



628 Hebron Avenue, Suite 400
 Glastonbury, CT 06033, USA.
 Tel: +1 (860) 368-3823
 Fax: +1 (860) 755-6876

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V2500-A1/A5/D5 PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Initial Issue of Service Bulletin V2500-ENG-72-0628.

Service Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 36 of the Service Bulletin.	Initial Issue.
	Pages 1 to 20 of the Appendix 1.	Initial Issue.
	Page 1 of the Appendix 2.	Initial Issue.
	Pages 1 to 2 of the Supplement.	Initial Issue.

V2500-ENG-72-0628
 Transmittal - Page 1 of 1

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ENGINE – INNER AND OUTER COMBUSTION CHAMBER LINERS WITH IMPROVED CHEMISTRY TO REDUCE
OXIDATION

1. Planning Information

A. Effectivity Data

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5

Engines from Serial No. V10001 thru V13190.

(b) V2522-A5, V2524-A5, V2527M-A5

Engines from Serial No. V15001 thru V16516, V16518, V16520, V16522 and V16524.

(2) Airbus A320

(a) V2500-A1

Engine Serial Nos. V0001 thru V0361.

(b) V2527-A5, V2527E-A5

Engines from Serial No. V10001 thru V13190.

(c) V2527-A5, V2527E-A5

Engine from Serial No. V15001 thru V16516, V16518, V16520, V16522 and V16524.

(3) Airbus A321

(a) V2530-A5, V2533-A5

Engine from Serial No. V10001 thru V13190.

(b) V2530-A5, V2533-A5

Engines from Serial No. V15001 thru V16516, V16518, V16520, V16522 and V16524.

(4) Boeing MD-90

(a) V2525-D5, V2528-D5

Engine Serial No. V20001 thru V20285.

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason**(1) Condition:**

Multiple V2500 operators are experiencing engine removals due to oxidation of combustor liner segments.

(2) Background:

Operating temperatures in the combustor lead to oxidation and burnback of combustor liner segments.

(3) Objective:

Incorporate a material with revised chemistry for the combustor liner inner and outer segments in order to increase oxidation resistance, improve combustor durability and extend time on wing.

(4) Substantiation:

Alloy characteristics testing has demonstrated that the revised chemistry alloy provides a significant benefit in oxidation life.

(5) Effects of Bulletin on:**(a) Removal/Installation:**

Not affected.

(b) Disassembly/Assembly:

Not affected.

(c) Cleaning:

Not affected.

(d) Inspection/Check:

Not affected.

(e) Repair:

Not affected.

(f) Testing:

Not affected.

(6) Supplemental Information

None.

D. Description

Replace the combustion chamber liner segments on rows 1 thru 4 or 1 thru 5 of the inner and outer combustion chamber assemblies.

E. Compliance

Category 7

Accomplish when supply of superseded parts has been depleted

F. Approval Data

The part number changes and/or part modifications specified in the Accomplishment Instructions and Material Information sections of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

G. Manpower

(1) In Service

(a) Not Applicable

(2) At Overhaul

(a) Outer Combustion Chamber Assembly and Marking Procedure: 7 hours

(b) Inner Combustion Chamber Assembly and Marking Procedure: 5 hours

(c) Total Necessary Man-hours: 12 hours

H. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No effect.

(3) Datum

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

I. Electrical Load Data

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

J. Software Accomplishment Summary

Not Applicable.

K. References

- (1) IAE V2500 Service Bulletin V2500-ENG-70-0253 (Information - Engine - Diffuser And Combustion Section - Provide New Inner And Outer Combustion Chambers With Increased Hardface Thickness And Relocated Cooling Holes).
- (2) IAE V2500 Service Bulletin V2500-ENG-70-0995 (Information - Engine - Inner And Outer Combustion Chamber Liners With Addition Of Single Crystal Material On Rows 3 And 4).
- (3) IAE V2500 Service Bulletin V2500-ENG-72-0006 (Engine - Diffuser And Combustion Group And Stage 1 Turbine Nozzle Assembly - Thermal Barrier Coating For Combustion Liners).
- (4) IAE V2500 Service Bulletin V2500-ENG-72-0060 (Engine - Diffuser And Combustion And Stage 1 Turbine Nozzle Assembly - Introduce Thermal Barrier Coating On Inner And Outer Combustion Chamber Liners).
- (5) IAE V2500 Service Bulletin V2500-ENG-72-0116 (Engine - Diffuser And Combustion Group And Stage 1 Turbine Nozzle Assembly - Provide New Inner And Outer Combustion Chamber With Generation II Liner Segments).
- (6) IAE V2500 Service Bulletin V2500-ENG-72-0239 (Engine - Diffuser And Combustor Group - Provide New Diffuser Group Adapters And Tube Assemblies).
- (7) IAE V2500 Service Bulletin V2500-ENG-72-0241 (Engine - Stage 1 Turbine Nozzle Assembly - Provide A New Stage 1 HPT Cooling Duct Assembly And Segments).
- (8) IAE V2500 Service Bulletin V2500-ENG-72-0315 (Engine - Diffuser And Combustion Group And Stage 1 Turbine Nozzle Assembly - Provide New Inner And Outer Combustion Chamber Liners with Addition of PWA 281 Coating).
- (9) IAE V2500 Service Bulletin V2500-ENG-72-0330 (Engine - Diffuser And Combustion Group - Provide New Bulkhead Liner Segments).
- (10) IAE V2500 Service Bulletin V2500-ENG-72-0331 (Engine - Diffuser And Combustion Group - Provide New Fuel Nozzle Guides).

- (11) IAE V2500 Service Bulletin V2500-ENG-72-0447 (Engine - Inner And Outer Combustion Chamber Liners With Addition Of Single Crystal Material On Rows 3 And 4).
- (12) IAE V2500 Service Bulletin V2500-ENG-72-0475 (Engine - HP Turbine Rotor Assembly - Introduce New First Stage Turbine Blades And Stage 1 HPT Cooling Duct Assembly With Decreased Flow).
- (13) IAE V2500 Service Bulletin V2500-ENG-72-0483 (Engine - New First Stage Duct Segments And HPT Vane Support).
- (14) IAE V2500 Service Bulletin V2500-ENG-72-0562 (Engine - High Pressure Turbine (HPT) - V2500 SelectOne™ Production And Retrofit - HPT Upgrade).
- (15) IAE V2500 Service Bulletin V2500-ENG-73-0131 (Engine - Fuel And Control - Replace Certain Fuel Nozzle Supply Manifold Assemblies And The Related Attaching Hardware).
- (16) IAE V2500 Service Bulletin V2500-ENG-79-0088 (Oil - Scavenge Oil Tubes - Re-Route Of Number 4 Bearing Scavenge Tube).
- (17) V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA, SV2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA and S-V2500-7IB), Chapter/Section 72-42-61, Figure 01 and 72-44-30, Figure 01.
- (18) V2500 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 and S-V2500-7SB), Chapter/Section 72-42-61, Figure 01 and 72-44-30, Figure 01.
- (19) V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30.
- (20) V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30.
- (21) V2500 Standard Practices/Processes Manual, Chapter/Section 70-09-00.
- (22) Internal Reference No. - 10VA001, 10VA001-01, 10VA001-02, 10VA001-03, 10VA001K, 10VA001Y, 10VA001Y-01, 12VK010, 12VK010A and 12VK010B.
- (23) ATA Locator - 72-40-00.

L. Other Publications Affected

- (1) V2500 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 and S-V2500-7IB), Chapter/Section 72-42-61, Figure 01 and 72-44-30, Figure 01.
- (2) V2500 Engine Manuals (E-V2500-1IA and E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30, Cleaning, Inspection and Repair, to add the new part.

M. Interchangeability of Parts

Old and new parts are directly interchangeable, however, to achieve the full benefit of this Service Bulletin it is recommended that new parts be incorporated in full sets.

Liner segments can be replaced individually or in sets at the operator's discretion, however, re-identification of the chamber assembly is not permissible unless fully incorporating the new part number for rows 1 thru 4 or 1 thru 5.

N. Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (Yes)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

2. Material Information

A. Material – Price and Availability

Modification kit is not required.

For Price and Availability of spares refer to the supplement of this Service Bulletin.

B. Industry Support Program

Not Applicable.

C. For V2500-A1 Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-42-61						
01-501	2A4309-01	1	.COMBUSTION CHAMBER ASSEMBLY – OUTER	-	2A3441-01	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-620	2A4295	10	..LINER SEGMENT, CC, 3 OD	-	2A3348	(2)(B1)(L)(I)
01-610	2A4297	10	..LINER SEGMENT, CC, 4 OD	-	2A3349	(2)(B3)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-680	2A4299	20	..LINER SEGMENT - BULKHEAD, OD OR	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT - BULKHEAD, OD	-	2A3324	(2)(B2)(L)(I)
72-44-30						
01-401	2A4311-01	1	.COMBUSTION CHAMBER ASSEMBLY - INNER	-	2A3351-01	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-600	2A4306	10	..LINER SEGMENT, CC, 3 ID IGN	-	2A3353	(2)(A)(L)(I)
01-580	2A4307	10	..LINER SEGMENT, CC, 4 ID	-	2A3322	(2)(B1)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)

D. For V2522-A5 (Standard), V2524-A5 (Standard), V2527-A5 (Standard), V2527E-A5 (Standard), V2527M-A5 (Standard), V2530-A5 (Standard) and V2533-A5 (Standard) Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-42-00						
01-001	2A4335	REF	GROUP, DIFFUSER AND COMBUSTION OR	-	2A9700	(1)(M)(R0)
01-001	2A4335	REF	GROUP, DIFFUSER AND COMBUSTION	-	2A4000	(1)(M)(R0)
72-42-61						



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-501	2A3345-002	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)
01-501	2A3345-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)
01-501	2A3345-002	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3345-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)
01-501	2A3440-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A3440-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A4312-01	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(2)(NP)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-001	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-001	(1)(M)(R0)

Aug.31/12

Aug.31/12 Initial Issue

V2500-ENG-72-0628

Page 9

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-002	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-002	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-620	2A4294	10	..LINER SEGMENT, CC, 3 OD	-	2A3316	(2)(A)(L)(I)
01-610	2A4296	10	..LINER SEGMENT, CC, 4 OD	-	2A3317	(2)(A)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD OR	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
01-501	2A3442-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-003	(1)(M)(R0)
01-501	2A3442-008	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-003	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
72-44-00						
01-001	2A4356	REF	GROUP, TURBINE NOZZLE	-	2A3915	(1)(M)(R0)
72-44-30						
01-401	2A4313-01	1	.CHAMBER, ASSEMBLY OF - INNER	-	2A3344-01	(2)(NP)
01-401	2A3344-003	1	.CHAMBER, ASSEMBLY OF - INNER	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-005	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-003	1	.COMBUSTION CHAMBER ASSEMBLY - INNER	-	2A3344-001	(1)(M)(R0)
01-401	2A3344-006	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-001	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-600	2A4305	10	..LINER SEGMENT, CC, 3 ID	-	2A3326	(2)(B1)(L)(I)
01-580	2A4307	10	..LINER SEGMENT, CC, 4 ID	-	2A3322	(2)(B1)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)
01-401	2A3344-004	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER OR	-	2A3344-002	(1)(M)(R0)
01-401	2A3344-007	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-002	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)

E. For V2525-D5 and V2528-D5 Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-42-61						
01-501	2A4312-01	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(2)(NP)
01-501	2A3345-002	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)
01-501	2A3345-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-501	2A3345-002	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3345-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)
01-501	2A3440-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A3440-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-001	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-001	(1)(M)(R0)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-002	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-002	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)

Aug.31/12

Aug.31/12 Initial Issue

V2500-ENG-72-0628

Page 13

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-620	2A4294	10	..LINER SEGMENT, CC, 3 OD	-	2A3316	(2)(A)(L)(I)
01-610	2A4296	10	..LINER SEGMENT, CC, 4 OD	-	2A3317	(2)(A)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD OR	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
01-501	2A3442-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-003	(1)(M)(R0)
01-501	2A3442-008	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-003	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD OR	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
72-44-30						
01-401	2A4313-01	1	.CHAMBER ASSEMBLY OF - INNER OR	-	2A3344-01	(2)(NP)
01-401	2A3344-003	1	.CHAMBER ASSEMBLY OF - INNER OR	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-005	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER OR	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-003	1	.COMBUSTION CHAMBER ASSEMBLY - INNER OR	-	2A3344-001	(1)(M)(R0)
01-401	2A3344-006	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-001	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-600	2A4305	10	..LINER SEGMENT, CC, 3 ID	-	2A3326	(2)(B1)(L)(I)
01-580	2A4307	10	..LINER SEGMENT, CC, 4 ID	-	2A3322	(2)(B1)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)
01-401	2A3344-004	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER OR	-	2A3344-002	(1)(M)(R0)

Aug.31/12

Aug.31/12 Initial Issue

V2500-ENG-72-0628

Page 15

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-401	2A3344-007	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-002	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)

F. For V2522-A5 (SelectOne™), V2524-A5 (SelectOne™), V2527-A5 (SelectOne™), V2527E-A5 (SelectOne™), V2527M-A5 (SelectOne™), V2530-A5 (SelectOne™), V2533-A5 (SelectOne™) Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-42-00						
01-001	2A4335	REF	GROUP, DIFFUSER AND COMBUSTION OR	-	2A9700	(1)(M)(R0)
01-001	2A4335	REF	GROUP, DIFFUSER AND COMBUSTION	-	2A4000	(1)(M)(R0)
72-42-61						
01-501	2A3345-002	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)
01-501	2A3345-003	1	.COMBUSTION CHAMBER, ASSEMBLY - OUTER OR	-	2A3345-01	(1)(M)(R0)
01-501	2A3345-002	1	.COMBUSTION CHAMBER, ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3345-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3345-001	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-501	2A3440-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-01	(1)(M)(R0)
01-501	2A3440-003	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-001	(1)(M)(R0)
01-501	2A3440-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A3440-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3440-002	(1)(M)(R0)
01-501	2A4312-01	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(2)(NP)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-006	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-01	(1)(M)(R0)
01-501	2A3442-004	1	.CHAMBER, ASSEMBLY OF - OUTER OR	-	2A3442-001	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-001	(1)(M)(R0)
01-501	2A3442-004	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER OR	-	2A3442-002	(1)(M)(R0)
01-501	2A3442-007	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-002	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT - 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT - 1 OD	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT - 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT - 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT - 2 OD IGN	-	2A3315	(2)(B2)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-620	2A4294	10	..LINER SEGMENT - 3 OD	-	2A3316	(2)(A)(L)(I)
01-610	2A4296	10	..LINER SEGMENT - 4 OD	-	2A3317	(2)(A)(L)(I)
01-600	2A4298	10	..LINER SEGMENT - 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT - OD BULKHEAD	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
01-501	2A3442-005	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-003	(1)(M)(R0)
01-501	2A3442-008	1	.COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A3442-003	(1)(M)(R0)
01-630	2A4289	9	..LINER SEGMENT, CC, 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT, CC, 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT, CC, 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT, CC, 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-600	2A4298	10	..LINER SEGMENT, CC, 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
72-44-00						
01-001	2A4334	REF	GROUP, TURBINE NOZZLE	-	2A4210	(1)(M)(R0)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-44-30						
01-401	2A4313-01	1	.CHAMBER ASSEMBLY OF - INNER	-	2A3344-01	(2)(NP)
01-401	2A3344-003	1	.CHAMBER ASSEMBLY OF - INNER	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-005	1	.CHAMBER ASSEMBLY OF - INNER	-	2A3344-01	(1)(M)(R0)
01-401	2A3344-003	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-001	(1)(M)(R0)
01-401	2A3344-006	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-001	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-600	2A4305	10	..LINER SEGMENT, CC, 3 ID	-	2A3326	(2)(B1)(L)(I)
01-580	2A4307	10	..LINER SEGMENT, CC, 4 ID	-	2A3322	(2)(B1)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)
01-401	2A3344-004	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-002	(1)(M)(R0)
01-401	2A3344-007	1	.COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A3344-002	(1)(M)(R0)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
72-42-00						
01-001	2A4330	REF	GROUP, DIFFUSER AND COMBUSTION	-	2A0700	(1)(M)(R0)
72-42-61						
01-501	2A4314-01	1	COMBUSTION CHAMBER ASSEMBLY - OUTER	-	2A4284-01	(1)(NP)(N)
01-501	2A4314-001	1	OR COMBUSTION CHAMBER, ASSEMBLY - OUTER	-	2A4284-01	(1)(M)(N)
01-630	2A4289	9	..LINER SEGMENT - 1 OD	-	2A3311	(2)(B2)(L)(I)
01-640	2A4290	1	..LINER SEGMENT - 1 OD IGN	-	2A3312	(2)(B1)(L)(I)
01-650	2A4291	8	..LINER SEGMENT - 2 OD	-	2A3313	(2)(B1)(L)(I)
01-660	2A4292	1	..LINER SEGMENT - 2 OD IGN	-	2A3314	(2)(B1)(L)(I)
01-670	2A4293	1	..LINER SEGMENT - 2 OD IGN	-	2A3315	(2)(B2)(L)(I)
01-600	2A4298	10	..LINER SEGMENT - 5 OD	-	2A3318	(2)(B1)(L)(I)
01-680	2A4299	20	..LINER SEGMENT - OD BULKHEAD	-	2A2452	(2)(B2)(L)(I)
01-680	2A4299	20	OR ..LINER SEGMENT, CC, BULKHEAD	-	2A3324	(2)(B2)(L)(I)
72-44-00						
01-001	2A4333	REF	GROUP, TURBINE NOZZLE	-	2A1500	(1)(M)(R0)
72-44-30						
01-401	2A4315-01	1	.COMBUSTION CHAMBER ASSEMBLY - INNER	-	2A4283-01	(1)(NP)(N)
01-401	2A4315-001	1	OR .COMBUSTION CHAMBER, ASSEMBLY - INNER	-	2A4283-01	(1)(M)(N)
01-540	2A4303	10	..LINER SEGMENT, CC, 1 ID	-	2A3319	(2)(A)(L)(I)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-620	2A4304	10	..LINER SEGMENT, CC, 2 ID	-	2A3320	(2)(A)(L)(I)
01-560	2A4308	10	..LINER SEGMENT, CC, 5 ID	-	2A3323	(2)(B2)(L)(I)

