

# SERVICE BULLETIN REVISION NOTICE

ENGINE — HIGH PRESSURE (HP) COMPRESSOR — V2500 SELECTONE PRODUCTION —  
INTRODUCTION OF REDESIGNED VARIABLE STATOR VANE (VSV) SYSTEM

Turbojet Engine Service Bulletin No. V2500-ENG-72-0564 Revision No. 1 dated August 16, 2018.

## Revision History

Original Issue September 22, 2008

Revision 1 August 16, 2018

## Reason for the Revision

To add cancelled PN 03-413-40E002 and new PN 03-413-45E002

To update the Service Bulletin format to current standards.

## This is a Complete Revision (Not Applicable to the SGML version)

The format of this Service Bulletin has been changed from previous versions. This revision shows flow bars and the revision date on the bottom of every page. Technical changes incorporated in this revision are marked with revision bars. The contents are in accordance with the list of effective pages.

## Effect of Revision on Prior Compliance

None.

## MODEL APPLICATION

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

## BULLETIN ISSUE SEQUENCE

V2500 Series 72-0564

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# SERVICE BULLETIN

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INTRODUCTION OF REDESIGNED VARIABLE STATOR VANE (VSV) SYSTEM

## MODEL APPLICATION

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

## BULLETIN ISSUE SEQUENCE

V2500 Series 72-0564

## ATA NUMBER

72-41-00

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## Compliance Category

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## Summary

The purpose of this Service Bulletin is to introduce a new production standard for the Variable Stator Vane (VSV) system by the introduction of new unison ring assemblies, a new VSV lever, a new crank shaft, new front split case bushes, and new Variable Inlet Guide Vanes (VIGV) and VSV's as the baseline standard for V2500 SelectOne.

## Planning Information

### Effectivity Data

#### Engine Models Applicable

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5  
Engine Serial No. V15002 onwards

### Concurrent Requirements

This Service Bulletin must be done at the same time as following Service Bulletins:

1. Reference 5, Service Bulletin No. V2500-ENG-72-0560.
2. Reference 6, Service Bulletin No. V2500-ENG-72-0561.
3. Reference 7, Service Bulletin No. V2500-ENG-72-0562.
4. Reference 8, Service Bulletin No. V2500-ENG-72-0563.
5. Reference 9, Service Bulletin No. V2500-ENG-73-0203.

### Reason

1. Condition: Wear to the centralized pads and outer case bushes, occurrence of VSV track check errors and a time consuming setting procedure have initiated a detailed review of the VSV system, resulting in the decision to improve the VSV system of the V2500-A5 engines.
2. Background: The V2500 SelectOne is a committed program to enhance the V2500 engine for improved efficiency and durability. The package features an optimized aerodynamic and mechanical design of the HP compressor blades and vanes. The VSV system has been redesigned to improve reliability and reduce maintenance costs.
3. Objective: The purpose of this Service Bulletin is to inform the operator that a new production standard of VSV system is introduced. The upgraded VSV system requires the introduction of new unison ring assemblies, a new VSV lever, a new crank shaft, new front split case bushes and new VIGV's and VSV's as baseline standard for V2500 SelectOne engines. Incorporation of this Service Bulletin is designed to improve the reliability and reduce the costs of production and assembly.
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.

### Description

The changes introduced by this Service Bulletin are as follows:

1. The unison rings are now either machined from solid or cast close to size and final machined. The unison rings are made of Titanium as they were before.

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2. The stage 3, 4 and 5 drive brackets are plates bolted to the side of the unison rings. The drive brackets are laser cut from flat sheet. Close tolerance attaching bolts replace the old dowel system.
3. The VIGV attaching point is now a close tolerance bolt which has replaced the drive pin that was welded on the unison ring. An additional close to size steel bush at the VIGV rod end has been incorporated on the bolt to remove excessive clearance in the system.
4. The bridge pieces are laser cut from flat plate. Close tolerance bolts replace the specially machined dowels and bolts used on the original parts. The parts are bolted axial to the engine axis.
5. An adjustable pad system, with one set of shims, is used to control the pad clearance. The pads have an insert made of Vespel SP21 and a lug on the reverse side to make sure that if the bond between the pad and the housing fails, the pad cannot slip out. The pads are either one or two bolt fixing according to their position.
6. The lever arms are machined from a single piece instead of a welded assembly. The ball is mounted on a pin which is swaged to the arm. The number of different arms has increased from 8 to 10 due to the need to clear other features.
7. The lever ball features a synthetic polymer material ball, with a low friction coefficient, which the unison ring pushes against to move the lever arm. As the unison ring moves, the lever moves in a flat arc.
8. The lever arm attachment was investigated and is close to the current form.

#### Compliance

##### Category 8

Accomplish based upon experience with the prior configuration.

#### 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.

#### Manpower

##### 1. In Service

..... Not Applicable.

##### 2. At Overhaul

..... Not Applicable.

#### Weight and Balance

##### 1. Weight Change

+ 0.5 lb (+ 0.23 kg).

##### 2. Moment Arm

No Effect.

##### 3. Datum

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

#### Electrical Load Data

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

#### Software Accomplishment Summary

Not Applicable.

#### References

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

1. ATA Locator — 72-41-30, 72-41-31, 72-41-32 and 72-41-34.
2. Internal Reference No. — 07SEL03R, 07SEL03R-01, 07SEL03RA, and 07SEL03RB.
3. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 70-01-00.
4. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-41-30, 72-41-31, 72-41-32 and 71-41-34.
5. V2500 Service Bulletin No. V2500-ENG-72-0560 (Engine — High Pressure (HP) Compressor — V2500 SelectOne Production — HP Compressor Upgrade).
6. V2500 Service Bulletin No. V2500-ENG-72-0561 (Engine — High Pressure (HP) Compressor — V2500 SelectOne Retrofit and Production — HP Compressor Upgrade).
7. V2500 Service Bulletin No. V2500-ENG-72-0562 (Engine — High Pressure Turbine (HPT) — V2500 SelectOne Retrofit and Production — HPT Upgrade).
8. V2500 Service Bulletin No. V2500-ENG-72-0563 (Engine — LP Turbine — Introduction of Turbine Vane Stage 3).
9. V2500 Service Bulletin No. V2500-ENG-73-0203 (Engine — Fuel and Control — Provide a New Electronic Engine Control (EEC) with A5 SCN20/Y Software).

#### Other Publications Affected

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

1. V2500 A1/A5 Series Aircraft Maintenance Manual (AMM), Chapters 75-32-41, 75-32-42 and 75-42-00.
2. V2500 A1/A5 Series Trouble Shooting Manual (TSM), Chapter 75-30-00.
3. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-00-40, 72-41-00, 72-41-30, 72-41-31, 72-41-32 and 72-41-34.
4. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-41-30, 72-41-31, 72-41-32 and 71-41-34.

#### Interchangeability of Parts

Affected (Refer to Material Information).

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Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

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## Material Information

### Material — Price and Availability

1. Part prices were not available at the time of Service Bulletin publication. Contact IAE Spares Management & Logistics for firm quotations.
2. There is no kit provided to do this Service Bulletin.
3. Part availability information is provided in material data Instructions — Disposition.

### Industry Support Program

Not Applicable.

The material data that follows is for each engine.

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

| New PN                      | Qty | Estimate of Unit Price (\$) | Keyword                               | Old PN                       | Instructions — Disposition |
|-----------------------------|-----|-----------------------------|---------------------------------------|------------------------------|----------------------------|
| 6B1138                      | 2   | *                           | .BUSH, CASING SHORT                   | 1035212<br>(72-41-31-01-244) | (S1)(1D)                   |
| 6B1139<br>(72-41-31-01-248) | 38  | *                           | .BUSH, CASING LONG                    |                              | (A)                        |
| 6B1142                      | 50  | *                           | .BUSH, CASING                         | 1035252<br>(72-41-31-01-254) | (S1)(2D)                   |
| 6B1141                      | 30  | *                           | .BUSH, CASING LONG                    | 1035272<br>(72-41-31-01-264) | (S1)(3D)                   |
| 6B1140                      | 2   | *                           | .BUSH, CASING SHORT                   | 1035232<br>(72-41-31-01-274) | (S1)(4D)                   |
| 6B1143<br>(72-41-31-01-293) | 60  | *                           | .BUSH, CASING SHORT                   |                              | (A)                        |
| 6B1142<br>(72-41-31-01-294) | 4   | *                           | .BUSH, CASING                         |                              | (A)                        |
| 6B1170                      | 38  | *                           | .VANE ASSEMBLY, INLET, VARIABLE LONG  | 6A8405<br>(72-41-32-01-500)  | (S1)                       |
| 6A8833                      | 2   | *                           | .VANE ASSEMBLY, INLET, VARIABLE SHORT | 6A8407<br>(72-41-32-01-600)  | (S1)                       |

