

SERVICE BULLETIN REVISION NOTICE

NON-MODIFICATION SERVICE BULLETIN - ENGINE - SEAL, AIR, HPT, 1 STAGE - REPLACEMENT OF

Turbojet Engine Service Bulletin No. V2500-ENG-72-0678 Revision No. 1 dated January 5, 2017.

Revision History

Original Issue December 13, 2016

Revision 1 dated January 5, 2017

Reason for the Revision

To clarify instructions for Industry Support Program.

Effect of Revision on Prior Compliance

None.

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

The contents are in accordance with the list of effective pages. All pages have the current revision number. Technical changes are marked with black bars.

MODEL APPLICATION

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

BULLETIN ISSUE SEQUENCE

V2500 Series 72-0678

Page

1 thru 10

Revision No.

1

Date

January 5/17

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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SERVICE BULLETIN

NON-MODIFICATION SERVICE BULLETIN - ENGINE - SEAL, AIR, HPT, 1
STAGE - REPLACEMENT OF

MODEL APPLICATION

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

BULLETIN ISSUE SEQUENCE

V2500 Series 72-0678

ATA NUMBER

72-45-12

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Compliance Category

6

P&W Distribution Code

V2500

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Summary

The purpose of this Non-Modification Service Bulletin (NMSB) is to replace twelve (12) suspect High Pressure Turbine (HPT) Stage 1 Air Seals, PN 2A3423. Production defects have been reported that may impact the certified life of these twelve (12) parts.

Planning Information

Effectivity Data

Engine Models Applicable

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5
Engine Serial Nos. V10001 thru V18254

V2525-D5, V2528-D5
Engine Serial Nos. V20001 thru V20285

Concurrent Requirements

There are no concurrent requirements.

Reason

1. Condition: Certain HPT 1st stage air seals may exhibit manufacturing defects which could impact the part certified life. These parts will require replacement with a new part.
2. Background: Production defects have been reported by one manufacturer in an area that may impact the certified life of these parts. Twelve (12) parts are suspect. There is no method to inspect for these defects; requiring replacement.
3. Objective: Replace the suspect parts with a new part.
4. Substantiation: Structural analysis based on location of reported manufacturing defect.
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 HPT 1st Stage Air Seal, PN 2A3423 if it has a serial number listed within the Accomplishment Instructions.

Compliance

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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 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.

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 — 72-45-12.
2. Internal Reference No. — 16VC338.
3. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-45-12.
4. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 72-45-12.
5. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-45-10.
6. V2500-D5 Series Engine Manual, P&W Ref. PN 2A4416, Chapter/Section 72-45-10.

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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. There is no kit provided to do this Service Bulletin.
2. Part availability information is provided in material data Instructions — Disposition.

Industry Support Program

For V2500-A5 and V2500-D5 Engines in the effectivity of this Service Bulletin.

Under this program the operator is offered support in the form of a discount for unused cycles of the HPT Stage 1 Air Seals, PN 2A3423 if deemed un-serviceable as a result of the accomplishment of this NMSB.

Pro Rata Discount will be calculated as follows:

$$((20,000 \text{ cycles} - \text{Actual cycles used} - 2,000 \text{ cycles stub time}) / 20,000 \text{ cycles}) \times \text{Catalog List Price} = \text{Pro Rata Discount}$$

To be eligible for this discount:

- HPT Stage 1 Air Seals, PN 2A3423 must be replaced with new.
- Proof of mutilation of HPT Stage 1 Air Seals, PN 2A3423 (countersigned by the local PW/IAE representative) must be provided to IAE.
- All required documentation must be submitted to IAE within 180 days of the applicable Shop Visit completion date. Requests received after the 180 day period, even if they are prior to the expiration date of this Support Program, will be ineligible for the IAE spare parts discount and disqualified.

No duplicate benefits through FHA, Service Policy or other Support Programs will be approved.

Customers are requested to place a purchase order for the parts through their normal PW/IAE spare parts channel.

Upon approval, IAE Materials Management will issue the applicable IAE spare parts discount to the Customer's account with IAE.

This support program is valid through December, 31, 2026.

If you have any questions concerning this offer please contact your IAE Customer Field Representative or Customer Fleet Director.

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
	1	133,140.00	SEAL - AIR, HPT, 1STG	2A3423 (72-45-12-01-040)	(4)(X)

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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
	1	133,140.00	SEAL - AIR, HPT, 1STG	2A3423 (72-45-12-01-040)	(4)(X)

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.

(4) Replace parts as specified in the Accomplishment Instructions if applicable.

Spare Parts Availability

(X) See Reference 3 or 4 for applicable part replacement.

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.

