



## SERVICE BULLETIN

ENGINE - FUEL AND CONTROL - ENGINE - PROVIDE AN ADDITIONAL WASHER ON THE HI-LOK PIN OF THE DATA ENTRY PLUG - CATEGORY CODE 6 - MOD.ENG-73-0005

1. Planning InformationA. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines prior to Serial No.'s V0014 through V0037, V0039 through V0041, V0043 through V0053, V0055, V0057, V0059, V0061, V0063, V0065 and V0067

B. Reason

## (1) Condition

The Hi-Lok pin which attaches the Data Entry Plug Assembly may have an insufficient amount of threads to bottom out the pin and the Hi-Lok collar against the Flange FC.

This could cause an incorrect installation of the Hi-Lok pin and collar.

## (2) Background

This condition has been encountered with the Hi-Lok pin and collar arrangement during the installation of the Data Entry Plug Assembly.

An addition of a spacer between the Hi-Lok collar and the Flange FC will ensure the correct installation.

## (3) Objective

To add a washer between the Hi-Lok collar and the Flange FC to enable the Data Entry Plug Assembly to be tightened correctly.

## (4) Substantiation

Substantiation test is not required.

## (5) Effect of Bulletin on workshop procedure:

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Removal/Installation	Affected (See Supplemental Information)
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

## (6) Supplemental Information

- (a) The installation of the Post-Service Bulletin configuration requires instructions for installing an additional washer to attach the Data Entry Plug Assembly to the Flange FC.

C. Description

- (1) The changes introduced by this Service Bulletin are as follows:

- (a) The washer PN4W2622 is added between the Hi-Lok collar and the Flange FC (See Figures 1 and 2).

- (2) New Hi-Lok pin and collar are required for replacement during rework.

D. Approval

The Part Number changes and/or part modifications described in Sections 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

E. Compliance

Category Code 6

Accomplish when the sub-assembly (i.e. module, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In Service	Not applicable
(2) At Overhaul (Note: The parts affected by this Service Bulletin are accessible at overhaul.)	
(a) To accomplish rework of the Data Entry Plug attaching parts	.. .. 21 minutes

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TOTAL 21 minutes

G. Material - Price and Availability

- (1) Modification kit not required. Parts supplied as single line items.
- (2) See "Material Information" section for prices and availability of future spares.

H. Tooling - Price and Availability

Special tools are not required to accomplish this Service Bulletin.

I. Weight and Balance

- (1) Weight change                      None
- (2) Moment arm                         No effect
- (3) Datum                                Engine front mount centerline  
(Power Plant Station (PPS) 100)

J. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

K. References

- (1) Internal Reference No.  
EC89VJ032
- (2) Other References  
V2500 Engine Illustrated Parts Catalog.

L. Other Publications Affected

- (1) V2500 Power Plant Illustrated Parts Catalog, 73-22-35.
- (2) V2500 Engine Illustrated Parts Catalog, 73-22-35.
- (3) V2500 Engine Manual, 73-22-35, Removal and Installation.

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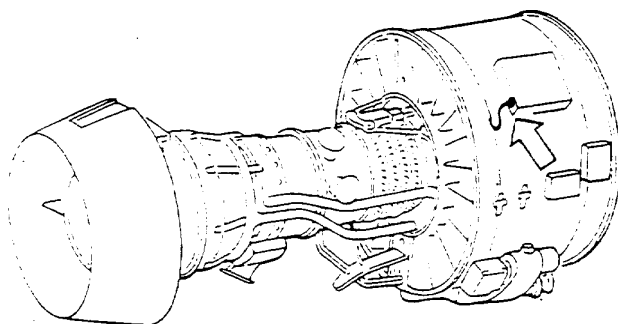
## 2. Accomplishment Instructions

