

# SERVICE BULLETIN REVISION NOTICE

NON-MODIFICATION SERVICE BULLETIN - ENGINE - PLATE, RING HPT, STAGE 2 -  
REPLACEMENT OF

Turbojet Engine Service Bulletin No. V2500-ENG-72-0681 Revision No. 2 dated January 9, 2017.

## Revision History

Original Issue December 13, 2016

Revision 1 dated January 5, 2017

Revision 2 dated January 9, 2017

## Reason for the Revision

To correct the date for Revision 1 from January 5, 2016 to January 5, 2017.

## 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 72-0681

## Page

## Revision No.

## Date

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**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 - PLATE, RING HPT,  
STAGE 2 - 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

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## ATA NUMBER

72-45-33

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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 two hundred eighty eight (288) suspect High Pressure Turbine (HPT) Stage 2 Ring Plates, PN 2A3437. Production defects have been reported that may impact the certified life of these two hundred eighty eight (288) 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 stage 2 ring plates 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. Two hundred eighty eight (288) parts are suspect. There is no method to inspect for these defects; requiring replacement.
3. Objective: Replace the suspect parts with new parts.
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 suspect HPT Stage 2 Ring Plate, PN 2A3437 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 — 72-45-33.
2. Internal Reference No. — 16VC446.
3. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-45-33.
4. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 72-45-33.
5. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-45-30.
6. V2500-D5 Series Engine Manual, P&W Ref. PN 2A4416, Chapter/Section 72-45-30.

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Other Publications Affected

Not Applicable.

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 2 Ring Plate, PN 2A3437 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 2 Ring Plate, PN 2A3437 must be replaced with new.
- Proof of mutilation of HPT Stage 2 Ring Plate, PN 2A3437 (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	88,460.00	PLATE - RING HPT, STAGE 2	2A3437 (72-45-33-01-020)	(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	88,460.00	PLATE - RING HPT, STAGE 2	2A3437 (72-45-33-01-020)	(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 Stage 2 Ring Plate, PN 2A3437, identified by serial number in Table 1. Reference 5 or 6. Engine Manual, Chapter/Section 72-45-30.
  - A. The HPT Stage 2 Ring Plate, PN 2A3437, 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 Stage 2 Ring Plate, PN 2A3437, 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 Stage 2 Ring Plate, PN 2A3437, when assembling the HPT Stage 2 Rotor Assembly. Reference 5 or 6. Engine Manual, Chapter/Section 72-45-30
3. Recording Instructions
  - A. A record of accomplishment is required.

Table 1

Serial Number				
PKLBH15016	PKLBH15017	PKLBH15018	PKLBH15019	PKLBH15020
PKLBH15022	PKLBH15025	PKLBH15026	PKLBH15027	PKLBH15028
PKLBH15031	PKLBH15032	PKLBH15033	PKLBH15034	PKLBH15035
PKLBH15036	PKLBH15037	PKLBH15040	PKLBH15042	PKLBH15043
PKLBH15044	PKLBH15045	PKLBH15047	PKLBH15048	PKLBH15049
PKLBH15050	PKLBH15051	PKLBH15052	PKLBH15055	PKLBH15056
PKLBH15057	PKLBH15058	PKLBH15059	PKLBH15060	PKLBH15061
PKLBH15062	PKLBH15064	PKLBH15065	PKLBH15066	PKLBH15070
PKLBH15071	PKLBH15072	PKLBH15075	PKLBH15082	PKLBH15083
PKLBH15084	PKLBH15085	PKLBH15086	PKLBH15087	PKLBH15088
PKLBH15089	PKLBH15091	PKLBH15092	PKLBH15093	PKLBH15094
PKLBH15095	PKLBH15096	PKLBH15097	PKLBH15098	PKLBH15099
PKLBH15100	PKLBH15101	PKLBH15102	PKLBH15103	PKLBH15104
PKLBH15105	PKLBH15106	PKLBH15107	PKLBH15108	PKLBH15109
PKLBH15110	PKLBH15111	PKLBH15112	PKLBH15113	PKLBH15114
PKLBH15115	PKLBH15116	PKLBH15117	PKLBH15118	PKLBH15119
PKLBH15120	PKLBH15121	PKLBH15122	PKLBH15123	PKLBH15124
PKLBH15125	PKLBH15126	PKLBH15127	PKLBH15128	PKLBH15129
PKLBH15130	PKLBH15131	PKLBH15132	PKLBH15133	PKLBH15134
PKLBH15136	PKLBH15137	PKLBH15138	PKLBH15139	PKLBH15140
PKLBH15141	PKLBH15142	PKLBH15143	PKLBH15144	PKLBH15145
PKLBH15146	PKLBH15147	PKLBH15148	PKLBH15149	PKLBH15150

