

SERVICE BULLETIN

NON-MODIFICATION SERVICE BULLETIN — ENGINE — HIGH PRESSURE TURBINE (HPT)
STAGE 2 VANE — INSPECT INTERNAL RIB AT 1ST PIECE PART INSPECTION

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 72-0688

ATA NUMBER

72-45-00

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

Compliance Category

6

P&W Distribution Code

V2500

September 6/18

V2500-ENG-72-0688

Summary

The purpose of this Non-Modification Service Bulletin (NMSB) is to inspect and replace, as required, a population of HPT stage 2 vanes (serial number specific) that are suspect of being manufactured with laser drill breakthrough on the leading edge rib. The HPT stage 2 vanes are to be inspected at first repair (VRS3591) for airfoil laser drilled holes that may have penetrated through the internal rib.

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 V18628

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

Engines serial numbers those affected by HPT 2nd Stage Ring Segment Vane Clusters PN, 2A4462, 2A4562, 2A6102 and 2A4072 or detail pieces HPT Stage 2 Vanes PN, 2A4482, 2A4582, 2A4272 and 2A4082.

Concurrent Requirements

There are no concurrent requirements.

Reason

1. Condition: Certain HPT stage 2 vanes may have airfoil laser drilled holes that have penetrated to the internal rib which could impact the part life.
2. Background: The manufacturing process may have led to laser drill breakthrough on the leading edge rib.
3. Objective: During the repair process (VRS3591, EM Task 72-45-24-300-024), use the existing inspection requirements to inspect the internal passage for laser drilled cooling holes that penetrated through the internal rib.
4. Substantiation: A structural and durability assessment of the non-conforming condition was completed and concluded that this non-conforming condition during first run will not adversely affect the time on-wing of the HPT stage 2 vane or the high pressure turbine module.
5. Effects of Bulletin on:
Removal/Installation: Not Affected.
Disassembly/Assembly: Not Affected.
Cleaning: Not Affected.
Inspection/Check: Affected.
Repair: Not Affected.
Testing: Not Affected.
6. Supplemental Information
None.

Description

At first repair (VRS3591) of HPT 2nd Stage Ring Segment Vane Clusters PN 2A4462, 2A4562, 2A6102, 2A4072 or detail pieces, HPT Stage 2 Vanes PN 2A4482, 2A4582, 2A4272 & 2A4082 with serial numbers listed in Tables 1, 2, 3 and 4, inspect per Reference 6 and 7, Engine Manual TASK 72-45-24-300-024 (VRS3591), for laser drilled cooling holes that penetrated through the internal rib.

Record the part number and serial number of inspection accomplishment and report the findings to your IAE Customer Field Representative or Customer Fleet Director.

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 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 — 72-45-00.
2. Internal Reference No. — 17VC209.
3. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 72-45-00.
4. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-45-00.
5. V2500-D5, Series Illustrated Parts Catalog, P&W Ref. PN 2A4426, Chapter/Section 72-45-00.
6. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-45-00.
7. V2500-D5 Series Engine Manual, P&W Ref. PN 2A4416, Chapter/Section 72-45-00.

Other Publications Affected

None.

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)

Material Information

Material — Price and Availability

1. There is no kit provided to do this Service Bulletin.
2. Part prices were not available at the time of Service Bulletin publication. Contact IAE Spares Management & Logistics for firm quotations.
3. 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 one-time discount of 75% off catalog list price for affected HPT stage 2 vanes (as listed in tables 1, 2, 3, and 4 of this NMSB) rejected per the accomplishment instructions.

To be eligible for this discount:

- Affected HPT stage 2 vanes (as listed in tables 1, 2, 3 and 4 of this NMSB) must be replaced with new.
- Determine through your local IAE field representative if the removed HPT stage 2 vane should be returned to PW/IAE for investigation.
- If return of the vane is not required, scrap tag or scrap report for applicable vanes, (countersigned by the local IAE representative) must be provided to IAE.
- PO for new part purchase 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, 2028.

