

# SERVICE BULLETIN REVISION NOTICE

NON-MODIFICATION — ENGINE — HIGH PRESSURE (HP) COMPRESSOR — STAGE 3 TO  
8 COMPRESSOR DRUM — ULTRASONIC INSPECTION PROCEDURE AND STAGE 3 TO 8  
COMPRESSOR DRUM REPLACEMENT NON-MODIFICATION SERVICE BULLETIN

Turbojet Engine Service Bulletin No. V2500-ENG-72-0594 Revision No. 8 dated February 13, 2020.

## Revision History

Original Issue dated May 20, 2009

Revision 1 dated June 5, 2009

Revision 2 dated June 11, 2009

Revision 3 dated August 7, 2009

Revision 4 dated October 13, 2009

Revision 5 dated November 23, 2009

Revision 6 dated April 12, 2010

Revision 7 dated June 19, 2012

Revision 8 dated February 13, 2020

## Reason for the Revision

The information contained in this Service Bulletin is replaced by the instructions supplied in the latest revision of Reference No. 1, Service Bulletin No. V2500-ENG-72-A0615. It is not necessary to do this Service Bulletin.

## Effect of Revision on Prior Compliance

None

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

The format of this Service Bulletin has been changed from Revision 7. See Reason for the Revision above.

## MODEL APPLICATION

V2500-A5

## BULLETIN ISSUE SEQUENCE

V2500 Series 72-0594

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## Revision No.

8

## Date

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**A copy of this Revision Notice and any future revision notices must be filed as a permanent record with your copy of the subject bulletin.**

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MODEL APPLICATION  
V2500-A5

BULLETIN ISSUE SEQUENCE  
V2500 Series 72-0594

ATA NUMBER  
72-00-00

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Compliance Category

NA

IAE Distribution Code

V2500

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## Summary

The information contained in this Non-Modification Service Bulletin is replaced by the instructions supplied in the latest revision of Reference No. 1, Service Bulletin No. V2500-ENG-72-A0615. It is not necessary to do this Non-Modification Service Bulletin.

## Planning Information

### Effectivity Data

**NOTE:** All data contained in this Non-Modification Service Bulletin has been updated and incorporated into Non-Modification Service Bulletin V2500-ENG-72-0615 Revision 3 dated Sep 20/11.

### Engine Models Applicable

Airbus A319, A320, A321

V2500-A5 Engines specified by engine serial number below are the engines that required inspection:

Group A Engine Serial Nos. V10001, V10096, V10101, V10102, V10103, V10474, V10475, V10478, V10481, V10518, V11482, V11516, V11521, V11788, V11840, V11842, V11848, V11849, V11939, V11980, V12038, V12042, V12044, V12120, V12122, V12129, V12131, V12142, V12148, V12150, V12166, V12168, V12174, V12178, V12223, V12227, V12242, V12252, V12263, V12270, V12289, V12294, V12314, V12330, V12345, V12352, V12354, V12373, V12377, V12389, V12391, V12394, V12396, V12400, V12406, V12408, V12414, V12416, V12420, V12425, V12427, V12443, V12451, V12477, V12480, V12488, V12489, V12495, V12524, V12539, V12541, V12543, V12567, V12569, V12573, V12575, V12576, V12601, V12603, V12620, V12623, V12646, V12652, V12668, V12686, V12703, V12705, V12721, V12725, V12751, V12753, V12756, V12758, V12763, V12765, V12768, V12772, V12774, V12775, V12793, V12795, V12849, V12851, V12879, V12881, V12884, V12888, V12921, V12930, V12934, V12968, V12977, V13137, V15003, V15004, V15006, V15009, V15033, and V15050.

**NOTE:** Group A engines are those which are currently, or were formerly, stationed and operated in India.

**NOTE:** Group A engine serial numbers were included in the initial issue and were updated as part of Revision 5.

Group B Engine Serial Nos. V10196, V10403, V10408, V10433, V10434, V10509, V10532, V10533, V10563, V10588, V10590, V10595, V10597, V10609, V10616, V10687, V10717, V10726, V10727, V10728, V10919, V10920, V10950, V10953, V10959, V11048, V11053, V11073, V11082, V11084, V11135, V11137, V11155, V11166, V11197, V11227, V11230, V11351, V11353, V11408, V11410, V11411, V11412, V11418, V11419, V11421, V11423, V11430, V11436, V11437, V11438, V11443, V11444, V11472, V11474, V11493, V11495, V11499, V11502, V11536, V11541, V11558, V11560, V11577, V11579, V11619, V11623, V11628, V11630, V11631, V11639, V11650, V11655, V11660, V11664, V11668, V11669, V11671, V11672, V11674, V11677, V11698, V11710, V11714, V11716, V11763, V11765, V11792, V11796, V11798, V11806, V11811, V11815, V11898, V11900, V12025, V12027, V12055, V12057, V12091, V12093, V12149, V12158, V12159, V12177, V12195, V12197, V12216, V12221, V12224, V12226, V12264, V12267, V12272, V12277, V12284, V12305, V12307, V12312, V12316, V12426, V12428, V12433, V12435, V12437, V12456, V12462, V12465, V12467, V12486, V12540, V12544, V12578, V12594, V12599, V12616, V12730, V12732, V12762, V12800, V12804, V12806, V12845, V12847, V12864, V12867, V12871, V12892, V12894, V12913, V12918, V12931, V12933, V12949, V12953, V12996,

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V13005, V13033, V13034, V13035, V13040, V13042, V13062, V13064, V13066, V13068, V13074, V13080, V13106, V13117, V15056, V15058, V15080, V15081, V15082, V15083, V15130, V15132, and V15192.

