



SERVICE BULLETIN

ENGINE - FUEL AND CONTROL - FUEL AND CONTROL - REWORK THE SUPPORT ASSEMBLY ALIGNMENT HOLES - CATEGORY CODE 6 - MOD.ENG-73-0016

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines before Serial No.V0122.

B. Reason

(1) Condition

Some operators may encounter difficulty when installing the Electronic Engine Control Mount Bolts because of a build-up of manufacturing tolerances.

(2) Background

The top Electronic Engine Control Mount Bolt could seize in the Support Bracket Floating Nut Plate during installation. When some Bolts were removed, damaged bolt threads were found. Investigation showed that tolerance build-up can lead to the Electronic Engine Control Mount Bolt misalignment with the floating nut of the support bracket. This could cause a foul with the bracket lead-in clearance hole for the floating nut plate.

(3) Objective

To eliminate misalignment between the Electronic Engine Control mounting holes and the floating nut plate clearance holes in the Support Brackets.

(4) Substantiation

Consider not necessary.

(5) Effect of Bulletin on workshop procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

(6) Supplemental Information:

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None.

C. Description

- (1) This modification provides new Support Brackets with larger lead-in clearance holes.

D. Approval

The Part Number changes and/or part modification 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 subassembly (i.e. modules, 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	TOTAL 1 hour 18 minutes
(a) To gain access 	25 minutes
(i) Remove floating nut plates	
(b) To embody 	40 minutes
(i) Machine the support assembly	
(c) To return to overhaul condition 	13 minutes
(i) Install floating nut plates 	10 minutes
(ii) Etch new parts numbers	3 minutes

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**SERVICE BULLETIN****G. Material Price and Availability**

- (1) Modification kit not required.
- (2) See "Material Information" section for prices and availability of future spares.

H. Tooling - Price and Availability

Special tools are not required.

I. Weight and Balance

- | | |
|-------------------|--|
| (1) Weight change | None |
| (2) Moment arm | No effect |
| (3) Datum | Engine front mount centerline
(Powerplant station P.P.S. (100)) |

J. Electrical Load Data

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

K. References

- (1) Internal Reference No.
89VA128
- (2) Other References
V2500 Engine Illustrated Parts Catalog.
V2500 Engine Manual.
V2500 Standard Practices Manual.
V2500 Component Maintenance Manual, Miscellaneous Mechanical.

L. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalog, Chapter/Section 73-22-34, Figure 1, to add the new parts.
- (2) V2500 Engine Manual, Chapter/Section 73-22-34, Cleaning, to add the new parts.
- (3) V2500 Engine Manual, Chapter/Section 73-22-34, Inspection, to add the new parts.

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- (4) V2500 Engine Manual, Chapter/Section 73-22-34, Repair, to add the new parts.

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2. Accomplishment Instructions

A. Rework Instructions

- (1) Do a modification on 2A0954-01 EEC Support Assembly (See Reference (1), Chapter/Section 73-22-34, Figure Item No.01-060) and identify as 2A1367-01 as follows:

Procedure	Supplementary Information	
(a) Remove the two Rivets that hold the Floating Nut Plate Lugs on the Support Assembly	Refer to Figure 2. Refer to the approved procedure in Reference (4), Repair-006 VRS3349 TASK 73-22-34-300-006.	
(b) Set-up and machine the support to Diameter D given in the Figure.	Refer to Figure 2, requirements.	
(c) Install the new 744382 Floating Nut Plate (1 off) on the Support Assembly with AS3228-102 Rivets (2 off).	Refer to Figure 2. Refer to the approved procedure in Reference (4), Repair-006 VRS3349 TASK 73-22-34-300-006.	
(d) Mark the new part number adjacent to the old part number. Use the vibration peen method.	Old Part Number 2A0954-01	New Part Number 2A1367-01
	Refer to Figure 2, requirements. Refer to the approved procedure in Reference (3), Control No./TASK No.70-09-00-400-501.	

- (2) Do a modification on 2A0955-01 EEC Support Assembly (See Reference (1), Chapter/Section 73-22-34, Figure Item No.01-120) and identify as 2A1368-01 as follows:

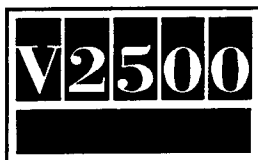
(a) Remove the two Rivets that hold the Floating Nut Plate Lugs on the Support Assembly.	Refer to Figure 3. Refer to the approved procedure in Reference (4), Repair-007 VRS3350 TASK 73-22-34-300-007.	
(b) Set-up and machine the Support to Diameter E given in the Figure.	Refer to Figure 3, requirements.	