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| New PN                    | Qty | Estimate of Unit Price (\$) | Keyword                              | Old PN                    | Instructions — Disposition |
|---------------------------|-----|-----------------------------|--------------------------------------|---------------------------|----------------------------|
| 6B1171                    | 27  | *                           | .VANE ASSEMBLY, LONG SPINDLE, STG 3  | 6A8720 (72-41-32-02-500)  | (S1)(5D)                   |
| 6A9021 (72-41-32-02-550)  | 3   | *                           | .VANE ASSEMBLY, INTERMEDIATE, STG 3  |                           | (A)                        |
| 6A8836                    | 2   | *                           | .VANE, SHORT SPINDLE, STG 3          | 6A8721 (72-41-32-02-600)  | (S1)                       |
| 6A8837                    | 46  | *                           | .VANE ASSEMBLY, LONG SPINDLE, STG 4  | 6A8731 (72-41-32-03-500)  | (S1)(6D)                   |
| 6A8838 (72-41-32-03-600)  | 4   | *                           | .VANE ASSEMBLY, SHORT SPINDLE, STG 4 |                           | (A)                        |
| 6A8840                    | 36  | *                           | .VANE, SHORT SPINDLE, STG 5          | 6A8725 (72-41-32-04-500)  | (S1)(7D)                   |
| 6A8839                    | 28  | *                           | .VANE, LONG SPINDLE, STG 5           | 6A8728 (72-41-32-04-600)  | (S1)(8D)                   |
| AS20626                   | 1   | *                           | .NUT, SELF LOCKING                   | U755246 (72-41-34-01-180) | (S1)                       |
| UP11193                   | 1   | *                           | .SPACER                              | 4W2623 (72-41-34-01-183)  | (S1)                       |
| BLT5382                   | 1   | *                           | .BOLT                                | BLT5362 (72-41-34-01-184) | (S1)                       |
| 6B1267                    | 1   | *                           | .SPACER                              | UP11083 (72-41-34-01-185) | (S1)                       |
| AS53979 (72-41-34-01-187) | 1   | *                           | .BOLT, HEXAGON                       |                           | (A)                        |
| 6B1075 (72-41-34-01-229)  | 2   | *                           | .SPACER                              |                           | (A)                        |
| AS54365                   | 1   | *                           | .NUT, REDUCED HEXAGON                | 4W0003 (72-41-34-01-232)  | (S1)                       |
| UP11193                   | 1   | *                           | .SPACER                              | 4W2623 (72-41-34-01-233)  | (S1)                       |

