

SERVICE BULLETIN

ENGINE — GASKET, ASSEMBLY — INTRODUCTION OF A NEW GASKET
ASSEMBLY TO MINIMIZE LEAKAGE

MODEL APPLICATION

V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5,
V2533-A5, V2525-D5, V2528-D5

BULLETIN ISSUE SEQUENCE

V2500 Series 72-0675

ATA NUMBER

72-40-00

IAE PROPRIETARY INFORMATION

This document is the property of International Aero Engines (IAE). You may not possess, use, copy or disclose this document or any information in it, for any purpose, including without limitation to design, manufacture, or repair parts, or obtain FAA or other government approval to do so, without IAE's express written permission. Neither receipt nor possession of this document alone, from any source, constitutes such permission. Possession, use, copying or disclosure by anyone without IAE's express written permission is not authorized and may result in criminal and/or civil liability.

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

Compliance Category

7

P&W Distribution Code

V2500

August 3/17

V2500-ENG-72-0675

Summary

The purpose of this Service Bulletin is to introduce a new gasket assembly (#4 Chevron Seal) to minimize diffuser case leakage.

Planning Information

Effectivity Data

Engine Models Applicable

V2500-A1

Engine Serial Nos. V0001 thru V0361

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

Engine Serial Nos. V10001 thru V13190

Engine Serial Nos. V15001 thru V18620

V2525-D5, V2528-D5

Engine Serial Nos. V20001 thru V20285

Concurrent Requirements

There are no concurrent requirements.

Reason

1. Condition: Assembly issues with the gasket assembly (#4 chevron seal) are causing the diffuser case to leak.
2. Background: The gasket assembly has been identified as the leakage area and bulging in the gasket assembly has been seen.
3. Objective: Replace the gasket assembly with one with reduced upper ID tolerance.
4. Substantiation: Gaskets were produced to the new dimensional tolerances and installed in engines with no reported leakage problems at assembly or in service.
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

Replace the gasket assembly.

Compliance

Category 7

Accomplish when supply of superseded parts has been depleted.

August 3/17

V2500-ENG-72-0675

Page 2

IAE PROPRIETARY INFORMATION

© IAE International Aero Engines AG (date as above). All rights reserved.
Not Subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

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 aircraft Type Certificate (TC) holder has been informed of this change.

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 — 72-40-00.
2. Internal Reference No. — 15VA006.
3. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 70-00-00.
4. V2500-A1 Series Illustrated Parts Catalog, P&W Ref. PN 2A4427, Chapter/Section 72-42-30 and 72-43-20.
5. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-42-30 and 72-43-20.
6. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 72-42-30 and 72-43-20.

7. V2500 Service Bulletin V2500-ENG-72-0065 (Engine - Diffuser And Combustion Group - Introduce A New No.4 Bearing Compartment Gasket).

Other Publications Affected

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. V2500-A1 Series Illustrated Parts Catalog, P&W Ref. PN 2A4427, Chapter/Section 72-42-30 and 72-43-20.
2. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-42-30 and 72-43-20.
3. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 72-42-30 and 72-43-20.

Interchangeability of Parts

Old and new parts are directly interchangeable. However, to achieve the full benefits of the new design it is recommended that this change be incorporated in sets.

Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (Yes)

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 V2500-A1 Engines:

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Instructions — Disposition
2A4525-01	2	*	GASKET - ASSEMBLY OF	2A0558 (72-42-30-01-100) (72-43-20-01-010)	(2)(A)(L)

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
2A4525-01	2	*	GASKET - ASSEMBLY OF	2A0558 (72-42-30-01-100) (72-43-20-01-010)	(2)(A)(L)

The material data that follows is for each engine.

For V2525-D5, V2528-D5 Engines:

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Instructions — Disposition
2A4525-01	2	*	GASKET - ASSEMBLY OF	2A0558 (72-42-30-01-100) (72-43-20-01-010)	(2)(A)(L)

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.

