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V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits the Revision 2 to Service Bulletin V2500-ENG-73-0198 and the Revision 2 to the Supplement

Document History

Service Bulletin Revision Status

Initial Issue	Aug. 8/07
Revision 1	Oct.26/07

Service Bulletin Revision 2

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 135 of the Service Bulletin	To update the Accomplishment Instructions.
All pages of the Supplement	Page 1 and 2 of the Supplement	To update the Price Information.

V2500-ENG-73-0198

Transmittal - Page 1 of 1

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ENGINE FUEL AND CONTROL – FUEL SYSTEM AIR TUBE – INTRODUCTION OF RE-ROUTED BURNER TO
ENGINE ELECTRONIC CONTROLLER (EEC) PRESSURE (PB) SENSE LINE TUBE ASSEMBLIES

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V12750.

(2) Airbus A320.

(a) V2500-A1 Engines prior to Serial No. V0362.

(b) V2524-A5, V2527-A5, V2527E-A5 Engines prior to Serial No. V12750.

(3) Airbus A321.

(a) V2530-A5, V2533-A5 Engines prior to Serial No. V12750.

B. Concurrent Requirements

The Service Bulletin that follows must be done before or or at the same time with this one:

(1) For V2500-A1 Engines:

V2500-ENG-79-0087	OIL – SCAVENGE OIL TUBES – RE-ROUTE OF NUMBER 4
–	BEARING SCAVENGE TUBE

(2) For V2500-A5 Engines:

V2500-ENG-79-0088	OIL – SCAVENGE OIL TUBES – RE-ROUTE OF NUMBER 4
–	BEARING SCAVENGE TUBE

C. Reason

(1) Problem

A number of in-flight "Sensor Faults" due to contamination with moisture in the vibe cylinder pressure sensor have caused an additional maintenance impact and customers dissatisfaction.



The V2500 A1 and A5 EECs have suffered from premature removals due to Pb sensor screen contamination and freezing. Aluminium hydroxide contamination as a result of oxidised aluminium from the compressor lining accumulates on the Pb sensor screens in the EEC. Once contaminated, the screen more readily attracts moisture which can freeze during flight, resulting in "ENG 1(2) SENSOR FAULT" ECAM warning. Further the current Pb sense line assembly is routed near a hot section (near the air cooled oil cooler (ACOC)) and a cooling zone of the engine which causes the accumulation of condensation water in the airstream. the current use of two water traps between the EEC and the bifurcation panel with bleed holes in both water traps provides a constant air flow and moisture travel towards the EEC.

(2) Evidence

The problem has been experienced on engines in service.

(3) Substantiation

The changes introduced by this Service Bulletin were the subject of satisfactory engineering analysis. This Service Bulletin complies with the applicable engine certification basis.

(4) Objective

Incorporation of this Service Bulletin is designed to improve the reliability.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Affected (Refer to 1.0. Other Publication Affected).

(d) Repair Schemes

Not affected.

(e) Interchangeability

Affected (Refer to 1.B. Concurrent Requirements).

(f) Fits and Clearances

Not affected.

D. Description

(1) This Service Bulletin introduces a rerouted PB sense line around the fan case and engine core. The changes contain modifications to the water trap system, an increased tube diameter between the bifurcation panel from 0.250 in. up to 0.375 in. and the EEC and a rerouted Pb sense line tube assembly away from the "hot" ACOC area. To enhance moisture condensation within the tube assembly and to ensure a permanent sufficient precipitation during engine run, the new design removes the upper water trap and replaces the lower water trap by a larger V2500 D5 version (with a bigger bleed hole) on the lowest pipe assembly position. An increase of tube diameters between the bifurcation panel and the EEC have a moist buffer effect due to air volume increase. In addition, a larger bore pipe has less of a tendency to block due to the meniscus effect of any liquid in it. Finally the rerouting of the Pb line away from the hot parts such as the ACOC, avoids increased temperature of the tubes and subsequent re-evaporation of already condensed water.