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| New PN                      | Qty | Estimate of Unit Price (\$) | Keyword                         | Old PN                             | Instructions — Disposition |
|-----------------------------|-----|-----------------------------|---------------------------------|------------------------------------|----------------------------|
| AS53979                     | 1   | *                           | .BOLT, HEXAGON                  | AS22626<br>(72-41-34-01-236)       | (S1)                       |
| AS54365                     | 1   | *                           | .NUT, REDUCED HEXAGON           | 4W0003<br>(72-41-34-01-282)        | (S1)                       |
| UP11193                     | 1   | *                           | .SPACER                         | 4W2623<br>(72-41-34-01-283)        | (S1)                       |
| AS53979                     | 1   | *                           | .BOLT, HEXAGON                  | AS22626<br>(72-41-34-01-286)       | (S1)                       |
| 6B1075<br>(72-41-34-01-329) | 2   | *                           | .SPACER                         |                                    | (A)                        |
| AS54365                     | 1   | *                           | .NUT, REDUCED HEXAGON           | 4W0003<br>(72-41-34-01-332)        | (S1)                       |
| AS53979                     | 1   | *                           | .BOLT, HEXAGON                  | AS22626<br>(72-41-34-01-334)       | (S1)                       |
| 6A8610                      | 1   | *                           | .SHAFT, ASSEMBLY                | 6A7975<br>(72-41-34-01-600)        | (S1)                       |
| 6A8611                      | 1   | *                           | ..SHAFT, CRANK                  | 6A7976<br>(72-41-34-01-630)        | (S1)                       |
| 6A8808                      | 1   | *                           | .HOUSING ASSEMBLY, REAR         | 6A7372<br>(72-41-34-01-760)        | (S1)                       |
| 03-413-45E002               | 1   | *                           | ..SPHERICAL BEARING, REAR       | 03-413-40E002<br>(72-41-34-01-774) | (S1)                       |
| 6B1127                      | 38  | *                           | .LEVER, VIGV ASSEMBLY, STANDARD | 6A7467<br>(72-41-34-02-100)        | (S1)(C)(9D)                |
| OR                          |     |                             |                                 |                                    |                            |
| 6B1146                      | 38  | *                           | .LEVER, VIGV ASSEMBLY, STANDARD | 6A7467<br>(72-41-34-02-100)        | (S1)(C)(9D)                |
| AS48513                     | 38  | *                           | .BOLT, BIHEX HD                 | 4W0409<br>(72-41-34-02-102)        | (S1)(9D)                   |
| 6B1128                      | 2   | *                           | .LEVER, VIGV ASSEMBLY, BALL UP  | 6A7468<br>(72-41-34-02-140)        | (S1)(C)                    |
| OR                          |     |                             |                                 |                                    |                            |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                        | Old PN                         | Instructions — Disposition |
|------------------------------|-----|-----------------------------|--------------------------------|--------------------------------|----------------------------|
| 6B1147                       | 2   | *                           | .LEVER, VIGV ASSEMBLY, BALL UP | 6A7468<br>(72-41-34-02-140)    | (S1)(C)                    |
| AS48513                      | 2   | *                           | .BOLT, BIHEX HD                | 4W0409<br>(72-41-34-02-142)    | (S1)                       |
| 6B1068                       | 2   | *                           | .PIECE, BRIDGING VIGV FRONT    | 6A7586<br>(72-41-34-02-200)    | (S1)                       |
| 6B1069<br>(72-41-34-02-201)  | 2   | *                           | .PIECE, BRIDGING VIGV REAR     |                                | (A)                        |
| AS54624                      | 8   | *                           | .BOLT                          | AS21013<br>(72-41-34-02-202)   | (S1)(C)(10D)               |
| OR                           |     |                             |                                |                                |                            |
| AS23524                      | 8   | *                           | .BOLT                          | AS21013<br>(72-41-34-02-202)   | (S1)(C)(10D)               |
| OR                           |     |                             |                                |                                |                            |
| AS23024                      | 8   | *                           | .BOLT                          | AS21013<br>(72-41-34-02-202)   | (S1)(C)(10D)               |
| OR                           |     |                             |                                |                                |                            |
| AS61424                      | 8   | *                           | .BOLT                          | AS21013<br>(72-41-34-02-202)   | (S1)(C)(10D)               |
| OR                           |     |                             |                                |                                |                            |
| AS57224                      | 8   | *                           | .BOLT                          | AS21013<br>(72-41-34-02-202)   | (S1)(C)(10D)               |
| AS20625<br>(72-41-34-02-204) | 8   | *                           | .NUT, SELF LOCKING             |                                | (A)                        |
| 6A9106                       | 1   | *                           | .RING, UNISON VIGV UPPER       | 6A7899<br>(72-41-34-02-440)    | (S1)                       |
| 6A9108                       | 1   | *                           | .RING, UNISON VIGV LOWER       | 6A7901<br>(72-41-34-02-540)    | (S1)                       |
| 6B1098                       | AR  | *                           | .SHIM, CENTRALIZER ADJUSTING   | 6A2629C01<br>(72-41-34-02-654) | (D)(S1)                    |
| 6B1099                       | AR  | *                           | .SHIM, CENTRALIZER ADJUSTING   | 6A2629C02<br>(72-41-34-02-655) | (D)(S1)                    |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                            | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|------------------------------------|--------------------------------|----------------------------|
| 6B1100 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C03<br>(72-41-34-02-656) | (D)(S1)                    |
| 6B1101 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C04<br>(72-41-34-02-657) | (D)(S1)                    |
| 6B1102 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C05<br>(72-41-34-02-658) | (D)(S1)                    |
| 6B1103 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C06<br>(72-41-34-02-659) | (D)(S1)                    |
| 6B1104 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C07<br>(72-41-34-02-660) | (D)(S1)                    |
| 6B1105 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C08<br>(72-41-34-02-661) | (D)(S1)                    |
| 6B1106 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C09<br>(72-41-34-02-662) | (D)(S1)                    |
| 6B1107 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C10<br>(72-41-34-02-663) | (D)(S1)                    |
| 6B1108 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C11<br>(72-41-34-02-664) | (D)(S1)                    |
| 6B1109 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C12<br>(72-41-34-02-665) | (D)(S1)                    |
| 6B1110 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C13<br>(72-41-34-02-666) | (D)(S1)                    |
| 6B1111 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C14<br>(72-41-34-02-667) | (D)(S1)                    |
| 6B1112 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2629C15<br>(72-41-34-02-668) | (D)(S1)                    |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                        | Old PN                         | Instructions — Disposition |
|------------------------------|-----|-----------------------------|------------------------------------------------|--------------------------------|----------------------------|
| 6B1113                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING             | 6A2629C16<br>(72-41-34-02-669) | (D)(S1)                    |
| 6B1114                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING             | 6A2629C17<br>(72-41-34-02-670) | (D)(S1)                    |
| 6B1066                       | 6   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER        | 6A3943<br>(72-41-34-02-680)    | (S1)(11D)                  |
| AS20625<br>(72-41-34-02-689) | 6   | *                           | .NUT, SELF<br>LOCKING                          |                                | (A)                        |
| 6B1067                       | 2   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER        | 6A3946<br>(72-41-34-02-730)    | (S1)                       |
| NND6905<br>(72-41-34-02-742) | 2   | *                           | ..BOLT,<br>CENTRALIZER                         |                                | (A)                        |
| AS20624<br>(72-41-34-02-743) | 4   | *                           | .NUT, SELF<br>LOCKING                          |                                | (A)                        |
| 6B1129                       | 27  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STANDARD,<br>STG 3 | 6A7460<br>(72-41-34-03-100)    | (S1)(C)(12D)               |
| OR                           |     |                             |                                                |                                |                            |
| 6B1148                       | 27  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STANDARD,<br>STG 3 | 6A7460<br>(72-41-34-03-100)    | (S1)(C)(12D)               |
| AS48513                      | 27  | *                           | .BOLT, BIHEX<br>HD                             | AS20911<br>(72-41-34-03-102)   | (S1)(13D)                  |
| 6B1131                       | 3   | *                           | .LEVER, VSV<br>ASSEMBLY,<br>CRANKED, STG<br>3  | 6A6547<br>(72-41-34-03-120)    | (S1)(C)(14D)               |
| OR                           |     |                             |                                                |                                |                            |
| 6B1150                       | 3   | *                           | .LEVER, VSV<br>ASSEMBLY,<br>CRANKED, STG<br>3  | 6A6547<br>(72-41-34-03-120)    | (S1)(C)(14D)               |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                              | Old PN                       | Instructions — Disposition |
|------------------------------|-----|-----------------------------|--------------------------------------|------------------------------|----------------------------|
| OR                           |     |                             |                                      |                              |                            |
| AS48513                      | 2   | *                           | .BOLT, BIHEX HD                      | AS20911<br>(72-41-34-03-122) | (S1)(18D)                  |
| 6B1130                       | 2   | *                           | .LEVER, VSV ASSEMBLY, BALL UP, STG 3 | 6A7461<br>(72-41-34-03-140)  | (S1)(C)                    |
| OR                           |     |                             |                                      |                              |                            |
| 6B1149                       | 2   | *                           | .LEVER, VSV ASSEMBLY, BALL UP, STG 3 | 6A7461<br>(72-41-34-03-140)  | (S1)(C)                    |
| AS48513<br>(72-41-34-03-142) | 2   | *                           | .BOLT, BIHEX HD                      |                              | (A)                        |
| 6B1070                       | 2   | *                           | .PIECE, BRIDGING VSV STG 3 FRONT     | 6A7594<br>(72-41-34-03-200)  | (S1)(15D)                  |
| 6B1071<br>(72-41-34-03-201)  | 2   | *                           | .PIECE, BRIDGING VSV STG 3 REAR      |                              | (A)                        |
| AS54624                      | 8   | *                           | .BOLT, BIHEX HD                      | AS21013<br>(72-41-34-03-202) | (S1)(C)(16D)               |
| OR                           |     |                             |                                      |                              |                            |
| AS23524                      | 8   | *                           | .BOLT, BIHEX HD                      | AS21013<br>(72-41-34-03-202) | (S1)(C)(16D)               |
| OR                           |     |                             |                                      |                              |                            |
| AS23024                      | 8   | *                           | .BOLT, BIHEX HD                      | AS21013<br>(72-41-34-03-202) | (S1)(C)(16D)               |
| OR                           |     |                             |                                      |                              |                            |
| AS57224                      | 8   | *                           | .BOLT, BIHEX HD                      | AS21013<br>(72-41-34-03-202) | (S1)(C)(16D)               |
| OR                           |     |                             |                                      |                              |                            |
| AS61424                      | 8   | *                           | .BOLT, BIHEX HD                      | AS21013<br>(72-41-34-03-202) | (S1)(C)(16D)               |
| AS20625<br>(72-41-34-03-204) | 8   | *                           | .NUT, SELF LOCKING                   |                              | (A)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                      | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|----------------------------------------------|--------------------------------|----------------------------|
| 6A9110 | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 3, UPPER<br>UNISON | 6A7903<br>(72-41-34-03-440)    | (S1)                       |
| 6A9112 | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 3, LOWER<br>UNISON | 6A7906<br>(72-41-34-03-540)    | (S1)                       |
| 6B1098 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C01<br>(72-41-34-03-654) | (D)(S1)                    |
| 6B1099 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C02<br>(72-41-34-03-655) | (D)(S1)                    |
| 6B1100 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C03<br>(72-41-34-03-656) | (D)(S1)                    |
| 6B1101 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C04<br>(72-41-34-03-657) | (D)(S1)                    |
| 6B1102 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C05<br>(72-41-34-03-658) | (D)(S1)                    |
| 6B1103 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C06<br>(72-41-34-03-659) | (D)(S1)                    |
| 6B1104 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C07<br>(72-41-34-03-660) | (D)(S1)                    |
| 6B1105 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C08<br>(72-41-34-03-661) | (D)(S1)                    |
| 6B1106 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C09<br>(72-41-34-03-662) | (D)(S1)                    |
| 6B1107 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C10<br>(72-41-34-03-663) | (D)(S1)                    |
| 6B1108 | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2630C11<br>(72-41-34-03-664) | (D)(S1)                    |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                 | Old PN                         | Instructions — Disposition |
|------------------------------|-----|-----------------------------|-----------------------------------------|--------------------------------|----------------------------|
| 6B1109                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2630C12<br>(72-41-34-03-665) | (D)(S1)                    |
| 6B1110                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2630C13<br>(72-41-34-03-666) | (D)(S1)                    |
| 6B1111<br>(72-41-34-03-667)  | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1112<br>(72-41-34-03-668)  | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1113<br>(72-41-34-03-669)  | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1114<br>(72-41-34-03-670)  | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1066                       | 2   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER | 6A6514<br>(72-41-34-03-680)    | (S1)(4D)                   |
| AS20625<br>(72-41-34-03-698) | 2   | *                           | .NUT, SELF<br>LOCKING                   |                                | (A)                        |
| 6B1067                       | 6   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER | 6A3988<br>(72-41-34-03-730)    | (S1)(11D)                  |
| AS20624<br>(72-41-34-03-734) | 12  | *                           | .NUT, SELF<br>LOCKING                   |                                | (A)                        |
| AS50625<br>(72-41-34-03-796) | 2   | *                           | .NUT, SELF<br>LOCKING                   |                                | (A)                        |
| AS54624<br>(72-41-34-03-798) | 2   | *                           | .BOLT, BIHEX<br>HD                      |                                | (A)(C)                     |
| OR                           |     |                             |                                         |                                |                            |
| AS23524<br>(72-41-34-03-798) | 2   | *                           | .BOLT, BIHEX<br>HD                      |                                | (A)(C)                     |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                 | Old PN                       | Instructions — Disposition |
|------------------------------|-----|-----------------------------|-----------------------------------------|------------------------------|----------------------------|
| OR                           |     |                             |                                         |                              |                            |
| AS23024<br>(72-41-34-03-798) | 2   | *                           | .BOLT, BIHEX HD                         |                              | (A)(C)                     |
| OR                           |     |                             |                                         |                              |                            |
| AS57224<br>(72-41-34-03-798) | 2   | *                           | .BOLT, BIHEX HD                         |                              | (A)(C)                     |
| OR                           |     |                             |                                         |                              |                            |
| AS61424<br>(72-41-34-03-798) | 2   | *                           | .BOLT, BIHEX HD                         |                              | (A)(C)                     |
| 6B1072<br>(72-41-34-03-800)  | 2   | *                           | .BRACKET, DRIVE VSV. STG 3              |                              | (A)                        |
| 6B1132                       | 46  | *                           | .LEVER, VSV ASSEMBLY, STANDARD, STG 4   | 6A7462<br>(72-41-34-04-100)  | (S1)(C)(17D)               |
| OR                           |     |                             |                                         |                              |                            |
| 6B1151                       | 46  | *                           | .LEVER, VSV ASSEMBLY, STANDARD, STG 4   | 6A7462<br>(72-41-34-04-100)  | (S1)(C)(17D)               |
| AS48513                      | 46  | *                           | .BOLT, BIHEX HD                         | AS20911<br>(72-41-34-04-102) | (S1)                       |
| 6B1133                       | 3   | *                           | .LEVER, VSV ASSEMBLY, STG 4, TDC        | 6A7463<br>(72-41-34-04-120)  | (S1)(C)(14D)               |
| OR                           |     |                             |                                         |                              |                            |
| 6B1152                       | 3   | *                           | .LEVER, VSV ASSEMBLY, STG 4, TDC        | 6A7463<br>(72-41-34-04-120)  | (S1)(C)(14D)               |
| AS48513                      | 3   | *                           | .BOLT, BIHEX HD                         | AS20911<br>(72-41-34-04-122) | (S1)(20D)                  |
| 6B1134<br>(72-41-34-04-140)  | 1   | *                           | .LEVER, VSV ASSEMBLY, STG 4, CRANKED UP |                              | (A)(C)                     |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                 | Old PN                       | Instructions — Disposition |
|------------------------------|-----|-----------------------------|-----------------------------------------|------------------------------|----------------------------|
| OR                           |     |                             |                                         |                              |                            |
| 6B1153<br>(72-41-34-04-140)  | 1   | *                           | .LEVER, VSV ASSEMBLY, STG 4, CRANKED UP |                              | (A)(C)                     |
| AS48513<br>(72-41-34-04-142) | 1   | *                           | .BOLT, BIHEX HD                         |                              | (A)                        |
| 6B1081                       | 2   | *                           | .PIECE, BRIDGING VSV, STG 4 FRONT       | 6A7893<br>(72-41-34-04-200)  | (S1)                       |
| 6B1082<br>(72-41-34-04-201)  | 2   | *                           | .PIECE, BRIDGING VSV, STG 4 REAR        |                              | (A)                        |
| AS54624                      | 8   | *                           | .BOLT, BIHEX HD                         | AS21013<br>(72-41-34-04-202) | (S1)(C)                    |
| OR                           |     |                             |                                         |                              |                            |
| AS23524                      | 8   | *                           | .BOLT, BIHEX HD                         | AS21013<br>(72-41-34-04-202) | (S1)(C)                    |
| OR                           |     |                             |                                         |                              |                            |
| AS23024                      | 8   | *                           | .BOLT, BIHEX HD                         | AS21013<br>(72-41-34-04-202) | (S1)(C)                    |
| OR                           |     |                             |                                         |                              |                            |
| AS57224                      | 8   | *                           | .BOLT, BIHEX HD                         | AS21013<br>(72-41-34-04-202) | (S1)(C)                    |
| OR                           |     |                             |                                         |                              |                            |
| AS61424                      | 8   | *                           | .BOLT, BIHEX HD                         | AS21013<br>(72-41-34-04-202) | (S1)(C)                    |
| AS20625<br>(72-41-34-04-203) | 8   | *                           | .NUT, SELF LOCKING                      |                              | (A)                        |
| 6B1075<br>(72-41-34-04-287)  | 2   | *                           | .SPACER                                 |                              | (A)                        |
| 6B1083                       | 2   | *                           | .BRACKET, DRIVE VSV, STG 4              | 6A7434<br>(72-41-34-04-360)  | (S1)(15D)                  |
| OR                           |     |                             |                                         |                              |                            |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                      | Old PN                         | Instructions — Disposition |
|------------------------------|-----|-----------------------------|----------------------------------------------|--------------------------------|----------------------------|
| 6B1083                       | 2   | *                           | .BRACKET,<br>DRIVE VSV, STG<br>4             | 6A2611<br>(72-41-34-04-360)    | (S1)(15D)                  |
| AS54624                      | 2   | *                           | .BOLT, BIHEX<br>HD                           | AS20911<br>(72-41-34-04-362)   | (S1)(C)                    |
| OR                           |     |                             |                                              |                                |                            |
| AS23524                      | 2   | *                           | .BOLT, BIHEX<br>HD                           | AS20911<br>(72-41-34-04-362)   | (S1)(C)                    |
| OR                           |     |                             |                                              |                                |                            |
| AS23024                      | 2   | *                           | .BOLT, BIHEX<br>HD                           | AS20911<br>(72-41-34-04-362)   | (S1)(C)                    |
| OR                           |     |                             |                                              |                                |                            |
| AS57224                      | 2   | *                           | .BOLT, BIHEX<br>HD                           | AS20911<br>(72-41-34-04-362)   | (S1)(C)                    |
| OR                           |     |                             |                                              |                                |                            |
| AS61424                      | 2   | *                           | .BOLT, BIHEX<br>HD                           | AS20911<br>(72-41-34-04-362)   | (S1)(C)                    |
| AS20625<br>(72-41-34-04-364) | 2   | *                           | .NUT, SELF<br>LOCKING                        |                                | (A)                        |
| 6A9114                       | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 4, UPPER<br>UNISON | 6A7888<br>(72-41-34-04-440)    | (S1)                       |
| 6A9116                       | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 4, LOWER<br>UNISON | 6A7890<br>(72-41-34-04-540)    | (S1)                       |
| 6B1098                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C01<br>(72-41-34-04-654) | (D)(S1)                    |
| 6B1099                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C02<br>(72-41-34-04-655) | (D)(S1)                    |
| 6B1100                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C03<br>(72-41-34-04-656) | (D)(S1)                    |