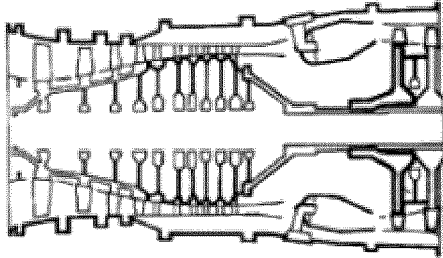
Accomplishment Instructions

1. Remove the suspect HPT 1st Stage Air Seal, PN 2A3423, identified by serial number in Table 1. Reference 5 or 6. Engine Manual, Chapter/Section 72-45-10.
 - A. The HPT 1st Stage Air Seal, PN 2A3423, identified by serial number in Table 1 must be either returned to IAE or scrapped locally. If scrapped, a photograph or digital image of the mutilated HPT 1st Stage Air Seal, PN 2A3423, and a copy of the scrap tag, countersigned by the local IAE representative, must be provided to IAE Warranty.
2. Install new non-suspect HPT 1st Stage Air Seal, PN 2A3423, when assembling the HPT Stage 1 Rotor Assembly. Reference 5 or 6. Engine Manual, Chapter/Section 72-45-10.
3. Recording Instructions
 - A. A record of accomplishment is required.

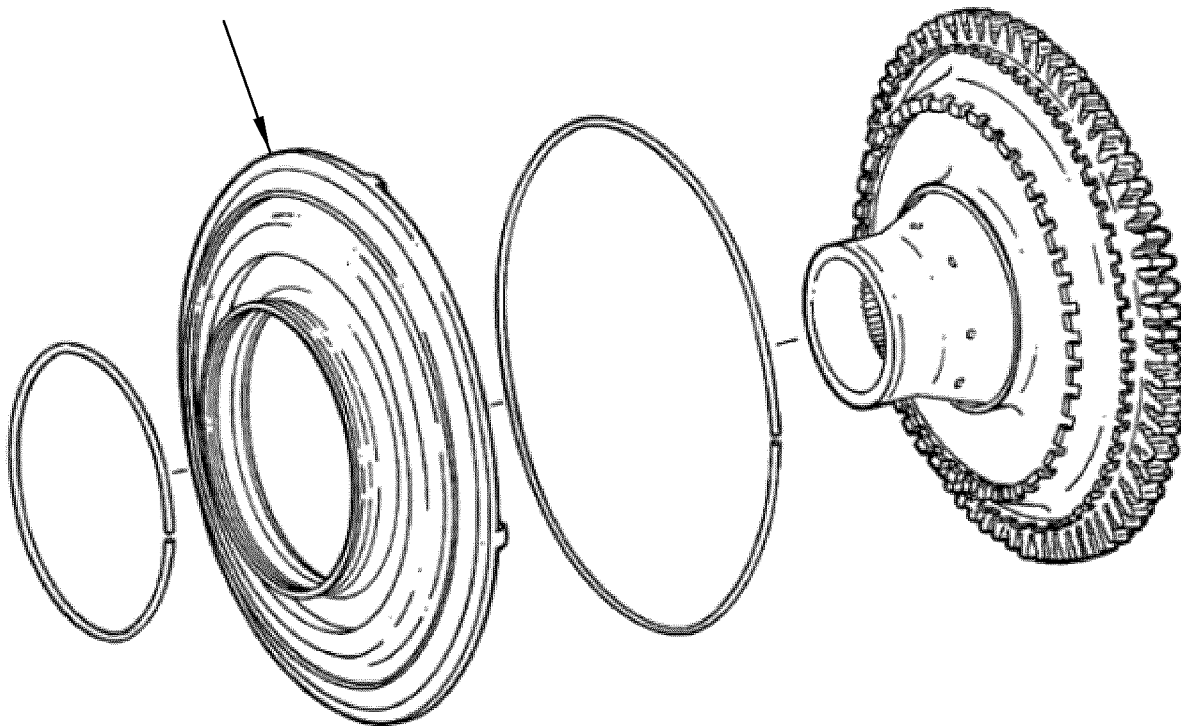
Table 1

Serial Number	
PKLBJC5390	PKLBJC5392
PKLBJC5394	PKLBJC5395
PKLBJC5397	PKLBJC5398
PKLBJC5406	PKLBJC5407
PKLBJC5412	PKLBJC5413
PKLBJC5414	PKLBJC5415

MODULE 40



2A3423
1ST STAGE HPT AIR SEAL
REPLACE AS SPECIFIED IN THE
ACCOMPLISHMENT INSTRUCTIONS



B526464

LOCATION OF THE 1ST STAGE HPT AIR SEAL
FIGURE 1

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Appendix

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EA 16VC338	MK/JAC
1	EA 16VC338A	MK/JAC

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
ENGINE MANUAL — D5	All	E-V2500-3IA	2A4416
CMM-EHC — D5	All	EHC-V2500-31A	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

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

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