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- (c) Install the new 744382 Floating Nut Plate (1 off) on the Support Assembly with AS3230-102 Rivets (2 off).
- Refer to Figure 3. Refer to the approved procedure in Reference (4), Repair-007 VRS3350 TASK 73-22-34-300-007.
- (d) Mark the new part number adjacent to the old part number. Use the vibration peen method.
- | Old Part Number | New Part Number |
|-----------------|-----------------|
| 2A0955-01 | 2A1368-01 |
- Refer to Figure 3, requirements. Refer to the approved procedure in Reference (3), Control No./TASK No.70-09-00-400-501.
- (3) Do a modification on 2A0956-01 EEC Support Assembly (See Reference (1), Chapter/Section 73-22-34, Figure Item No.01-180) and identify as 2A1369-01 as follows:
- (a) Remove the two Rivets that hold the Floating Nut Plate Lugs on the Support Assembly.
- Refer to Figure 4. Refer to the approved procedure in Reference (4), Repair-008 VRS3351 TASK 73-22-34-300-008.
- (b) Set-up and machine the Support to Diameter F given in the Figure.
- Refer to Figure 4, requirements.
- (c) Install the new 744382 Floating Nut Plate (1 off) on the Support Assembly with AS3230-102 Rivets (2 off).
- Refer to Figure 4. Refer to the approved procedure in Reference (4), Repair-008 VRS3351 TASK 73-22-34-300-008.
- (d) Mark the new part number adjacent to the old part number. Use the vibration peen method.
- | Old Part Number | New Part Number |
|-----------------|-----------------|
| 2A0956-01 | 2A1369-01 |
- Refer to Figure 4, requirements. Refer to the approved procedure in Reference (3), Control No./TASK no.70-09-00-400-501.
- (4) Do a modification on 2A1349-01 EEC Support Assembly (See Reference (1), Chapter/Section 73-22-34, Figure Item No.01-010) and identify as 2A1370-01 as follows:



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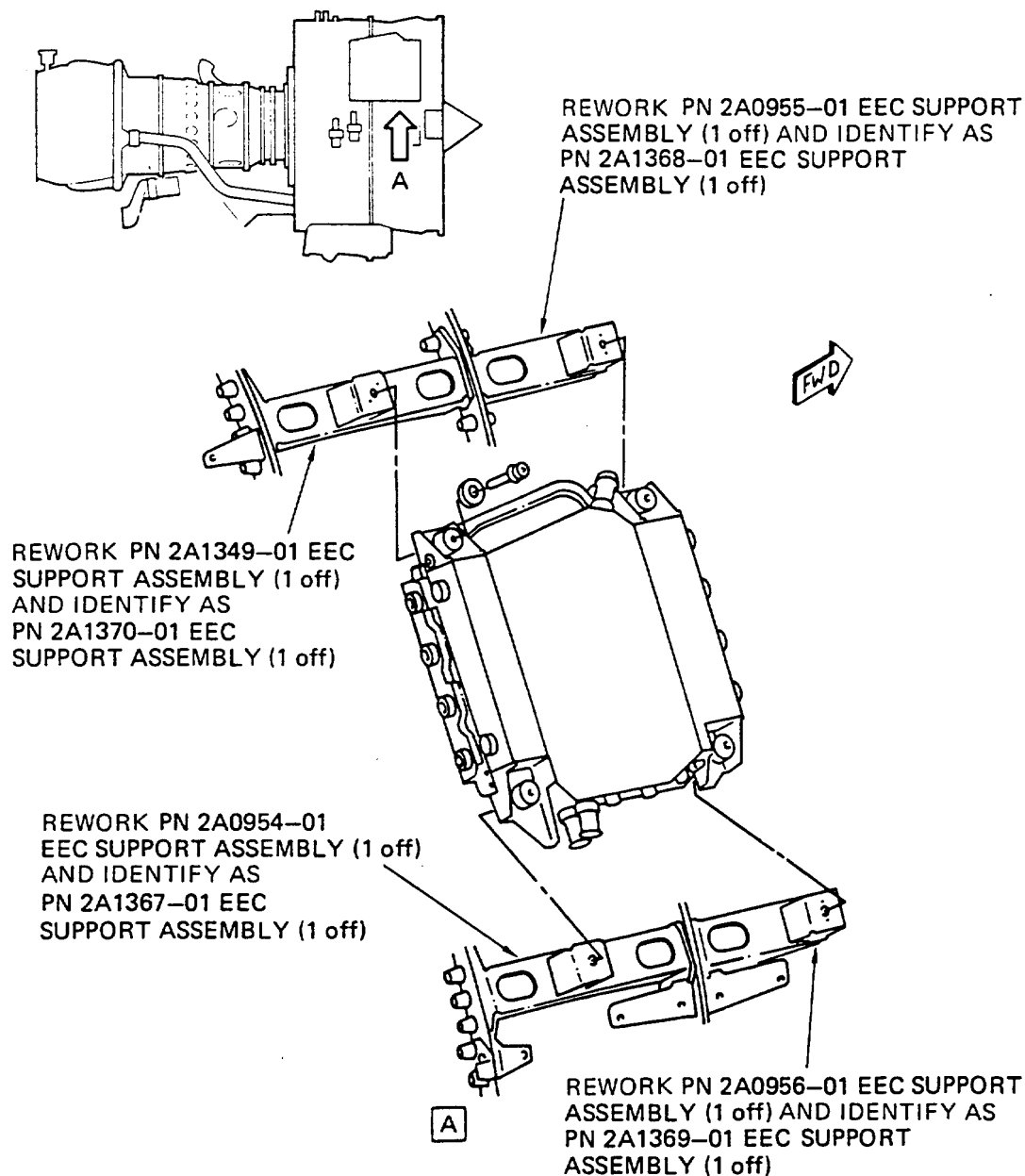
- | | | | | | |
|---|--|-----------------|-----------------|-----------|-----------|
| (a) Remove the two Rivets that hold the Floating Nut Plate Lugs on the Support Assembly. | Refer to Figure 5. Refer to the approved procedure in Reference (4), Repair-005 VRS3348 TASK 73-22-34-300-005. | | | | |
| (b) Set-up and machine the Support to Diameter G given in the Figure. | Refer to Figure 5, requirements. | | | | |
| (c) Install the new 744382 Floating Nut Plate (1 off) on the Support Assembly with AS3228-102 Rivets (2 off). | Refer to Figure 5. Refer to the approved procedure in Reference (4), Repair-005 VRS3348 TASK 73-22-34-300-005. | | | | |
| (d) Mark the new part number adjacent to the old part number. Use the vibration peen method. | <table border="0"> <tbody> <tr> <td>Old Part Number</td> <td>New Part Number</td> </tr> <tr> <td>2A1349-01</td> <td>2A1370-01</td> </tr> </tbody> </table> <p>Refer to Figure 5, requirements. Refer to the approved procedure in Reference (3), Control No./TASK No.70-09-00-400-501.</p> | Old Part Number | New Part Number | 2A1349-01 | 2A1370-01 |
| Old Part Number | New Part Number | | | | |
| 2A1349-01 | 2A1370-01 | | | | |

B. Assembly Instructions

- (1) Install 2A1367-01 Support Assembly (1 off), 2A1368-01 Support Assembly (1 off), 2A1369-01 Support Assembly (1 off) and 2A1370-01 Support Assembly (1 off) by the approved procedures in Reference (2), Chapter/Section 72-00-32 Installation-01. See Figure 1.

C. Recording Instructions

- (1) A record of accomplishment is necessary.