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	*	SEGMENT, RING HPT STG 2 VANE	2A4462 (72-45-24-02-050 S)	(4)(X)
	1	*	SEGMENT, RING HPT STG 2 VANE	2A4562 (72-45-24-02-260 Q)	(4)(X)
	1	*	RING SEGMENT AND VANE CLUSTER	2A6102 (72-45-24-02-050 Q)	(4)(X)
	1	*	RING SEGMENT AND VANE CLUSTER	2A4072 (72-45-24-02-260 O)	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4482	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4582	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4272 (72-45-24-02-130 I) (72-45-24-02-350 L)	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4082 (72-45-24-02-420 L)	(4)(X)

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	*	RING SEGMENT AND VANE CLUSTER	2A6102 (72-45-24-02-050 S)	(4)(X)
	1	*	RING SEGMENT AND VANE CLUSTER	2A4072 (72-45-24-02-260 R)	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4482	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4582	(4)(X)

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Instructions — Disposition
	1	*	VANE, ASSY OF HPT STG 2	2A4272 (72-45-24-02-130 K) (72-45-24-02-350 K)	(4)(X)
	1	*	VANE, ASSY OF HPT STG 2	2A4082 (72-45-24-02-420 K)	(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) Do an inspection as specified in the Accomplishment Instructions.

Spare Parts Availability

(X) See Reference 4 or 5, Illustrated Parts Catalog for applicable replacement parts.

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

NOTE: This inspection should be accomplished prior to application of turbofix and or welding operation. Laser drilled cooling holes that penetrated through the internal rib may not exceed the repair limit.

1. During first repair of the HPT 2nd stage vanes listed in Tables 1, 2, 3 and 4, visually inspect the internal passage through the outer platform forward passage opening with a borescope. Refer to Reference 6 and 7, Engine Manual TASK 72-45-24-300-024 (VRS3591). See Figure 1.
2. Recording Instructions
 - A. A record of accomplishment is required.
 - B. Record the PN and SN of inspection accomplishment and report the findings to your IAE Customer Field Representative or Customer Fleet Director.
 - C. Provide scrap tag or scrap report for applicable vanes countersigned by your local IAE representative.

Table 1 — Serial Numbers for HPT Stage 2 Vane Detail Piece PN 2A4082

PKLBNJ7959	PKLBNJ7883	PKLBNJ7884	PKLBNJ7885	PKLBNJ7886
PKLBNJ7887	PKLBNJ7888	PKLBNJ7891	PKLBNJ7895	PKLBNJ7961
PKLBNJ7965	PKLBNJ7966	PKLBNJ7967	PKLBNJ7968	PKLBNJ7970
PKLBNJ7973	PKLBNJ7974	PKLBNJ7975	PKLBNJ7987	PKLBNJ7988
PKLBNR2521	PKLBNR2539	PKLBNR2540	PKLBNR2541	PKLBNR2542
PKLBNR2544	PKLBNR2549	PKLBNR2551		

Table 2 — Serial Numbers for HPT Stage 2 Vane Detail Piece PN 2A4272

PKLBP91563	PKLBP91534	PKLBP91556	PKLBP91560	PKLBP91574
PKLBP91669	PKLBP91687	PKLBP91692	PKLBP91696	PKLBP91700
PKLBP91807	PKLBP91808	PKLBP91815	PKLBP91816	PKLBP91829
PKLBP91874	PKLBP91903	PKLBP91909	PKLBP91963	PKLBP91964
PKLBP91966	PKLBP91968	PKLBP92028	PKLBP92030	PKLBP92031
PKLBP92032	PKLBP92034	PKLBP92035	PKLBP92036	PKLBP92040
PKLBP92042	PKLBP92043	PKLBP92044	PKLBP92045	PKLBP92047
PKLBP92062	PKLBP92070	PKLBP92089	PKLBP92091	PKLBP92094
PKLBP92108	PKLBP92109	PKLBP92111	PKLBP92147	PKLBP92157
PKLBP92158	PKLBP92185	PKLBP92186	PKLBP92188	PKLBP92194
PKLBP92195	PKLBP92249	PKLBP92250	PKLBP92254	PKLBP92258
PKLBP92259	PKLBP92274	PKLBP92275	PKLBP92276	PKLBP92277
PKLBP92278	PKLBP92279	PKLBP92289	PKLBP92290	PKLBP92301