### A. Rework Instructions

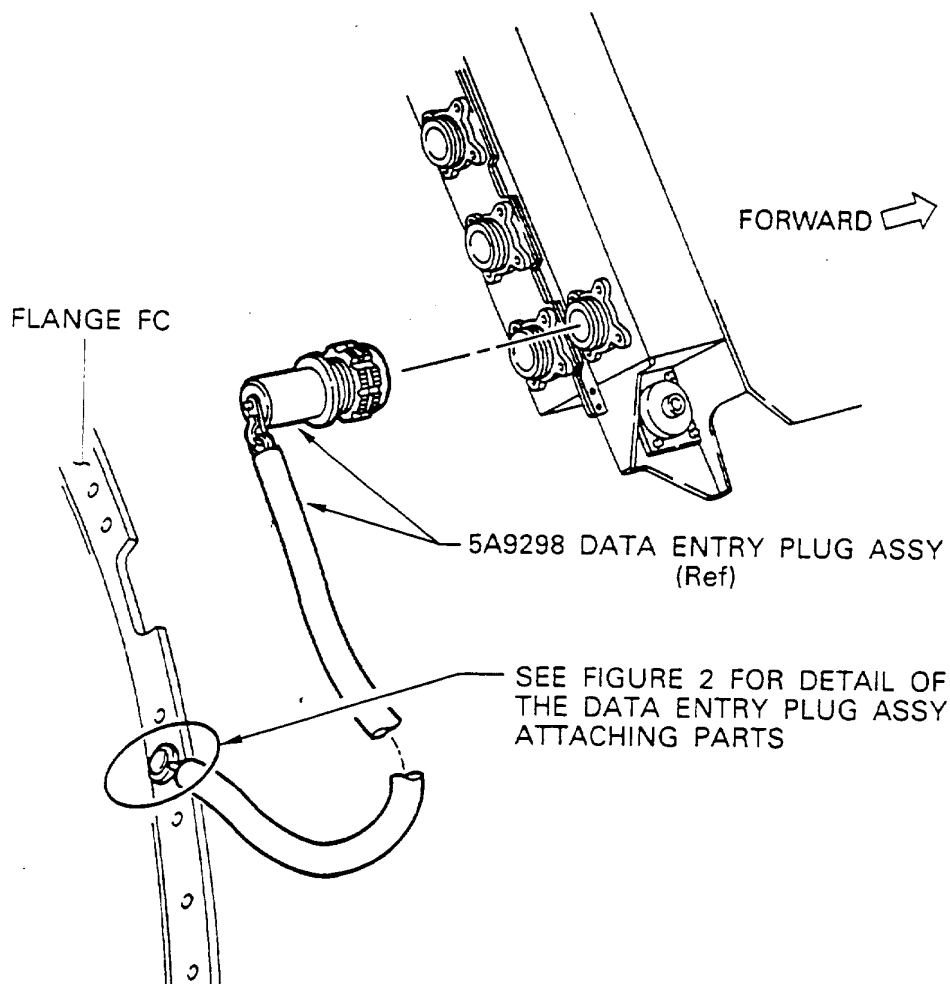
- (1) Find the location of PN5A9298, Data Entry Plug Assy where it is attached to the FC Flange (Refer to Figure 1).
- (2) Remove PN HL94DU8, Hi-Lok collar, PN5A9298, Data Entry Plug Assy and PN HL12V8-4, Hi-Lok pin from the FC Flange (Refer to Figures 2 and 3).
- (3) Discard PN HL94DU8, Hi-Lok collar and PN HL12V8-4, Hi-Lok pin which are removed from the FC Flange.
- (4) Install new PN HL12V8-4, Hi-Lok pin, PN5A9298, Data Entry Plug Assy, new PN4W2622, Washer and new PN HL94DU8 Hi-Lok collar to the FC Flange (Refer to Figure 2).
- (5) Tighten new PN HL94DU8, Hi-Lok collar on new PN HL12V8-4, Hi-Lok pin until the hexagon nut of new PN HL94DU8, Hi-Lok collar is sheared off, and discard the sheared hexagon nut (Refer to Figure 3).

### B. Recording Instructions

- (1) A record of accomplishment is necessary.



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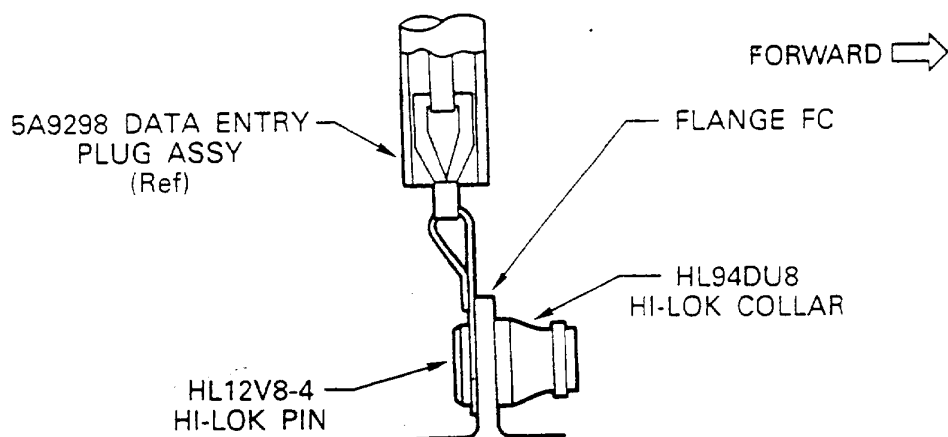


Location of the data entry plug assembly attaching parts  
Fig.1

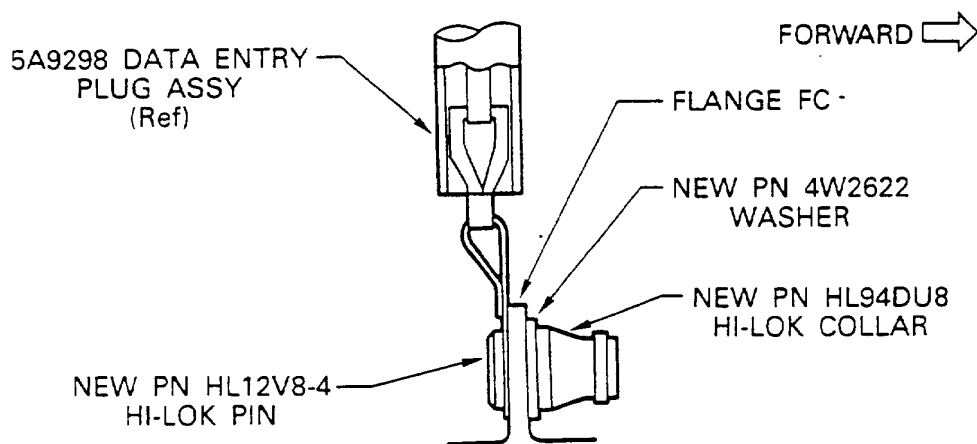
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BEFORE ALTERATION