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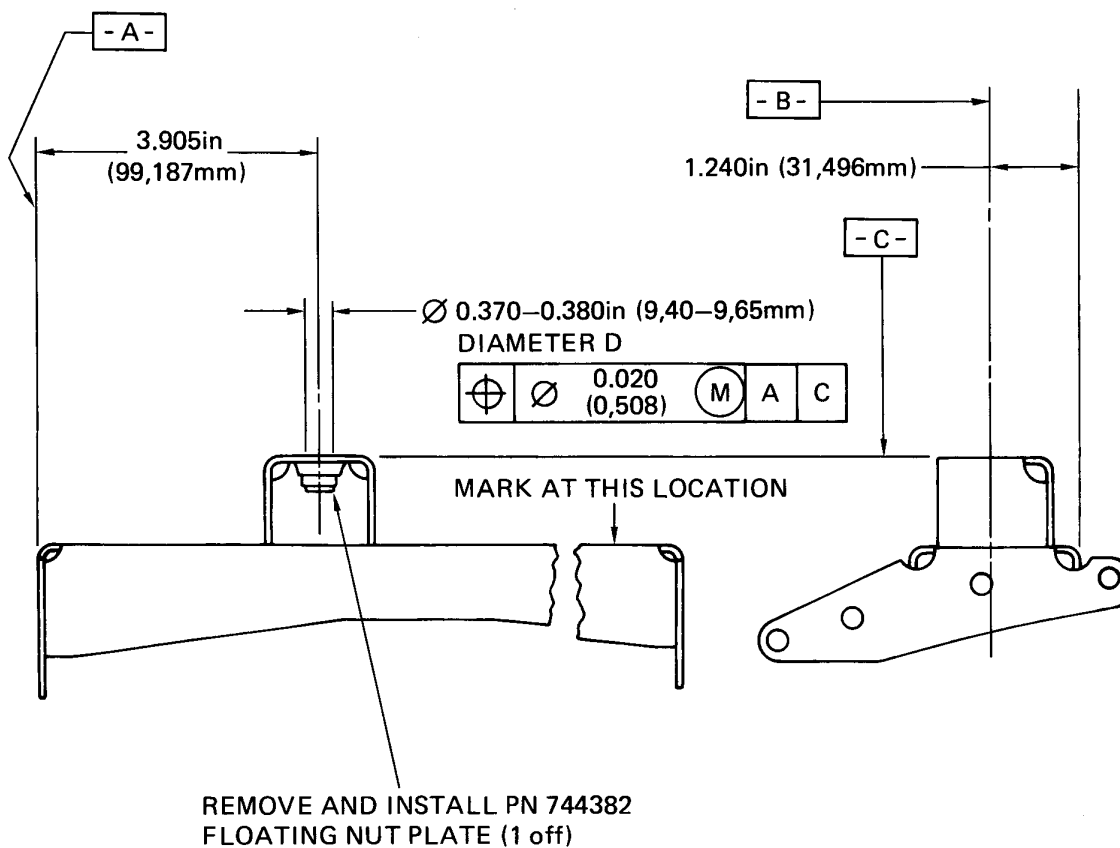
Location of EEC Support Assemblies
Fig.1

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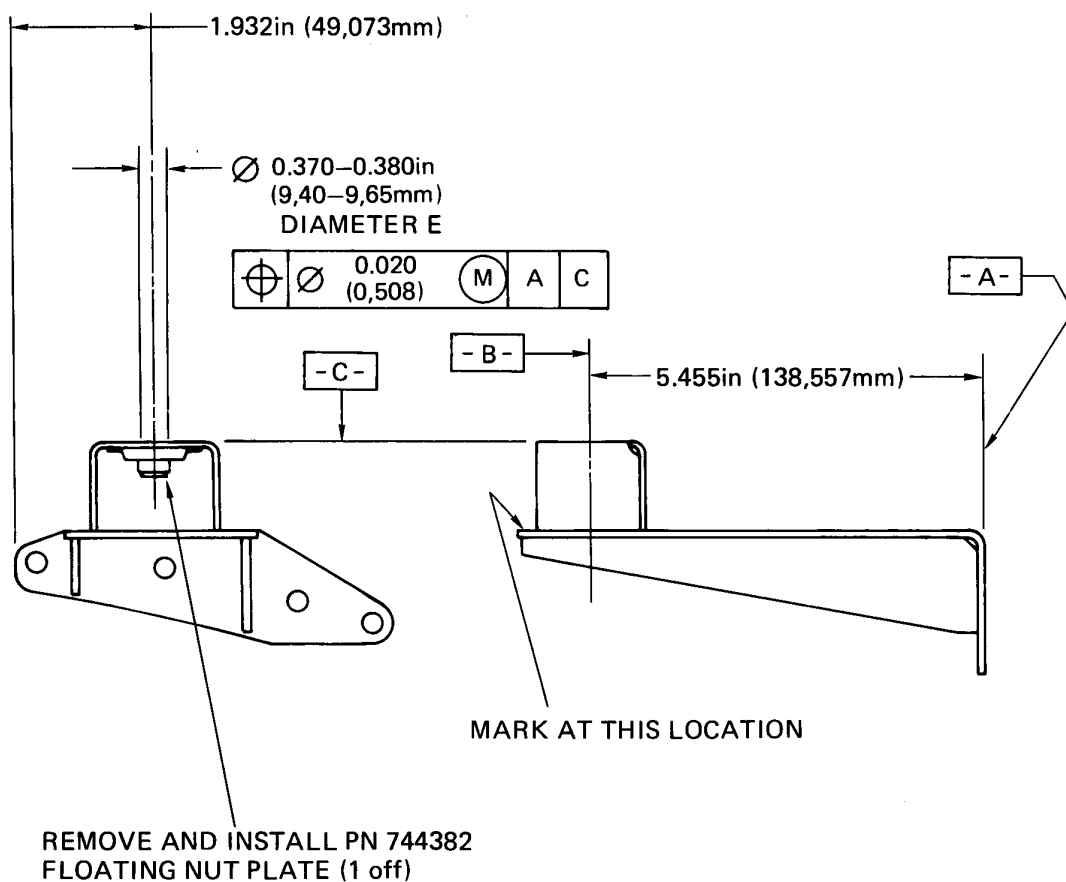
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Modification of 2A0954-01 of EEC Support Assembly
Fig.2