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

August 3/17

V2500-ENG-72-0675

Page 5

IAE PROPRIETARY INFORMATION

© IAE International Aero Engines AG (date as above). All rights reserved.
Not subject to the EAR per 15 C.F.R Chapter 1, Part 734.3(b)(3).

Spare Parts Availability

(A) The new part is available.

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

Vendor Services or Special Components/Materials

Not Applicable.

Tooling — Price and Availability

Special tools are not required to accomplish this Service Bulletin.

Reidentified Parts

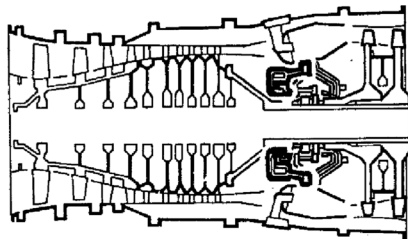
Not Applicable.

Other Material Information Data

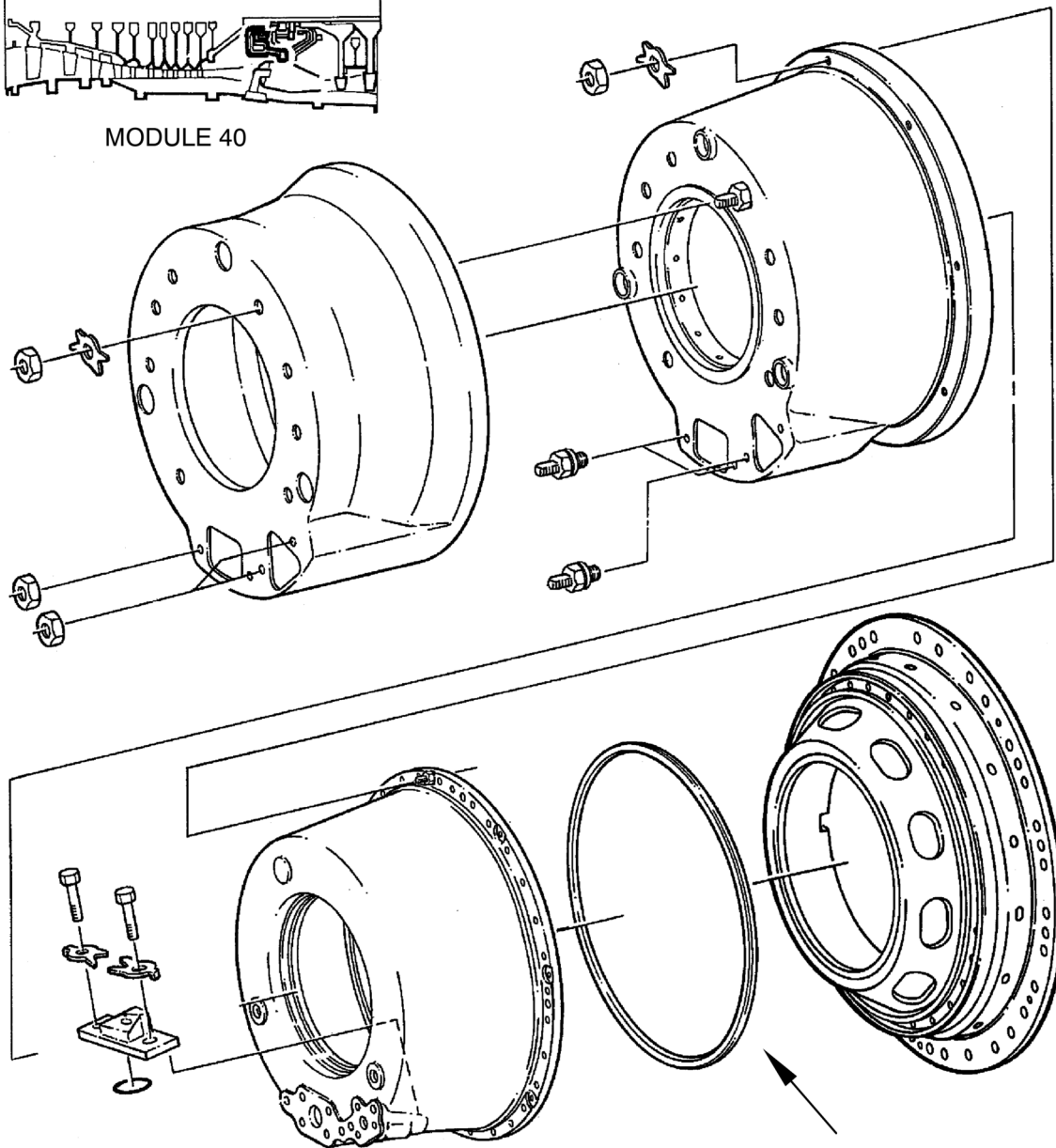
Not Applicable.