(2) The changes introduced are:

(a) The following tube assemblies are revised:

- (i) Air - Pb Disconnect to EEC Disconnect
- (ii) Air - Pb Disconnect to Disconnect
- (iii) Air - Pb Bifurcation Panel to Disconnect
- (iv) Air - Pb Disconnect to Bifurcation Panel
- (v) Air - HP10 Disconnect to HP10 Solenoid
- (vi) Air - HP10 Disconnect to Solenoid Disconnect
- (vii) Air - HP10 Bifurcation Panel to Disconnect
- (viii) Air - HP10 Bleed Valve to Bifurcation Panel

(b) The clip positions that follow are deleted:

CP1027, CP1028, CP1441, CP6122.

Additional for V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

CP0590.

(c) The clip positions that follow are revised:

CP0582, CP0584, CP0586, CP0587, CP1017, CP1409, CP1418, CP1420,
CP1422, CP1423, CP1426, CP1431, CP1442, CP6094.

Additional for V2500-A1 Engines and V2500-A5 Engines which have SB ENG
79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

CP0590.

(d) The following clip positions are introduced:

CP1481, CP1482, CP1480.

(e) A revised support bracket for CP1482 is introduced.

(f) A new support bracket for CP1481 is introduced.

(g) A redesigned vented water trap for the Pb sense line is introduced.

NOTE: The Assembly Instruction of this Service Bulletin is divided into two
parts as follows:

PART 1 – Applicable for engines 'In Service'.

PART 2 – Applicable for engines 'At Overhaul'.

E. Compliance

Category Code 6

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

F. 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 models listed.

G. Manpower

(1) In Service

Total – 11 Hours:

(a) To gain access – 20 Minutes.

(b) To embody – 10 Hours 20 Minutes.

(c) To return the engine to a serviceable status - 20 Minutes.

(2) At Overhaul

Applicable (Hours not affected).

H. Material Price and Availability

Modification kits MKVA173019801 for A1 Engines and MKVA573019801 for A5 Engines are available to permit accomplishment of this Service Bulletin.

For the modification kit prices and availability or prices and availability of future spares, refer to supplement to this Service Bulletin.

I. Tooling Price and Availability

Special tools are not required.

J. Industry Support Information

Not applicable.

K. Weight and Balance

(1) Weight Change

Plus 0.2 lb (0,09 kg)

(2) Moment Arm

1.6 in. (40,6 mm) rearward

(3) Datum

Engine Front Mount Centreline (Power Plant Station (PPS) 100).

L. Electrical Load Data

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

M. Software Accomplishment Summary

Not applicable.

N. References

(1) IAE Service Information Letter SIL 252.

(2) A319/A320/A321 Aircraft Maintenance Manual, Chapters 71-13-00 and 78-32-00 Opening/Closing.



- (3) A319/A320/A321 Aircraft Maintenance Manual, Chapter 73-22-34 EEC System Test.
- (4) A319/A320/A321 Aircraft Maintenance Manual, Chapter 73-22-00 FADEC System Test.
- (5) A319/A320/A321 Aircraft Maintenance Manual, Chapter 71-00-00 No. 3 and No. 6 Test.
- (6) IAE V2500 Engine Manual (E-V2500-1IA), Chapters 72-00-32 and 72-00-40 Removal/Installation.
- (7) IAE V2500 Standard Practices/Procedures Manual (SPP-V2500-1IA), Chapters 70-41-01, 70-42-05 and 70-43-01.
- (8) V2500 Service Bulletin:
 - (a) For V2500-A1 Engines:

V2500-ENG-79-0087 - OIL - SCAVENGE OIL TUBES - RE-ROUTE OF NUMBER 4 BEARING SCAVENGE TUBE
 - (b) For V2500-A5 Engines:

V2500-ENG-79-0088 - OIL - SCAVENGE OIL TUBES - RE-ROUTE OF NUMBER 4 BEARING SCAVENGE TUBE
- (9) Reference Aircraft Modification No. 38449.
- (10) Internal Reference No.:

Engineering Change No. 06VR007.
- (11) ATA Locator - 36-11-47, 70-41-01, 70-42-05, 70-43-01, 71-00-00, 71-13-00, 71-51-41, 72-00-32, 72-00-40, 73-22-00, 73-22-34, 73-22-49, 75-23-48, 75-32-49, 78-32-00 and 79-21-49.