PKLBP92305	PKLBP92306	PKLBP92308	PKLBP92314	PKLBP92315
PKLBP92335	PKLBP92336	PKLBP92338	PKLBP92339	PKLBP92342
PKLBP92345	PKLBP92347	PKLBP92352	PKLBP92377	PKLBP92383
PKLBP92384	PKLBP92386	PKLBP92387	PKLBP92388	PKLBP92389
PKLBP92398	PKLBP92400	PKLBP92402	PKLBP92403	PKLBP92406
PKLBP92409	PKLBP92410	PKLBP92412	PKLBP92413	PKLBP92415
PKLBP92417	PKLBP92420	PKLBP92425	PKLBP92428	PKLBP92431
PKLBP92439	PKLBP92456	PKLBP92466	PKLBP92468	PKLBP92470
PKLBP92471	PKLBP92475	PKLBP92477	PKLBP92478	PKLBP92480
PKLBP92483	PKLBP92485	PKLBP92486	PKLBP92489	PKLBP92490
PKLBP92496	PKLBP92500	PKLBP92502	PKLBP92503	PKLBP92504
PKLBP92505	PKLBP92510	PKLBP97381	PKLBP97386	PKLBP97393
PKLBP97422	PKLBP97423	PKLBP97424	PKLBP97425	PKLBP97426
PKLBP97429	PKLBP97430	PKLBP97431	PKLBP97439	PKLBP97440
PKLBP97441	PKLBP97448	PKLBP97454	PKLBP97456	PKLBP97459
PKLBP97463	PKLBP97468	PKLBP97469	PKLBP97470	PKLBP97475
PKLBP97478	PKLBP97484	PKLBP97486	PKLBP97487	PKLBP97497
PKLBP97510	PKLBP97587	PKLBP97670	PKLBP97673	PKLBP97682
PKLBP97686	PKLBP97690	PKLBP97691	PKLBP97693	PKLBP97695
PKLBP97697	PKLBP97701	PKLBP97702	PKLBP97703	PKLBP97704
PKLBP97705	PKLBP97706	PKLBP97707	PKLBP97708	PKLBP97709
PKLBP97710	PKLBP97711			

Table 3 — Serial Numbers for HPT Stage 2 Vane Detail Piece PN 2A4482

PKLBP10033	PKLBN53541	PKLBN53603	PKLBN53624	PKLBP10024
PKLBP10028	PKLBP10032	PKLBP10318	PKLBP10456	PKLBP10588
PKLBP10610	PKLBP10611	PKLBP10612	PKLBP10613	PKLBP10614
PKLBP10616	PKLBP10617	PKLBP10619	PKLBP10620	PKLBP10621
PKLBP10650	PKLBP10796	PKLBP10798	PKLBP10800	PKLBP10802
PKLBP10804	PKLBP10805	PKLBP10884	PKLBP10895	PKLBP10935
PKLBP10936	PKLBP10937	PKLBP10945	PKLBP11168	PKLBP11193
PKLBP11198	PKLBP11200	PKLBP11202	PKLBP11205	PKLBP11212
PKLBP11219	PKLBP11257	PKLBP11267	PKLBP11291	PKLBP11295
PKLBP11298	PKLBP11301	PKLBP11303	PKLBP11304	PKLBP11321

