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V2500-A1/A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Revision 4 of Service Bulletin V2500-ENG-72-0567.

Document History

Service Bulletin Revision Status

Initial Issue.	Nov.27/08.
Revision 1.	May 11/09.
Revision 2.	May 3/10.
Revision 3.	May 29/13.

Service Bulletin Revision 4

Remove	Incorporate	Reason for change
All Pages of the Service Bulletin.	Pages 1 to 7 of the Service Bulletin.	To revise Disposition Code (A).
All Pages of the Supplement.	Page 1 of the Supplement.	No change.

V2500-ENG-72-0567
Transmittal - Page 1 of 1

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise IAE International Aero Engines AG

ENGINE – LOW PRESSURE (LP) TURBINE – INTRODUCTION OF NEW INNER AIRSEAL STAGE 6 WITH 4
VENTILATION HOLES, FOR BEARING NO.5 COMPARTMENT

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5 Engines from Serial No. V13020 onwards.

(b) V2522-A5, V2524-A5 Engines from Serial No. V15003 onwards.

(2) Airbus A320

(a) V2500-A1 Engines from Serial No. V0362 onwards.

(b) V2527-A5, V2527E-A5, V2527M-A5 Engines from Serial No. V13020 onwards.

(c) V2527-A5, V2527E-A5, V2527M-A5 Engines from Serial No. V15003 onwards.

(3) Airbus A321

(a) V2530-A5, V2533-A5 Engines from Serial No. V13020 onwards.

(b) V2530-A5, V2533-A5 Engines from Serial No. V15003 onwards.

(4) Boeing MD-90

(a) V2525-D5, V2528-D5 from Engine Serial No. V20286 onwards.

B. Concurrent Requirements

This Service Bulletin must not be incorporated before the following Service Bulletin has been incorporated:

V2500-ENG-79-0093.

ENGINE – OIL – TO ANNOUNCE A NEW SCAVENGE OIL PUMP WITH IMPROVED COMPARTMENT
NO.5 SCAVENGING PERFORMANCE

C. Reason

Introduction of new Inner Airseal Stage 6 with 4 ventilation holes in order to eliminate pressure reversal in bearing No.5 compartment and thus to avoid tailpipe smoke.



(1) Background

A number of V2500-A1/A5/D5 powered Aircraft have experienced tailpipe smoke during aborted takeoffs.

(2) Objective

A new No.5 compartment Inner Airseal Stage 6 with 4 through holes will provide correct buffer air pressure for the Bearing Chamber. This change must be incorporated with an improved oil scavenge Pump (Refer to paragraph 1.B. "Concurrent Requirements").

(3) Substantiation

The new Inner Airseal Stage 6 was successfully tested in a development engine.

(4) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Affected.

(e) Interchangeability

Affected – Refer to paragraph 1.B. Concurrent Requirements.

(f) Fits and Clearances

Not affected.

(5) Supplementary Information

None.

D. Description

Introduction of new Inner Airseal Stage 6 with 4 ventilation holes.

E. Compliance

Category Code 8

Accomplish based upon experience with the prior configuration.

F. Approval

The part number changes and/or part modification described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Models listed.

G. Manpower

(1) In Service

Not applicable.

(2) At Overhaul

Not applicable.

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

H. Material Price and Availability

(1) Modification kit is not required.

(2) Refer "Material Information" section for availability.

For prices see Supplement of this Service Bulletin.

I. Tooling Price and Availability

None.

J. Industry Support Information

None.

K. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No effect.

(3) Datum

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

L. Electrical Load Data

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

M. Software Accomplishment Summary

Not applicable.

N. References

(1) Internal Reference No.:

Engineering Change No. 07VM008, 07VM008-01, 07VM008-02, 07VM008-03,
07VM008-04 and 07VM008A.

O. Other Publications Affected

- (1) V2500 Engine Manual Chapter/Section 72-50-00, Cleaning, to add the new Part Numbers.
- (2) V2500 Engine Manual Chapter/Section 72-50-00, Inspection/Check, to add the new Part Numbers.
- (3) V2500 Engine Manual Chapter/Sections 72-50-00, Repair, to add the new Part Numbers.
- (4) The V2500-A1/A5/D5 Engine Illustrated Parts Catalogs (S-V2500-1IA, S-V2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, S-V2500-7IB) will be revised to include the new part. Refer to Section 2. Material Information for ATA Locations.
- (5) IAE V2500-A5 SelectOne™ Engine Illustrated Parts Catalogs (S-V2500-2SA, S-V2500-2SB, S-V2500-5SA, S-V2500-5SB, S-V2500-6SA, S-V2500-6SB, S-V2500-7SA, S-V2500-7SB) will be revised to include the new part. Refer to Section 2. "Material Information" for ATA Locations.
- (6) V2500 Time Limits Manual (TLM).
 - (a) For the effect on declared life, the V2500 A1/A5 Time Limit Manual (T-V2500-1IA) Section 05-10-01, Group A Parts Life following TASKs will be updated:

05-10-01-200-001-A00 for V2500-A1 Engines.