NOTE: Group B engines are those which are currently flying into India.

NOTE: Group B engine serial numbers were added as part of Revision 1 and were updated as part of Revision 5.

Group C Engine Serial Nos. V10107, V10108, V10138, V10181, V10184, V10251, V10260, V10261, V10294, V10321, V10382, V10383, V10417, V10422, V10423, V10440, V10459, V10462, V10463, V10496, V10557, V10559, V10592, V10594, V10602, V10607, V10627, V10628, V10635, V10706, V11310, V11509, V11510, V11513, V11518, V11523, V11533, V11535, V11537, V11572, V11582, V11583, V11615, V11784, V11799, V11816, V11818, V11869, V11879, V11884, V12082, and V12084.

NOTE: Group C engines are those which have previously flown into India.

NOTE: Group C engine serial numbers were added as part of Revision 1.

Group D Engine Serial Nos. V10004, V10195, V10204, V10341, V10503, V10519, V10531, V10937, V11899, V11904, V11917, V11937, V11978, V11982, V11999, V12000, V12002, V12037, V12041, V12327, V12333, V12347, V12404, V12412, V12432, V12445, V12586, V12723, V12754, V13071, V13124, V13170, V13171, V15001, V15007, V15104, V15111, V15161, V15162, V15168, V15191, V15205, V15207, and V15216.

NOTE: Group D was updated as part of Revision 5 and contained engines that have been introduced to India since Revision 2, or have had new or used cleaned drums fitted with pre-SB 72-0596 (non-silver coated nuts).

NOTE: Any additional engine prior to ESN V13182 (V25xxAQ0y, A5 engines\*) or V15246 (V25xxSQ0y\*, A5 SelectOne Production standard engines) entering service to be stationed and operated in India after 27-Aug-09 should be considered part of Group D.

For the determination of HPC stage 3 – 8 drum cycles, relevant to the compliance times on Group D engines with drums that were previously stationed and operated in India, the cycles should be considered equal to the number of cycles flown since first operating in India.

These conditions applied unless the engine meets the requirements of para D.(1). upon entering service in India.

\*Where "x" indicated the rating and 2y" indicated the FMU standard.

NOTE: If a drum had been replaced and the replacement had never flown into India, Non-Modification Service Bulletin inspection was not required.

Group E Engine Serial Nos. V11720, V11722, V11772, V11774, V11986, V12013, and V12193.

NOTE: Group E engines are sampling engines, they were added as part of Revision 6.

#### Concurrent Requirements

There are no concurrent requirements.

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### Reason

1. Condition: Crack indications had been found on High Pressure Compressor (HPC) 3 – 8 drums during overhaul. The indications were highlighted during an Engine Manual (EM) crack inspection procedure of the stage 7 – 8 disc internal cavity.
2. Background: None.
3. Objective: None.
4. Substantiation: None.
5. Effects of Bulletin on:
  - Removal/Installation: Not Affected.
  - Disassembly/Assembly: Not Affected.
  - Cleaning: Not Affected.
  - Inspection/Check: Not Affected.
  - Repair: Not Affected.
  - Testing: Not Affected.
6. Supplemental Information
  - None.

### Description

None – Action superseded.

### Compliance

None – Action superseded.

### Approval Data

The intent to supersede this Non-Modification Service Bulletin V2500-ENG-72-0594 has been shown to comply with the applicable Federal Aviation Regulations and is FAA APPROVED for the engine models listed.

The information contained in this Non-Modification Service Bulletin is replaced by the instructions specified in the latest revision of Reference No. 1, Non-Modification Service Bulletin No. V2500-ENG-72-A0615. It is not necessary to do this Non-Modification Service Bulletin.

### Manpower

None – Action superseded.

### Weight and Balance

Not changed.

### Electrical Load Data

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

### Software Accomplishment Summary

Not Applicable.

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#### References

1. IAE V2500 Non-Modification Service Bulletin V2500-ENG-72-A0615 — Engine — High Pressure (HP) Stage 3 To 8 Compressor Drum — Ultrasonic Inspection Procedure And Stage 3 To 8 Compressor Drum Replacement.
2. Internal Reference No. EC09VR837G.

#### Other Publications Affected

None.

#### Interchangeability of Parts

Not Applicable.

#### 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. The information contained in this Non-Modification Service Bulletin is replaced by the instructions specified in the latest revision of Reference No. 1, Non-Modification Service Bulletin No. V2500-ENG-72-A0615. It is not necessary to do this Non-Modification Service Bulletin.

### Industry Support Program

Not Applicable.

### Tooling — Price and Availability

Special tools are not required to accomplish this Service Bulletin.

### Reidentified Parts

Not Applicable.

### Other Material Information Data

Not Applicable.

## Modification and Spares Information

### Parts Modification Conditions

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

Not Applicable.

### Vendor Services or Special Components/Materials

Not Applicable.



#### Accomplishment Instructions

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## Appendix

### Added Data

#### Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC09VR837G	RR
1	EC09VR837G	RR
2	EC09VR837G	RR
3	EC09VR837G	RR
4	EC09VR837G	RR
5	EC09VR837G	RR
6	EC09VR837G	RR
7	EC09VR837G	RR
8	EA19VG375	JM/RCM

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

To calculate part life, include the hours and/or cycles since the part was made. Use the total hours or cycles to calculate life limits that are the result of part modification, a part used in an engine with different thrust, or for some other reason.

**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

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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	