AFTER ALTERATION

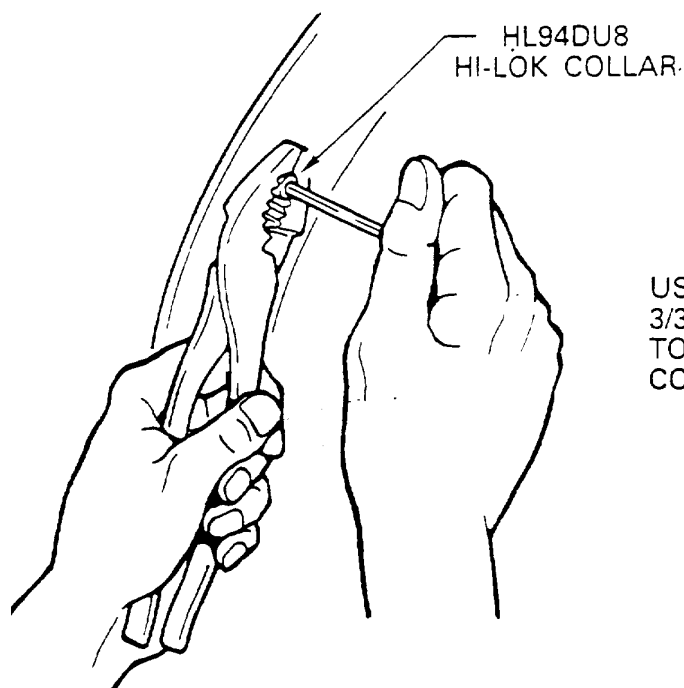
Before and after alteration of the data entry plug assembly attaching parts  
Fig.2

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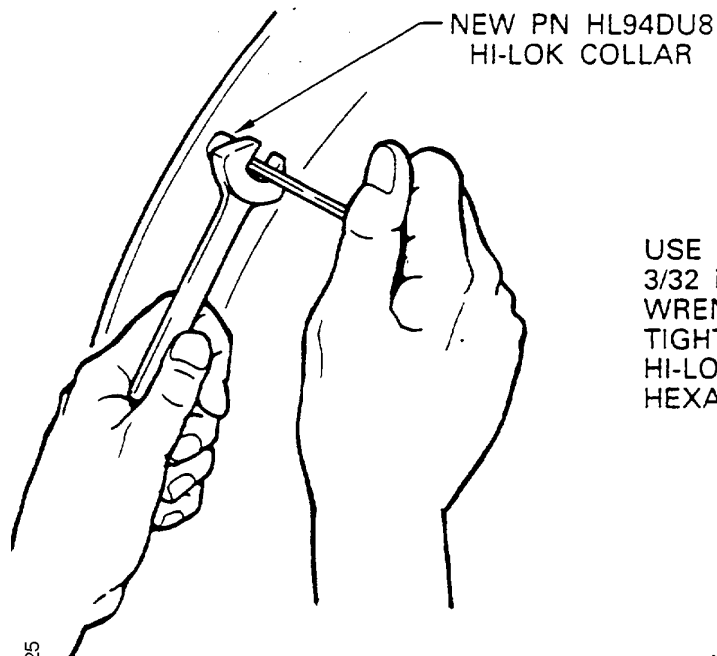


## SERVICE BULLETIN

Printed in Great Britain



USE THE ALLEN WRENCH SIZE  $\frac{3}{32}$  in. AND THE PLIERS TO LOOSEN HL94DU8 HI-LOK COLLAR.



USE THE ALLEN WRENCH SIZE  $\frac{3}{32}$  in. AND THE OPEN-END WRENCH SIZE  $\frac{7}{16}$  in. TO TIGHTEN NEW PN HL94DU8 HI-LOK COLLAR UNTIL THE HEXAGON NUT IS SHEARED OFF.

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Rework of the data entry plug assembly attaching parts  
Fig.3

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3. Material Information

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

HL94DU8 (73-22-35)	1	10.50	Collar, Hi-Lok	HL94DU8 (01-110)	(A)(1D)
HL12V8-4 (73-22-35)	1	22.50	Pin, Hi-Lok	HL12V8-4 (01-114)	(A)(1D)
4W2622 (73-22-35)	1	4.14	Washer	- (01-112)	(A)(2D)

C. Instruction/Disposition Code Statements:

- (A) New part is currently available for sale.
- (1D) Old part destroyed during rework.
- (2D) Additional part.

NOTE: The Estimated 1989 Unit Prices shown are provided for planning purposes only and do not constitute a firm quotation. Contact IAE's Spare Parts Sales Department for information concerning firm prices.

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