05-10-01-200-001-B00 for A5 V2527E/V2530 Engines.

05-10-01-200-001-C00 for A5 V2522/V2524/2527/V2527M Engines.

05-10-01-200-001-D00 for A5 V2533 Engines.

05-10-01-200-001-E00 for A5 V2527E/V2530 SelectOne™ Engines.

05-10-01-200-001-F00 for A5 V2522/V2524/V2527/V2527M SelectOne™ Engines.

05-10-01-200-001-G00 for A5 V2533 SelectOne™ Engines.

- (b) For the effect on declared life, the V2500 D5 Time Limit Manual (T-V2500-3IA) Section 05-10-01, Group A Parts Life following TASKs will be updated:

05-10-01-200-001-A00 for V2500 D5 V2525 Engines.

05-10-01-200-001-B00 for V2500 D5 V2528 Engines.

P. Interchangeability of Parts

Affected – Refer to Section 2. "Material Information".

2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts to be reworked:

Not applicable.

C. New production parts:

See supplement of this Service Bulletin.

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
A1/A5/D5 Engines:						
72-50-00						
01-240	3A3063	1	Seal Air, Turbine, Inner , Stage 6	-	3A0078	(A)(B)(S1)

D. Instruction and Disposition Codes:

R (A) Old part will continue to be supplied until stock is exhausted.

(B) New part is spareable for refurbishment only.

(S1) Old and new part are not interchangeable.

NOTE: The configuration "new Inner Airseal Stage 6" with "old Scavenge Pump" (pre SBE 79-0093) is not permitted due to impact to the required correct buffer air.

3. Accomplishment Instructions

A. Examine LP-Turbine Module number after accomplishment of this Service Bulletin as subsequent given.

- (1) Make sure that the module part number reflect the correct module numbering as given below.
- (2) If required cross out old number and reidentify the module with the new number as given below (Refer to SPP TASK 70-09-00-400-501).

Use vibro-peening method.

A1 Engines:

NEW PART NUMBER	OLD PART NUMBER
4W5222	4W5192

A5 Engines 22 to 30k

NEW PART NUMBER	OLD PART NUMBER
4W5227	4W6423

A5 Engines 33k

NEW PART NUMBER	OLD PART NUMBER
4W5224	4W6243

A5 SelectOne™
Engines

NEW PART NUMBER	OLD PART NUMBER
4W5225	4W6253

D5 Engines:

NEW PART NUMBER	OLD PART NUMBER
4W5223	4W6427

B. Assembly Instructions

- (1) None.

C. Recording Instructions

- (1) A record of accomplishment is required.

ENGINE - LOW PRESSURE (LP) TURBINE - INTRODUCTION OF NEW INNER AIRSEAL STAGE 6 WITH 4
VENTILATION HOLES, FOR BEARING NO.5 COMPARTMENT

SUPPLEMENT - PRICES AND AVAILABILITY

The prices (if shown) are for estimating purposes only and as such are given in good faith, without commercial liability for advanced planning purposes only. Refer to IAE Spares and/or current price catalogue for current prices.

1. Modification Kit:

Not applicable.

2. New Production Parts:

Part No.	Description	Unit Price US Dollars
3A3063	Seal Air, Turbine, Inner, Stg.6	24,550.00

3. Tools

None.



International Aero Engines

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- Quality rating of the Accomplishment Instructions	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
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- Is this Service Bulletin easy to understand ?	<input type="checkbox"/> Yes	<input type="checkbox"/> No			

If you have had difficulties to perform this Service Bulletin please quote below the area(s) and give a short description of the issue:

Planning Information Section:		Material Information Section:	Accomplishment Instruction Section:
<input type="checkbox"/> 1.A.	<input type="checkbox"/> 1.I.	<input type="checkbox"/> 2.A.	<input type="checkbox"/> General
<input type="checkbox"/> 1.B.	<input type="checkbox"/> 1.J.	<input type="checkbox"/> 2.B.	<input type="checkbox"/> Get Access
<input type="checkbox"/> 1.C.	<input type="checkbox"/> 1.K.	<input type="checkbox"/> 2.C.	<input type="checkbox"/> Removal/Installation
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<input type="checkbox"/> 1.F.	<input type="checkbox"/> 1.N.	<input type="checkbox"/> 2.F.	<input type="checkbox"/> Close the Access
<input type="checkbox"/> 1.G.	<input type="checkbox"/> 1.O.		<input type="checkbox"/> Log Book Entry
<input type="checkbox"/> 1.H.	<input type="checkbox"/> 1.P.		

Explanatory notes:

Operator:	Overhaul Site:
Name/Title:	Date:

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Email: GPIAECUSTCOM@IAEV2500.COM**