

SERVICE BULLETIN

NON-MODIFICATION SERVICE BULLETIN — ENGINE — REAR STATIC SEAL, HIGH PRESSURE
COMPRESSOR (HPC) — REPLACEMENT OF SUSPECT HPC REAR STATIC SEALS

MODEL APPLICATION

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

BULLETIN ISSUE SEQUENCE

V2500 Series 72-0641

ATA NUMBER

72-42-50

IAE PROPRIETARY INFORMATION

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Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

Compliance Category

6

July 22/14

V2500-ENG-72-0641

Summary

See Reason.

Planning Information

Effectivity Data

Engine Models Applicable

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5
Engine Serial No. V16670
Engine Serial No. V16674

Concurrent Requirements

There are no concurrent requirements.

Reason

Two high pressure compressor rear static seals have been found manufactured from material which does not meet the design specification requirements.

Description

Replace the High Pressure Compressor Rear Static Seal, PN 6B1412, with a replacement part manufactured to the correct material design specification.

Compliance

Category 6

Accomplish when the subassembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

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.

The compliance statement and the procedures described in this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model listed.

Manpower

1. In Service
..... Not Applicable.
2. At Overhaul
..... Not Applicable.

Weight and Balance

1. Weight Change
None.

2. Moment Arm

No Effect.

3. Datum

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 — 72-42-50.
2. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-00-40 and 72-40-00.
3. Engineering Change No. 13VR614.

Other Publications Affected

None.

Interchangeability of Parts

Not Affected.

Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

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
6B1412	1	*	SEAL — HPC, REAR STATIC	6B1412 (72-42-50-01-100)	(3)(C)

Instructions/Disposition Code Statements:

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.

(3) It is necessary to replace the used part with a replacement part during accomplishment of this Non-Modification Service Bulletin.

Spare Parts Availability

(C) The old part will continue to be supplied.

Vendor Services or Special Components/Materials

Not Applicable.

Tooling — Price and Availability

Special tools are not required to accomplish this Service Bulletin.

Reidentified Parts

Not Applicable.

Other Material Information Data

Refer to the related manual tasks given in the Accomplishment Instruction of this Non-Modification Service Bulletin.

Accomplishment Instructions

1. General
 - A. Obey all the WARNINGS and CAUTIONS in the procedures that are referred to.
2. Remove the high pressure compressor system module from the engine (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-00-40-020-000).
3. Disassemble the high pressure compressor system module (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-40-00-030-000).
4. Remove the diffuser case assembly (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-40-00-030-005).
 - A. Remove the used HPC Rear Static Seal (72-42-50, 01-100), PN 6B1412.
5. Install the diffuser case assembly (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-40-00-430-002).
 - A. Install a replacement HPC Rear Static Seal (72-42-50, 01-100), PN 6B1412.
6. Assemble the high pressure compressor system module (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-40-00-430-000).
7. Install the high pressure compressor system module on the engine (Refer to Reference 2, V2500 A1/A5 Series Engine Manual, Task 72-00-40-420-000).
8. Make sure that the work area is clean of tools, equipment, and other unwanted materials.
9. Recording Instructions
 - A. Record the incorporation of Non-Modification Service Bulletin V2500-ENG-72-0641 in the applicable engine record.
 - B. Inform the local IAE office that Non-Modification Service Bulletin V2500-ENG-72-0641 has been accomplished and provide local Field Representative with the results and findings.

Appendix

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC13VR614	MR/RR

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
ENGINE MANUAL — D5	All	E-V2500-3IA	2A4416
CMM-EHC — D5	All	EHC-V2500-3IA	2A4418
CMM-FN — D5	All	FN-V2500-3IA	2A4419
CMM-MMC — D5	All	MECH-V2500-3IA	2A4420
CMM-THD — D5	All	THD-V2500-3IA	2A4423
TLM	All	T-V2500-3IA	2A4417
SPPM (SPM) — D5	All	SPP-V2500-1IA	2A4414
EIPC — A1	V2500-A1102Q00	S-V2500-1IA	2A4427

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	
EIPC — D5	V2525/V2528-AQ02	S-V2500-3IA	2A4426
	V2525/V2528-AQ03	S-V2500-3IB	
	V2525/V2528-AQ04	S-V2500-3IC	