



**International Aero Engines
NON-MODIFICATION
SERVICE BULLETIN**

Date: July 15/09

**NON-MODIFICATION SERVICE BULLETIN – ENGINE – HP COMPRESSOR BLADES -
INSPECTION OF THE HPC STAGE 8 LOCKING BLADE CORNER RADIUS**

V2500-A5 SERIES PROPULSION SYSTEM NON-MODIFICATION SERVICE BULLETIN

This document transmits the Initial Issue of Non-Modification Service Bulletin V2500-ENG-72-0599.

Initial Issue

Remove

Incorporate

Reason for change

Pages 1 to 6 of
the Service Bulletin

Initial Issue

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**NON-MODIFICATION SERVICE BULLETIN – ENGINE – HP COMPRESSOR BLADES -
INSPECTION OF THE HPC STAGE 8 LOCKING BLADE CORNER RADIUS****1. Planning Information****A. Effectivity**

(1) Airbus A319, A320, A321

(a) V2500-A5 Engines from Serial Number V12220 to V13160.

B. Concurrent Requirements

None.

C. Reason

During manufacture, the corner radii in some of the right and left hand stage 8 rotor locking blades were machined to tighter radii than required (0.09 mm instead of 0.9 mm). The tight radii could initiate cracks resulting in the release of a small portion of the platform into the gas path.

D. Description

This Non-Modification Service Bulletin details the inspection procedure for the affected HPC stage 8 locking blades during overhaul.

E. Compliance

Category 6

Accomplish when the Sub-Assembly is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

F. Approval

The compliance statement at paragraph E. (Compliance) and the procedures in Section 3 (Accomplishment Instructions) of this non-modification service bulletin comply with the Federal Aviation Regulations and are FAA-approved for the engine model listed.

G. References

- (1) IAE V2500 Engine Manual, Chapters 72-00-40, 72-41-00, 72-41-10 and 72-41-15.
- (2) V2500 Standard Practices/Processes Manual, Chapters 70-09-00, 70-21-00 and 70-22-03.

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- (3) V2500 Overhaul Processes and Consumable Index, Section 06.
- (4) Engineering Change No. 09VR892
- (5) ATA locator 72-41-15.

H. Manpower

Estimate of man-hours necessary to embody this Non-Modification Service Bulletin in full:

- (1) In Service

Not affected.

- (2) At overhaul

One hour for inspection of four HPC stage 8 rotor locking blades.

I. Tools and Equipment

Radius gauge capable to measure radii of less than 1 mm.

2. Material Information

None.

3. Accomplishment Instructions

A. Examine the HP Compressor Stage 8 Rotor Locking Blades

- (1) Examine the HP Compressor stage 8 rotor locking blade slots at inspection location 10 in accordance with SUBTASK 72-41-15-222-095
 - (a) Visually examine the locking slot corner radius as shown in figure 1 and 2.
 - (b) Measure the corner radius with a radius gauge
 - (c) Radius 0.9 ± 0.2 mm Accept
 - (d) Other than A. (1) (c) Reject the locking blade.

Visually examine the blade corner radius for cracks. If cracked, measure the crack length and take a photo.
 - (e) Mark all HPC stage 8 rotor locking blades that failed inspection as unserviceable and scrap.
 - (f) Complete the Accomplishment Proforma to record the number of HPC stage 8 rotor locking blades that have been rejected due to a non-conforming corner radius at location 10.

B. Record of Accomplishment

- (1) Record “NMSB-ENG-72-0599” in the applicable engine records
- (2) Complete the Accomplishment Proforma on page 5 of this Non-Modification Service Bulletin.
 - (a) When the accomplishment instructions are completed, inform the local IAE office that this Non-Modification-Service Bulletin has been accomplished.
 - (b) Pass the Accomplishment Proforma and pictures to the local IAE office.