0. Other Publications Affected

- (1) A319/A320/A321 Aircraft Maintenance Manual, Chapters 73-22-49 and 36-11-47.
- (2) IAE V2500 Engine Manual (E-V2500-1IA), Chapters 72-00-32 and 72-00-40 Removal/Installation.
- (3) IAE V2500 Component Maintenance Manual Miscellaneous Mechanical (CMM-MECH-V2500-1IA), Chapters 36-11-47, 71-51-41, 73-22-49 and 75-32-49 Cleaning, Inspection/Check.

- (4) IAE V2500 Component Maintenance Manual Tubes, Hoses and Ducts (CMM-THD-V2500-1IA), Chapters 73-22-49 and 75-32-49 Cleaning, Inspection/Check.
- (5) For effect on Illustrated Parts Catalogue (IPC), refer to 2. Material Information.

P. Interchangeability of Parts

Affected (Refer to paragraph 2.E. Instruction disposition codes).

2. Material Information

A. The kit required consists of the following parts:

For A1 Engines:

Modification kit MKVA173019801 consists of the parts that follow (excluding attaching parts):

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
73-22-49						
03-800	6A9096	1	.Bracket Assy, Support	-	6A7420	
03-848	6A9098	1	.Bracket	-	-	
05-500	6A9123	1	.Tube Assy, Air - Bifurcation Panel to Pressure Sensor 3	-	6A6203	
06-100	6A9040	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	6A6211	
06-264	6A7398	1	.Plug Assy, Vented	-	-	
06-500	6A9045	1	.Tube Assy, Air - Fuel System - EEC to Bifurcation Panel.Tube, Assy	-	6A6212	
07-100	6A9039	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	5A8800	
07-800	5W8351	1	.Bracket	-	-	
75-32-49						
03-500	6A9042	1	.Tube Assy, Air - Stg 10 Solenoid to Stg 10 Bleed Valve	-	5A9146	
04-100	6A6212	1	.Tube Assy, Air - EEC to Bifurcation Panel	-	6A6222	
04-500	6A9041	1	.Tube Assy, Air-Bleed Valve- Servo - Solenoid to Bifurcation Panel		6A6223	

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
14-100	6A9044	1	.Tube Assy, Air - Bleed Valve Servo - Bifurcation Panel to Valve	-	6A6199	

For A5 Engines:

Modification kit MKVA573019801 consists of the parts that follows (excluding attaching parts):

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
73-22-49						
03-800	6A9096	1	.Bracket Assy, Support	-	6A7420	
03-848	6A9098	1	.Bracket	-	-	
05-500	6A9043	1	.Tube Assy, Air - Bifurcation Panel to Pressure Sensor 3	-	6A6235 or 6A6236	
06-100	6A9040	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	6A6211	
06-264	6A7398	1	.Plug Assy, Vented	-	-	
06-500	6A9045	1	.Tube Assy, Air - Fuel System - EEC to Bifurcation Panel.Tube, Assy	-	6A6212	
07-100	6A9039	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	5A8800	
07-800	5W8351	1	.Bracket	-	-	
75-32-49						
03-500	6A9042	1	.Tube Assy, Air - Stg 10 Solenoid to Stg 10 Bleed Valve	-	5A9146 or 6A6194	

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
04-500	6A9041	1	.Tube Assy, Air-Bleed Valve- Servo - Solenoid to Bifurcation Panel		6A6223	
14-100	6A9044	1	.Tube Assy, Air - Bleed Valve Servo - Bifurcation Panel to Valve	-	6A6199	

B. Parts to be reworked:

None.