G. Instructions/Disposition Code Statements:

Parts Modification Conditions

(1) The new part can be obtained by modification of the old part as specified in the Accomplishment Instructions.

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

Spare Parts Availability

(A) The new part is available.

(B1) The new part will be available approximately September 30, 2012.

(B2) The new part will be available approximately October 30, 2012.

(B3) The new part will be available approximately January 30, 2013.

(L) The old part will be supplied until the supply is fully used.

(M) It is possible to get the new part only by modification.

(N) The old part is not available.

(NP) The part is an item that is usually not procured as a spare item.

(R0) This is a reference part only and cannot be procured.

Cleaning, Inspection and Repair Information

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

H. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

I. Reidentified Parts

Reidentified Parts Data

New PN	Keyword	Old PN	Model
2A4330	GROUP, DIFFUSER AND COMBUSTION	2A0700	A5 SelectOne™
2A4335	GROUP, DIFFUSER AND COMBUSTION	2A9700	A5 Standard, A5 SelectOne™
2A4355	GROUP, DIFFUSER AND COMBUSTION	2A4000	A5 Standard, A5 SelectOne™
2A4309-01	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3441-01	A1
2A3345-002	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3345-01	A5 Standard, A5 SelectOne™ and D5
2A3345-003	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3345-01	A5 Standard, A5 SelectOne™ and D5
2A3345-002	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3345-001	A5 Standard & A5 SelectOne™ and D5
2A3345-004	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3345-001	A5 Standard, A5 SelectOne™ and D5
2A3440-003	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-01	A5 Standard, A5 SelectOne™ and D5
2A3440-005	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-01	A5 Standard, A5 SelectOne™ and D5
2A3440-003	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-001	A5 Standard, A5 SelectOne™ and D5
2A3440-006	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-001	A5 Standard, A5 SelectOne™ and D5

2A3440-004	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-002	A5 Standard, A5 SelectOne™ and D5
2A3440-007	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3440-002	A5 Standard, A5 SelectOne™ and D5
2A3442-004	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-01	A5 Standard, A5 SelectOne™ and D5
2A3442-006	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-01	A5 Standard, A5 SelectOne™ and D5
2A3442-004	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-001	A5 Standard, A5 SelectOne™ and D5
2A3442-007	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-001	A5 Standard, A5 SelectOne™ and D5
2A3442-004	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-002	A5 Standard, A5 SelectOne™ and D5
2A3442-007	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-002	A5 Standard, A5 SelectOne™ and D5
2A3442-005	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-003	A5 Standard, A5 SelectOne™ and D5
2A3442-008	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A3442-003	A5 Standard, A5 SelectOne™ and D5
2A4314-01	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A4284-01	A5 SelectOne™
2A4314-001	COMBUSTION CHAMBER ASSEMBLY - OUTER	2A4284-01	A5 SelectOne™
2A4356	GROUP, TURBINE NOZZLE	2A3915	A5 Standard
2A4333	GROUP, TURBINE NOZZLE	2A1500	A5 SelectOne™

2A4334	GROUP, TURBINE NOZZLE	2A4210	A5 SelectOne™
2A4311-01	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3351-01	A1
2A3344-003	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-01	A5 Standard, A5 SelectOne™ and D5
2A3344-005	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-01	A5 Standard, A5 SelectOne™ and D5
2A3344-004	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-002	A5 Standard, A5 SelectOne™ and D5
2A3344-007	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-002	A5 Standard, A5 SelectOne™ and D5
2A3344-003	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-001	A5 Standard, A5 SelectOne™ and D5
2A3344-006	COMBUSTION CHAMBER ASSEMBLY - INNER	2A3344-001	A5 Standard, A5 SelectOne™ and D5
2A4315-01	COMBUSTION CHAMBER ASSEMBLY - INNER	2A4283-01	A5 SelectOne™
2A4315-001	COMBUSTION CHAMBER ASSEMBLY - INNER	2A4283-01	A5 SelectOne™

J. Other Material Information Data

Not applicable.

3. Accomplishment Instructions

(1) Outer Combustion Chamber Assembly And Marking Procedure.

- (a) Remove and replace outer liner segments per the procedures specified in Reference 19 or 20, Engine Manual, Chapter/Section 72-42-61, Repair 015 (VRS3540). See Figure 1 for the location of the parts.
- (b) Remove and replace bulkhead liner segments per the procedures specified in Reference 19 or 20, Engine Manual, Chapter/Section 72-42-61, Repair 008 (VRS3096).
- (c) Substitute liner segment part numbers as shown in Table 1-1.

NOTE: Liner segments can be replaced individually or in sets at the operator's discretion; however, re-identification of the chamber assembly is not permissible unless fully incorporating the new part numbers as specified in Table 1-1.

Table 1-1. Liner Segment Part Numbers (Outer Combustion Chamber Assembly)

Old Segment PN	New Segment PN	Outer Liner Segment Description	Quantity per Assembly
2A3311	2A4289	Row 1	9
2A3312	2A4290	Row 1 (Igniter)	1
2A3313	2A4291	Row 2	8
2A3314	2A4292	Row 2 (Igniter)	1
2A3315	2A4293	Row 2 (Igniter)	1
2A3316	2A4294	Row 3	10 (A5 Standard, A5 SelectOne™ and D5)
2A3348	2A4295	Row 3	10 (A1 only)
2A3317	2A4296	Row 4	10 (A5 Standard, A5 SelectOne™ and D5)
2A3349	2A4297	Row 4	10 (A1 only)
*2A3318	*2A4298	Row 5	10
2A2452 or 2A3324	2A4299	Bulkhead Liner Segment	20

NOTE: *Row 5 replacement is optional for re-identification purposes.

- (d) Re-identify the outer combustion chamber assembly only if fully incorporating the new liner segments; however, full incorporation of new Row 5 liner segments is optional. Assembly re-identification numbers are assigned accordingly as shown in Table 1-2. Re-identify using the vibration peen method per Reference 21, Standard Practices and Processes Manual Chapter/Section 70-09-00, Marking of Parts. Locate new part marking adjacent to cancelled part marking.

Table 1-2. Assembly Re-Identification Numbers (Outer Combustion Chamber Assembly)

Old Assembly Part Number	New Assembly PN		Engine Model
	Rows 1 - 5 and Bulkhead are Replaced	Rows 1 - 4 and Bulkhead are Replaced	
2A3441-01	2A4309-01	*	A1
2A3345-01	2A3345-002	2A3345-003	A5 Standard, A5 SelectOne™ and D5
2A3345-001	2A3345-002	2A3345-004	
2A3440-01	2A3440-003	2A3440-005	
2A3440-001	2A3440-003	2A3440-006	
2A3440-002	2A3440-004	2A3440-007	
2A3442-01	2A3442-004	2A3442-006	
2A3442-001	2A3442-004	2A3442-007	
2A3442-002	2A3442-004	2A3442-007	
2A3442-003	**2A3442-005	**2A3442-008	
2A4284-01	**2A4314-01	**2A4314-001	
			A5 SelectOne™

* Signifies no change in part number using new Liner.

** Signifies these part numbers have single crystal liners on rows 3 and 4.

(2) Inner Combustion Chamber Assembly And Marking Procedure.

- (a) Remove and replace inner liner segments per the procedures specified in Reference 19 or 20, Engine Manual, Chapter/Section 72-44-30, Repair 001 (VRS3173). See Figure 2 for the location of the parts.
- (b) Substitute Liner segment part numbers as shown in Table 2-1

NOTE: Liner segments can be replaced individually or in sets at the operator's discretion; however, re-identification of the chamber assembly is not permissible unless fully incorporating the new part numbers as specified in Table 2-1.

Table 2-1. Inner Combustion Chamber Assembly Part Numbers

Old PN	New PN	Inner Liner Segment Description	Quantity per Assembly
2A3319	2A4303	Row 1	10
2A3320	2A4304	Row 2	10
2A3326	2A4305	Row 3	10 (A5 Standard, A5 SelectOne™ and D5)
2A3353	2A4306	Row 3	10 (A1 only)
2A3322	2A4307	Row 4	10
*2A3323	*2A4308	Row 5	10

NOTE: *Row 5 replacement is optional for re-identification purposes.

- (c) Re-identify the inner combustion chamber assembly only if fully incorporating the new liner segments; however, full incorporation of new Row 5 liner segments is optional. Assembly re-identification numbers are assigned accordingly as shown in Table 2-2. Re-identify using the vibration peen method per Reference 21, Standard Practices and Processes Manual Chapter/Section 70-09-00, Marking of Parts. Locate new part marking adjacent to cancelled part marking.

Table 2-2. Assembly Re-Identification Numbers (Inner Combustion Chamber Assembly)

Old Assembly Part Number	New Assembly PN		Engine Model
	Rows 1 - 5 are Replaced	Rows 1 - 4 are Replaced	
2A3351-01	2A4311-01	*	A1
2A3344-01	2A3344-003	2A3344-005	A5 Standard, A5 SelectOne™ and D5
2A3344-001	2A3344-003	2A3344-006	
2A3344-002	**2A3344-004	**2A3344-007	
2A4283-01	**2A4315-01	**2A4315-001	A5 SelectOne™

* Signifies no change in part number using new liner.

** Signifies these part numbers have single crystal liners on rows 3 and 4.

- (3) During engine assembly, identify the modified diffuser and combustion group by the vibration peen method specified in Reference 21, Standard Practices Manual, Chapter/Section 70-09-00, Marking of Parts. Mark the new part number near the old part number as shown in Figure 3. Part number identification is provided in the list that follows:

NOTE: V2500-A1 and V2500-D5 Group part numbers are not re-identified.

Identification of the Diffuser and Combustion Group

New PN	Old PN	Engine Model
2A4330	2A0700	A5 SelectOne™
2A4335	2A9700	A5 Standard and A5 SelectOne™
2A4335	2A4000	A5 Standard and A5 SelectOne™

- (4) During engine assembly, identify the modified turbine nozzle group by the vibration peen method specified in Reference 21, Standard Practices Manual, Chapter/Section 70-09-00, Marking of Parts. Mark the new part number near the old part number as shown in Figure 4. Part number identification is provided in the list that follows:

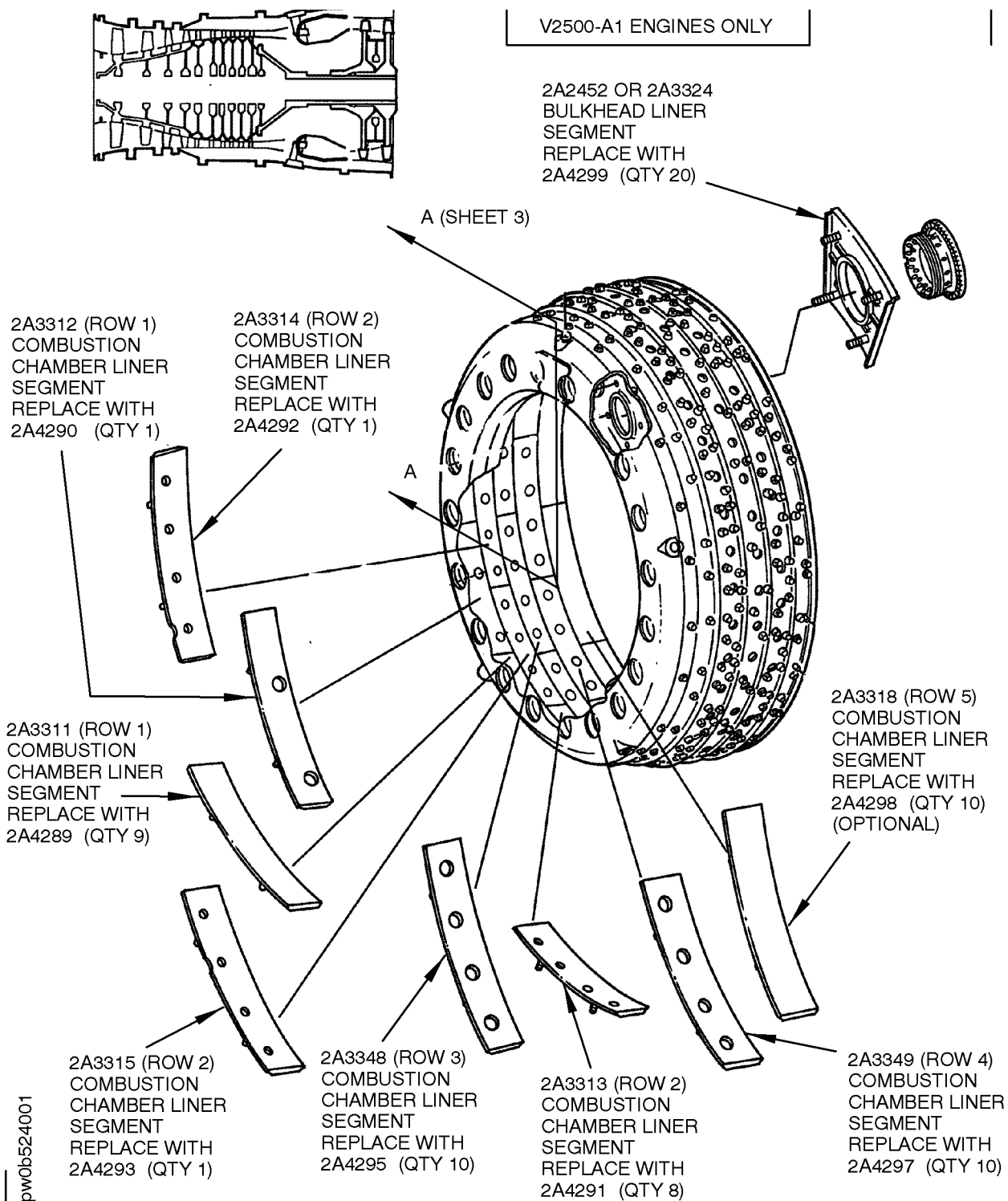
NOTE: V2500-A1 and V2500-D5 Group part numbers are not re-identified.

