1 STG	2A2801	V2500-A5	15,000	
W	1601	HUB – TURBINE, 2 STG	2A4802	V2500-A5	20,000	
W	1601	HUB – TURBINE, 2 STG	2A3002	V2500-A5	15,000	
W	1602	SEAL – AIR, HPT, 1 – 2A4157 2 STG		V2500-A5	20,000	
W	1602	SEAL – AIR, HPT, 1 – 2A1350 2 STG		V2500-A5	15,000	
W	1603	SEAL – AIR, HPT, 1 2A3423 STG (TOBI)		V2500-A5	20,000	
W	1604	SEAL – AIR, HPT, 1 2A3923 STG		V2500-A5	20,000	
W	1605	PLATE – RING, BLADE, 2A3437 HPT, 2 STG		V2500-A5	20,000	
W	1605	PLATE – RING, BLADE, 2A3426 HPT, 2 STG		V2500-A5	15,000	

APPENDIX 2
Supplement – Prices and Availability

V2500–A5, –A5 SelectOne Retrofit Standard and –A5 SelectOne Production Standard

1. Modification Kit

A. There is a kit number PN 2A4243 to do this Service Bulletin.

2. Material Cost

A. Part prices were not available at the time of Service Bulletin publication. Contact IAE's Spare Parts Sales Department for firm quotations.

B. There is a kit, number PN 2A4243 to do this Service Bulletin. Contact IAE's Spare Parts Sales Department for firm quotations.

3. New Production Parts

New Production Part Number	Description	Unit Price US Dollars
2A4210	Turbine Nozzle Group	
2A4085	Support Assy – HPT Stg 1	
2A4088–01	Seal Assy – Brush Stg 1	
2A4161	Lock – Support, Seal Stg 1	
NAS1398C3A4	Rivet – Blind Stg 1	
2A4081*	Vane Assy – HPT Stg 1	
2A4271	Vane Assy – HPT Stg 1	
2A4126	Seal – HPT Stg 1	
2A4086	TOBI Duct Assy – HPT Stg 1	
2A4220*	Rotor and Stator Assy	
2A4250	Rotor and Stator Assy	
2A9921	Turbine Rotor – HPT Stg 1	
2A9721	Blade – HPT Stg 1	
2A4087	Case and Vane Assy – HPT Stg 1	
2A4130	Support – HPT Stg 1	
2A4129	Seal – HPT Stg 1	
2A4136	Gasket	
2A4131	Band Segment	
2A4133	Band Segment	
2A4169	Duct Segment	

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New Production Part Number	Description	Unit Price US Dollars
2A4106	Seal	
2A4182	Vane Assy - HPT Stg 2	
2A4162	Ring Segment - HPT Stg 2 Vane Cluster	
2A4127	Seal - HPT Stg 2	
2A4262	Ring Segment - HPT Stg 2 Vane Cluster (Boro)	
2A4145	Seal - Feather - HPT Stg 2	
2A4128	Seal - HPT Stg 2	
2A4163	Gasket	
2A4282	Vane Assy - HPT Stg 2	
2A4182	Vane Assy - HPT Stg 2 (Boro)	
2A4222*	Turbine Rotor - HPT Stg 2	
2A4522	Turbine Rotor - HPT Stg 2	
2A4122*	Blade Assy - HPT Stg 2	
2A4422	Blade Assy - HPT Stg 2	

\*The new part is applicable to Engine Serial Nos. V15001 and 15002 only Pre SB 72-0575 and/or SB 72-0576.

APPENDIX 3Supplement – Added Data

## Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC 07SEL01P EC 07SEL02P	JP/TR
1	EC 09VA007 IEN 09VC017 EC 09VA027 EA 13VC056	JP/JHD/CMS



U.S. Department  
of Transportation  
**Federal Aviation  
Administration**

Engine and Propeller Directorate

Engine Certification Office  
12 New England Executive Park  
Burlington, MA 01803  
(781) 238-7140, Fax: (781) 238-7199

**AUG 19 2013**

Mr. Karl Yeager  
IAE Flight Safety, Certification and Airworthiness  
400 Main Street  
East Hartford, CT 06108

Dear Mr. Yeager:

Subject: IAE global Alternative Method of Compliance  
(AMOC) to Airworthiness Directive (AD) 2011-25-08

The Federal Aviation Administration (FAA) Engine Certification Office (ECO) received your letter dated June 6, 2013, requesting a global AMOC to AD 2011-25-08, paragraph F and paragraph G, for the International Aero Engines (IAE) V2500 series engines. Paragraph F of AD 2011-25-08 requires periodic borescope inspections using IAE service bulletin (SB) V2500-ENG-72-580 revision 3. Paragraph G of AD 2011-25-08 requires specific parts be installed per SB V2500-ENG-72-0542 revision 1, or SB V2500-ENG-72-0483 revision 3 as mandatory terminating action.

IAE AMOC proposal would use SB V2500-ENG-72-0580 revision 4, for compliance with paragraph F instead of SB V2500-ENG-72-0580 revision 3. The AMOC proposal would also use SB V2500-ENG-72-0483 revision 4, SB V2500-ENG-72-0562 initial release or SB V2500-ENG-72-0562 revision 1 to comply with paragraph G instead of SB V2500-ENG-72-0483 revision 3.

The ECO reviewed the supporting data for your request and determined that the substitutions and revisions to the service information are equivalent to the original references in the AD. Therefore, the FAA approves your Global AMOC to paragraph F and paragraph G of AD 2011-25-08 to use SB V2500-ENG-72-0580 revision 4, for compliance with paragraph F instead of SB V2500-ENG-72-0580 revision 3 and to use SB V2500-ENG-72-0483 revision 4, SB V2500-ENG-72-0562 initial release or SB V2500-ENG-72-0562 revision 1 to comply with paragraph G instead of SB V2500-ENG-72-0483 revision 3.

We have determined that this AMOC is of general applicability to the IAE V2500 series engine type designs, and therefore this letter is issued to IAE with the understanding that it may subsequently be distributed to operators. Operators may then use this letter, along with evidence of compliance with the terms of this letter, to document compliance to AD 2011-25-08.

This FAA AMOC is transferable with the engine(s) to another owner or operator.

IAE PROPRIETARY INFORMATION

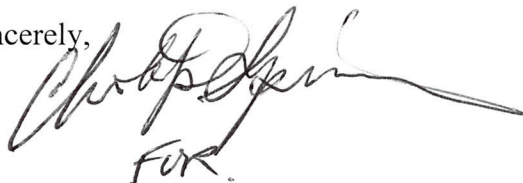
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Before using this AMOC, operators must notify their appropriate principal inspector, or lacking a principal inspector, the manager of the local flight standards district office/certificate holding district office.

All provisions of FAA AD 2011-25-08 that are not specifically referenced above remain fully applicable and must be complied with accordingly.

If you have any questions or need additional information, please contact Martin Adler at 781-238-7157, fax 781-238-7199, or via electronic mail at [martin.adler@faa.gov](mailto:martin.adler@faa.gov).

Sincerely,

A handwritten signature in black ink, appearing to read 'Thomas Boudreau', with the letters 'FUR' written below it.

Thomas Boudreau  
Manager, Engine Certification Office

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