C. New production parts:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
For A1 Engines:						
36-11-47						
01-149	4W0102 or 4W0342	1	.Bolt (CP6094)	-	4W0102	(1)(3)(C)
01-150	K8831	2	.Washer (CP6094)	-	-	(1)(A)
71-51-41						
02-087	4W0117 or 4W0357	1	.Bolt (CP1017)	-	4W0116	(1)(3) (S1)
02-092	5W1032 or UP10481	1	.Spacer (CP1017)	-	5W1032	(C)
02-787	4W0104 or 4W0344	1	.Bolt (CP1442)	-	4W0104	(1)(3)(C)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
73-22-49						
02-578	4W0104 or 4W0344	1	.Bolt (CP1426)	-	4W0111	(1)(3) (C)(S1)
03-133	4W0128 or 4W0368	1	.Bolt (CP0582)	-	4W0127	(1)(3) (C)(S1)
03-136	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
03-141	4W0123 or 4W0363	1	.Bolt (CP0584)	-	4W0123	(C)
03-142	K8831	1	.Washer (CP0584)	-	5W1086	(1)(S1)
03-144	400WSS4 or AS62404	1	.Clip (CP0584)	-	400WSS4	(C)
03-146	5W1032 or UP10481	1	.Spacer (CP0584)	-	5W1032	(C)
03-150	K8831	1	.Washer (CP0586)	-	5W1086	(1)(S1)
03-152	400WSS4 or AS62404	1	.Clip (CP0586)	-	400WSS4	(C)
03-154	5W1032 or UP10481	1	.Spacer (CP0582)	-	5W1032	(C)
03-800	6A9096	1	.Bracket Assy, Support	-	6A7420	(1)(S1)
03-846	4W0001	2	.Nut	-	-	(1)(3)(A)
03-847	4W0102	2	.Bolt	-	-	(1)(3)(A)
03-848	6A9098	1	.Bracket	-	-	(1)(3)(A)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
05-500	6A9123	1	.Tube Assy, Air - Bifurcation Panel to Pressure Sensor 3	-	6A6203	(1)(S1)
05-536	TA025022-041		.Clamp, Loop Style, Cushion-	-		(1)(A)
06-100	6A9040	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	6A6211	(1)(S1)
06-184	AS62406	1	.Clip (CP1418)	-	AS62404	(1)(S1)
06-192	AS62406	1	.Clip (CP1420)	-	AS62404	(1)(S1)
06-202	6A9084	1	..Adaptor	-	5W8019	(S1)
06-226	UP10758	1	..Connector	-	-	(A)
06-228	UP10757	1	..Connector, 3 Way	-	-	(A)
06-232	UP11155	1	..Inter-Tube Support Bracket	-	-	(A)
06-234	AS15802	1	..Adaptor, Straight Tube	-	-	(A)
06-264	6A7398	1	.Plug Assy, Vented	-	-	(1)(A)
06-265	AS15781	1	..Wire, Thrust	-	-	(A)
06-266	AS15705	1	..Nut, Tube Coupling	-	-	(A)
06-500	6A9045	1	.Tube, Assy	-	6A6212	(1)(3D) (S1)
06-536	AS62406	1	.Clip (CP0582)	-	400WSS4	(1)(S1)
06-544	AS62406	1	.Clip (CP0584)	-	400WSS4	(1)(S1)
06-600	AS15779	1	..Wire, Thrust	-	AS15777	(S1)
06-601	AS15703	1	..Nut, Tube Coupling	-	AS15701	(S1)
06-602	LK40979	1	..Ferrule	-	AS15768	(S1)