Identification of the Turbine Nozzle Group

New PN	Old PN	Engine Model
2A4356	2A3915	A5 Standard

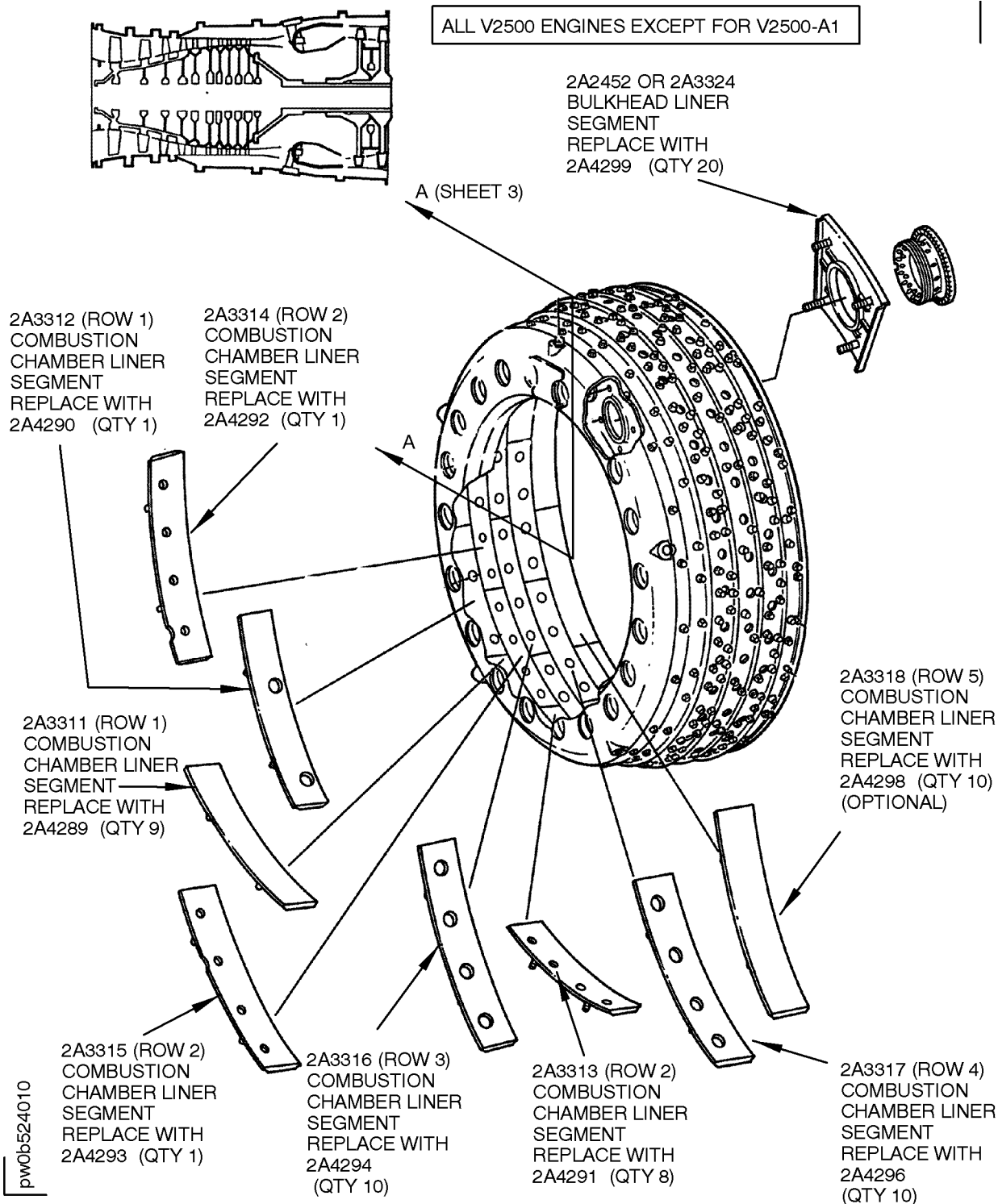


2A4333	2A1500	A5 SelectOne™
2A4334	2A4210	A5 SelectOne™



LOCATION AND IDENTIFICATION OF THE COMBUSTION CHAMBER OUTER LINER SEGMENTS
72-42-61

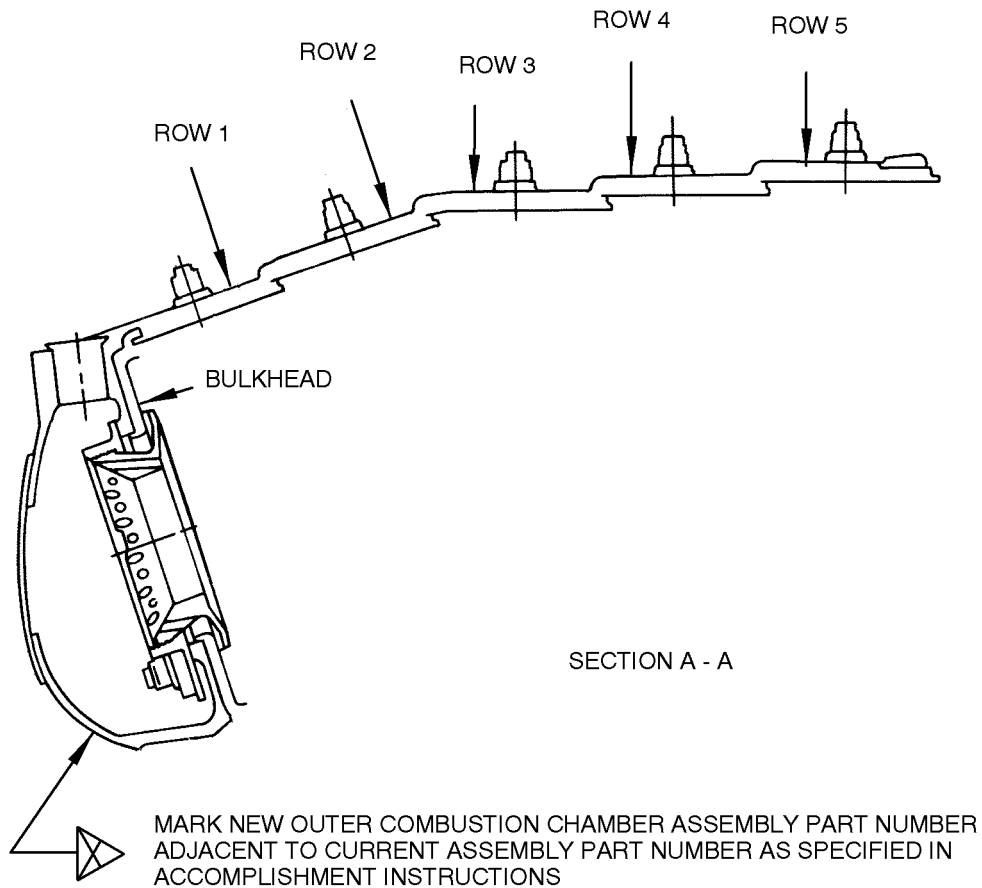
Figure 1, Sheet 1



LOCATION AND IDENTIFICATION OF THE COMBUSTION CHAMBER OUTER LINER SEGMENTS
72-42-61

Figure 1, Sheet 2

OUTER COMBUSTION CHAMBER CASE WITH LINERS AND BULKHEAD



pw0b524003

LOCATION AND IDENTIFICATION OF THE COMBUSTION CHAMBER OUTER LINER SEGMENTS
72-42-61

Figure 1, Sheet 3

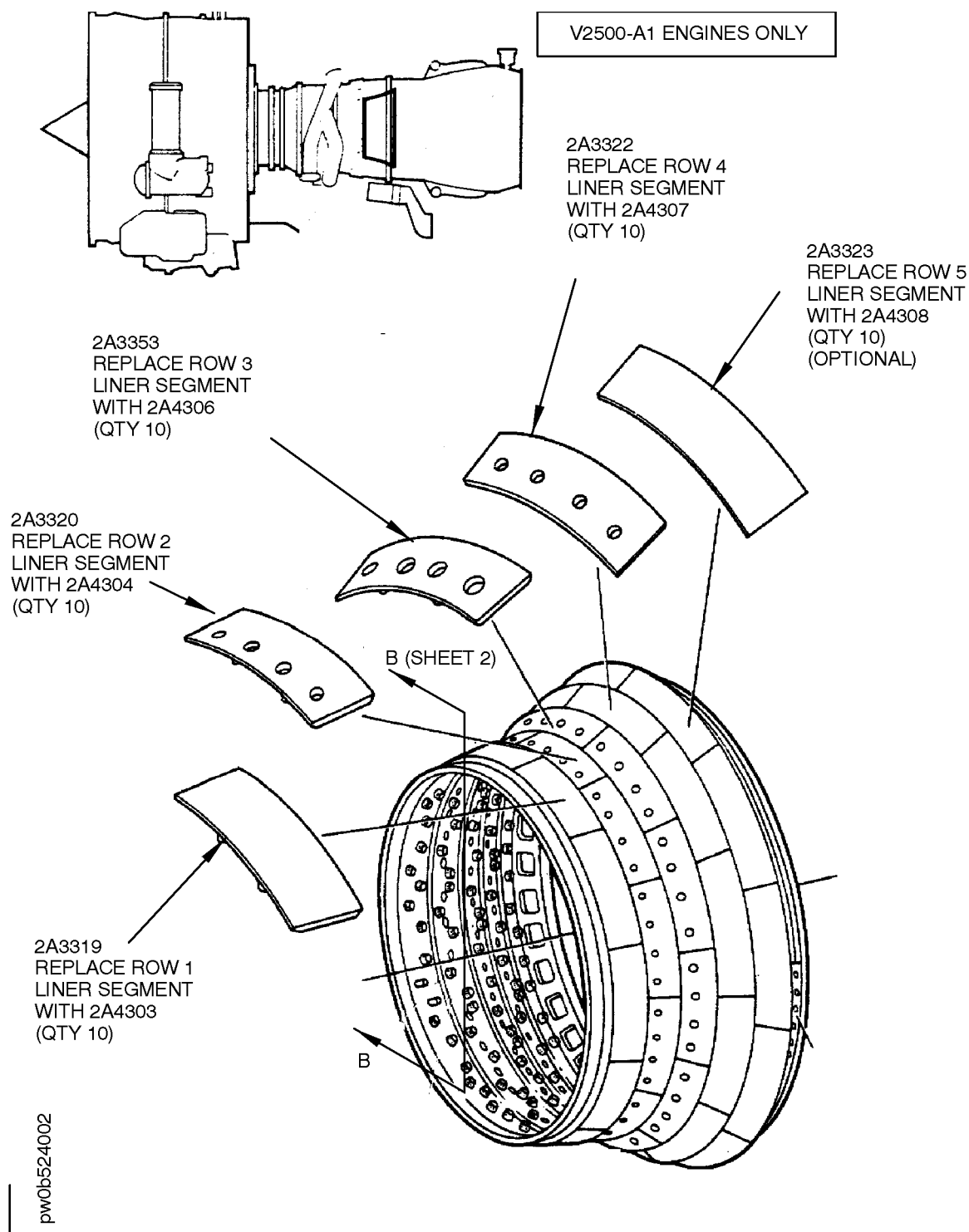
Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628

Page 31

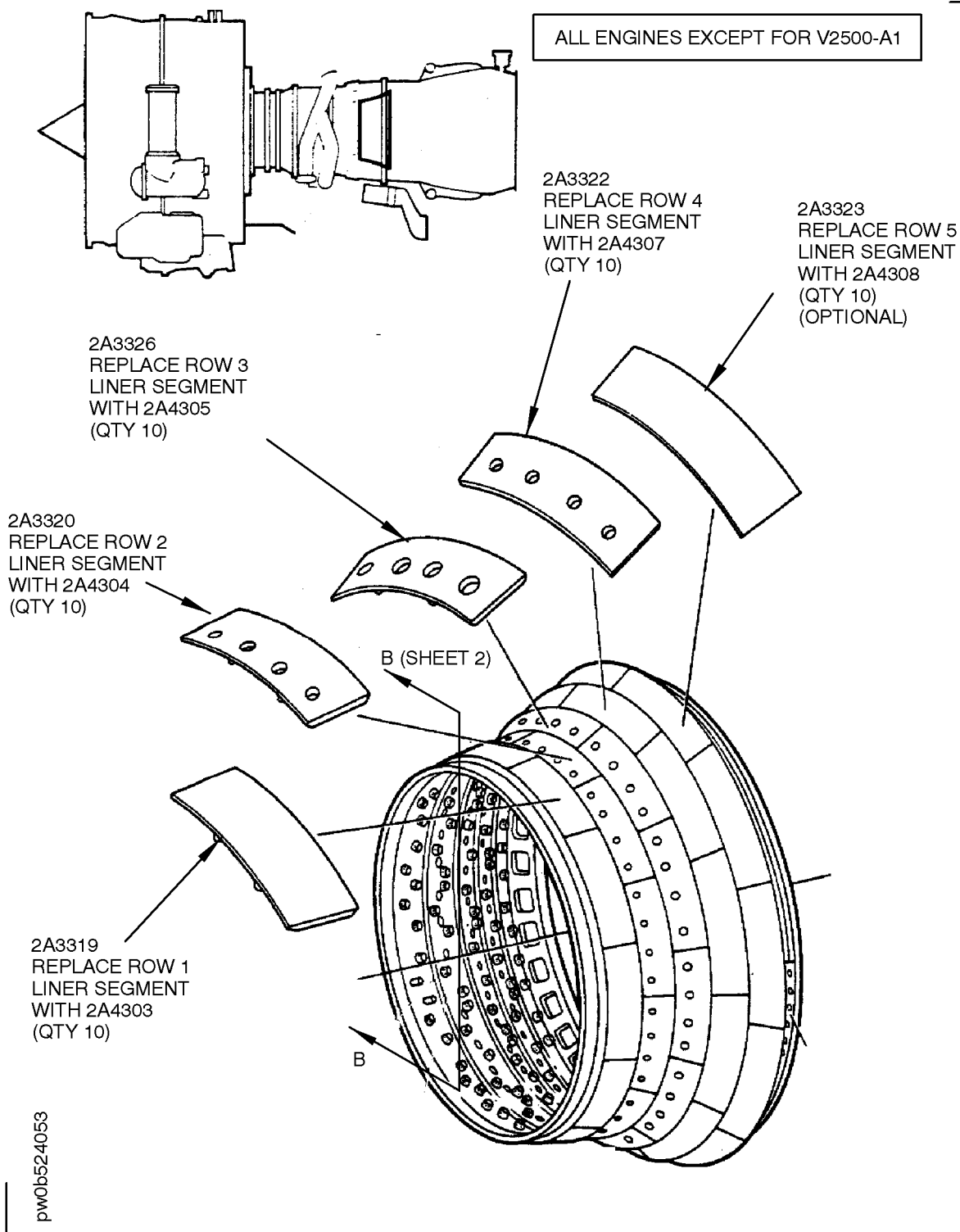
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LOCATION AND IDENTIFICATION OF THE INNER COMBUSTION LINER SEGMENTS
72-44-30