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| New PN                      | Qty | Estimate of Unit Price (\$) | Keyword                            | Old PN                         | Instructions — Disposition |
|-----------------------------|-----|-----------------------------|------------------------------------|--------------------------------|----------------------------|
| 6B1101                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C04<br>(72-41-34-04-657) | (D)(S1)                    |
| 6B1102                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C05<br>(72-41-34-04-658) | (D)(S1)                    |
| 6B1103                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C06<br>(72-41-34-04-659) | (D)(S1)                    |
| 6B1104                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C07<br>(72-41-34-04-660) | (D)(S1)                    |
| 6B1105                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C08<br>(72-41-34-04-661) | (D)(S1)                    |
| 6B1106                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C09<br>(72-41-34-04-662) | (D)(S1)                    |
| 6B1107                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C10<br>(72-41-34-04-663) | (D)(S1)                    |
| 6B1108                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C11<br>(72-41-34-04-664) | (D)(S1)                    |
| 6B1109                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C12<br>(72-41-34-04-665) | (D)(S1)                    |
| 6B1110                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING | 6A2632C13<br>(72-41-34-04-666) | (D)(S1)                    |
| 6B1111<br>(72-41-34-04-667) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING |                                | (A)(D)                     |
| 6B1112<br>(72-41-34-04-668) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING |                                | (A)(D)                     |
| 6B1113<br>(72-41-34-04-669) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING |                                | (A)(D)                     |

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|------------------------------|-----|-----------------------------|-------------------------------------------------|------------------------------|----------------------------|
| 6B1114<br>(72-41-34-04-670)  | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING              |                              | (A)(D)                     |
| 6B1080                       | 8   | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING              | 6A7394<br>(72-41-34-04-680)  | (S1)(16D)                  |
| OR                           |     |                             |                                                 |                              |                            |
| 6B1080                       | 8   | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING              | 6A2468<br>(72-41-34-04-680)  | (S1)(16D)                  |
| AS20624<br>(72-41-34-04-698) | 16  | *                           | .NUT, SELF<br>LOCKING                           |                              | (A)                        |
| 6B1136                       | 36  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STG 5, BALL<br>UP   | 6A7464<br>(72-41-34-05-100)  | (S1)(C)(19D)               |
| OR                           |     |                             |                                                 |                              |                            |
| 6B1155                       | 36  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STG 5, BALL<br>UP   | 6A7464<br>(72-41-34-05-100)  | (S1)(C)(19D)               |
| AS48513                      | 36  | *                           | .BOLT, BIHEX<br>HD                              | AS20911<br>(72-41-34-05-102) | (S1)(7D)                   |
| 6B1135                       | 28  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STG 5, BALL<br>DOWN | 6A7466<br>(72-41-34-05-140)  | (S1)(C)(8D)                |
| 6B1154                       | 28  | *                           | .LEVER, VSV<br>ASSEMBLY,<br>STG 5, BALL<br>DOWN | 6A7466<br>(72-41-34-05-140)  | (S1)(C)(8D)                |
| AS48513<br>(72-41-34-05-142) | 28  | *                           | .BOLT, BIHEX<br>HD                              |                              | (A)                        |
| 6B1084                       | 2   | *                           | .PIECE,<br>BRIDGING VSV<br>STG 5 FRONT          | 6A7898<br>(72-41-34-05-200)  | (S1)                       |
| 6B1085<br>(72-41-34-05-201)  | 2   | *                           | .PIECE,<br>BRIDGING VSV<br>STG 5 REAR           |                              | (A)                        |