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Serial Number				
PKLBH15151	PKLBH15152	PKLBH15153	PKLBH15154	PKLBH15155
PKLBH15156	PKLBH15157	PKLBH15158	PKLBH15159	PKLBH15160
PKLBH15161	PKLBH15162	PKLBH15163	PKLBH15164	PKLBH15165
PKLBH15166	PKLBH15167	PKLBH15168	PKLBH15169	PKLBH15170
PKLBH15171	PKLBH15172	PKLBH15174	PKLBH15175	PKLBH15176
PKLBH15177	PKLBH15178	PKLBH15179	PKLBH15180	PKLBH15181
PKLBH15182	PKLBH15183	PKLBH15184	PKLBH15185	PKLBH15187
PKLBH15188	PKLBH15190	PKLBH15191	PKLBH15192	PKLBH15193
PKLBH15195	PKLBH15196	PKLBH15197	PKLBH15198	PKLBH15199
PKLBH15200	PKLBH15201	PKLBH15202	PKLBH15203	PKLBH15204
PKLBH15205	PKLBH15207	PKLBH15208	PKLBH15210	PKLBH15211
PKLBH15212	PKLBH15213	PKLBH15214	PKLBH15216	PKLBH15217
PKLBH15218	PKLBH15219	PKLBH15220	PKLBH15223	PKLBH15224
PKLBH15225	PKLBH15226	PKLBH15227	PKLBH15228	PKLBH15230
PKLBH15231	PKLBH15233	PKLBH15234	PKLBJC5162	PKLBJC5163
PKLBJC5164	PKLBJC5165	PKLBJC5166	PKLBJC5167	PKLBJC5168
PKLBJC5169	PKLBJC5170	PKLBJC5171	PKLBJC5172	PKLBJC5173
PKLBJC5174	PKLBJC5175	PKLBJC5176	PKLBJC5177	PKLBJC5178
PKLBJC5179	PKLBJC5180	PKLBJC5181	PKLBJC5182	PKLBJC5183
PKLBJC5184	PKLBJC5185	PKLBJC5186	PKLBJC5187	PKLBJC5188
PKLBJC5189	PKLBJC5190	PKLBJC5191	PKLBJC5192	PKLBJC5193
PKLBJC5194	PKLBJC5196	PKLBJC5197	PKLBJC5198	PKLBJC5199
PKLBJC5200	PKLBJC5201	PKLBJC5202	PKLBJC5203	PKLBJC5204
PKLBJC5205	PKLBJC5206	PKLBJC5207	PKLBJC5208	PKLBJC5209
PKLBJC5210	PKLBJC5211	PKLBJC5212	PKLBJC5213	PKLBJC5214
PKLBJC5216	PKLBJC5217	PKLBJC5218	PKLBJC5219	PKLBJC5220
PKLBJC5221	PKLBJC5222	PKLBJC5223	PKLBJC5224	PKLBJC5226
PKLBJC5227	PKLBJC5228	PKLBJC5229	PKLBJC5230	PKLBJC5231
PKLBJC5232	PKLBJC5233	PKLBJC5234	PKLBJC5235	PKLBJC5236
PKLBJC5237	PKLBJC5238	PKLBJC5239	PKLBJC5240	PKLBJC5242
PKLBJC5243	PKLBJC5244	PKLBJC5246	PKLBJC5247	PKLBJC5248
PKLBJC5249	PKLBJC5250	PKLBJC5251	PKLBJC5252	PKLBJC5254
PKLBJC5255	PKLBJC5256	PKLBJC5257	PKLBJC5258	PKLBJC5259