Figure 2, Sheet 1

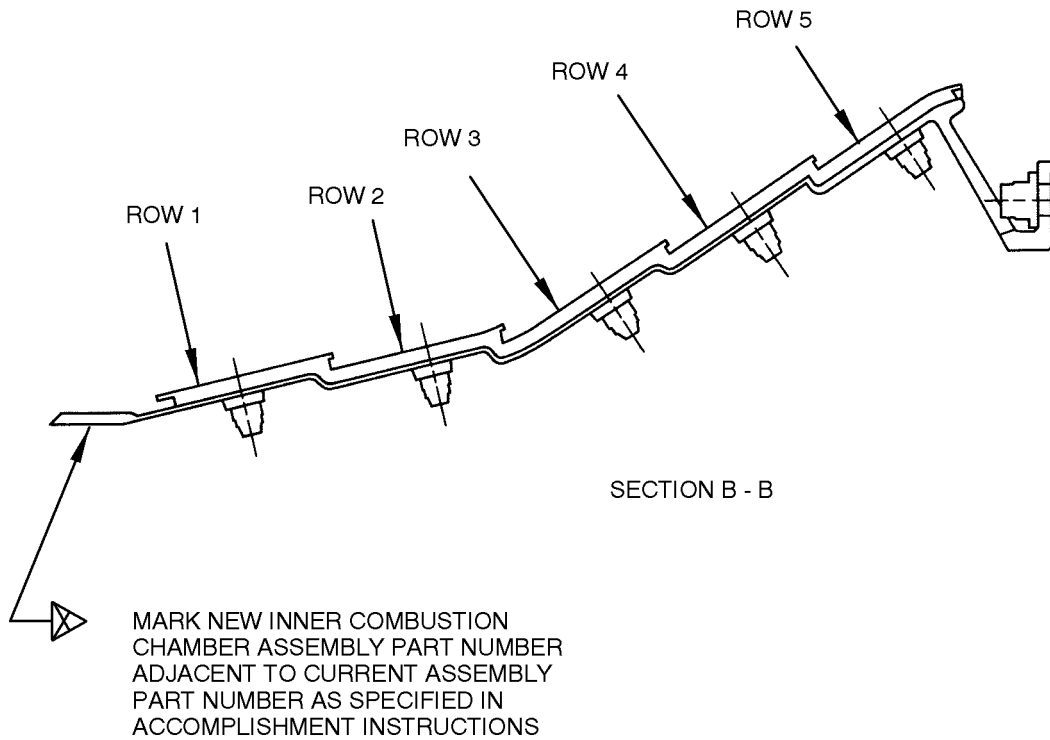


LOCATION AND IDENTIFICATION OF THE INNER COMBUSTION LINER SEGMENTS
72-44-30

Figure 2, Sheet 2



INNER COMBUSTION CASE WITH LINERS

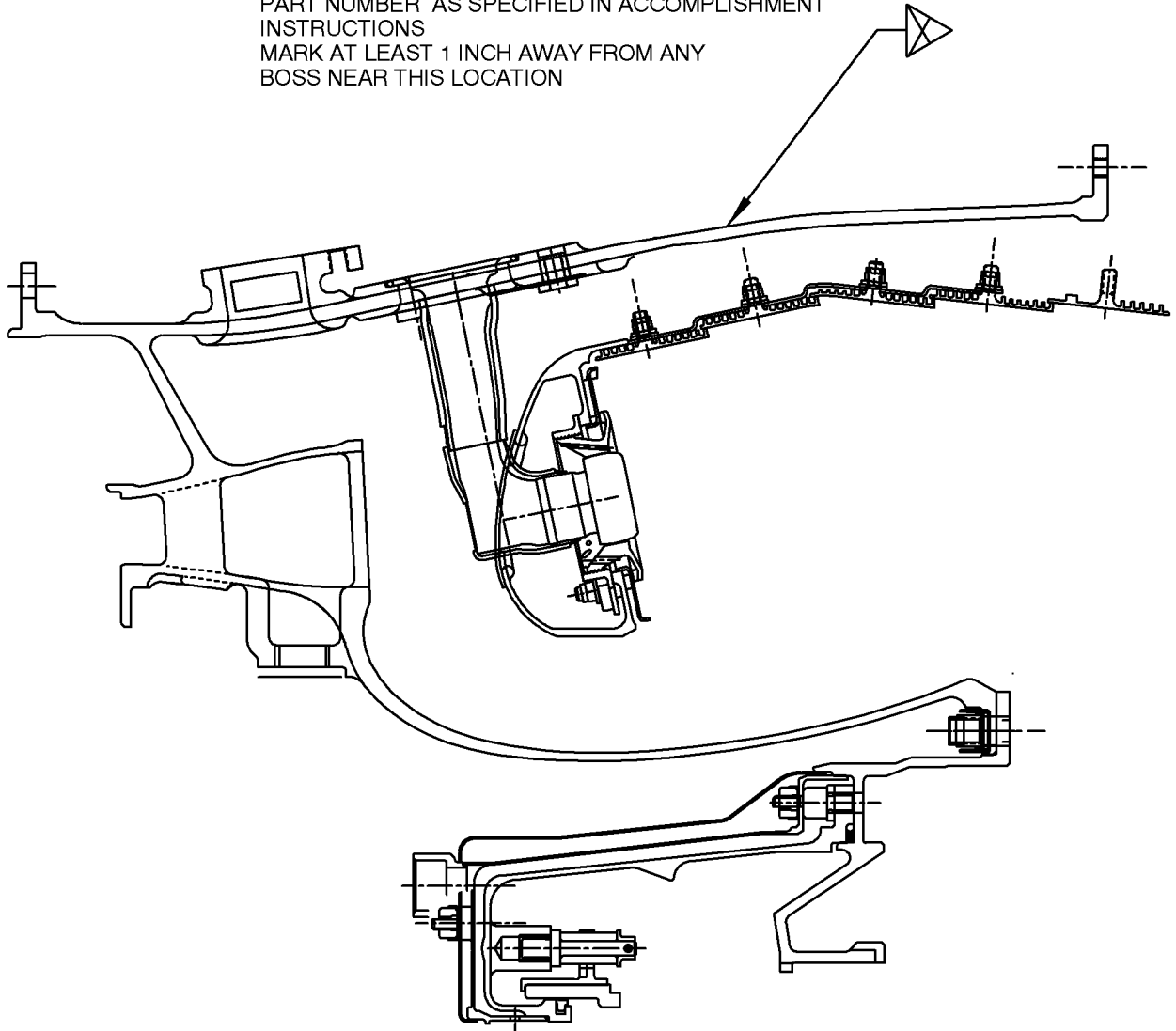


pw0b524004

LOCATION AND IDENTIFICATION OF THE INNER COMBUSTION LINER SEGMENTS
72-44-30

Figure 2, Sheet 3

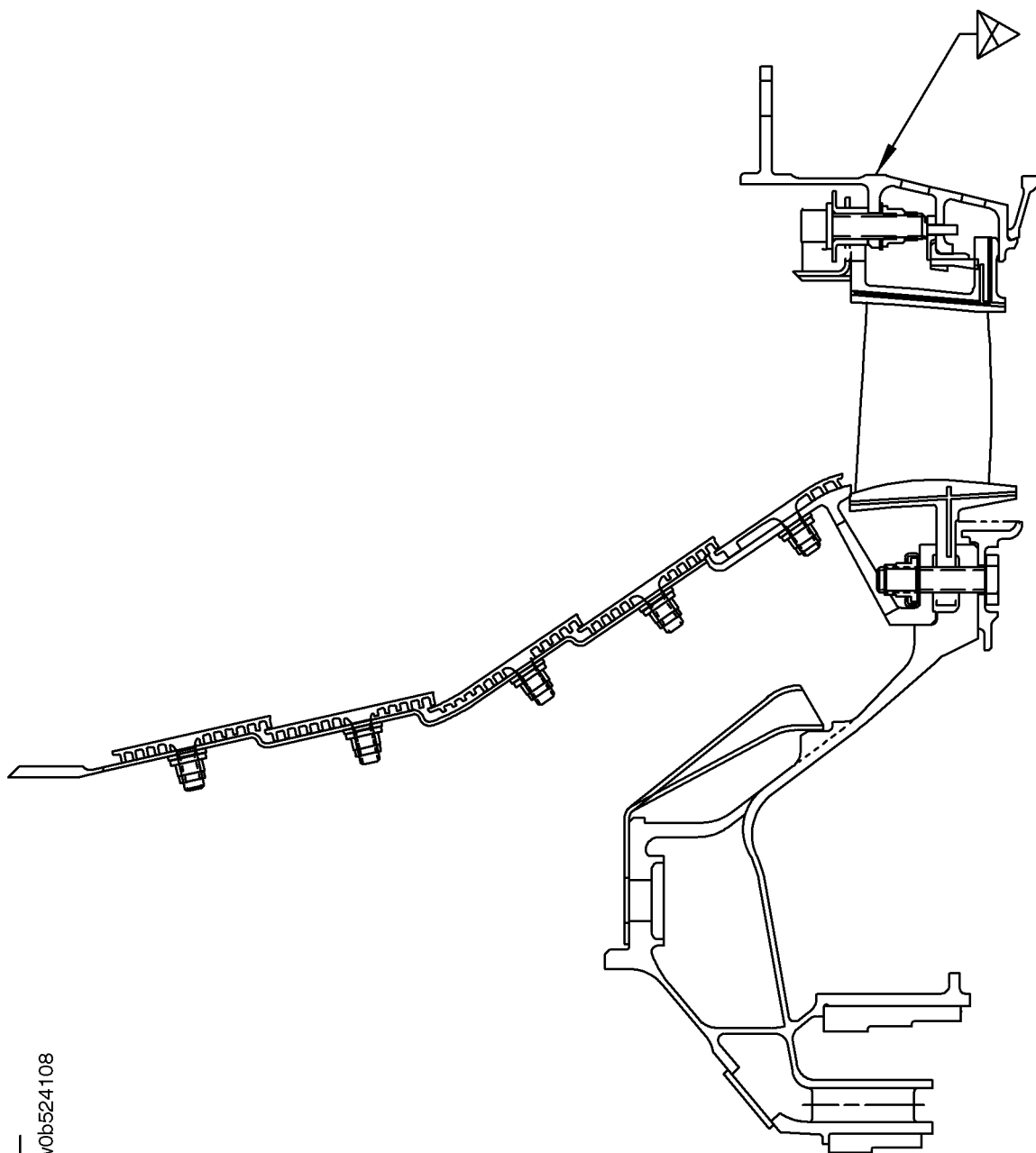
MARK NEW DIFFUSER AND COMBUSTION GROUP
PART NUMBER ADJACENT TO CURRENT GROUP
PART NUMBER AS SPECIFIED IN ACCOMPLISHMENT
INSTRUCTIONS
MARK AT LEAST 1 INCH AWAY FROM ANY
BOSS NEAR THIS LOCATION



pw0b524109

LOCATION AND IDENTIFICATION OF THE DIFFUSER AND COMBUSTOR GROUP
FIGURE 3

MARK NEW TURBINE NOZZLE GROUP
PART NUMBER ADJACENT TO CURRENT
GROUP PART NUMBER AS SPECIFIED IN
ACCOMPLISHMENT INSTRUCTIONS



pw0b524108

LOCATION AND IDENTIFICATION OF THE TURBINE NOZZLE GROUP
FIGURE 4

APPENDIX 1Parts Progression To Show the Changed Part in Relation to Other Parts

OUTER COMBUSTION CHAMBER CASE ASSEMBLY (V2500-A1 ENGINE ONLY)

MODIFICATIONS

BASE LINE

THE COMBUSTION CHAMBER HOOD
FOR 2A1385 DOES NOT HAVE THE
NON-FUNCTIONAL RIBS (WHICH ARE
CAST INTO THE HOOD FOR 2A1383)

V2500-ENG-72-0006

ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - THERMAL BARRIER
COATING FOR COMBUSTION LINERS

V2500-ENG-72-0060

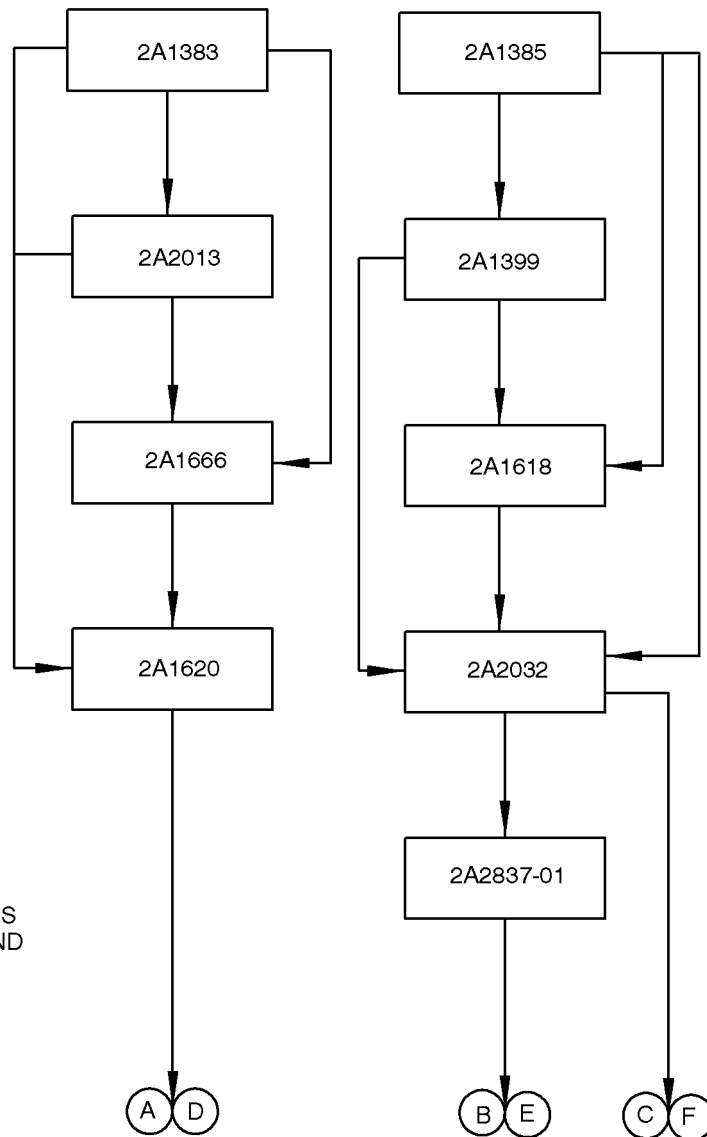
ENGINE - DIFFUSER AND COMBUSTION
AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL
BARRIER COATING ON INNER AND
OUTER COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116

ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES WITH GENERATION II
LINER SEGMENTS

V2500-ENG-70-0253

INFORMATION - ENGINE - DIFFUSER AND
COMBUSTION SECTION - PROVIDE NEW
INNER AND OUTER COMBUSTION CHAMBERS
WITH INCREASED HARDFACE THICKNESS AND
RELOCATED COOLING HOLES