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|------------------------------|-----|-----------------------------|---------------------------------|------------------------------|----------------------------|
| AS54624                      | 8   | *                           | .BOLT, BIHEX HD                 | AS21013<br>(72-41-34-05-202) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS23524                      | 8   | *                           | .BOLT, BIHEX HD                 | AS21013<br>(72-41-34-05-202) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS23024                      | 8   | *                           | .BOLT, BIHEX HD                 | AS21013<br>(72-41-34-05-202) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS57224                      | 8   | *                           | .BOLT, BIHEX HD                 | AS21013<br>(72-41-34-05-202) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS61424                      | 8   | *                           | .BOLT, BIHEX HD                 | AS21013<br>(72-41-34-05-202) | (S1)(C)                    |
| AS20625<br>(72-41-34-05-203) | 8   | *                           | .NUT, SELF LOCKING              |                              | (A)                        |
| 6B1086                       | 2   | *                           | .BRACKET, DRIVE VSV STG 5       | 6A7435<br>(72-41-34-05-360)  | (S1)(15D)                  |
| OR                           |     |                             |                                 |                              |                            |
| 6B1086                       | 2   | *                           | .BRACKET, DRIVE VSV STG 5       | 6A3688<br>(72-41-34-05-360)  | (S1)(15D)                  |
| AS54624                      | 2   | *                           | .PIECE, BRIDGING VSV STG 5 REAR | AS20911<br>(72-41-34-05-362) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS23524                      | 2   | *                           | .PIECE, BRIDGING VSV STG 5 REAR | AS20911<br>(72-41-34-05-362) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |
| AS23024                      | 2   | *                           | .PIECE, BRIDGING VSV STG 5 REAR | AS20911<br>(72-41-34-05-362) | (S1)(C)                    |
| OR                           |     |                             |                                 |                              |                            |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword                                      | Old PN                         | Instructions — Disposition |
|------------------------------|-----|-----------------------------|----------------------------------------------|--------------------------------|----------------------------|
| AS57224                      | 2   | *                           | .PIECE,<br>BRIDGING VSV<br>STG 5 REAR        | AS20911<br>(72-41-34-05-362)   | (S1)(C)                    |
| OR                           |     |                             |                                              |                                |                            |
| AS61424                      | 2   | *                           | .PIECE,<br>BRIDGING VSV<br>STG 5 REAR        | AS20911<br>(72-41-34-05-362)   | (S1)(C)                    |
| AS20625<br>(72-41-34-05-364) | 2   | *                           | .BRACKET,<br>DRIVE VSV STG<br>5              |                                | (A)                        |
| 6A9118                       | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 5, UPPER<br>UNISON | 6A7894<br>(72-41-34-05-440)    | (S1)                       |
| 6A9120                       | 1   | *                           | .RING<br>ASSEMBLY,<br>STG 5, LOWER<br>UNISON | 6A7896<br>(72-41-34-05-540)    | (S1)                       |
| 6B1098                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C01<br>(72-41-34-05-654) | (D)(S1)                    |
| 6B1099                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C02<br>(72-41-34-05-655) | (D)(S1)                    |
| 6B1100                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C03<br>(72-41-34-05-656) | (D)(S1)                    |
| 6B1101                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C04<br>(72-41-34-05-657) | (D)(S1)                    |
| 6B1102                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C05<br>(72-41-34-05-658) | (D)(S1)                    |
| 6B1103                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C06<br>(72-41-34-05-659) | (D)(S1)                    |
| 6B1104                       | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING           | 6A2632C07<br>(72-41-34-05-660) | (D)(S1)                    |

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| New PN                      | Qty | Estimate of Unit Price (\$) | Keyword                                 | Old PN                         | Instructions — Disposition |
|-----------------------------|-----|-----------------------------|-----------------------------------------|--------------------------------|----------------------------|
| 6B1105                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C08<br>(72-41-34-05-661) | (D)(S1)                    |
| 6B1106                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C09<br>(72-41-34-05-662) | (D)(S1)                    |
| 6B1107                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C10<br>(72-41-34-05-663) | (D)(S1)                    |
| 6B1108                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C11<br>(72-41-34-05-664) | (D)(S1)                    |
| 6B1109                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C12<br>(72-41-34-05-665) | (D)(S1)                    |
| 6B1110                      | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      | 6A2632C13<br>(72-41-34-05-666) | (D)(S1)                    |
| 6B1111<br>(72-41-34-05-667) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1112<br>(72-41-34-05-668) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1113<br>(72-41-34-05-669) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1114<br>(72-41-34-05-670) | AR  | *                           | .SHIM,<br>CENTRALIZER<br>ADJUSTING      |                                | (A)(D)                     |
| 6B1080                      | 8   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER | 6A7395<br>(72-41-34-05-680)    | (S1)(16D)                  |
| OR                          |     |                             |                                         |                                |                            |
| 6B1080                      | 8   | *                           | .SUPPORT,<br>ASSEMBLY OF<br>CENTRALIZER | 6A3091<br>(72-41-34-05-680)    | (S1)(16D)                  |

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| New PN                       | Qty | Estimate of Unit Price (\$) | Keyword            | Old PN                       | Instructions — Disposition |
|------------------------------|-----|-----------------------------|--------------------|------------------------------|----------------------------|
| AS20624<br>(72-41-34-05-698) | 16  | *                           | .NUT, SELF LOCKING |                              | (A)                        |
| AS54826                      | 1   | *                           | .BOLT              | AS26424<br>(72-41-34-07-081) | (S1)                       |

The material data that follows is for each engine.

Redundant Parts:

