

# ALERT SERVICE BULLETIN REVISION NOTICE

NON-MODIFICATION SERVICE BULLETIN — ENGINE — DISK STAGE 6, LOW PRESSURE  
TURBINE (LPT) — REMOVAL OF SUSPECT DISKS

Turbojet Engine Service Bulletin No. V2500-ENG-72-A0697 Revision No. 1 dated November 27, 2018.

## Revision History

Original Issue September 21, 2018

Revision 1 dated November 27, 2018

## Reason for the Revision

To change Instructions/Dispositions Code 4, from "Do an inspection as specified in the Accomplishment Instructions" to "Replace part as specified in the Accomplishment Instructions".

To change "material non-conformance" to "non-conformance in the material."

## 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

## BULLETIN ISSUE SEQUENCE

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## 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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# ALERT SERVICE BULLETIN

NON-MODIFICATION SERVICE bULLETIN — ENGINE — DISK STAGE 6, LOW  
PRESSURE TURBINE (LPT) — REMOVAL OF SUSPECT DISKS

## MODEL APPLICATION

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

## BULLETIN ISSUE SEQUENCE

V2500 Series 72-A0697

## ATA NUMBER

72-50-31

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## Compliance Category

3

## P&W Distribution Code

V2500

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## Summary

The purpose of this Service Bulletin is to replace eight (8) suspect Low Pressure Turbine (LPT) Stage 6 Disks, PN 3A2996, serial number specific. A potential non-conformance in the material has been reported that may impact the certified life of these eight (8) parts.

## Planning Information

### Effectivity Data

#### Engine Models Applicable

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

Engine Serial No. V10631

Engine Serial No. V12329

Engine Serial No. V12494

Engine Serial No. V13107

Engine Serial No. V18679

Engine Serial No. V18681

Engine Serial No. V18684

Engine Serial No. V18690

### Concurrent Requirements

There are no concurrent requirements.

### Reason

1. Condition: Certain LPT stage 6 disks exhibit a potential non-conformance in the material which may impact the part certified life. These parts will require replacement within the time limits of this NMSB.
2. Background: A potential non-conformance in the material has been reported from the respective manufacturing lot in certain area(s) that impact the certified life of these parts. Eight (8) parts are known to be affected. There is no method to inspect for these defects; requiring replacement.
3. Objective: Replace the affected parts within the time limits of this NMSB.
4. Substantiation: Structural analysis based on location of reported non-conformance in the material.
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.

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### Description

Replace the LPT Stage 6 Disks, PN 3A2996, if the serial number is listed in Table 1 within the Compliance section.

### Compliance

Category 3

Accomplish within 5,000 cycles since new.

Table 1: Suspect Stage 6 LPT Disk Serial Numbers

Serial Number	Serial Number
MAP04258	MAP04259
MAP04260	MAP04430
MAP04431	MAP08718
MAP08719	MAP08721

### 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. In The Shop  
To Replace the LPT Stage 6 Disk ..... 130 hours.

### 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.

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## 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 — 72-50-31.
2. Internal Reference No. — 18VM001.
3. V2500 Standard Practices and Processes, P&W Ref. PN 2A4414, Chapter/Section 72-00-00.
4. V2500-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-50-31.
5. V2500 A1/A5 Series Engine Manual, P&W Ref. PN 2A4407, Chapter/Section 72-00-50, 72-50-00, 72-50-10, and 72-50-30.

## 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-A5 Series Illustrated Parts Catalog, P&W Ref. PN 2A4428, Chapter/Section 72-50-31.

## 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 availability information is provided in material data Instructions — Disposition.

### Industry Support Program

If you have one of the eight (8) affected engines listed with the potential non-conforming LPT stage 6 disks, please contact your IAE Customer Field Representative or Customer Fleet Director for details of the commercial support being offered.

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	155,560.00	DISK, TURBINE, STG.6	3A2996 (72-50-31-01-050)	(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 part as specified in the Accomplishment Instructions.

#### Spare Parts Availability

- (X) See Reference 4, 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.

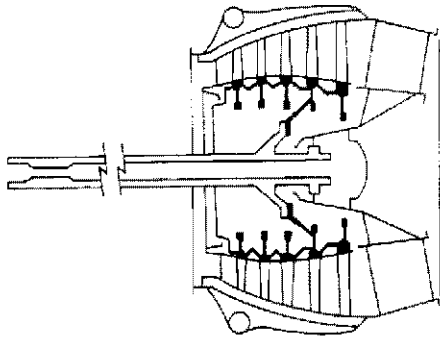
### Other Material Information Data

Not Applicable.