C. Affected part numbers

- | | |
|------------|---------------------|
| (1) 6A6464 | (L/H Locking Blade) |
| (2) 6A6465 | (R/H Locking Blade) |

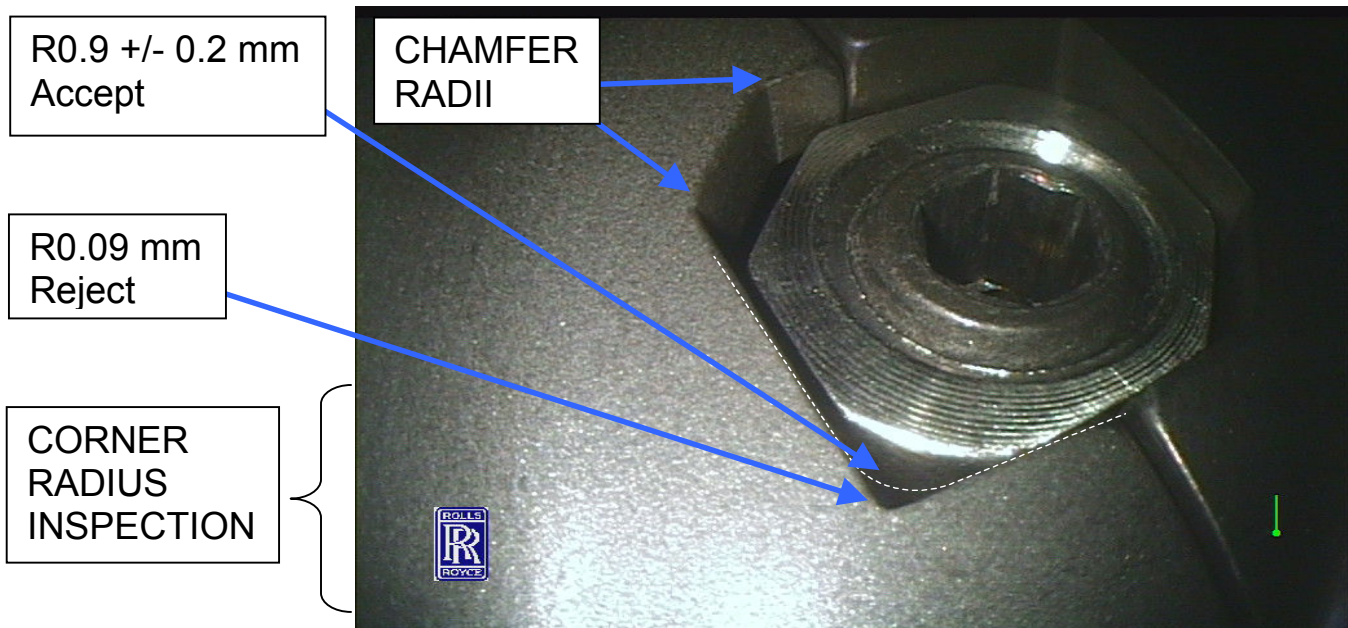


Figure 1: Appearance of the blade locking slot corner radius
Example of blade that fails inspection and is unserviceable

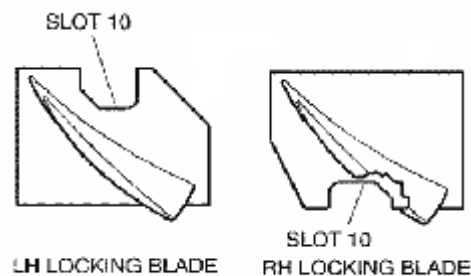


Figure 2: Stage 8 rotor locking blade inspection location 10

Stage 8 Blade Inspection Accomplishment Proforma

Engine Details

Engine Serial Number: _____ TSN: _____ CSN: _____

Number of locking blades that failed corner radius inspection: _____

TSN: _____ CSN: _____

Overhaul shop: _____

Number of locking blades with cracks at corner radius: None ☐ one ☐ two ☐

If cracked, measured crack length: _____

**NOTE: The IAE Local Rep. Should send the Proforma via PSComm
with topic “HPC: Rotating”**

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