| New PN | Qty | Estimate of Unit Price (\$) | Keyword                       | Old PN                       | Instructions — Disposition |
|--------|-----|-----------------------------|-------------------------------|------------------------------|----------------------------|
|        | 40  | *                           | .WASHER, SEALING, VIGV        | 6A3789<br>(72-41-30-01-100)  | (N)                        |
|        | 32  | *                           | .WASHER, SEALING, VANES STG 3 | 6A3790<br>(72-41-30-01-150)  | (N)                        |
|        | 50  | *                           | .WASHER, SEALING, VANES STG 4 | 6A3791<br>(72-41-30-01-200)  | (N)                        |
|        | 1   | *                           | .PIN, COTTER SPLIT            | SP90E4<br>(72-41-34-01-178)  | (N)                        |
|        | 1   | *                           | .LEVER, ACTUATING, STG 4      | 6A4516<br>(72-41-34-01-500)  | (N)                        |
| OR     |     |                             |                               |                              |                            |
|        | 1   | *                           | .LEVER, ACTUATING, STG 4      | 6A7806<br>(72-41-34-01-500)  | (N)                        |
|        | 1   | *                           | .LEVER, ACTUATING, STG 4      | 6A8682<br>(72-41-34-01-520)  | (N)                        |
|        | 2   | *                           | .NUT                          | 4W0003<br>(72-41-34-01-522)  | (N)                        |
|        | 2   | *                           | .BOLT                         | AS26326<br>(72-41-34-01-523) | (N)                        |
|        | 1   | *                           | .LEVER, ACTUATING, STG 3      | 6A8681<br>(72-41-34-01-560)  | (N)                        |
|        | 2   | *                           | .BOLT                         | AS26318<br>(72-41-34-01-562) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                            | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|------------------------------------|--------------------------------|----------------------------|
|        | 2   | *                           | .NUT, SELF LOCKING                 | 4W0003<br>(72-41-34-01-563)    | (N)                        |
|        | 2   | *                           | .BOLT                              | AS21115<br>(72-41-34-01-564)   | (N)                        |
|        | 2   | *                           | ..INSERT, SCREW THREAD             | AGS3733<br>(72-41-34-01-614)   | (N)                        |
|        | REF | *                           | ..BEARING ASSEMBLY, REAR SPHERICAL | 6A7551<br>(72-41-34-01-774)    | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C01<br>(72-41-34-02-060) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C02<br>(72-41-34-02-062) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C03<br>(72-41-34-02-064) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C04<br>(72-41-34-02-066) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C05<br>(72-41-34-02-068) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C06<br>(72-41-34-02-070) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C07<br>(72-41-34-02-072) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C08<br>(72-41-34-02-074) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C09<br>(72-41-34-02-076) | (N)                        |
|        | 80  | *                           | .SPACER                            | 6A2272C10<br>(72-41-34-02-078) | (N)                        |
|        | 8   | *                           | .LEVER ASSEMBLY, VIGV BRIDGE HPC   | 6A7469<br>(72-41-34-02-120)    | (N)                        |
|        | 8   | *                           | .BOLT                              | 4W0409<br>(72-41-34-02-122)    | (N)                        |
|        | 1   | *                           | ..PIN, SHOULDER                    | 6A2438<br>(72-41-34-02-130)    | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|----------------------------------------|--------------------------------|----------------------------|
|        | 2   | *                           | .BOLT, WIRE LOCK                       | AS43411<br>(72-41-34-02-203)   | (N)                        |
|        | 6   | *                           | .WASHER                                | UP12204<br>(72-41-34-02-205)   | (N)                        |
|        | 2   | *                           | .WASHER                                | UP12203<br>(72-41-34-02-207)   | (N)                        |
|        | 16  | *                           | ..BUSHING, SLEEVE                      | BRR12496<br>(72-41-34-02-460)  | (N)                        |
|        | 4   | *                           | ..SPACER                               | 6A2860<br>(72-41-34-02-462)    | (N)                        |
|        | 16  | *                           | ..BUSHING, SLEEVE                      | BRR12496<br>(72-41-34-02-560)  | (N)                        |
|        | 8   | *                           | .BOLT                                  | BLT5410<br>(72-41-34-02-682)   | (N)                        |
|        | 8   | *                           | .WASHER                                | 4W2621<br>(72-41-34-02-684)    | (N)                        |
|        | 1   | *                           | ...PAD                                 | 6A2919<br>(72-41-34-02-692)    | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.031 IN (0.787 MM) | 6A2624C01<br>(72-41-34-02-704) | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.030 IN (0.763 MM) | 6A2624C02<br>(72-41-34-02-705) | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.029 IN (0.737 MM) | 6A2624C03<br>(72-41-34-02-706) | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.027 IN (0.687 MM) | 6A2624C04<br>(72-41-34-02-707) | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.025 IN (0.637 MM) | 6A2624C05<br>(72-41-34-02-708) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                         | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|-------------------------------------------------|--------------------------------|----------------------------|
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.023 IN (0.587<br>MM) | 6A2624C06<br>(72-41-34-02-709) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.021 IN (0.537<br>MM) | 6A2624C07<br>(72-41-34-02-710) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.019 IN (0.487<br>MM) | 6A2624C08<br>(72-41-34-02-711) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.017 IN (0.437<br>MM) | 6A2624C09<br>(72-41-34-02-712) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.015 IN (0.387<br>MM) | 6A2624C10<br>(72-41-34-02-713) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.014 IN (0.345<br>MM) | 6A2624C11<br>(72-41-34-02-714) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.012 IN (0.305<br>MM) | 6A2624C12<br>(72-41-34-02-715) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.010 IN (0.254<br>MM) | 6A2624C13<br>(72-41-34-02-716) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.007 IN (0.178<br>MM) | 6A2624C14<br>(72-41-34-02-717) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.006 IN (0.152<br>MM) | 6A2624C15<br>(72-41-34-02-718) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|----------------------------------------|--------------------------------|----------------------------|
|        | AR  | *                           | .WASHER, ADJUSTING 0.005 IN (0.127 MM) | 6A2624C16<br>(72-41-34-02-719) | (N)                        |
|        | AR  | *                           | .WASHER, ADJUSTING 0.004 IN (0.102 MM) | 6A2624C17<br>(72-41-34-02-720) | (N)                        |
|        | 2   | *                           | .BOLT                                  | BLT5412<br>(72-41-34-02-732)   | (N)                        |
|        | 2   | *                           | .BOLT                                  | BLT5411<br>(72-41-34-02-733)   | (N)                        |
|        | 2   | *                           | .HOUSING ASSEMBLY, RH-VIGV CONN        | 6A3949<br>(72-41-34-02-750)    | (N)                        |
|        | 2   | *                           | .BOLT                                  | BLT5412<br>(72-41-34-02-752)   | (N)                        |
|        | 2   | *                           | .BOLT                                  | BLT5411<br>(72-41-34-02-753)   | (N)                        |
|        | 1   | *                           | .BRACKET, RIG PIN, HPC                 | 6A7408<br>(72-41-34-02-780)    | (N)                        |
|        | 1   | *                           | .BRACKET, RIG PIN, HPC                 | 6A4289<br>(72-41-34-02-780)    | (N)                        |
|        | 2   | *                           | .NUT, SELF LOCKING                     | AS20624<br>(72-41-34-02-782)   | (N)                        |
|        | 2   | *                           | .BOLT                                  | AS28121<br>(72-41-34-02-784)   | (N)                        |
|        | 2   | *                           | .SPACER                                | 6A3677<br>(72-41-34-02-786)    | (N)                        |
|        | 64  | *                           | .SPACER                                | 6A2037C01<br>(72-41-34-03-060) | (N)                        |
|        | 64  | *                           | .SPACER                                | 6A2037C02<br>(72-41-34-03-062) | (N)                        |
|        | 64  | *                           | .SPACER                                | 6A2037C03<br>(72-41-34-03-064) | (N)                        |
|        | 64  | *                           | .SPACER                                | 6A2037C04<br>(72-41-34-03-066) | (N)                        |
|        | 64  | *                           | .SPACER                                | 6A2037C05<br>(72-41-34-03-068) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                            | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|------------------------------------|--------------------------------|----------------------------|
|        | 64  | *                           | .SPACER                            | 6A2037C06<br>(72-41-34-03-070) | (N)                        |
|        | 64  | *                           | .SPACER                            | 6A2037C07<br>(72-41-34-03-070) | (N)                        |
|        | 64  | *                           | .SPACER                            | 6A2037C08<br>(72-41-34-03-072) | (N)                        |
|        | 64  | *                           | .SPACER                            | 6A2037C09<br>(72-41-34-03-076) | (N)                        |
|        | 22  | *                           | .NUT, SELF LOCKING                 | 4W0002<br>(72-41-34-03-103)    | (N)                        |
|        | 8   | *                           | .NUT, SELF LOCKING                 | 4W0002<br>(72-41-34-03-123)    | (N)                        |
|        | 2   | *                           | .NUT, SELF LOCKING                 | 4W0002<br>(72-41-34-03-143)    | (N)                        |
|        | 4   | *                           | .WASHER                            | UP12204<br>(72-41-34-03-205)   | (N)                        |
|        | 1   | *                           | .BRIDGE PIECE ASSEMBLY, STG.3, STB | 6A7593<br>(72-41-34-03-280)    | (N)                        |
|        | 4   | *                           | .BOLT                              | AS21013<br>(72-41-34-03-282)   | (N)                        |
|        | 1   | *                           | .BOLT                              | AS21008<br>(72-41-34-03-284)   | (N)                        |
|        | 4   | *                           | .WASHER                            | UP12204<br>(72-41-34-03-285)   | (N)                        |
|        | 1   | *                           | .SPACER, WASHER                    | BA41252<br>(72-41-34-03-287)   | (N)                        |
|        | 12  | *                           | ..BUSHING, SLEEVE                  | BRR12496<br>(72-41-34-03-460)  | (N)                        |
|        | 2   | *                           | ..BRACKET, ASSEMBLY STG 3 ACT RING | 6A2869<br>(72-41-34-03-470)    | (N)                        |
|        | 1   | *                           | ..BRACKET, ASSEMBLY                | 6A7905<br>(72-41-34-03-520)    | (N)                        |
|        | 12  | *                           | ..BUSHING, SLEEVE                  | BRR12496<br>(72-41-34-03-560)  | (N)                        |
|        | 2   | *                           | ..BRACKET, ASSEMBLY STG 3 ACT RING | 6A2869<br>(72-41-34-03-570)    | (N)                        |