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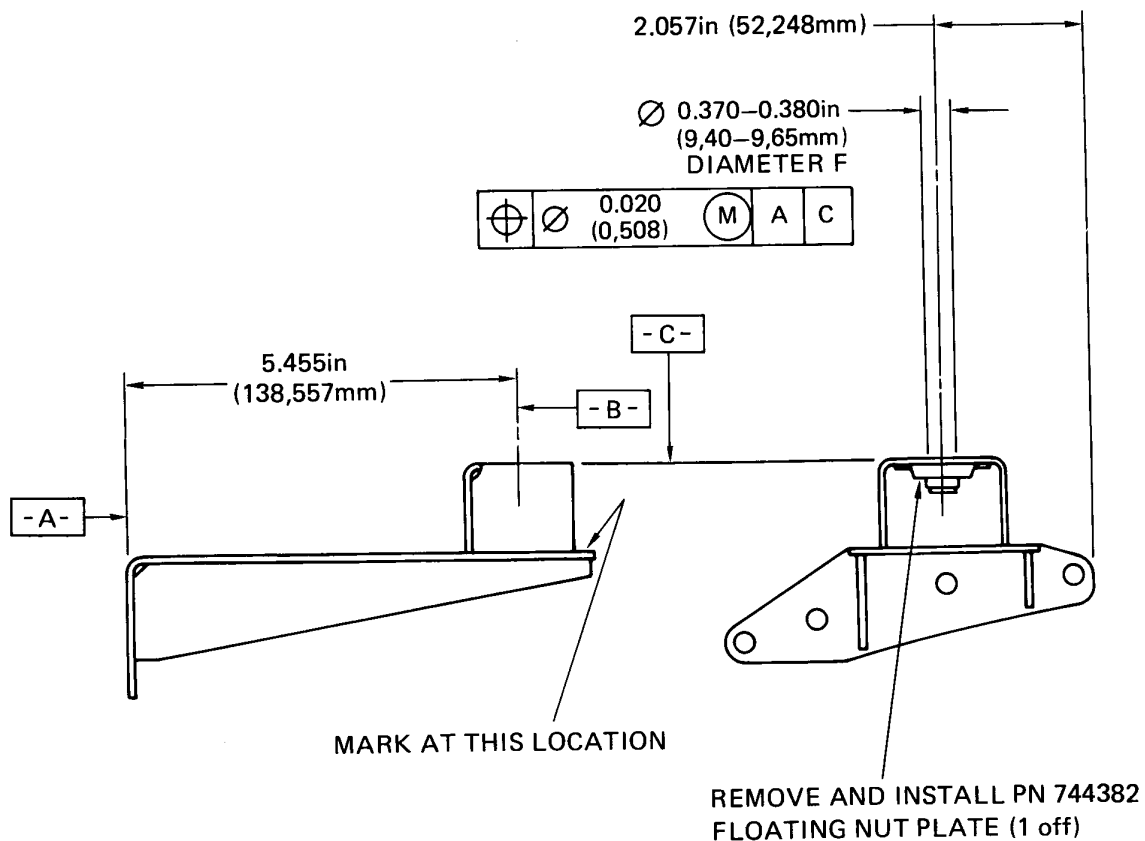
Modification of 2A955-01 of EEC Support Assembly
Fig.3

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Modification of 2A956-01 of EEC Support Assembly
Fig.4