PKLBP11324	PKLBP11355	PKLBP11356	PKLBP11362	PKLBP11363
PKLBP11364	PKLBP11365	PKLBP11367	PKLBP11427	PKLBP11462
PKLBP11666	PKLBP11675	PKLBP11701	PKLBP11703	PKLBP11742
PKLBP11776	PKLBP11777	PKLBP11779	PKLBP11793	PKLBP11945
PKLBP12068	PKLBP12094	PKLBP12121	PKLBP12136	PKLBP12177
PKLBP12233	PKLBP12255	PKLBP12257	PKLBP12270	PKLBP12286
PKLBP12312	PKLBP12321	PKLBP12380	PKLBP12468	PKLBP12471
PKLBP12478	PKLBP12487	PKLBP12493	PKLBP12511	PKLBP12512
PKLBP12513	PKLBP12514	PKLBP12516	PKLBP12518	PKLBP12521
PKLBP12522	PKLBP12524	PKLBP12525	PKLBP12527	PKLBP12528
PKLBP12543	PKLBP12544	PKLBP12551	PKLBP12554	PKLBP12555
PKLBP12563	PKLBP12568	PKLBP12651	PKLBP12653	PKLBP12660
PKLBP12665	PKLBP12667	PKLBP12672	PKLBP12673	PKLBP12731
PKLBP12761	PKLBP12799	PKLBP12800	PKLBP12803	PKLBP12810
PKLBP12812	PKLBP12817	PKLBP12820	PKLBP12821	PKLBP12822
PKLBP12825	PKLBP12827	PKLBP12830	PKLBP12832	PKLBP12833
PKLBP12836	PKLBP12837	PKLBP12839	PKLBP12853	PKLBP12855
PKLBP12858	PKLBP12865	PKLBP12869	PKLBP12878	PKLBP12883
PKLBP12886	PKLBP12888	PKLBP12892	PKLBP12898	PKLBP12902
PKLBP12907	PKLBP12923	PKLBP12924	PKLBP12925	PKLBP12939
PKLBP12940	PKLBP12941	PKLBP12942	PKLBP12943	PKLBP12945
PKLBP12946	PKLBP12955	PKLBP12957	PKLBP12961	PKLBP12962
PKLBP12979	PKLBP12983	PKLBP12986	PKLBP12988	PKLBP12990
PKLBP12995	PKLBP12996	PKLBP12997	PKLBP13001	PKLBP13005
PKLBP13007	PKLBP13009	PKLBP13011	PKLBP13030	PKLBP13033
PKLBP13038	PKLBP13041	PKLBP13044	PKLBP13047	PKLBP13048
PKLBP13049	PKLBP13053	PKLBP13056	PKLBP13059	PKLBP13060
PKLBP13063	PKLBP13066	PKLBP13068	PKLBP13070	PKLBP13073
PKLBP13075	PKLBP13076	PKLBP13077	PKLBP13078	PKLBP13084
PKLBP13085	PKLBP13086	PKLBP13093	PKLBP13095	PKLBP13097
PKLBP13121	PKLBP13130	PKLBP13146	PKLBP13165	PKLBP13166
PKLBP13167	PKLBP13168	PKLBP13169	PKLBP13171	PKLBP13172
PKLBP13173	PKLBP13174	PKLBP13175	PKLBP13177	PKLBP13178
PKLBP13179	PKLBP13183	PKLBP13188	PKLBP13191	PKLBP13195

PKLBP13199	PKLBP13206	PKLBP13210	PKLBP13212	PKLBP13235
PKLBP13238	PKLBP13251	PKLBP13253	PKLBP13261	PKLBP13264
PKLBP13265	PKLBP13268	PKLBP13269	PKLBP13270	PKLBP13271
PKLBP13273	PKLBP13274	PKLBP13275	PKLBP13276	PKLBP13278
PKLBP13279	PKLBP13280	PKLBP13281	PKLBP13283	PKLBP13284
PKLBP13285	PKLBP13286	PKLBP13288	PKLBP13289	PKLBP13290
PKLBP13292	PKLBP13293	PKLBP13294	PKLBP13298	PKLBP13299
PKLBP13300	PKLBP13301	PKLBP13304	PKLBP13307	PKLBP13308
PKLBP13310	PKLBP13323	PKLBP13331	PKLBP13332	PKLBP13333
PKLBP13335	PKLBP13336	PKLBP13337	PKLBP13338	PKLBP13340
PKLBP13341	PKLBP13342	PKLBP13346	PKLBP13349	PKLBP13350
PKLBP13352	PKLBP13354	PKLBP13356	PKLBP13357	PKLBP13358
PKLBP13360	PKLBP13362	PKLBP13364	PKLBP13367	PKLBP13368
PKLBP13369	PKLBP13373	PKLBP13374	PKLBP13375	PKLBP13376
PKLBP13380	PKLBP13381	PKLBP13382	PKLBP13383	PKLBP13385
PKLBP13386	PKLBP13387	PKLBP13388	PKLBP13389	PKLBP13391
PKLBP13392	PKLBP13394	PKLBP13396	PKLBP13397	PKLBP13398
PKLBP13399	PKLBP13400	PKLBP13402	PKLBP13403	PKLBP13406
PKLBP13407	PKLBP13409	PKLBP13410	PKLBP13411	PKLBP13416
PKLBP13419	PKLBP13422	PKLBP13423	PKLBP13427	PKLBP13429
PKLBP13431	PKLBP13432	PKLBP13434	PKLBP13435	PKLBP13436
PKLBP13438	PKLBP13440	PKLBP13441	PKLBP13442	PKLBP13443
PKLBP13444	PKLBP13447	PKLBP13450	PKLBP13456	PKLBP13460
PKLBP13463	PKLBP13465	PKLBP13466	PKLBP13468	PKLBP13469
PKLBP13472	PKLBP13473	PKLBP13476	PKLBP13478	PKLBP13479
PKLBP13480	PKLBP13481	PKLBP13482	PKLBP13484	PKLBP13485
PKLBP13487	PKLBP13489	PKLBP13492	PKLBP13493	PKLBP13495
PKLBP13496	PKLBP13497	PKLBP13498	PKLBP13499	PKLBP13500
PKLBP13501	PKLBP13502	PKLBP13503	PKLBP13506	PKLBP13510
PKLBP13519	PKLBP13521	PKLBP13522	PKLBP13525	PKLBP13528
PKLBP13530	PKLBP13542	PKLBP13543	PKLBP13544	PKLBP13545
PKLBP13546	PKLBP13548	PKLBP13550	PKLBP13551	PKLBP13552
PKLBP13554	PKLBP13556	PKLBP13579	PKLBP13594	PKLBP13613
PKLBP13615	PKLBP13616	PKLBP13622	PKLBP13623	PKLBP13626