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|--------|-----|-----------------------------|-------------------------------------------------|--------------------------------|----------------------------|
|        | 2   | *                           | ...INSERT,<br>SCREW<br>THREAD                   | AGS3731<br>(72-41-34-03-573)   | (N)                        |
|        | 8   | *                           | .BOLT                                           | AS20911<br>(72-41-34-03-682)   | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.031 IN (0.787<br>MM) | 6A2625C01<br>(72-41-34-03-704) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.030 IN (0.763<br>MM) | 6A2625C02<br>(72-41-34-03-705) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.029 IN (0.737<br>MM) | 6A2625C03<br>(72-41-34-03-706) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.027 IN (0.687<br>MM) | 6A2625C04<br>(72-41-34-03-707) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.025 IN (0.637<br>MM) | 6A2625C05<br>(72-41-34-03-708) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.023 IN (0.587<br>MM) | 6A2625C06<br>(72-41-34-03-709) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.021 IN (0.537<br>MM) | 6A2625C07<br>(72-41-34-03-710) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.019 IN (0.487<br>MM) | 6A2625C08<br>(72-41-34-03-711) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING                           | 6A2625C09<br>(72-41-34-03-712) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                         | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|-------------------------------------------------|--------------------------------|----------------------------|
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.015 IN (0.387<br>MM) | 6A2625C10<br>(72-41-34-03-713) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.014 IN (0.345<br>MM) | 6A2625C11<br>(72-41-34-03-714) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.012 IN (0.305<br>MM) | 6A2625C12<br>(72-41-34-03-715) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.010 IN (0.254<br>MM) | 6A2625C13<br>(72-41-34-03-716) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.007 IN (0.178<br>MM) | 6A2625C14<br>(72-41-34-03-717) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.006 IN (0.152<br>MM) | 6A2625C15<br>(72-41-34-03-718) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.005 IN (0.127<br>MM) | 6A2625C16<br>(72-41-34-03-719) | (N)                        |
|        | AR  | *                           | .WASHER,<br>ADJUSTING<br>0.004 IN (0.102<br>MM) | 6A2625C17<br>(72-41-34-03-720) | (N)                        |
|        | 8   | *                           | .BOLT                                           | BLT5412<br>(72-41-34-03-732)   | (N)                        |
|        | 1   | *                           | .BRACKET,<br>STG 3 RIG PIN<br>LOCATING          | 6A8683<br>(72-41-34-03-770)    | (N)                        |
|        | 2   | *                           | .BOLT                                           | AS20911<br>(72-41-34-03-772)   | (N)                        |
|        | 2   | *                           | .DOWEL,<br>HOLLOW                               | 6A3680<br>(72-41-34-03-776)    | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                  | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|------------------------------------------|--------------------------------|----------------------------|
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C01<br>(72-41-34-04-060) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C02<br>(72-41-34-04-062) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C03<br>(72-41-34-04-064) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C04<br>(72-41-34-04-066) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C05<br>(72-41-34-04-068) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C06<br>(72-41-34-04-070) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C07<br>(72-41-34-04-072) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C08<br>(72-41-34-04-074) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C09<br>(72-41-34-04-076) | (N)                        |
|        | 100 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C10<br>(72-41-34-04-078) | (N)                        |
|        | 42  | *                           | .NUT, SELF<br>LOCKING                    | 4W0002<br>(72-41-34-04-103)    | (N)                        |
|        | 8   | *                           | .NUT, SELF<br>LOCKING                    | 4W0002<br>(72-41-34-04-123)    | (N)                        |
|        | 4   | *                           | .WASHER,<br>STRIP STG. 4<br>BRIDGE PIECE | 6A7604<br>(72-41-34-04-204)    | (N)                        |
|        | 8   | *                           | .WASHER                                  | UP12204<br>(72-41-34-04-205)   | (N)                        |
|        | 4   | *                           | ..BUSH                                   | UP12206<br>(72-41-34-04-220)   | (N)                        |
|        | 2   | *                           | .DOWEL,<br>HOLLOW<br>SECURING            | 6A8208<br>(72-41-34-04-366)    | (N)                        |
|        | 21  | *                           | ..BUSH                                   | UP12206<br>(72-41-34-04-460)   | (N)                        |
|        | 2   | *                           | ..BRACKET,<br>ASSEMBLY STG<br>4 ACT RING | 6A2881<br>(72-41-34-04-470)    | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                          | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|--------------------------------------------------|--------------------------------|----------------------------|
|        | 21  | *                           | ..BUSH                                           | UP12206<br>(72-41-34-04-560)   | (N)                        |
|        | 3   | *                           | ..BRACKET,<br>ASSEMBLY STG<br>4 ACT RING         | 6A2881<br>(72-41-34-04-570)    | (N)                        |
|        | 1   | *                           | ..BRACKET,<br>ASSEMBLY<br>STG. 4 LOWER           | 6A7892<br>(72-41-34-04-580)    | (N)                        |
|        | 2   | *                           | ...INSERT,<br>SCREW<br>THREAD                    | AGS3731<br>(72-41-34-04-583)   | (N)                        |
|        | 1   | *                           | ..BRACKET<br>ASSEMBLY<br>STG. 4, LOWER<br>UNISON | 6A7601<br>(72-41-34-04-630)    | (N)                        |
|        | 8   | *                           | .BOLT                                            | AS20911<br>(72-41-34-04-682)   | (N)                        |
|        | AR  | *                           | .SPACER 0.031<br>IN (0.787 MM)                   | 6A4342C01<br>(72-41-34-04-704) | (N)                        |
|        | AR  | *                           | .SPACER 0.030<br>IN (0.763 MM)                   | 6A4342C02<br>(72-41-34-04-705) | (N)                        |
|        | AR  | *                           | .SPACER 0.029<br>IN (0.737 MM)                   | 6A4342C03<br>(72-41-34-04-706) | (N)                        |
|        | AR  | *                           | .SPACER 0.027<br>IN (0.687 MM)                   | 6A4342C04<br>(72-41-34-04-707) | (N)                        |
|        | AR  | *                           | .SPACER 0.025<br>IN (0.637 MM)                   | 6A4342C05<br>(72-41-34-04-708) | (N)                        |
|        | AR  | *                           | .SPACER 0.023<br>IN (0.587 MM)                   | 6A4342C06<br>(72-41-34-04-709) | (N)                        |
|        | AR  | *                           | .SPACER 0.021<br>IN (0.537 MM)                   | 6A4342C07<br>(72-41-34-04-710) | (N)                        |
|        | AR  | *                           | .SPACER 0.019<br>IN (0.487 MM)                   | 6A4342C08<br>(72-41-34-04-711) | (N)                        |
|        | AR  | *                           | .SPACER 0.017<br>IN (0.437 MM)                   | 6A4342C09<br>(72-41-34-04-712) | (N)                        |
|        | AR  | *                           | .SPACER 0.015<br>IN (0.387 MM)                   | 6A4342C10<br>(72-41-34-04-713) | (N)                        |
|        | AR  | *                           | .SPACER 0.014<br>IN (0.345 MM)                   | 6A4342C11<br>(72-41-34-04-714) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                          | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|----------------------------------|--------------------------------|----------------------------|
|        | AR  | *                           | .SPACER 0.012 IN (0.305 MM)      | 6A4342C12<br>(72-41-34-04-715) | (N)                        |
|        | AR  | *                           | .SPACER 0.010 IN (0.254 MM)      | 6A4342C13<br>(72-41-34-04-716) | (N)                        |
|        | AR  | *                           | .SPACER 0.007 IN (0.178 MM)      | 6A4342C14<br>(72-41-34-04-717) | (N)                        |
|        | AR  | *                           | .SPACER 0.006 IN (0.152 MM)      | 6A4342C15<br>(72-41-34-04-718) | (N)                        |
|        | AR  | *                           | .SPACER 0.005 IN (0.127 MM)      | 6A4342C16<br>(72-41-34-04-719) | (N)                        |
|        | AR  | *                           | .SPACER 0.004 IN (0.102 MM)      | 6A4342C17<br>(72-41-34-04-720) | (N)                        |
|        | 4   | *                           | .HOUSING ASSEMBLY                | 6A4343<br>(72-41-34-04-730)    | (N)                        |
|        | 8   | *                           | .BOLT                            | AS20927<br>(72-41-34-04-732)   | (N)                        |
|        | 8   | *                           | .WASHER                          | 4W2621<br>(72-41-34-04-733)    | (N)                        |
|        | 2   | *                           | ..INSERT, SCREW THREAD           | AG3731<br>(72-41-34-04-736)    | (N)                        |
|        | 1   | *                           | ..PAD, RUBBING                   | 6A2929<br>(72-41-34-04-744)    | (N)                        |
|        | 1   | *                           | .BRACKET, STG 4 RIG PIN LOCATING | 6A8684<br>(72-41-34-04-770)    | (N)                        |
|        | 2   | *                           | .BOLT                            | AS20911<br>(72-41-34-04-772)   | (N)                        |
|        | 2   | *                           | .DOWEL, HOLLOW                   | 6A3680<br>(72-41-34-04-776)    | (N)                        |
|        | 128 | *                           | .SPACER, ADJUSTING               | 6A2035C01<br>(72-41-34-05-060) | (N)                        |
|        | 128 | *                           | .SPACER, ADJUSTING               | 6A2035C02<br>(72-41-34-05-062) | (N)                        |
|        | 128 | *                           | .SPACER, ADJUSTING               | 6A2035C03<br>(72-41-34-05-064) | (N)                        |
|        | 128 | *                           | .SPACER, ADJUSTING               | 6A2035C04<br>(72-41-34-05-066) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                  | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|------------------------------------------|--------------------------------|----------------------------|
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C05<br>(72-41-34-05-068) | (N)                        |
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C06<br>(72-41-34-05-070) | (N)                        |
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C07<br>(72-41-34-05-072) | (N)                        |
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C08<br>(72-41-34-05-074) | (N)                        |
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C09<br>(72-41-34-05-076) | (N)                        |
|        | 128 | *                           | .SPACER,<br>ADJUSTING                    | 6A2035C10<br>(72-41-34-05-078) | (N)                        |
|        | 52  | *                           | .NUT, SELF<br>LOCKING                    | 4W0002<br>(72-41-34-05-103)    | (N)                        |
|        | 8   | *                           | .LEVER<br>ASSEMBLY, VSV<br>BRIDGE HPC    | 6A7465<br>(72-41-34-05-120)    | (N)                        |
|        | 8   | *                           | .NUT, SELF<br>LOCKING                    | 4W0002<br>(72-41-34-05-123)    | (N)                        |
|        | 1   | *                           | ..PIN                                    | 6A4338<br>(72-41-34-05-130)    | (N)                        |
|        | 4   | *                           | .NUT, SELF<br>LOCKING                    | 4W0002<br>(72-41-34-05-143)    | (N)                        |
|        | 4   | *                           | .WASHER,<br>STRIP STG. 5<br>BRIDGE PIECE | 6A7612<br>(72-41-34-05-204)    | (N)                        |
|        | 8   | *                           | .WASHER                                  | UP12204<br>(72-41-34-05-205)   | (N)                        |
|        | 6   | *                           | ..BUSH                                   | UP12206<br>(72-41-34-05-220)   | (N)                        |
|        | 2   | *                           | .DOWEL,<br>SLEEVE                        | UP10817<br>(72-41-34-05-366)   | (N)                        |
|        | 26  | *                           | ..BUSH                                   | UP12206<br>(72-41-34-05-460)   | (N)                        |
|        | 2   | *                           | ..BRACKET,<br>ASSEMBLY<br>STAGE 5        | 6A2889<br>(72-41-34-05-470)    | (N)                        |
|        | 26  | *                           | ..BUSH                                   | UP12206<br>(72-41-34-05-560)   | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                                | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|----------------------------------------|--------------------------------|----------------------------|
|        | 1   | *                           | ..BRACKET, ASSEMBLY STG 5              | 6A2889<br>(72-41-34-05-570)    | (N)                        |
|        | 2   | *                           | ...INSERT, SCREW THREAD                | AGS3731<br>(72-41-34-05-573)   | (N)                        |
|        | 1   | *                           | ..BRACKET ASSEMBLY STG 5, LOWER UNISON | 6A7609<br>(72-41-34-05-580)    | (N)                        |
|        | 2   | *                           | ...INSERT, SCREW THREAD                | AGS3731<br>(72-41-34-05-583)   | (N)                        |
|        | 1   | *                           | ..BRACKET ASSEMBLY, STG 5              | 6A3681<br>(72-41-34-05-620)    | (N)                        |
|        | 4   | *                           | ...INSERT, SCREW THREAD                | AGS3731<br>(72-41-34-05-623)   | (N)                        |
|        | 8   | *                           | .BOLT                                  | AS20911<br>(72-41-34-05-682)   | (N)                        |
|        | AR  | *                           | .SPACER 0.031 IN (0.787 MM)            | 6A4339C01<br>(72-41-34-05-704) | (N)                        |
|        | AR  | *                           | .SPACER 0.030 IN (0.767 MM)            | 6A4339C02<br>(72-41-34-05-705) | (N)                        |
|        | AR  | *                           | .SPACER 0.029 IN (0.737 MM)            | 6A4339C03<br>(72-41-34-05-706) | (N)                        |
|        | AR  | *                           | .SPACER 0.027 IN (0.687 MM)            | 6A4339C04<br>(72-41-34-05-707) | (N)                        |
|        | AR  | *                           | .SPACER 0.025 IN (0.637 MM)            | 6A4339C05<br>(72-41-34-05-708) | (N)                        |
|        | AR  | *                           | .SPACER 0.023 IN (0.587 MM)            | 6A4339C06<br>(72-41-34-05-709) | (N)                        |
|        | AR  | *                           | .SPACER 0.021 IN (0.537 MM)            | 6A4339C07<br>(72-41-34-05-710) | (N)                        |
|        | AR  | *                           | .SPACER 0.019 IN (0.487 MM)            | 6A4339C08<br>(72-41-34-05-711) | (N)                        |
|        | AR  | *                           | .SPACER 0.017 IN (0.437 MM)            | 6A4339C09<br>(72-41-34-05-712) | (N)                        |