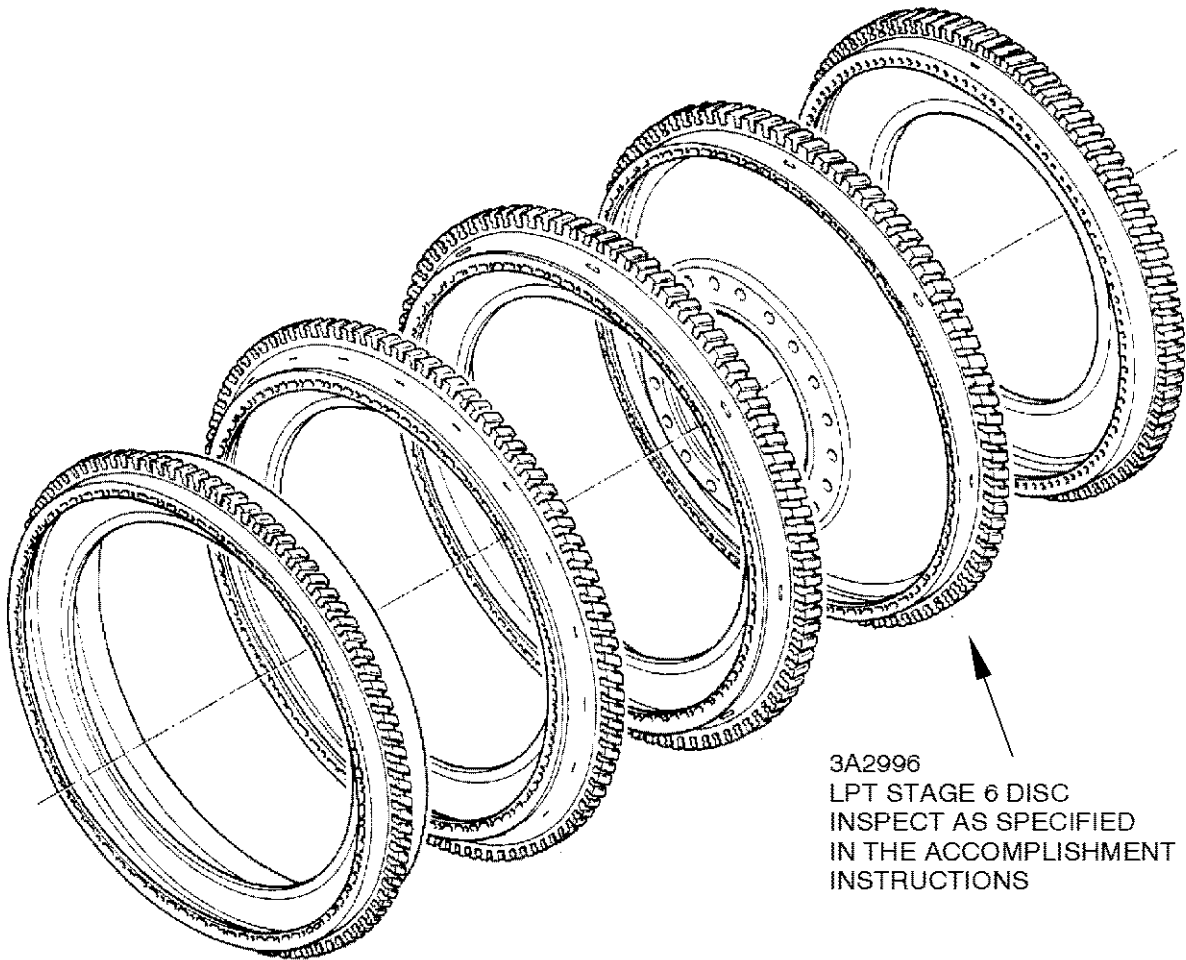
## Accomplishment Instructions

1. Disassemble the engine sufficiently to remove the LPT Stage 6 Disk, PN 3A2996. See Figure 1.
  - A. Disassemble the engine sufficiently to remove the LPT module assembly as specified in Reference 5, Engine Manual, Task 72-00-50-020-000.
  - B. Disassemble the LPT module assembly sufficiently to remove the LPT stage 6 rotor assembly as specified in Reference 5, Engine Manual, Task 72-50-10-030-000.
  - C. Remove the LPT stage 6 blades from the suspect LPT Stage 6 Disk, PN 3A2996 as specified in Reference 5, Engine Manual, Task 72-50-30-040-002. See Table 1 for suspect LPT Stage 6 Disk, PN 3A2996 serial numbers.
2. Replace the suspect LPT Stage 6 Disk, PN 3A2996.
  - A. Replace the suspect LPT stage 6 disk with a non-suspect LPT Stage 6 Disk, PN 3A2996.
  - B. The suspect LPT Stage 6 Disk, PN 3A2996, identified by serial number in Table 1 must be scrapped and it must be ensured that the re-utilization is 100% excluded. A photograph or digital image of the mutilated LPT stage 6 disk and a copy of the scrap tag, countersigned by the local IAE representative, must be provided to IAE Warranty.
3. Install the non-suspect LPT stage 6 disk
  - A. Assemble the LPT stage 6 rotor assembly as specified in Reference 5, Engine Manual, Task 72-50-30-440-004.
  - B. Install the LPT stage 6 rotor assembly and subsequent assemblies into the LPT case and rotor assembly as specified in Reference 5, Engine Manual, Task 72-50-10-430-000.
  - C. Install the LPT module assembly into the engine as specified in Reference 5, Engine Manual, Task 72-50-00-430-000.
4. Recording Instructions
  - A. A record of accomplishment is required.





MODULE 50



B527664

LOCATION OF THE LPT STAGE 6 DISK

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Figure 1

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## Appendix

### Added Data

#### Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC 18VM001	JP/DJ/MTU/JAC
1	EA 18VC490	JP/JT/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
SPPM (SPM) — A1, A5, D5	All	SPP-V2500-1IA	2A4414

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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	

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