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
06-642	AS15806	1	..Adaptor, Union	-	AS15802	(S1)
06-660	AS62406	1	.Clip (CP1442)	-	-	(1)(A) (S1)
06-665	4W0115 or 4W0355	1	.Bolt (CP1409)	-	-	(1)(3) (A)(C)
06-666	K8831	2	.Washer (CP1409)	-	-	(1)(A)
06-668	AS62406	1	.Clip (CP1409)	-	-	(1)(A)
06-670	UP10480	1	.Spacer (CP1409)	-	-	(1)(A)
06-672	4W0001	1	.Nut (CP1409)	-	-	(1)(3)(A)
07-100	6A9039	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	5A8800	(1)(S1)
07-200	AS15779	1	..Wire, Thrust	-	AS15777	(S1)
07-201	AS15703	1	..Nut, Tube Coupling	-	AS15701	(S1)
07-202	AS15726	1	..Ferrule, Welding Tube	-	AS15768	(S1)
07-253	4W0102 or 4W0342	1	.Bolt (CP1482)	-	-	(1)(3)(A)
07-254	K8831	1	.Washer (CP1482)	-	-	(1)(A)
07-256	AS62406	1	.Clip (CP1482)	-	-	(1)(A)
07-260	4W0001	1	.Nut (CP1482)	-	-	(1)(3)(A)
07-261	4W0102 or 4W0342	1	.Bolt (CP1481)	-	-	(1)(3) (A)(C)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
07-262	K8831	1	.Washer (CP1481)	—	—	(1)(A)
07-264	AS62406	1	.Clip (CP1481)	—	—	(1)(A)
07-268	4W0001	1	.Nut (CP1481)	—	—	(1)(3)(A)
07-272	AS62406	1	.Clip (CP1017)	—	—	(1)(A)
07-280	AS62406	1	.Clip (CP0586)	—	—	(1)(A)
07-800	5W8351	1	.Bracket	—	—	(1)(A)
07-801	4W0164	1	.Bolt	—	—	(1)(3)(A)
07-802	4W0002	1	.Nut	—	—	(1)(3)(A)
10-157	4W0102 or 4W0342	1	.Bolt (CP1480)	—	—	(1)(3) (A)(C)
10-158	K8831	1	.Washer (CP1480)	—	—	(1)(A)
10-160	AS62404	1	.Clip (CP1480)	—	—	(1)(A)
10-164	4W0001	1	.Nut (CP1480)	—	—	(1)(3)(A)
10-536	400WSS4 or AS62404	1	.Clip (CP0582)	—	—	(1)(A)(C)
10-544	400WSS4 or AS62404	1	.Clip (CP0584)	—	—	(1)(A)(C)
10-552	400WSS4 or AS62404	1	.Clip (CP0586)	—	—	(1)(A)(C)

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
75-23-48						
02-183	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
75-32-49						
03-500	6A9042	1	.Tube Assy, Air - Stg 10 Solenoid to Stg 10 Bleed Valve	-	5A9146	(1)(S1)
04-100	6A6212	1	.Tube Assy, Air - EEC to Bifurcation Panel	-	6A6222	(1)(3D) (S1)
04-125	4W0103 or 4W0343	1	.Bolt (CP0587)	-	-	(1)(3) (A)(C)
04-126	5W1086	1	.Washer (CP0587)	-	-	(1)(A)
04-128	400WSS4 or AS62404	1	.Clip (CP0587)	-	400WSS4	(C)
04-132	4W0043	1	.Nut (CP0587)	-	-	(1)(3)(A)
04-136	400WSS4 or AS62404	1	.Clip (CP0586)	-	400WSS4	(C)
04-144	400WSS4 or AS62404	1	.Clip (CP0584)	-	400WSS4	(C)
04-152	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
04-240	AS15777	1	..Wire, Thrust	-	-	(A)
04-241	AS15701	1	..Nut, Tube Coupling	-	-	(A)
04-242	AS15768	1	..Adaptor, Straight Tube	-	AS15802	(S1)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
04-253	4W0102	1	.Bolt (CP1422)	—	—	(1)(3)(A)
04-254	K8831	1	.Washer (CP1422)	—	—	(1)(A)
04-256	AS62404	1	.Clip (CP1422)	—	—	(1)(A)
04-260	4W0001	1	.Nut (CP1422)	—	—	(1)(3)(A)
04-261	4W0105	1	.Bolt (CP1423)	—	—	(1)(3)(A)
04-262	K8831	2	.Washer (CP1423)	—	—	(1)(A)
04-264	AS62404	1	.Clip (CP1423)	—	—	(1)(A)
04-268	4W0001	1	.Nut (CP1423)	—	—	(1)(3)(A)
04-500	6A9041	1	.Tube Assy, Air - Bleed Valve Servo - Solenoid to Bifurcation Panel	—	6A6223	(1)(S1)
04-541	4W0116 or 4W0356	1	.Bolt (CP1420)	—	4W0115	(1)(3) (C)(S1)
04-591	4W0114 or 4W0354	1	.Bolt (CP1418)	—	4W0114	(1)(3)(C)
04-605	AS15802	1	..Adaptor, Straight Tube	—	—	(A)
04-656	AS62404	1	.Clip (CP1431)	—	—	(1)(A)
08-136	400WSS4 or AS62404	1	.Clip (CP0586)	—	400WSS4	(C)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
08-144	400WSS4 or AS62404	1	.Clip (CP0584)	-	400WSS4	(C)
08-152	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
10-581	4W0104 or 4W0344	1	.Bolt (CP1431)	-	4W0104	(3)(C)
10-582	K8831	1	.Washer (CP1431)	-	-	(1)(2D)
14-100	6A9044	1	.Tube Assy, Air - Bleed Valve Servo - Bifurcation Panel to Valve	-	6A6199	(1)(S1)