PKLBP13628	PKLBP13650	PKLBP13651	PKLBP13656	PKLBP13659
PKLBP13662	PKLBP13664	PKLBP13668	PKLBP13670	PKLBP13671
PKLBP13675	PKLBP13677	PKLBP13702	PKLBP13706	PKLBP13708
PKLBP13709	PKLBP13710	PKLBP13722	PKLBP13728	PKLBP13731
PKLBP13734	PKLBP13744	PKLBP13745	PKLBP13747	PKLBP13748
PKLBP13749	PKLBP13750	PKLBP13751	PKLBP13753	PKLBP13754
PKLBP13755	PKLBP13756	PKLBP13757	PKLBP13758	PKLBP13759
PKLBP13762	PKLBP13770	PKLBP13771	PKLBP13772	PKLBP13773
PKLBP13775	PKLBP13777	PKLBP13780	PKLBP13781	PKLBP13782
PKLBP13783	PKLBP13784	PKLBP13786	PKLBP13791	PKLBP13796
PKLBP13797	PKLBP13800	PKLBP13801	PKLBP13803	PKLBP13804
PKLBP13805	PKLBP13807	PKLBP13808	PKLBP13809	PKLBP13810
PKLBP13811	PKLBP13812	PKLBP13815	PKLBP13818	PKLBP13819
PKLBP13820	PKLBP13821	PKLBP13822	PKLBP13823	PKLBP13824
PKLBP13825	PKLBP13826	PKLBP13827	PKLBP13828	PKLBP13829
PKLBP13830	PKLBP13831	PKLBP13834	PKLBP13836	PKLBP13837
PKLBP13838	PKLBP13839	PKLBP13840	PKLBP13841	PKLBP13842
PKLBP13843	PKLBP13844	PKLBP13845	PKLBP13846	PKLBP13849
PKLBP13850	PKLBP13852	PKLBP13853	PKLBP13855	PKLBP13856
PKLBP13857	PKLBP13858	PKLBP13859	PKLBP13860	PKLBP13861
PKLBP13862	PKLBP13863	PKLBP13864	PKLBP13865	PKLBP13866
PKLBP13868	PKLBP13869	PKLBP13870	PKLBP13872	PKLBP13873
PKLBP13874	PKLBP13875	PKLBP13876	PKLBP13877	PKLBP13878
PKLBP13879	PKLBP13880	PKLBP13881	PKLBP13882	PKLBP13883
PKLBP13885	PKLBP13886	PKLBP13887	PKLBP13888	PKLBP13889
PKLBP13890	PKLBP13891	PKLBP13893	PKLBP13894	PKLBP13896
PKLBP13897	PKLBP13900	PKLBP13901	PKLBP13903	PKLBP13904
PKLBP13905	PKLBP13906	PKLBP13907	PKLBP13908	PKLBP13909
PKLBP13910	PKLBP13911	PKLBP13912	PKLBP13913	PKLBP13914
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PKLBP13921	PKLBP13922	PKLBP13923	PKLBP13924	PKLBP13925
PKLBP13926	PKLBP13928	PKLBP13929	PKLBP13931	PKLBP13933
PKLBP13934	PKLBP13936	PKLBP13937	PKLBP13939	PKLBP13940
PKLBP13941	PKLBP13944	PKLBP13945	PKLBP13946	PKLBP13947