Accomplishment Instructions

1. Replace the Gasket Assembly, PN 2A0558 with PN 2A4525-01. See Figure 1 and Figure 2.
2. Recording Instructions
 - A. A record of accomplishment is required.



MODULE 40



2A0558
GASKET ASSEMBLY
REPLACE WITH
2A4525-01

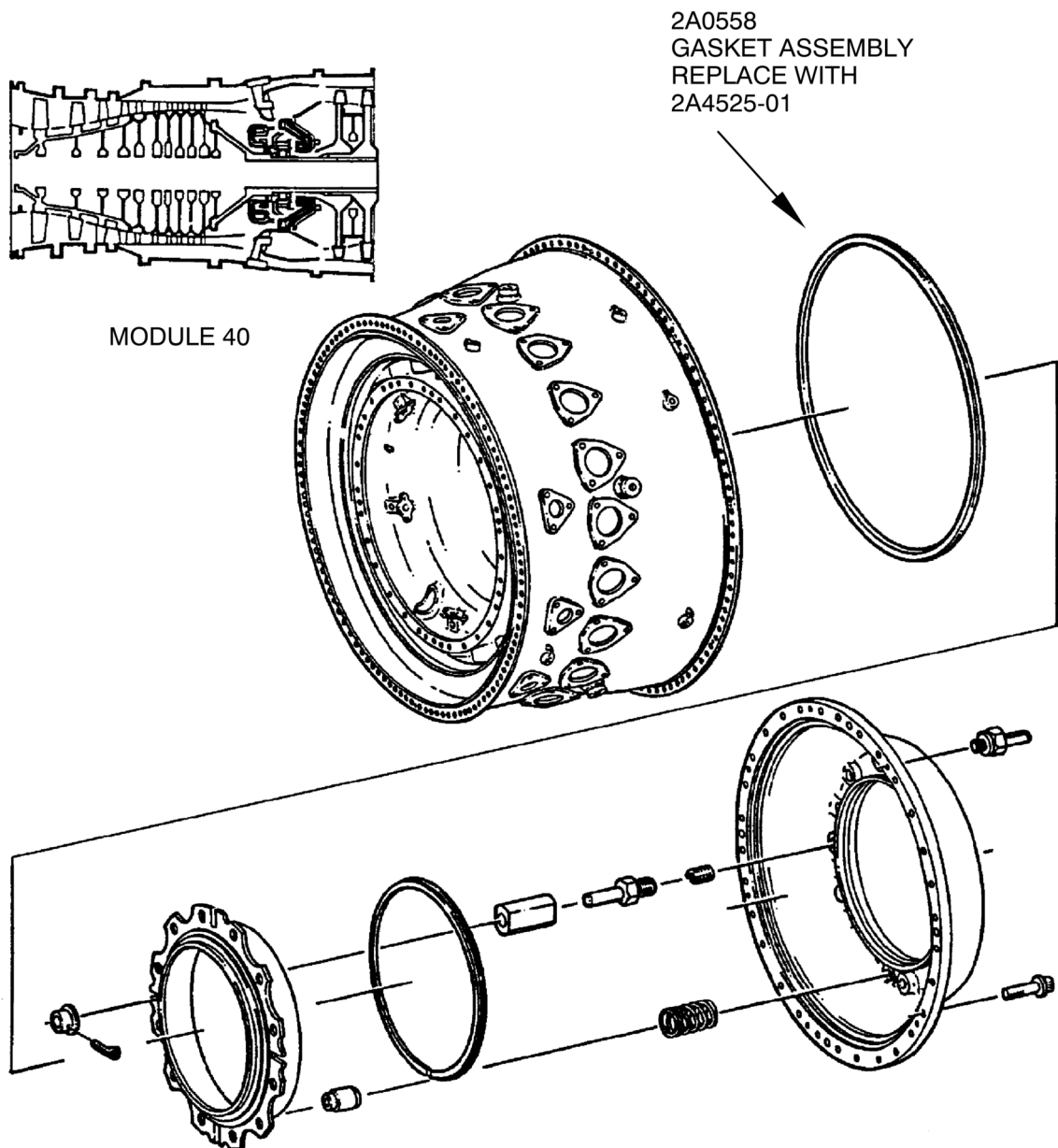
B526345

LOCATION OF THE GASKET ASSEMBLY
FIGURE 1

August 3/17

V2500-ENG-72-0675

Page 8



B526346

LOCATION OF THE GASKET ASSEMBLY
FIGURE 2

August 3/17