For A5 Engines:

36-11-47

01-149	4W0102 or 4W0342	1	.Bolt (CP6094)	-	4W0102	(3)(C)
01-150	K8831	1	.Washer (CP6094)	-	-	(2)(2D)

71-51-41

02-087	4W0117 or 4W0357	1	.Bolt (CP1017)	-	4W0117 or 4W0116	(3)(C)
02-787	4W0104 or 4W0344	1	.Bolt (CP1442)	-	4W0104	(3)(C)

73-22-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02-578	4W0104 or 4W0344	1	.Bolt (CP1426)	—	4W0111	(2)(3) (C)(S1)

For A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

73-22-49

03-133	4W0123 or 4W0363	1	.Bolt (CP0582)	—	4W0123	(2)(3)(C)
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For A5 Engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

73-22-49

03-133	4W0128 or 4W0368	1	.Bolt (CP0582)	—	4W0127	(2)(3) (C)(S1)
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For A5 Engines:

73-22-49

03-136	400WSS4 or AS62404	1	.Clip (CP0582)	—	400WSS4	(C)
03-141	4W0123 or 4W0363	1	.Bolt (CP0584)	—	4W0123	(C)
03-142	K8831	1	.Washer (CP0584)	—	5W1086	(2)(S1)
03-144	400WSS4 or AS62404	1	.Clip (CP0584)	—	400WSS4	(C)
03-149	4W0123 or 4W0363	1	.Bolt (CP0586)	—	4W0123	(C)
03-150	K8831	1	.Washer (CP0586)	—	5W1086	(2)(S1)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
03-152	400WSS4 or AS62404	1	.Clip (CP0586)	-	400WSS4	(C)
03-800	6A9096	1	.Bracket Assy, Support	-	6A7420	(2)(S1)
03-846	4W0001	2	.Nut	-	-	(2)(3)(A)
03-847	4W0102	2	.Bolt	-	-	(2)(3)(A)
03-848	6A9098	1	.Bracket	-	-	(2)(A)

For A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

73-22-49

05-500	6A9043	1	.Tube Assy, Air - Bifurcation Panel to Pressure Sensor 3	-	6A6236	(2)(S1)
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For A5 Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

73-22-49

05-500	6A9043	1	.Tube Assy, Air - Bifurcation Panel to Pressure Sensor 3	-	6A6235	(2)(S1)
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For A5 Engines:

73-22-49

05-536	TA025022-041		.Clamp, Loop Style, Cushion-	-		(2)(A)
06-100	6A9040	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	6A6211	(2)(S1)
06-184	AS62406	1	.Clip (CP1418)	-	AS62404	(2)(S1)
06-192	AS62406	1	.Clip (CP1420)	-	AS62404	(2)(S1)
06-202	6A9084	1	..Adaptor	-	5W8019	(S1)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
06-226	UP10758	1	..Connector	-	-	(A)
06-228	UP10757	1	..Connector, 3 Way	-	-	(A)
06-232	UP11155	1	..Inter-Tube Support Bracket	-	-	(A)
06-234	AS15802	1	..Adaptor, Straight Tube	-	-	(A)
06-264	6A7398	1	.Plug Assy, Vented	-	-	(2)(A)
06-265	AS15781	1	..Wire, Thrust	-	-	(A)
06-266	AS15705	1	..Nut, Tube Coupling	-	-	(A)
06-500	6A9045	1	.Tube Assy, Air - Fuel System - EEC to Bifurcation Panel	-	6A6212	(2)(3D) (S1)
06-536	AS62406	1	.Clip (CP0582)	-	400WSS4	(2)(S1)
06-544	AS62406	1	.Clip (CP0584)	-	400WSS4	(2)(S1)
06-600	AS15779	1	..Wire, Thrust	-	AS15777	(S1)
06-601	AS15703	1	..Nut, Tube Coupling	-	AS15701	(S1)
06-602	LK40979	1	..Ferrule	-	AS15768	(S1)
06-642	AS15806	1	..Adaptor, Union	-	AS15802	(S1)
06-660	AS62406	1	.Clip (CP1442)	-	-	(2)(A)
06-665	4W0115 or 4W0355	1	.Bolt (CP1409)	-	-	(2)(3)(A)
06-666	K8831	2	.Washer (CP1409)	-	-	(2)(A)
06-668	AS62406	1	.Clip (CP1409)	-	-	(2)(A)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
06-670	UP10480	1	.Spacer (CP1409)	-	-	(2)(A)
06-672	4W0001	1	.Nut (CP1409)	-	-	(2)(3)(A)
07-100	6A9039	1	.Tube Assy, Fuel System - EEC to Bifurcation Panel	-	5A8800	(2)(S1)
07-200	AS15779	1	..Wire, Thrust	-	AS15777	(S1)
07-201	AS15703	1	..Nut, Tube Coupling	-	AS15701	(S1)
07-202	AS15726	1	..Ferrule, Welding Tube	-	AS15768	(S1)
07-253	4W0102 or 4W0342	1	.Bolt (CP1482)	-	-	(2)(3) (A)(C)
07-254	K8831	1	.Washer (CP1482)	-	-	(2)(A)
07-256	AS62406	1	.Clip (CP1482)	-	-	(2)(A)
07-260	4W0001	1	.Nut (CP1482)	-	-	(2)(3)(A)
07-261	4W0102 or 4W0342	1	.Bolt (CP1481)	-	-	(2)(3) (A)(C)
07-262	K8831	1	.Washer (CP1481)	-	-	(2)(A)
07-264	AS62406	1	.Clip (CP1481)	-	-	(2)(A)
07-268	4W0001	1	.Nut (CP1481)	-	-	(2)(3)(A)
07-272	AS62406	1	.Clip (CP1017)	-	-	(2)(A)
07-280	AS62406	1	.Clip (CP0586)	-	-	(2)(A)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
07-800	5W8351	1	.Bracket	-	-	(2)(A)
07-801	4W0164	1	.Bolt	-	-	(2)(3)(A)
07-802	4W0002	1	.Nut	-	-	(2)(3)(A)
10-157	4W0102 or 4W0342	1	.Bolt (CP1480)	-	-	(2)(3) (A)(C)
10-158	K8831	1	.Washer (CP1480)	-	-	(2)(A)
10-160	AS62404	1	.Clip (CP1480)	-	-	(2)(A)
10-164	4W0001	1	.Nut (CP1480)	-	-	(2)(3)(A)
10-536	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
10-544	400WSS4 or AS62404	1	.Clip (CP0584)	-	400WSS4	(C)
10-552	400WSS4 or AS62404	1	.Clip (CP0586)	-	400WSS4	(C)
75-23-48						
02-183	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)