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| New PN | Qty | Estimate of Unit Price (\$) | Keyword                     | Old PN                         | Instructions — Disposition |
|--------|-----|-----------------------------|-----------------------------|--------------------------------|----------------------------|
|        | AR  | *                           | .SPACER 0.015 IN (0.387 MM) | 6A4339C10<br>(72-41-34-05-713) | (N)                        |
|        | AR  | *                           | .SPACER 0.014 IN (0.345 MM) | 6A4339C11<br>(72-41-34-05-714) | (N)                        |
|        | AR  | *                           | .SPACER 0.012 IN (0.305 MM) | 6A4339C12<br>(72-41-34-05-715) | (N)                        |
|        | AR  | *                           | .SPACER 0.010 IN (0.254 MM) | 6A4339C13<br>(72-41-34-05-716) | (N)                        |
|        | AR  | *                           | .SPACER 0.007 IN (0.178 MM) | 6A4339C14<br>(72-41-34-05-717) | (N)                        |
|        | AR  | *                           | .SPACER 0.006 IN (0.152 MM) | 6A4339C15<br>(72-41-34-05-718) | (N)                        |
|        | AR  | *                           | .SPACER 0.005 IN (0.127 MM) | 6A4339C16<br>(72-41-34-05-719) | (N)                        |
|        | AR  | *                           | .SPACER 0.004 IN (0.102 MM) | 6A4339C17<br>(72-41-34-05-720) | (N)                        |
|        | 4   | *                           | .HOUSING ASSEMBLY           | 6A4335<br>(72-41-30-05-730)    | (N)                        |
|        | 8   | *                           | .BOLT                       | AS20923<br>(72-41-34-05-730)   | (N)                        |
|        | 8   | *                           | .WASHER                     | 4W2621<br>(72-41-34-05-733)    | (N)                        |
|        | 2   | *                           | ..INSERT, SCREW THREAD      | AGS3731<br>(72-41-34-05-736)   | (N)                        |
|        | 1   | *                           | ..PAD, RUBBING              | 6A2932<br>(72-41-34-05-744)    | (N)                        |
|        | 1   | *                           | .BRACKET, RIG PIN           | 6A7411<br>(72-41-34-05-760)    | (N)                        |
|        | 1   | *                           | .BRACKET, RIG PIN           | 6A5523<br>(72-41-34-05-760)    | (N)                        |
|        | 2   | *                           | .BOLT                       | AS20911<br>(72-41-34-05-762)   | (N)                        |
|        | 2   | *                           | .DOWEL, HOLLOW              | 6A3680<br>(72-41-34-05-766)    | (N)                        |

Instructions/Disposition Code Statements:

Parts Modification Conditions

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Estimated part prices are provided when they are available at time of publication. The Estimate of Unit Price is only for planning purposes and does not constitute a firm quotation. An asterisk (\*) is shown where part pricing information was unavailable. In either case, contact IAE Spares for firm quotations.

#### Spare Parts Availability

- (A) The new part is available.
- (C) Alternate parts are fully and freely interchangeable.
- (D) The quantity of parts to be installed must be calculated during assembly of the HP compressor assembly.
- (N) The old part is not available.
- (S1) Old and new parts are not interchangeable.
- (1D) Quantity decreased from 80 to 2.
- (2D) Quantity decreased from 228 to 50.
- (3D) Quantity decreased from 60 to 30.
- (4D) Quantity decreased from 4 to 2.
- (5D) Quantity decreased from 30 to 27.
- (6D) Quantity decreased from 50 to 46.
- (7D) Quantity decreased from 60 to 36.
- (8D) Quantity increased from 4 to 28.
- (9D) Quantity increased from 30 to 38.
- (10D) Quantity increased from 6 to 8.
- (11D) Quantity increased from 4 to 6.
- (12D) Quantity increased from 22 to 27.
- (13D) Quantity decreased from 28 to 27.
- (14D) Quantity decreased from 8 to 3.
- (15D) Quantity increased from 1 to 2.
- (16D) Quantity increased from 4 to 8.
- (17D) Quantity increased from 42 to 46.
- (18D) Quantity decreased from 4 to 2.
- (19D) Quantity decreased from 52 to 36.
- (20D) Quantity decreased from 4 to 3.

#### Tooling — Price and Availability

Special tools are not required to accomplish this Service Bulletin.

#### Reidentified Parts

Not Applicable.

#### Other Material Information Data

Not Applicable.

Accomplishment Instructions

1. Not Applicable.

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AppendixAdded DataInternal Reference Information

| Revision No. | Reference Document                        | Origination |
|--------------|-------------------------------------------|-------------|
| Original     | EC 07SEL03R,<br>07SEL03R-01,<br>07SEL03RA | RR          |
| 1            | EC 07SEL03RB                              | MM/RCM      |

Number values shown in parentheses adjacent to U.S. values are International System of units (SI) equivalents.

**NOTE:** In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, the following Technical Publications cross reference table is provided.

Technical Publications Cross Reference Table

| Publication             | Engine Model(s) | IAE IETM Pub Ref | P&W Part Number |
|-------------------------|-----------------|------------------|-----------------|
| ENGINE MANUAL — A1, A5  | All             | E-V2500-1IA      | 2A4407          |
| CMM-EHC — A1, A5        | All             | EHC-V2500-1IA    | 2A4409          |
| CMM-FN — A1, A5         | All             | FN-V2500-1IA     | 2A4410          |
| CMM-MMC — A1, A5        | All             | MECH-V2500-1IA   | 2A4411          |
| CMM-THD — A1, A5        | All             | THD-V2500-1IA    | 2A4412          |
| TLM — A1, A5            | All             | T-V2500-1IA      | 2A4408          |
| SPPM (SPM) — A1, A5, D5 | All             | SPP-V2500-1IA    | 2A4414          |



| Publication | Engine Model(s)         | IAE IETM Pub Ref | P&W Part Number |
|-------------|-------------------------|------------------|-----------------|
| EIPC — A5   | V2522/V2524/V2527M-AQ02 | S-V2500-6IA      | 2A4428          |
|             | V2522/V2524/V2527M-AQ03 | S-V2500-6IB      |                 |
|             | V2522/V2524/V2527M-SQ02 | S-V2500-6SA      |                 |
|             | V2522/V2524/V2527M-SQ03 | S-V2500-6SB      |                 |
|             | V2522/V2524/V2527M-SQ04 | S-V2500-6NA      |                 |
|             | V2522/V2524/V2527M-SQ05 | S-V2500-6NB      |                 |
|             | V2527/V2527E-AQ02       | S-V2500-7IA      |                 |
|             | V2527/V2527E-AQ03       | S-V2500-7IB      |                 |
|             | V2527/V2527E-SQ02       | S-V2500-7SA      |                 |
|             | V2527/V2527E-SQ03       | S-V2500-7SB      |                 |
|             | V2527/V2527E-SQ04       | S-V2500-7NA      |                 |
|             | V2527/V2527E-SQ05       | S-V2500-7NB      |                 |
|             | V2530-AQ02              | S-V2500-2IA      |                 |
|             | V2530-AQ03              | S-V2500-2IB      |                 |
|             | V2530-SQ02              | S-V2500-2SA      |                 |
|             | V2530-SQ03              | S-V2500-2SB      |                 |
|             | V2530-SQ04              | S-V2500-2NA      |                 |
|             | V2530-SQ05              | S-V2500-2NB      |                 |
|             | V2533-AQ02              | S-V2500-5IA      |                 |
|             | V2533-AQ03              | S-V2500-5IB      |                 |
|             | V2533-SQ02              | S-V2500-5SA      |                 |
|             | V2533-SQ03              | S-V2500-5SB      |                 |
|             | V2533-SQ04              | S-V2500-5NA      |                 |
|             | V2533-SQ05              | S-V2500-5NB      |                 |