A, B, C - CONTINUED ON SHEET 2
D, E, F - CONTINUED ON SHEET 3

pw0b524054

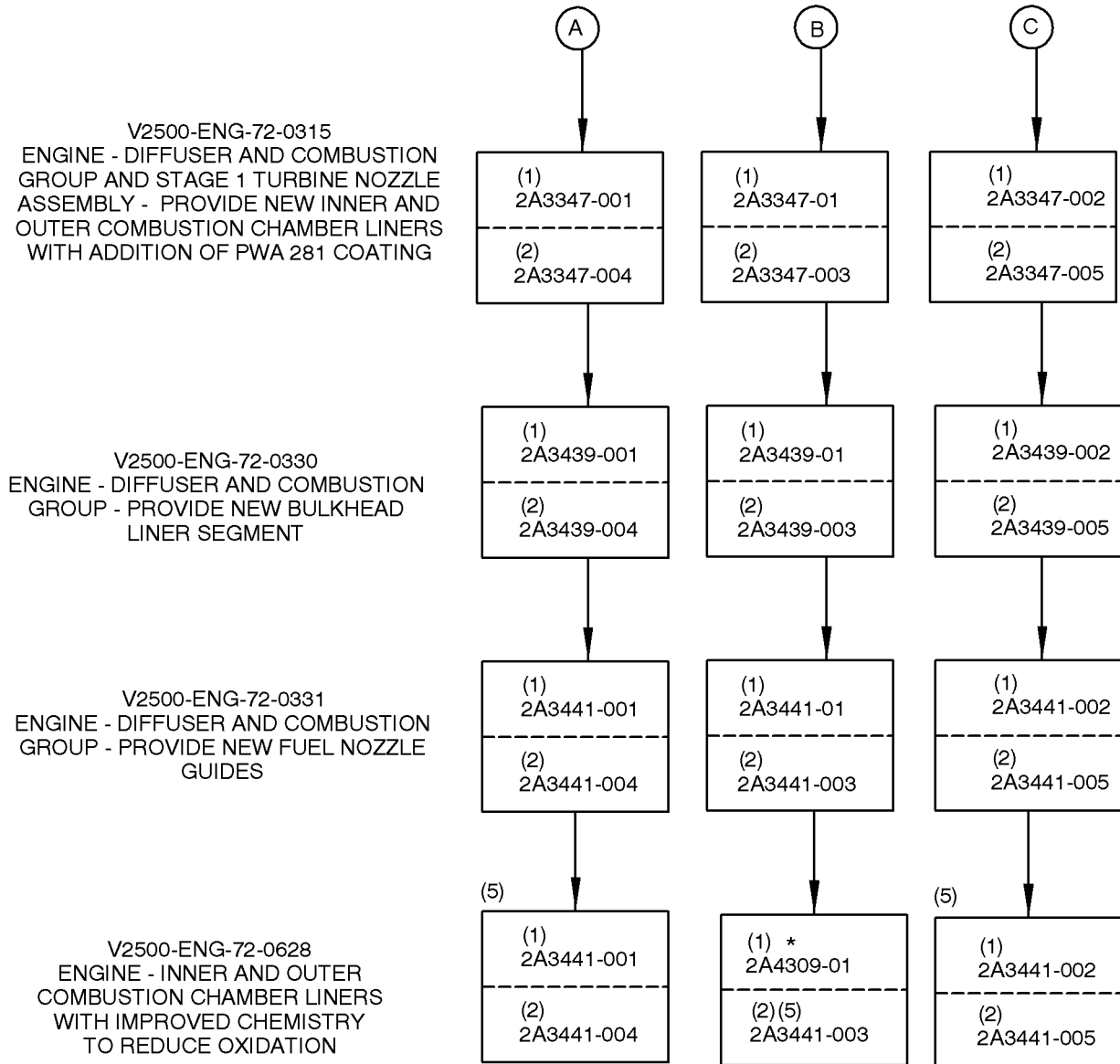
FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY (V2500-A1 ENGINES ONLY) Chart A, Sheet 1

Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628
Appendix 1 - Page 2

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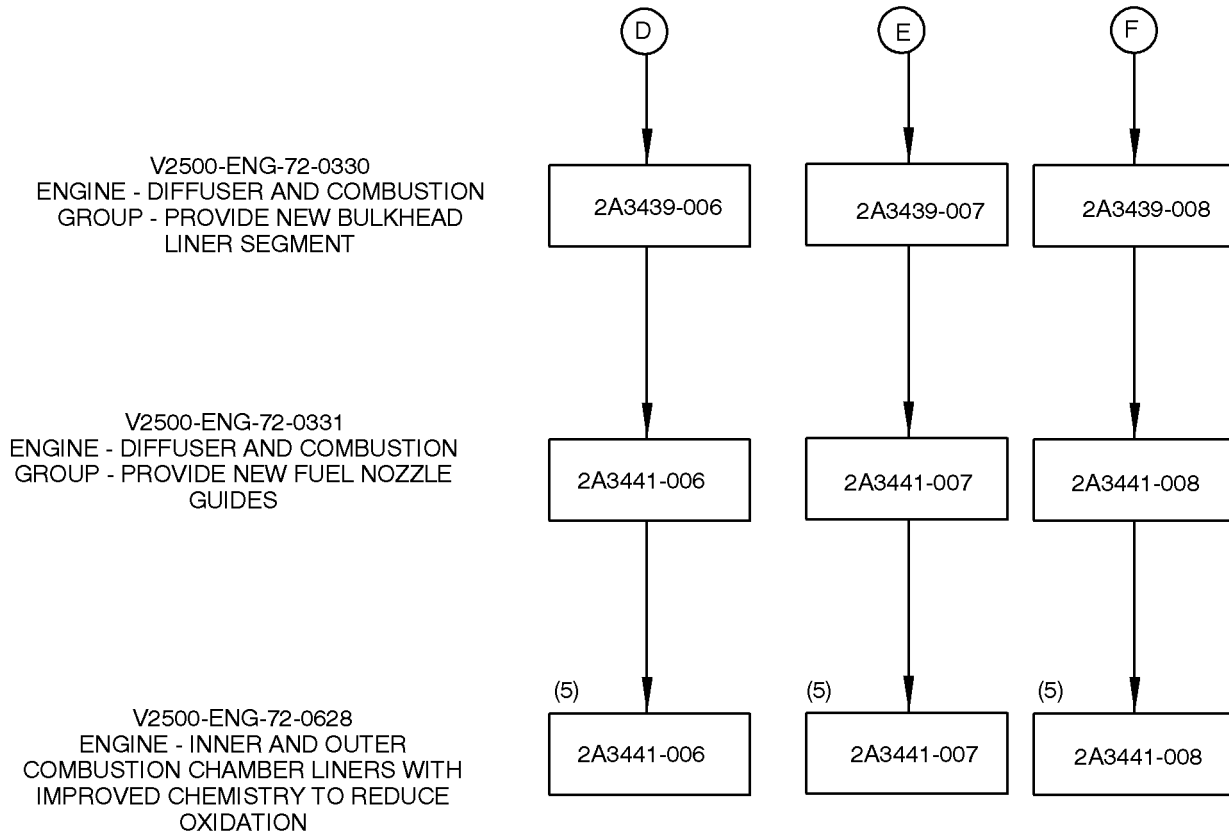
(1) WHEN ROW 1, 2, 3, 4 & 5 LINERS ARE REPLACED
(2) ONLY ROWS 1, 2, 3 & 4 LINERS ARE REPLACED

* PRODUCTION (REF)

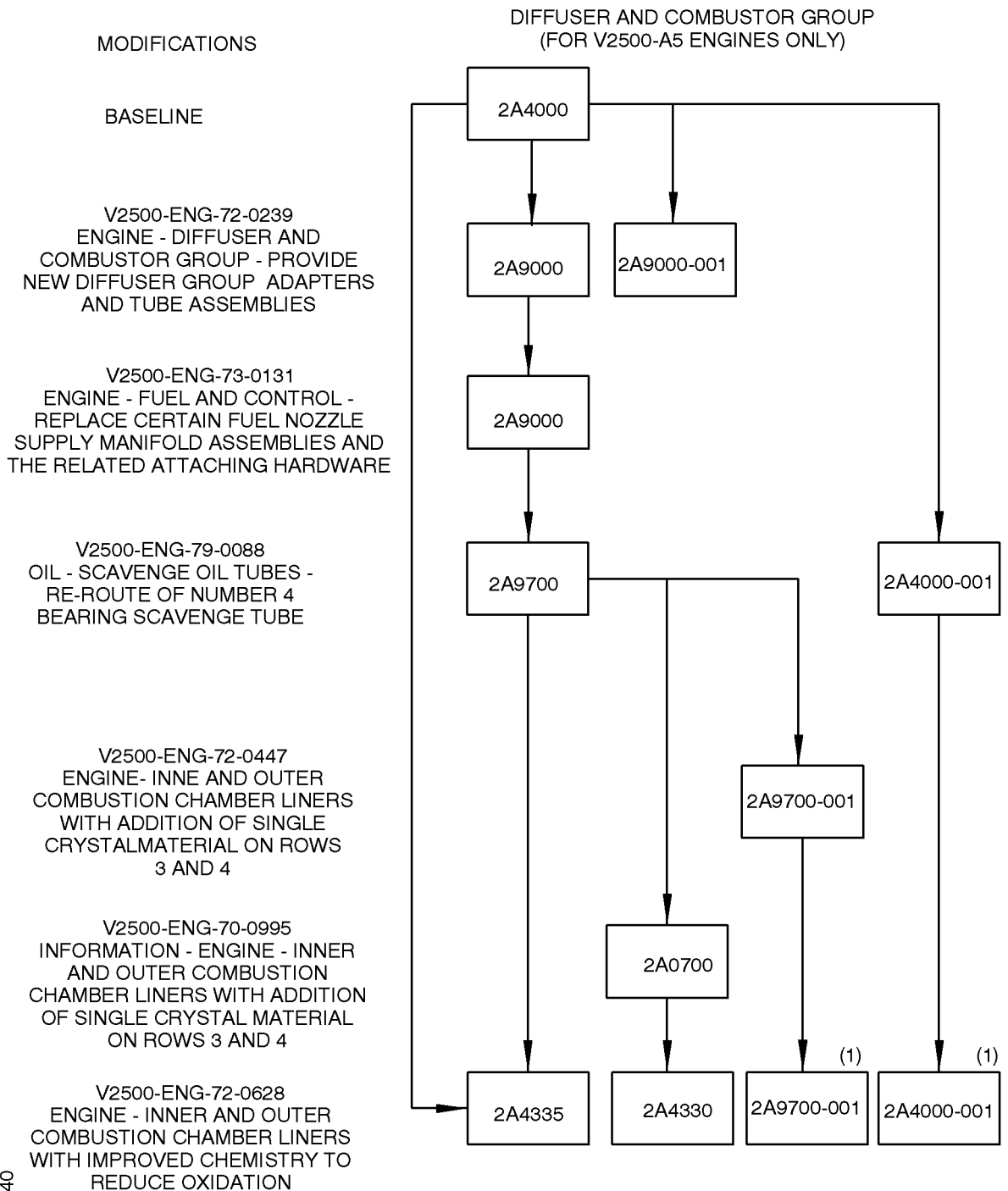
(5) NO CHANGE IN PART NUMBER WITH NEW LINERS

A, B, C - CONTINUED FROM SHEET 1

FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY
(V2500-A1 ENGINES ONLY)
Chart A, Sheet 2



FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY
(V2500-A1 ENGINES ONLY)
Chart A, Sheet 3



(1) THESE PARTS ARE NOT RE-IDENTIFIED

**FAMILY TREE - DIFFUSER AND COMBUSTION GROUP
Chart B**

MODIFICATIONS

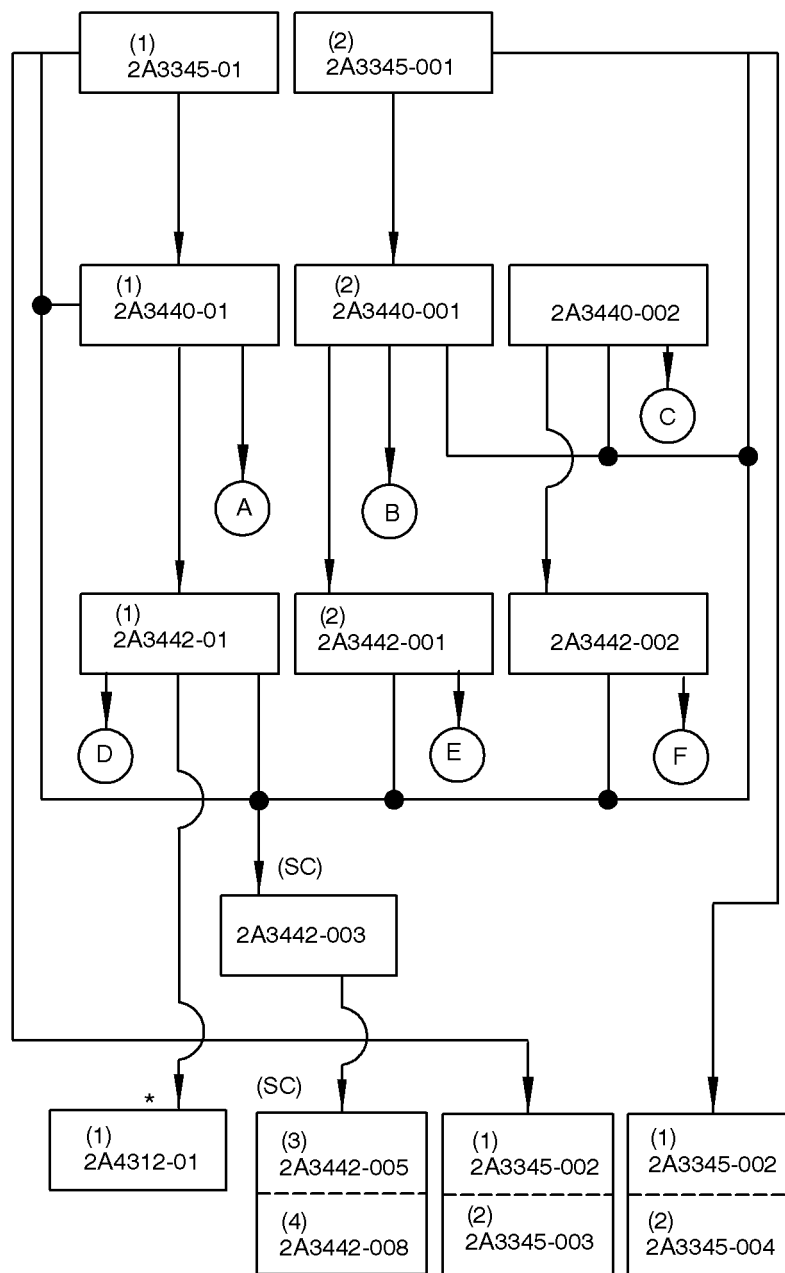
V2500-ENG-72-0315
ENGINE - DIFFUSER AND
COMBUSTION GROUP AND STAGE 1
TURBINE NOZZLE ASSY - PROVIDE
NEW INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF
PWA 281 COATING

V2500-ENG-72-0330
ENGINE - DIFFUSER AND
COMBUSTION GROUP - PROVIDE
NEW BULKHEAD LINER SEGMENT

V2500-ENG-72-0331
ENGINE - DIFFUSER AND
COMBUSTION GROUP - PROVIDE
NEW FUEL NOZZLE GUIDES

V2500-ENG-72-0447
ENGINE- INNE AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF SINGLE CRYSTAL
MATERIAL ON ROWS 3 AND 4

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION

**OUTER COMBUSTION CHAMBER CASE ASSEMBLY
(ALL ENGINES EXCEPT V2500-A1)**


- (1) ROW 1, 2, 3, 4 & 5 LINERS ARE REPLACED
(2) ONLY ROWS 1, 2, 3, & 4 LINERS ARE REPLACED
(3) ROWS 1, 2, and 5 LINERS ARE REPLACED
(4) ONLY ROWS 1 & 2 LINERS ARE REPLACED