PKLBP13948	PKLBP13949	PKLBP13950	PKLBP13951	PKLBP13952
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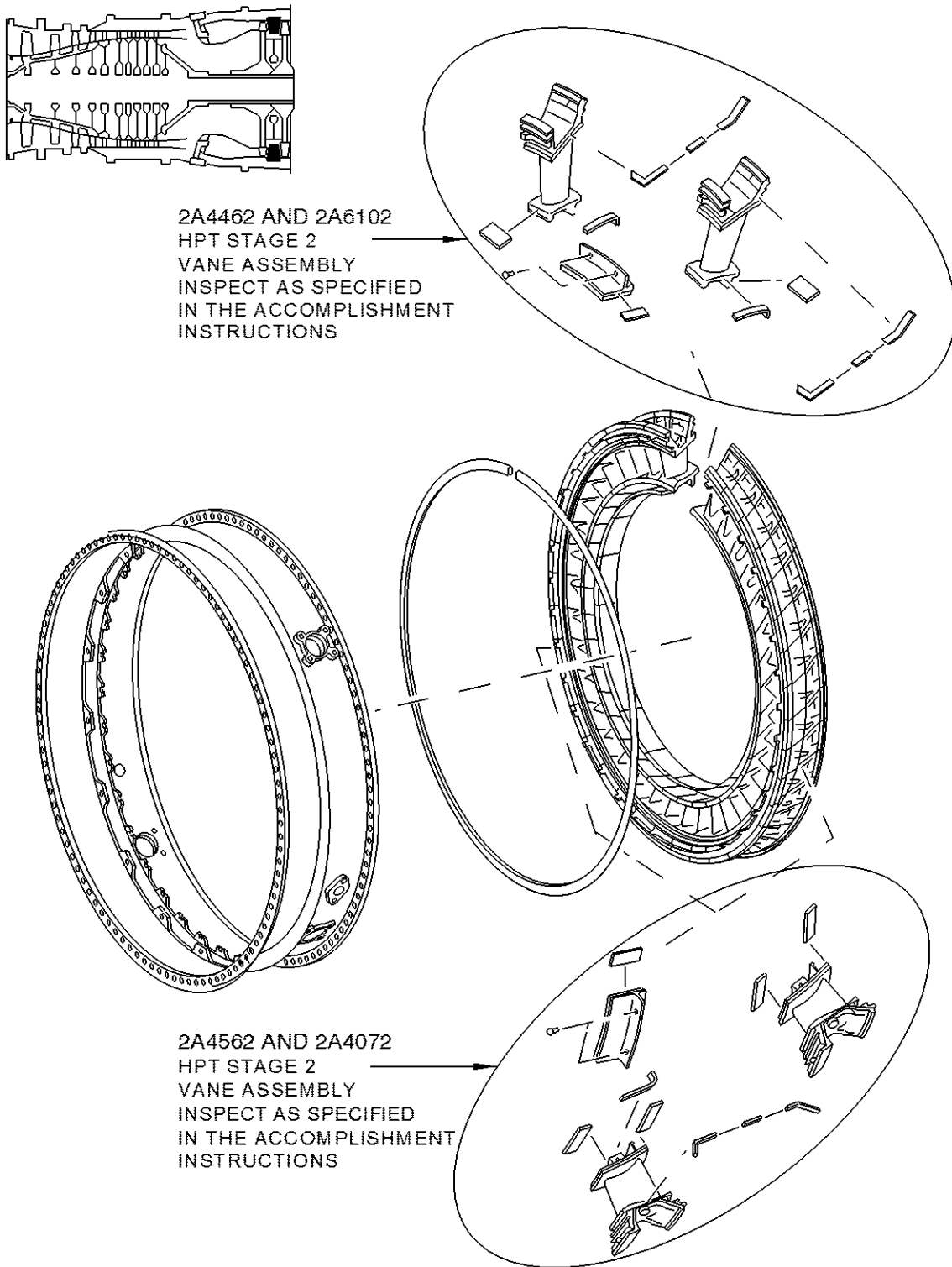
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Table 4 — Serial Numbers for HPT Stage 2 Vane Detail Piece PN 2A4582