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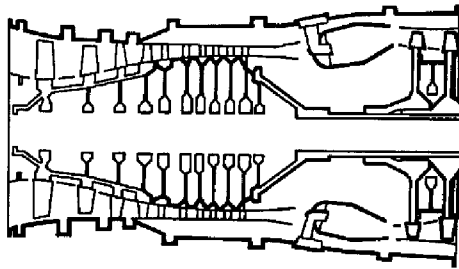
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Serial Number				
PKLBJC5260	PKLBJC5261	PKLBJC5262	PKLBJC5263	PKLBJC5264
PKLBJC5265	PKLBJC5266	PKLBJC5267	PKLBJC5268	PKLBJC5269
PKLBJC5283	PKLBJC5287	PKLBJC5294		

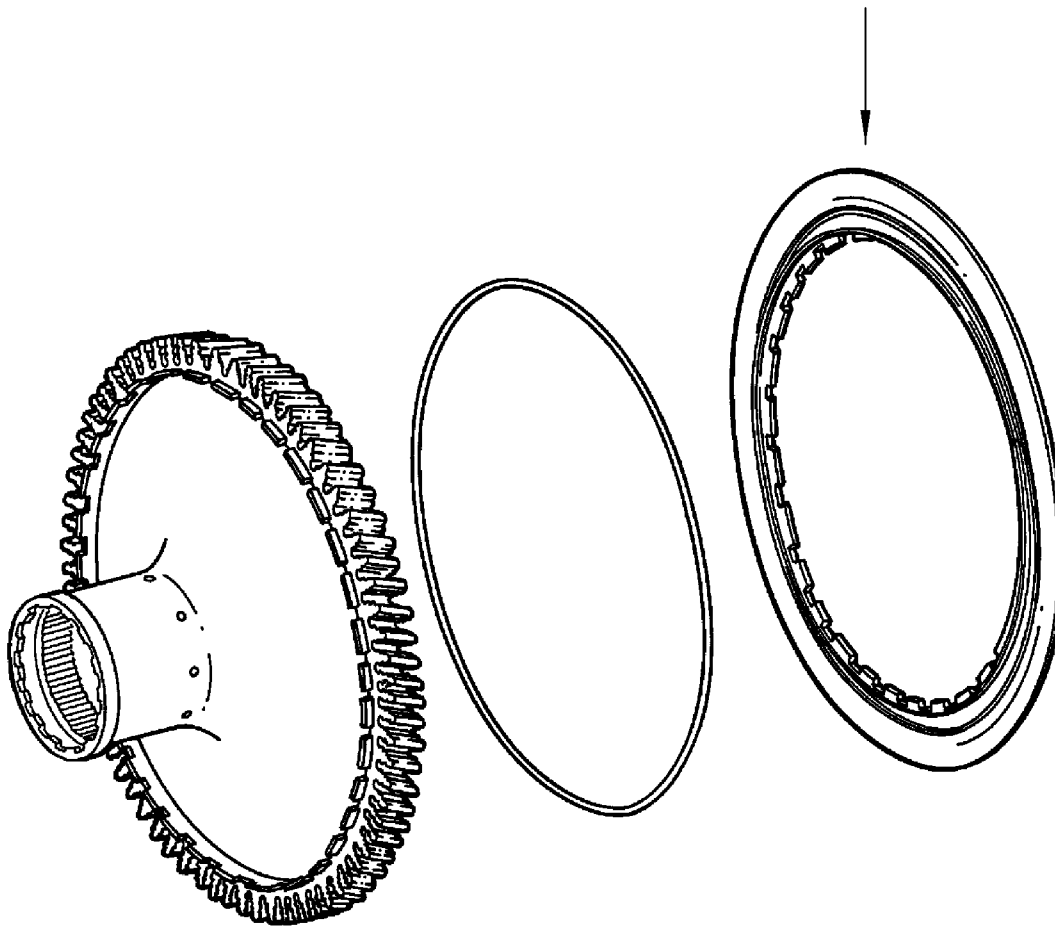
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2A3437  
HPT STAGE 2 RING PLATE  
REPLACE AS SPECIFIED IN THE  
ACCOMPLISHMENT INSTRUCTIONS



B526466

LOCATION OF THE STAGE 2 HPT RING PLATE  
FIGURE 1

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## Appendix

### Added Data

#### Internal Reference Information

Revision No.	Reference Document	Origination
Original	EA 16VC446	MK/JAC
1	EA 16VC446A	MK/JAC
2	EA 16VC446A	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-V2500-3IA	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

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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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