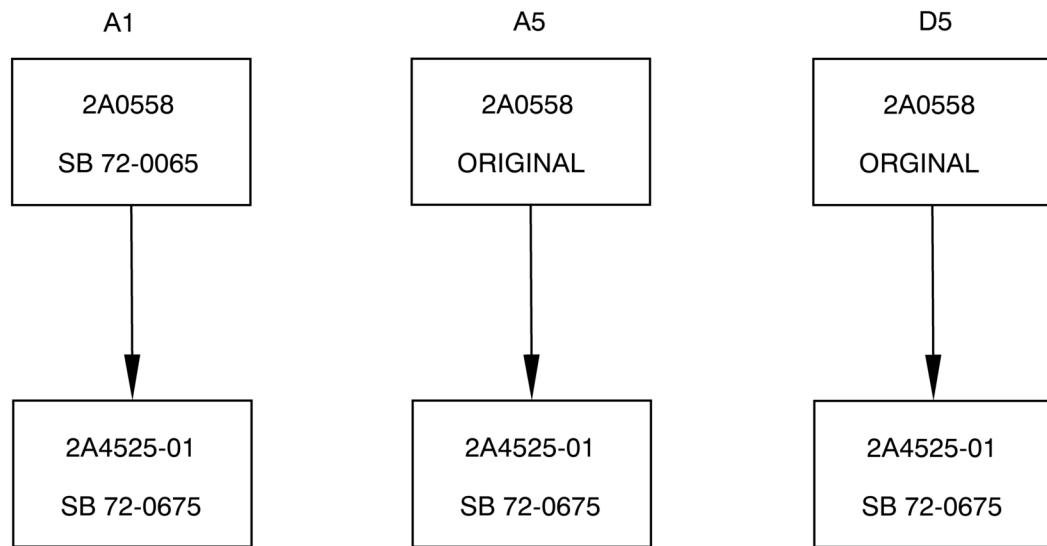
V2500-ENG-72-0675

Page 9

Appendix

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

See Figure 3.



B526350

GASKET ASSEMBLY
FIGURE 3

August 3/17

V2500-ENG-72-0675

Page 11

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC 15VA006	AC/RCM

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 — D5	All	T-V2500-3IA	2A4417
SPPM (SPM) — A1, A5, 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	