A, B, C, D, E, F CONTINUED ON SHEET 2

* PRODUCTION
(SC) SINGLE CRYSTAL

**FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY
(ALL ENGINES EXCEPT A1)
Chart C, Sheet 1**

Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628
Appendix 1 - Page 6

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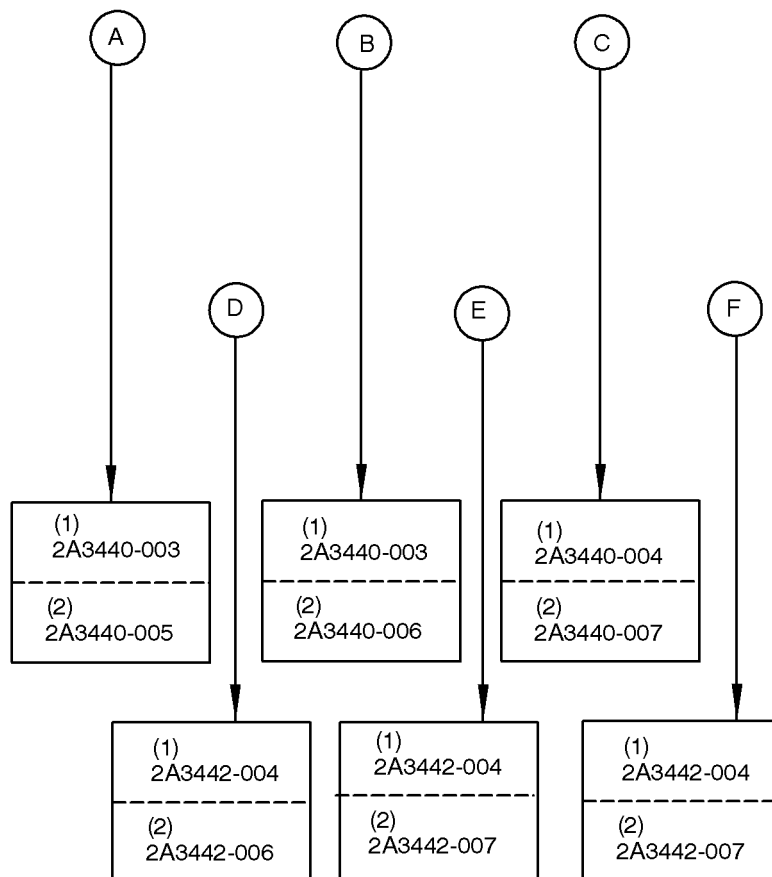
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pw0b524005

V2500-ENG-72-0330
ENGINE - DIFFUSER AND
COMBUSTION GROUP - PROVIDE
NEW BULKHEAD LINER SEGMENT

V2500-ENG-72-0331
ENGINE - DIFFUSER AND
COMBUSTION GROUP - PROVIDE
NEW FUEL NOZZLE GUIDES

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION



A, B, C, D, E, F FROM SHEET 1

- (1) ROWS 1, 2, 3, 4 & 5 LINERS ARE REPLACED
(2) ONLY ROWS 1, 2, 3 & 4 LINERS ARE REPLACED

pw0b524060

FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY
(ALL ENGINES EXCEPT A1)
Chart C, Sheet 2

Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628

Appendix 1 - Page 7

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MODIFICATIONS

V2500-ENG-70-0995
 INFORMATION - ENGINE - INNER
 AND OUTER COMBUSTION CHAMBER
 LINERS WITH ADDITION OF SINGLE
 CRYSTAL MATERIAL ON ROWS 3 AND 4

V2500-ENG-72-0628
 ENGINE - INNER AND OUTER
 COMBUSTION CHAMBER LINERS
 WITH IMPROVED CHEMISTRY TO
 REDUCE OXIDATION

(SC)

2A4284-01

(SC)

 (3)
 2A4314-01

 (4)
 2A4314-001

(SC) SINGLE CRYSTAL

(3) ROWS 1, 2 & 5 LINERS ARE REPLACED
 (4) ONLY ROWS 1 & 2 LINERS ARE REPLACED

pw0b524067

FAMILY TREE - OUTER COMBUSTION CHAMBER CASE ASSEMBLY
 (ALL ENGINES EXCEPT A1)
 Chart C, Sheet 3

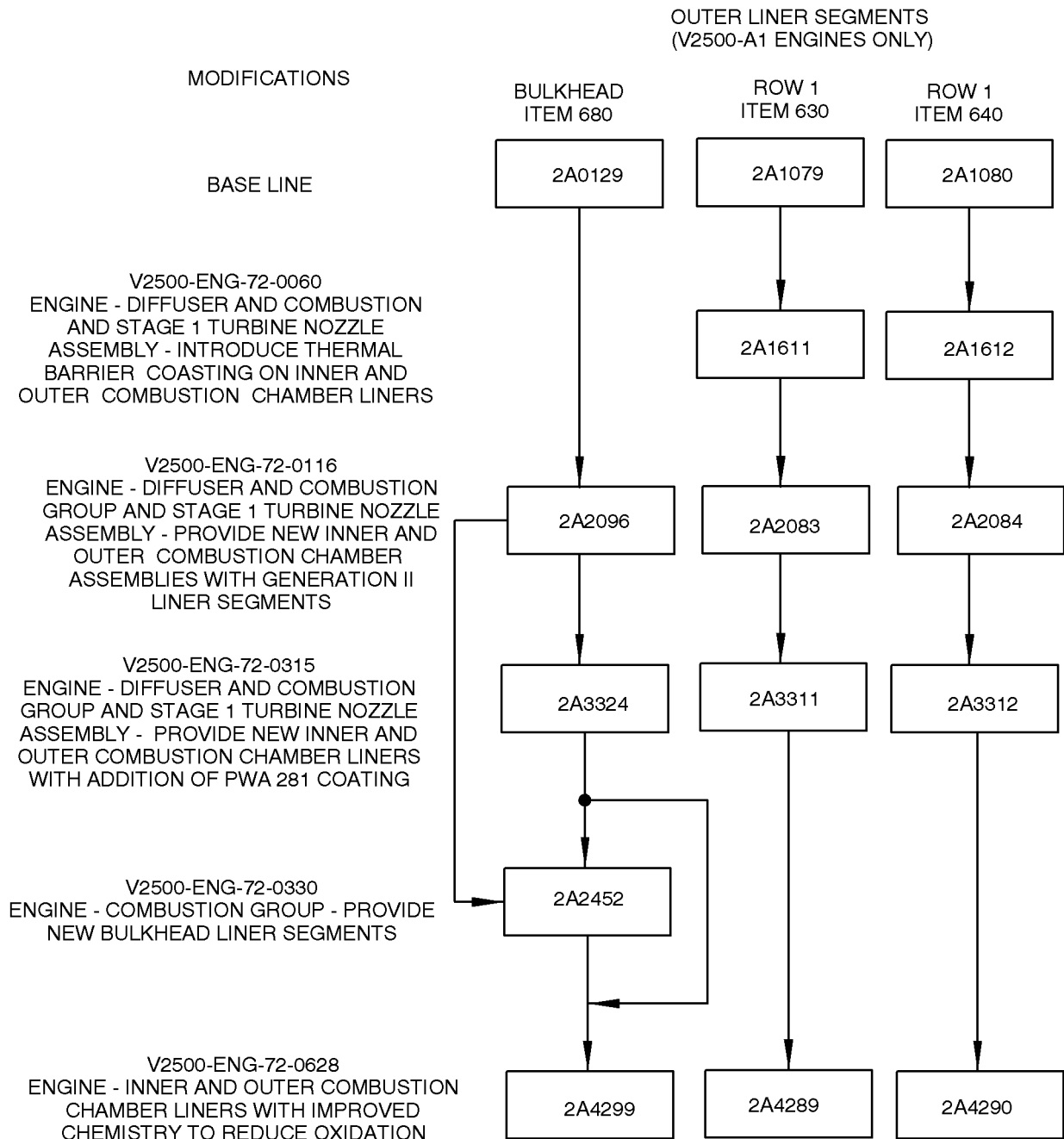
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 Aug.31/12 Initial Issue

V2500-ENG-72-0628

Appendix 1 - Page 8

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pw0b524076

FAMILY TREE - OUTER COMBUSTION CHAMBER LINER SEGMENTS (V2500-A1 ONLY)
Ref. Catalog Sequence No. 72-42-61. Fig. 1
Chart D, Sheet 1

MODIFICATIONS

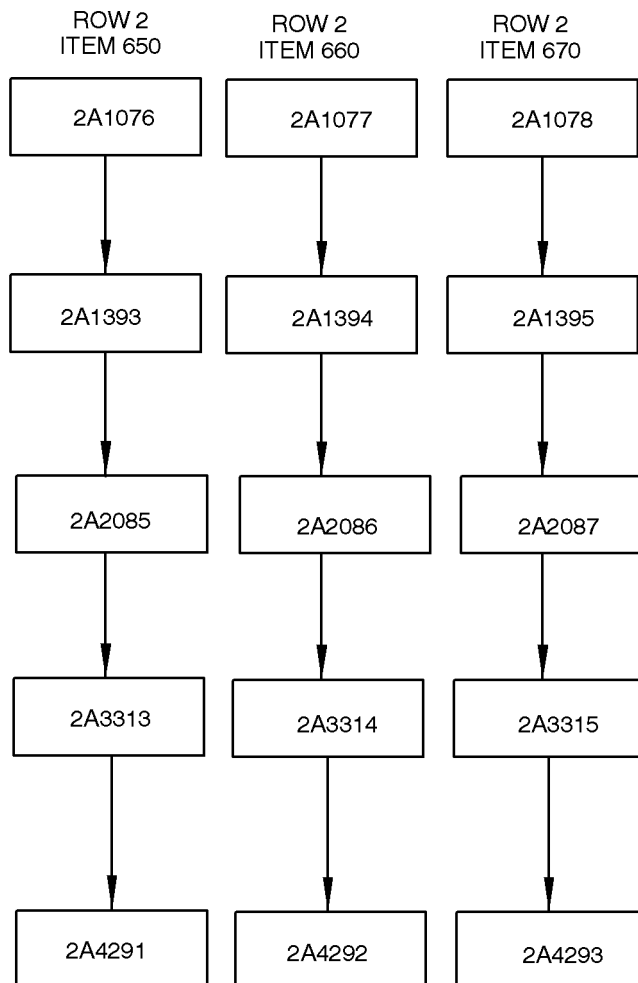
BASE LINE

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL
BARRIER COATING ON INNER AND
OUTER COMBUSTION CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER
ASSEMBLIES WITH GENERATION II
LINER SEGMENTS

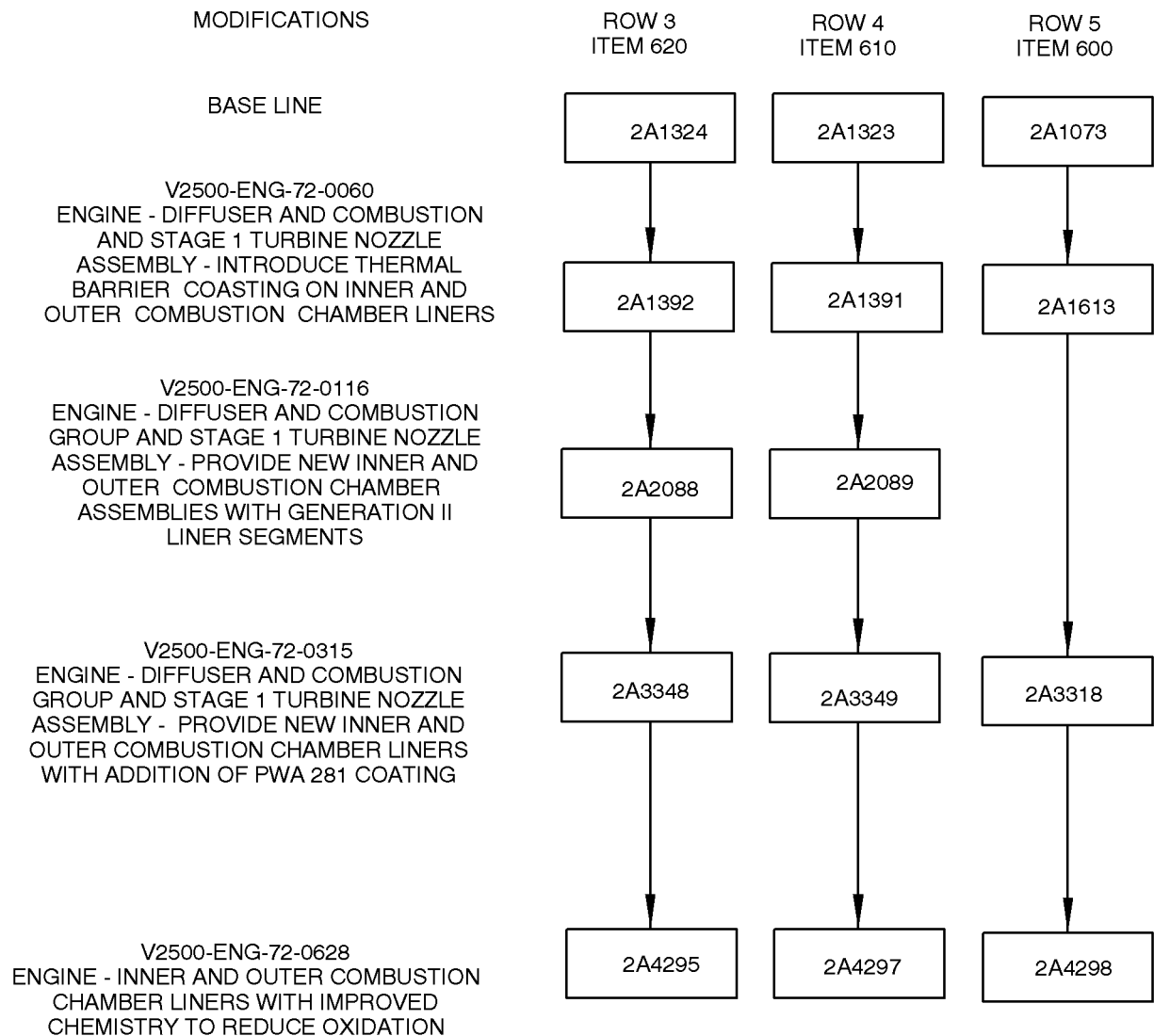
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH IMPROVED
CHEMISTRY TO REDUCE OXIDATION



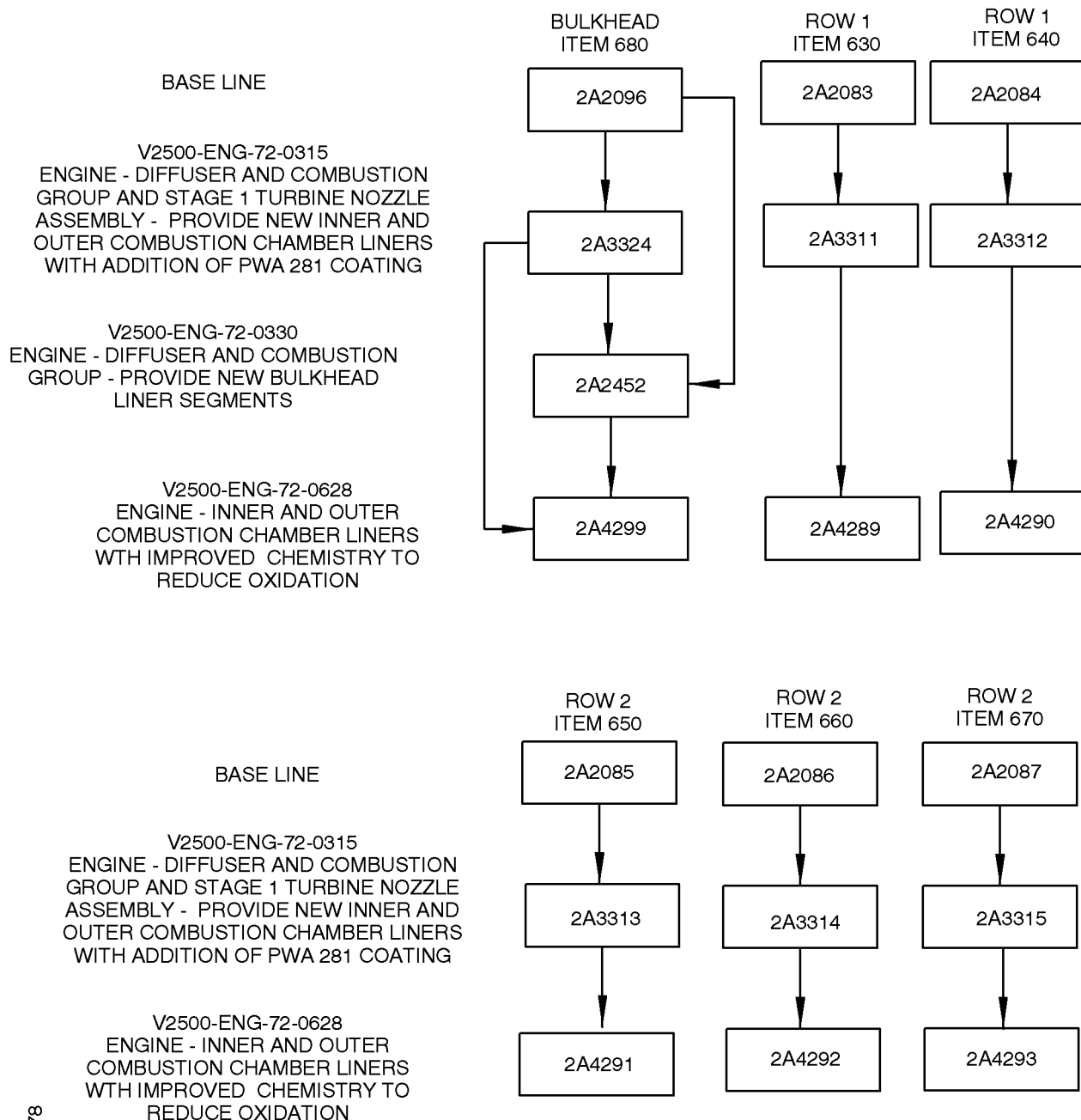
FAMILY TREE - OUTER COMBUSTION CHAMBER LINER SEGMENTS (V2500-A1 ONLY)
Ref. Catalog Sequence No. 72-42-61. Fig. 1
Chart D, Sheet 2