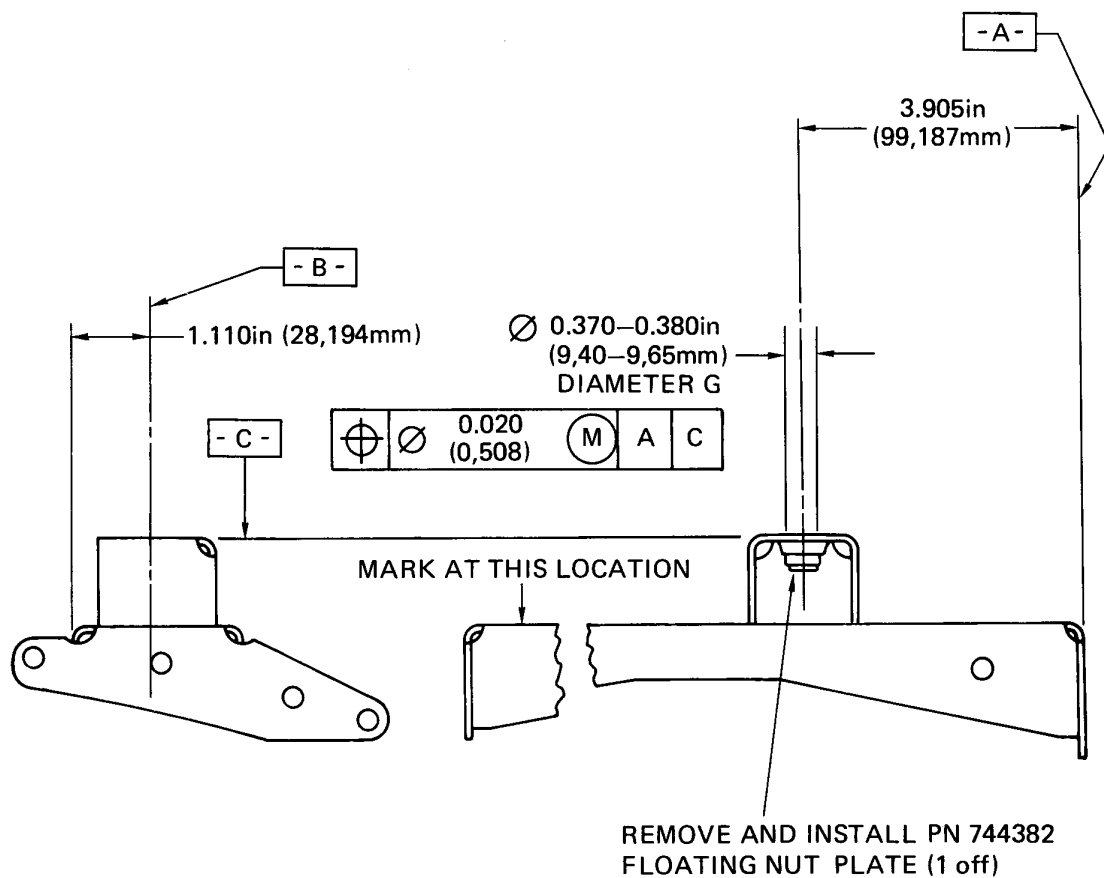
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Modification of 2A1349-01 of EEC Support Assembly
Fig.5

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3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
2A1367-01 (73-22-34)	1	2247.00	Support-EEC, Assembly	2A0954-01 (01-060)	(1D)(A) (B)
2A1368-01 (73-22-34)	1	252.00	Support-EEC, Assembly	2A0955-01 (01-120)	(1D)(A) (B)
2A1369-01 (73-22-34)	1	252.00	Support-EEC, Assembly	2A0956-01 (01-180)	(1D)(A) (B)
2A1370-01 (73-22-34)	1	2247.00	Support-EEC, Assembly	2A1349-01 (01-010)	(1D)(A) (B)

C. Expendable parts

Part No.	ATA/IPC No.	Qty	Keyword
AS3228-102	73-22-34, 01-020,01-100	4	Rivet
AS3230-102	73-22-34, 01-160,01-198	4	Rivet
744382	73-22-34, 01-040,01-080, 01-140,01-200	4	Nut, Option

D. Instruction/Disposition Code Statements:

- (1D) Old part can be reworked and reidentified to the New Part Number.
- (A) New part is currently available.
- (B) Old part will no longer be available.

NOTE: The estimated 1990 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

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