International Aero Engines

SERVICE BULLETIN

Nov. 24/98

Subject: Transmittal of Revision 1 to Service Bulletin V2500-ENG-73-0126.

Service Bulletin Revision History:

Event	Date
Initial Issue	Sep. 25/98.
Revision 1	Nov. 24/98.

Reason for Revision:

(1) Correct 1. D. and G..

Effect on Past Compliance:

None.

List of Effective Pages:

Page No.	Revision No.	Effective Date
1 to 3	Revision 1	Nov. 24/98.

IAE Propulsion System
NON-MODIFICATION
SERVICE BULLETIN

INSPECTION AND REPLACEMENT OF FUEL NOZZLE LOCATION CLIPPING BRACKETS (NON-MODIFICATION)

MODEL APPLICATION

V2500-D5

BULLETIN INDEX LOCATOR

73-13-41

Compliance Category Code

4

Internal Reference No.

98VR823

INSPECTION AND REPLACEMENT OF FUEL NOZZLE LOCATION CLIPPING BRACKETS (NON-MODIFICATION)

1 Planning Information

A. Effectivity

(1) Aircraft: Boeing DPD MD90

(2) Engine: V2500-D5

B. Reason

The purpose of this Non Modification Service Bulletin is to instruct operators to inspect fuel nozzle locations on the combustion casing for evidence of hot gas leakage, especially at locations where clipping brackets are installed. In instances where leakage has occurred it is necessary to examine these brackets for serviceability. If observed damage is beyond serviceability limits operators are instructed to replace brackets. During A check inspections, where leakage has occurred, fuel nozzle bolt torques are to be checked as instructed in F below. Similarly, during C check inspections, where a bracket is present, bolt torques are to be checked as instructed in F below.

C. Compliance

Category Code 4

D. Approval

R The compliance statement at 1.C. and the procedures in 1.F. of this Non-Modification Service
R Bulletin comply with the Federal Aviation Regulations and are FAA-Approved for the engine model
R listed.

E. References

IAE Engineering Change No. 98VR823
Service Information Letter No. 125

F. Action

(1) At next A check and subsequent A checks accomplish the intent of this Service Bulletin by inspecting all fuel nozzle locations for evidence of hot gas leakage.

(2) If no leakage is observed proceed to next nozzle location. Continue this procedure until all locations have been inspected. If leakage is observed inspect any bracket at the location. Examine the bracket for the following:

(i) Edge of bolt hole on bracket visible under bolt head;
(ii) Footprint of bolt head extending beyond bolt head diameter;
(iii) Visible creep deformation.

(3) If any of the above are observed replace the bracket and record all observations of hot gas leakage and the break-away torque on each of the securing bolts.

(4) For each nozzle location where hot gas leakage is observed, but no bracket distress is present remove the lockwire from the three retaining bolts, untorque each bolt one at a time recording the break-away torque value. Retorque the bolts to the specified torque. Continue this procedure of untorquing, recording and retorquing for each bolt in turn until all three bolts at the nozzle location have been retorqued. Install lockwire to the bolts.

(5) At next C check and subsequent C checks:

(A) Inspect all nozzle locations for evidence of hot gas leakage and replace any brackets not meeting the criteria given in step (2).

(B) At nozzle locations 2, 6, 9, 12, 16, 19 and 20 (clockwise looking forward from top dead-centre) where a bracket was not rejected during step (A), break and re-make the torque on each bolt one at a time as per the procedure given in step (4). Record all break-away torque data and supply to IAE representative.

(6) All inspection observations and bolt torque data should be passed to the IAE representative.

G. Record of Accomplishment

R Not required.