V2500-A1 OUTER LINER SEGMENTS



pw0b524074

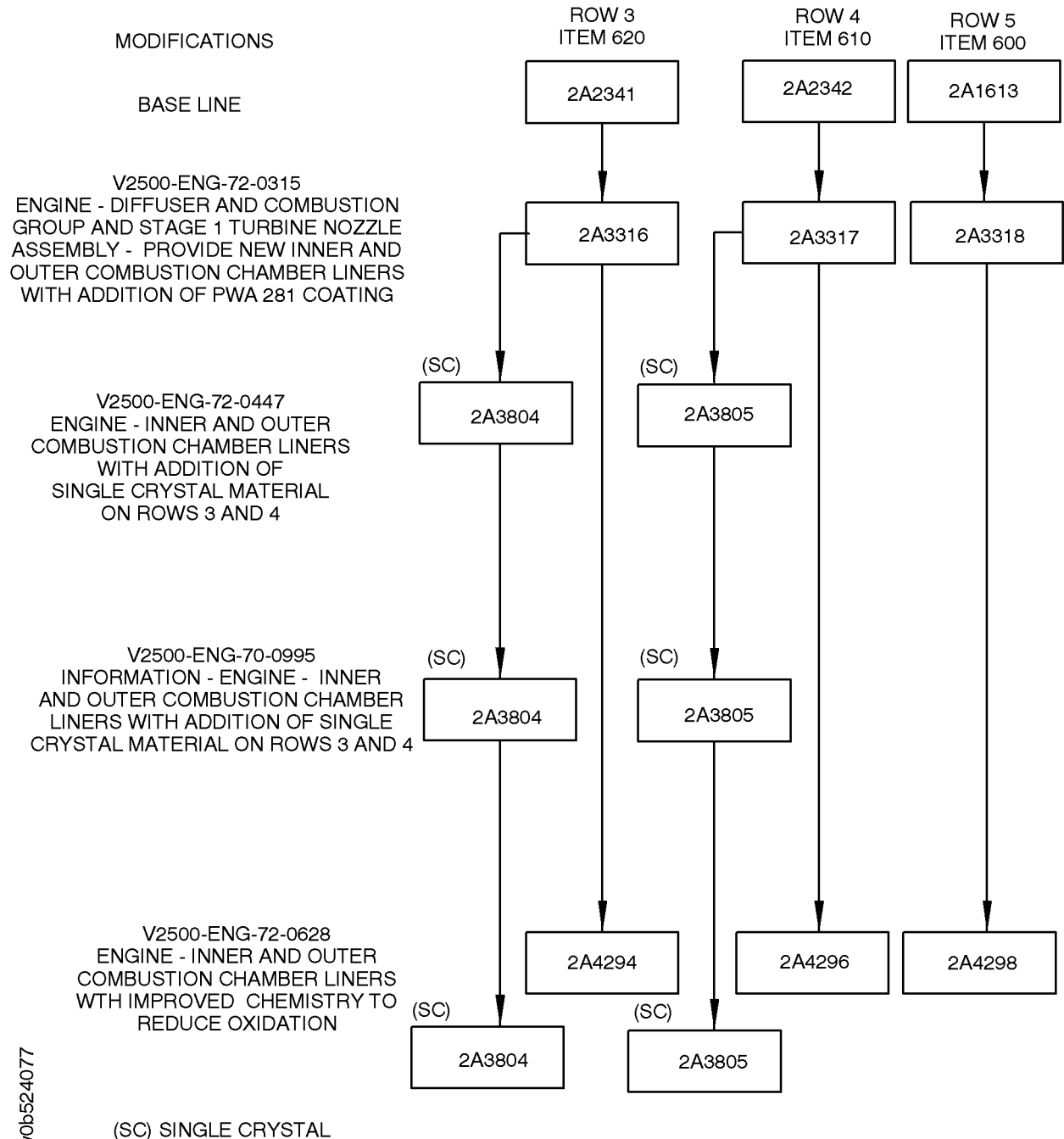
FAMILY TREE - OUTER COMBUSTION CHAMBER LINER SEGMENTS (V2500-A1 ONLY)
Ref. Catalog Sequence No. 72-42-61. Fig. 1
Chart D, Sheet 3

MODIFICATIONS
**OUTER LINER SEGMENTS
(ALL ENGINES EXCEPT FOR V2500-A1)**


pw0b524078

FAMILY TREE – OUTER COMBUSTION CHAMBER LINER SEGMENTS
(ALL ENGINES EXCEPT V2500-A1) Ref. Catalog Sequence No. 72-42-61. Fig. 1
Chart E, Sheet 1

OUTER LINER SEGMENTS
(ALL ENGINES EXCEPT FOR V2500-A1)



pw0b524077

FAMILY TREE - OUTER COMBUSTION CHAMBER LINER SEGMENTS
(ALL ENGINES EXCEPT V2500-A1) Ref. Catalog Sequence No. 72-42-61. Fig. 1
Chart E, Sheet 2

MODIFICATIONS

BASELINE

V2500-ENG-72-0241
ENGINE - STAGE 1 TURBINE
NOZZLE ASSEMBLY - PROVIDE
A NEW STAGE 1 HPT COOLING
DUCT ASSEMBLY AND SEGMENTS

V2500-ENG-72-0475
ENGINE - HP TURBINE ROTOR
ASSEMBLY - INTRODUCE NEW
FIRST STAGE TURBINE BLADES
AND STAGE 1 HPT COOLING DUCT
ASSEMBLY WITH DECREASED FLOW

V2500-ENG-72-0483
ENGINE - NEW FIRST STAGE DUCT
SEGMENTS AND HPT VANE SUPPORT

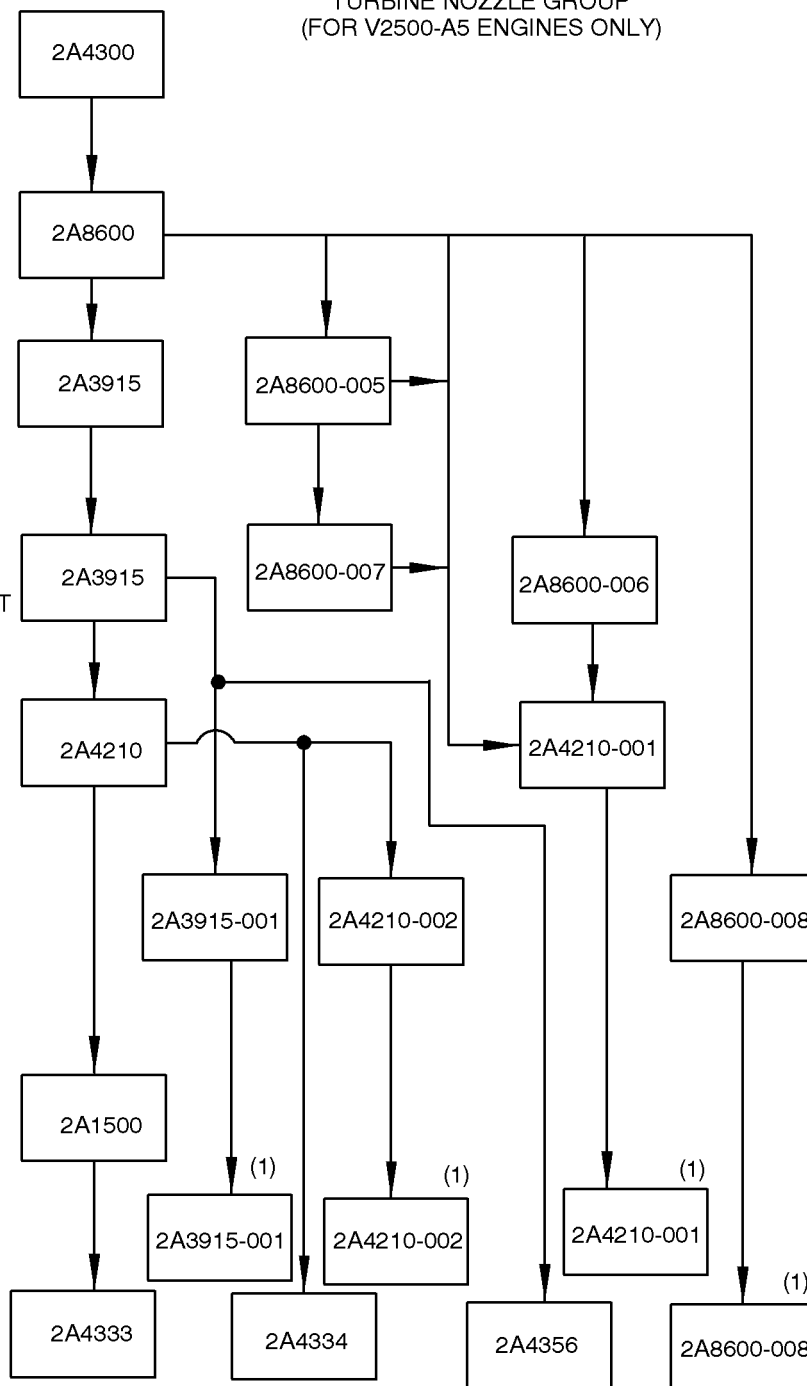
V2500-ENG-72-0562
ENGINE - HIGH PRESSURE
TURBINE (HPT) - V2500
SELECTONE PRODUCTION
AND RETROFIT- HPT UPGRADE

V2500-ENG-72-0447
ENGINE- INNE AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF SINGLE
CRYSTAL MATERIAL ON ROWS
3 AND 4

V2500-ENG-70-0995
INFORMATION - ENGINE - INNER
AND OUTER COMBUSTION CHAMBER
LINERS WITH ADDITION OF SINGLE
CRYSTAL MATERIAL ON
ROWS 3 AND 4

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION

TURBINE NOZZLE GROUP
(FOR V2500-A5 ENGINES ONLY)



(1) THESE PARTS ARE NOT RE-IDENTIFIED

FAMILY TREE - TURBINE NOZZLE GROUP

Ref. Catalog Sequence No. 72-44-00, Fig. 01 Item 001

Chart F

Aug.31/12

Aug.31/12 Initial Issue

V2500-ENG-72-0628

Appendix 1 – Page 14

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pw0b524437

V2500-A1 INNER LINER SEGMENT ASSEMBLY

MODIFICATIONS

V2500-ENG-72-0006
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - THERMAL BARRIER COATING
FOR COMBUSTION LINERS

V2500-ENG-72-0060
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - INTRODUCE THERMAL BARRIER
COATING ON INNER AND OUTER COMBUSTION
CHAMBER LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER ASSEMBLIES
WITH GRNATION II LINER ASSEMBLIES

V2500-ENG-70-0253
INFORMATION - ENGINE- DIFFUSER AND
COMBUSTION SECTION - PROVIDE NEW
INNER AND OUTER COMBUSTION CHAMBERS
WITH INCREASED HARDFACE THICKNES AND
RELOCATED COOLING HOLES

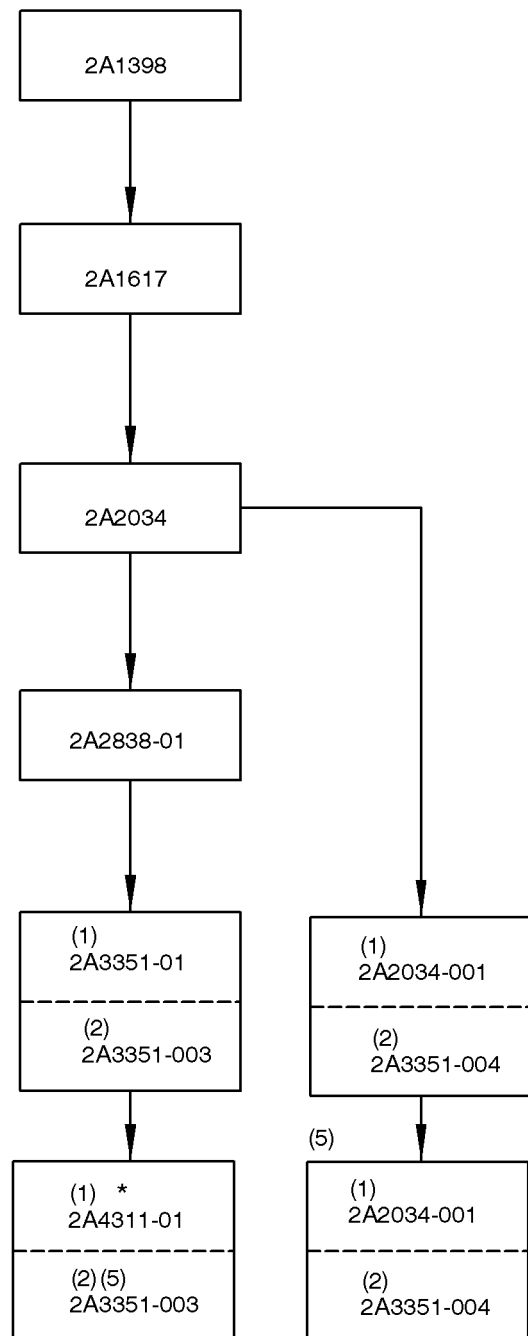
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH IMPROVED
CHEMISTRY TO REDUCE OXIDATION

(1) ROWS 1, 2, 3, 4, & 5 ARE REPLACED
(2) ONLY ROWS 1, 2, 3, & 4 ARE REPLACED

(5) NO PART NUMBER CHANGE WITH NEW LINERS

* PRODUCTION (REF)



FAMILY TREE - INNER COMBUSTION CHAMBER CASE ASSEMBLY
(V2500-A1 ONLY) Ref. Catalog Sequence No. 72-42-61, Fig. 1 Item 420
Chart G

MODIFICATIONS

INNER LINER FOR ALL ENGINES (EXCEPT V2500-A1)