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PKLBN55349	PKLBN55352	PKLBN55355	PKLBN55356	PKLBN55365
PKLBN55372	PKLBN55377	PKLBN55382	PKLBN55387	PKLBN55388
PKLBN55389	PKLBN55393	PKLBN55394	PKLBN55401	PKLBN55402
PKLBN55405	PKLBN55406	PKLBN55410	PKLBN55411	PKLBN55414
PKLBN55416	PKLBN55420	PKLBN55423	PKLBN55425	PKLBN55428
PKLBN55429	PKLBN55431	PKLBN55432	PKLBN55433	PKLBN55434
PKLBN55435	PKLBN55436	PKLBN55437	PKLBN55438	PKLBN55439
PKLBN55440	PKLBN55443	PKLBN55444	PKLBN55445	PKLBN55446
PKLBN55447	PKLBN55448	PKLBN55450	PKLBN55451	PKLBN55452
PKLBN55453	PKLBN55454	PKLBN55455	PKLBN55461	PKLBN55463
PKLBN55464	PKLBN55465	PKLBN55466	PKLBN55467	PKLBN55470
PKLBN55471	PKLBN55472	PKLBN55475	PKLBN55476	PKLBN55478
PKLBN55480	PKLBN55482	PKLBN55483	PKLBN55485	PKLBN55486
PKLBN55492	PKLBN55493	PKLBN55497	PKLBN55501	PKLBN55503
PKLBN55512	PKLBN55514	PKLBN55515	PKLBN55516	PKLBN55517
PKLBN55518	PKLBN55519	PKLBN55520	PKLBN55521	PKLBN55522
PKLBN55523	PKLBN55524	PKLBN55526	PKLBN55527	PKLBN55528
PKLBN55529	PKLBN55530	PKLBN55532	PKLBN55533	PKLBN55534
PKLBN55535	PKLBN55537	PKLBN55538	PKLBN55540	PKLBN55541
PKLBN55542	PKLBN55543	PKLBN55544	PKLBN55547	PKLBN55548

PKLBN55549	PKLBN55552	PKLBN55553	PKLBN55554	PKLBN55611
PKLBN55613	PKLBN55614	PKLBN55617	PKLBN55618	PKLBN55619
PKLBN55620	PKLBN55621	PKLBN55622	PKLBN55623	PKLBN55624
PKLBN55625	PKLBN55626	PKLBN55627	PKLBN55628	PKLBN55629
PKLBN55630	PKLBN55631	PKLBN55632	PKLBN55633	PKLBN55634
PKLBN55635	PKLBN55636	PKLBN55637	PKLBN55638	PKLBN55639
PKLBN55640	PKLBN55642	PKLBN55643	PKLBN55644	PKLBN55645
PKLBN55647	PKLBN55648	PKLBN55649	PKLBN55650	PKLBN55651
PKLBN55652	PKLBN55653	PKLBN55654	PKLBN55655	PKLBN55656
PKLBN55657	PKLBN55658	PKLBN55691	PKLBN55692	PKLBN55693
PKLBN55694	PKLBN55695	PKLBN55696	PKLBN55697	PKLBN55698
PKLBN55699	PKLBN55701	PKLBN55702	PKLBN55703	PKLBN55704
PKLBN55705	PKLBN55706	PKLBN55707	PKLBN55708	PKLBN55709
PKLBN55710	PKLBN55711	PKLBN55712	PKLBN55713	PKLBN55714
PKLBN55715	PKLBN55716	PKLBN55717	PKLBN55718	PKLBN55719
PKLBN55721	PKLBN55722			



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LOCATION OF THE HPT STAGE 2 VANE ASSEMBLY
72-45-24
FIGURE 1

AppendixAdded DataInternal Reference Information

Revision No.	Reference Document	Origination
Original	EC 17VC209	JO/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	