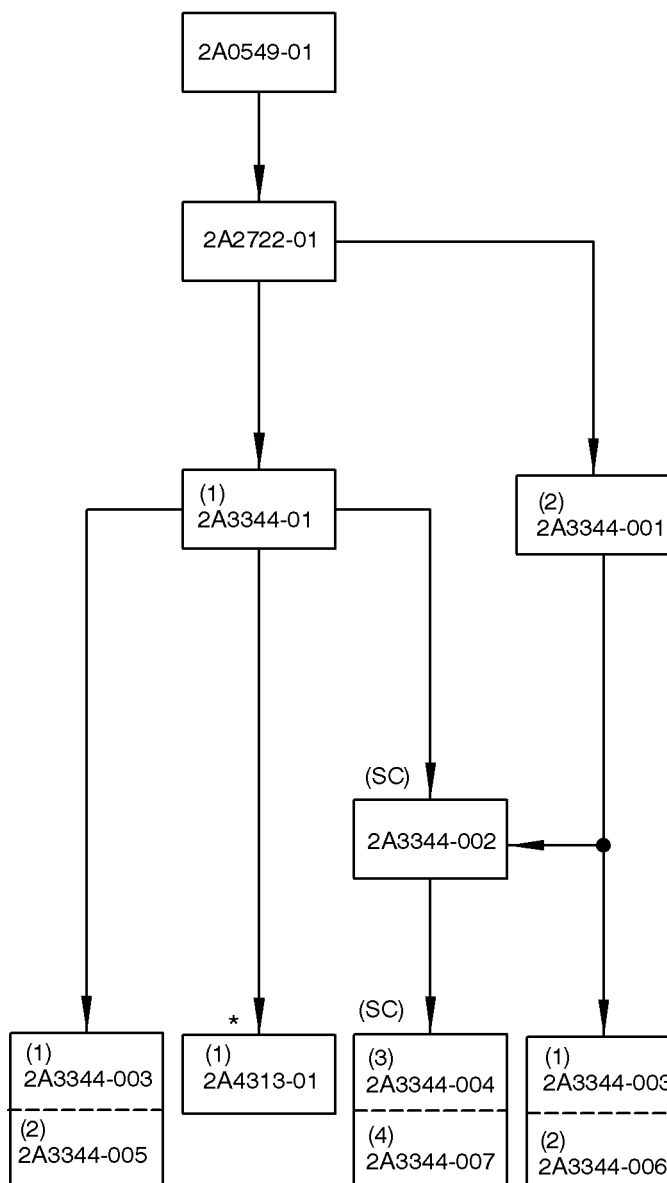
BASE LINE

V2500-ENG-72-0159
ENGINE - DIFFUSER AND COMBUSTION
INTRODUCE NEW INNER AND OUTER
COMBUSTION CHAMBER ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0447
ENGINE - INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH ADDITION OF SINGLE
CRYSTAL MATERIAL ON ROWS 3 AND 4

V2500-ENG-72-0628
ENGINE - INNER AND OUTER COMBUSTION
CHAMBER LINERS WITH IMPROVED
CHEMISTRY TO REDUCE OXIDATION



- (1) ROW 1, 2, 3, 4 & 5 LINERS ARE REPLACED
(2) ONLY ROWS 1, 2, 3, & 4 LINERS ARE REPLACED
(3) ROWS 1,2, AND 5 LINERS ARE REPLACED
(4) ONLY ROWS 1 & 2 LINERS ARE REPLACED

* PRODUCTION

(SC) SINGLE CRYSTAL

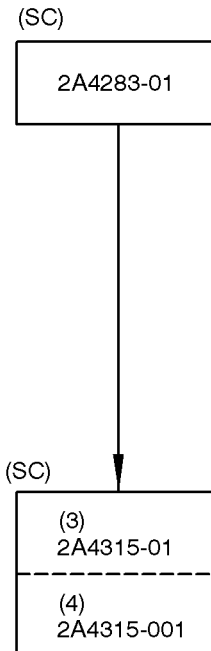
FAMILY TREE - INNER COMBUSTION CHAMBER CASE ASSEMBLY
(ALL ENGINES EXCEPT A1) Ref. Catalog Sequence No. 72-42-61, Fig. 1 Item 420
Chart H

INNER COMBUSTION CHAMBER CASE ASSEMBLY
(V2500-A5 ENGINES ONLY WITH SINGLE CRYSTAL OPTION)

MODIFICATIONS

V2500-ENG-70-0995
INFORMATION - ENGINE - INNER
AND OUTER COMBUSTION CHAMBER
LINERS WITH ADDITION OF SINGLE
CRYSTAL MATERIAL ON ROWS 3 AND 4

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION



(SC) SINGLE CRYSTAL

- (3) ROWS 1, 2 & 5 LINERS ARE REPLACED
- (4) ONLY ROWS 1 & 2 LINERS ARE REPLACED

pw0b524083

FAMILY TREE - INNER COMBUSTION CHAMBER CASE ASSEMBLY (ALL V2500-A5 ENGINES
WITH SINGLE CRYSTAL OPTION) Ref. Catalog Sequence No. 72-42-61, Fig. 1 Item 420
Chart I

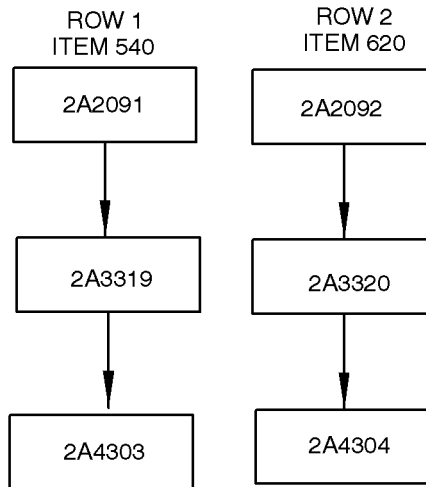
Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628
Appendix 1 - Page 17

MODIFICATIONS
BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION

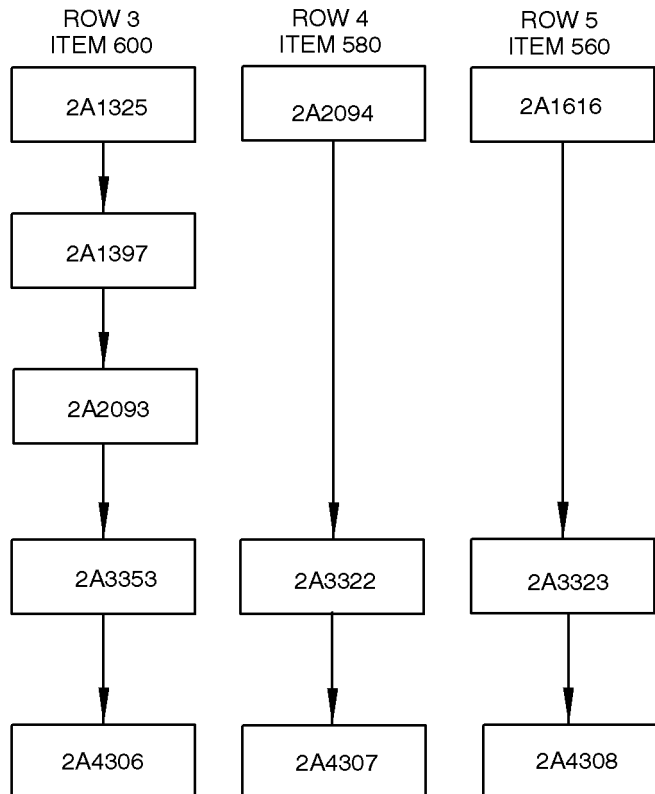
**INNER LINER SEGMENTS
(FOR V2500-A1 ENGINES ONLY)**

BASE LINE

V2500-ENG-72-0006
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - THERMAL BARRIER COATING
FOR COMBUSTION LINERS

V2500-ENG-72-0116
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER ASSEMBLIES
WITH GRNATION II LINER ASSEMBLIES

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION



**FAMILY TREE – INNER COMBUSTION CHAMBER LINER ASSEMBLY
(V2500-A1 ENGINES ONLY) Ref. Catalog Sequence No. 72-42-61, Fig. 1
Chart J**

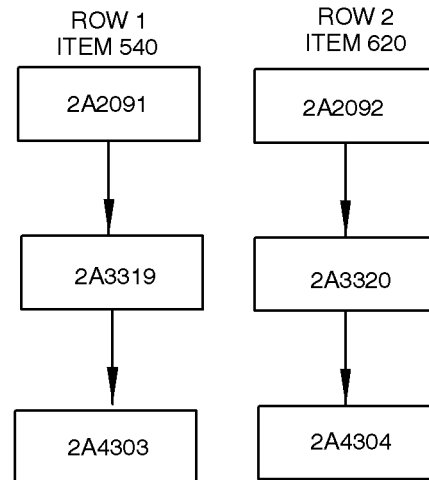
INNER LINER SEGMENTS
(ALL ENGINES EXCEPT FOR V2500-A1 & SINGLE CRYSTAL OPTION)

MODIFICATIONS

BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

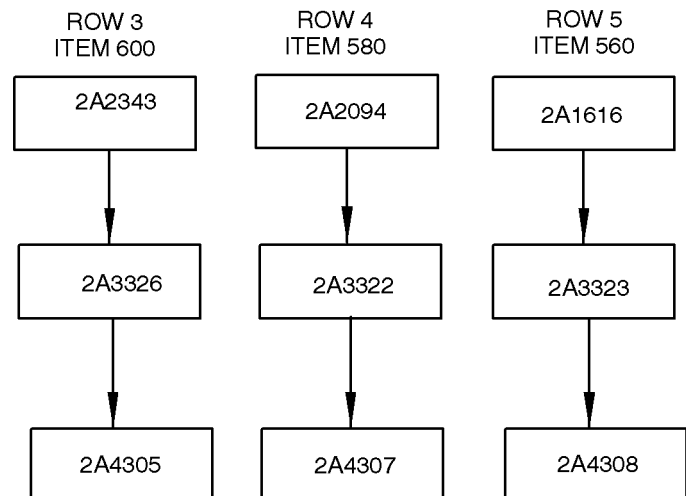
V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION



BASE LINE

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION



pw0b524079

FAMILY TREE - INNER COMBUSTION CHAMBER LINER ASSEMBLY
(ALL ENGINES EXCEPT V2500-A1) Ref. Catalog Sequence No. 72-42-61, Fig. 1
Chart K

**COMBUSTION CHAMBER LINER SEGMENT
V2500-A5 ENGINES ONLY WITH SINGLE CRYSTAL OPTION)**

MODIFICATIONS

V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION

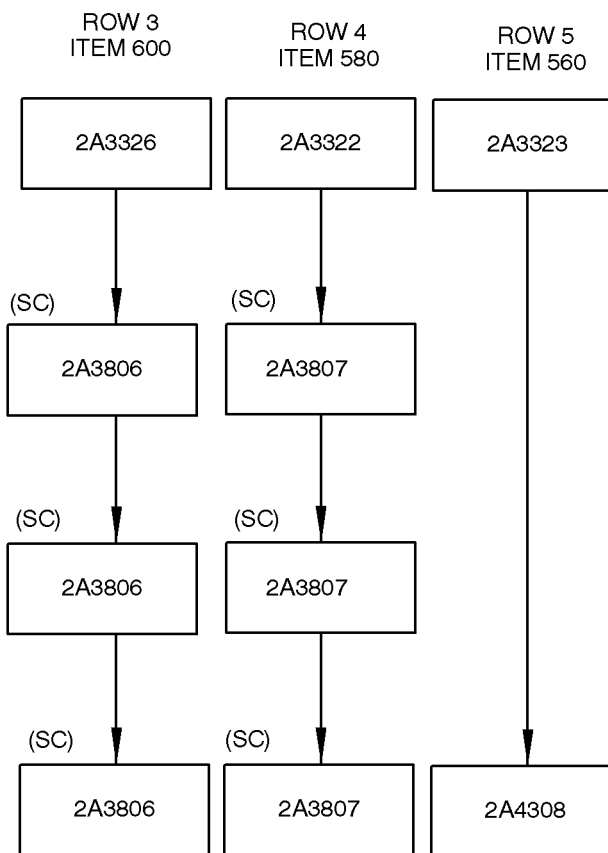
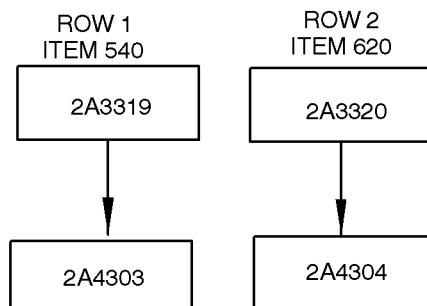
V2500-ENG-72-0315
ENGINE - DIFFUSER AND COMBUSTION
GROUP AND STAGE 1 TURBINE NOZZLE
ASSEMBLY - PROVIDE NEW INNER AND
OUTER COMBUSTION CHAMBER LINERS
WITH ADDITION OF PWA 281 COATING

V2500-ENG-72-0447
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
SINGLE CRYSTAL MATERIAL
ON ROWS 3 AND 4

V2500-ENG-70-0995
INFORMATION - ENGINE - INNER
AND OUTER COMBUSTION CHAMBER
LINERS WITH ADDITION OF SINGLE
CRYSTAL MATERIAL ON ROWS 3 AND 4

V2500-ENG-72-0628
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH IMPROVED CHEMISTRY TO
REDUCE OXIDATION

(SC) SINGLE CRYSTAL



**FAMILY TREE – INNER COMBUSTION CHAMBER LINER ASSEMBLY
(SINGLE CRYSTAL OPTION) Ref. Catalog Sequence No. 72-42-61, Fig. 1
Chart L**

APPENDIX 2Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC10VA001, EC10VA001-01, EC10VA001-02, EC10VA001-03, EC10VA001K, EC10VA001Y, EC10VA001Y-01, EC12VK010, EC12VK010A and EC12VK010B	ARO/CMS

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

ENGINE – INNER AND OUTER COMBUSTION CHAMBER LINERS WITH IMPROVED CHEMISTRY TO REDUCE
OXIDATIONSupplement – Prices and Availability

The prices 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 Catalog for current prices.

1. Modification Kit

Not applicable.

2. Material Cost

A. The estimated price of new material to do this Service Bulletin using new replacement parts is \$ 122,600,00.

3. New Production Parts

New Production Part Number	Description	Unit Price US Dollars
2A4289	LINER SEGMENT, CC, 1 OD	1018.00
2A4290	LINER SEGMENT, CC, 1 OD	1018.00
2A4291	LINER SEGMENT, CC, 2 OD	1018.00
2A4292	LINER SEGMENT, CC, 2 OD IGN	1018.00
2A4293	LINER SEGMENT, CC, 2 OD IGN	1018.00
2A4294	LINER SEGMENT, CC, 3 OD	1018.00
2A4295	LINER SEGMENT, CC, 3 OD	1018.00
2A4296	LINER SEGMENT, CC, 4 OD	1018.00
2A4297	LINER SEGMENT, CC, 4 OD	1018.00

Aug.31/12
Aug.31/12 Initial Issue

V2500-ENG-72-0628
Supplement Page 1 of 2

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New Production Part Number	Description	Unit Price US Dollars
2A4298	LINER SEGMENT, CC, 5 OD	1018.00
2A4299	LINER SEGMENT, CC, BULKHEAD	1018.00
2A4303	LINER SEGMENT, CC, 1 ID	1018.00
2A4304	LINER SEGMENT, CC, 2 ID	1018.00
2A4305	LINER SEGMENT, CC, 3 ID	1018.00
2A4306	LINER SEGMENT, CC, 3 ID IGN	1018.00
2A4307	LINER SEGMENT, CC, 4 ID	1018.00
2A4308	LINER SEGMENT, CC, 5 ID	1018.00



International Aero Engines™

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- Quality rating of the Illustration	☐ 1	☐ 2	☐ 3	☐ 4	☐ 5
- Is this Service Bulletin easy to understand ?	☐ Yes	☐ No			

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Planning Information Section:		Material Information Section:	Accomplishment Instruction Section:
☐ 1.A.	☐ 1.I.	☐ 2.A.	☐ General
☐ 1.B.	☐ 1.J.	☐ 2.B.	☐ Get Access
☐ 1.C.	☐ 1.K.	☐ 2.C.	☐ Removal/Installation
☐ 1.D.	☐ 1.L.	☐ 2.D.	☐ Inspection
☐ 1.E.	☐ 1.M.	☐ 2.E.	☐ Test
☐ 1.F.	☐ 1.N.	☐ 2.F.	☐ Close the Access
☐ 1.G.	☐ 1.O.		☐ Log Book Entry
☐ 1.H.	☐ 1.P.		

Explanatory notes:

Operator:	Overhaul Site:
Name/Title:	Date:

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