R For A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

R 75-32-49

R R R	03-500	6A9042	1	.Tube Assy, Air - Stg 10 Solenoid to Stg 10 Bleed Valve	-	6A6194	(2)(S1)
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	FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
R				For A5 Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081)			
R				incorporated:			
R				75-32-49			
R	03-500	6A9042	1	.Tube Assy, Air - Stg 10	-	5A9146	(2)(S1)
R				Solenoid to Stg 10 Bleed			
R				Valve			
R				For A5 Engines:			
				75-32-49			
	04-100	6A6212	1	.Tube Assy, Air - EEC to	-	6A6222	(2)(4D)
				Bifurcation Panel			(S1)
	04-125	4W0103	1	.Bolt	-	-	(2)(3)
		or		(CP0587)			(A)(C)
		4W0343					
	04-126	5W1086	1	.Washer	-	-	(2)(A)
				(CP0587)			
	04-128	400WSS4	1	.Clip	-	400WSS4	(C)
		or		(CP0587)			
		AS62404					
	04-132	4W0043	1	.Nut	-	-	(2)(3)(A)
				(CP0587)			
	04-136	400WSS4	1	.Clip	-	400WSS4	(C)
		or		(CP0586)			
		AS62404					
	04-144	400WSS4	1	.Clip	-	400WSS4	(C)
		or		(CP0584)			
		AS62404					
	04-152	400WSS4	1	.Clip	-	400WSS4	(C)
		or		(CP0582)			
		AS62404					
	04-240	AS15777	1	..Wire, Thrust	-	-	(A)
	04-241	AS15701	1	..Nut, Tube Coupling	-	-	(A)
	04-242	AS15768	1	..Adaptor, Straight Tube	-	AS15802	(S1)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
04-253	4W0102	1	.Bolt (CP1422)	—	—	(2)(3)(A)
04-254	K8831	1	.Washer (CP1422)	—	—	(2)(A)
04-256	AS62404	1	.Clip (CP1422)	—	—	(2)(A)
04-260	4W0001	1	.Nut (CP1422)	—	—	(2)(3)(A)
04-261	4W0105	1	.Bolt (CP1423)	—	—	(2)(3)(A)
04-262	K8831	2	.Washer (CP1423)	—	—	(2)(A)
04-264	AS62404	1	.Clip (CP1423)	—	—	(2)(A)
04-268	4W0001	1	.Nut (CP1423)	—	—	(2)(3)(A)
04-500	6A9041	1	.Tube Assy, Air - Bleed Valve Servo - Solenoid to Bifurcation Panel	—	6A6223	(2)(S1)
04-541	4W0116 or 4W0356	1	.Bolt (CP1420)	—	4W0115	(2)(3) (C)(S1)
04-591	4W0114 or 4W0354	1	.Bolt (CP1418)	—	4W0114	(3)(C)
04-605	AS15802	1	..Adaptor, Straight Tube	—	—	(A)
04-656	AS62404	1	.Clip (CP1431)	—	—	(2)(A)
08-136	400WSS4 or AS62404	1	.Clip (CP0586)	—	400WSS4	(C)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
08-144	400WSS4 or AS62404	1	.Clip (CP0584)	-	400WSS4	(C)
08-152	400WSS4 or AS62404	1	.Clip (CP0582)	-	400WSS4	(C)
10-581	4W0104 or 4W0344	1	.Bolt (CP1431)	-	4W0104	(2)(3) (A)(C)
10-582	K8831	1	.Washer (CP1431)	-	K8831	(2)(2D)
14-100	6A9044	1	.Tube Assy, Air - Bleed Valve Servo - Bifurcation Panel to Valve	-	6A6199	(2)(S1)

D. Redundant parts:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
71-51-41						
For A1 Engines:						
02-088	-	1	.Washer (CP1017)	-	5W1086	(1)(B)
For A5 Engines:						
02-088	-	1	.Washer (CP1017)	-	K8831 or 5W1086	(2)(B)
For all Engines:						
73-22-49						
02-579	-	1	.Washer (CP1426)	-	K8831	(1)(1D)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02-583	-	1	.Spacer (CP1426)	-	UP10479	(1)(2)(B)
03-188	-	1	.Bolt (CP1441)	-	4W0102	(1)(2)(B)
03-189	-	1	.Washer (CP1441)	-	K8831	(1)(2)(B)
03-191	-	1	.Clip (CP1441)	-	AS62404	(1)(2)(B)
03-195	-	1	.Nut (CP1441)	-	4W0001	(1)(2)(B)
06-128	-	1	.Clip (CP1426)	-	AS62404	(B)
06-218	-	1	..Receptacle, Assy	-	6A8092	(B)
06-242	-	1	..Adaptor, Straight Tube	-	AS15802	(B)
06-250	-	1	..Washer, Flat	-	MS9321-10	(B)
06-552	-	1	.Clip, Loop Type (CP0586)	-	400WSS4	(1)(2)(B)
06-557	-	1	.Bolt (CP0587)	-	4W0119	(1)(2)(B)
06-558	-	1	.Washer (CP0587)	-	5W1086	(1)(2)(B)
06-560	-	1	.Clip, Loop Type (CP0587)	-	400WSS4	(1)(2)(B)
For A1 Engines:						
06-562	-	1	.Spacer (CP0587)	-	5W1033	(1)(B)
For A5 Engines:						
06-562	-	1	.Spacer (CP0587)	-	UP10482 or 5W1033	(2)(B)

For all Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
06-564	-	1	.Nut (CP0587)	-	4W0043	(1)(2)(B)
06-573	-	1	.Bolt (CP1422)	-	4W0102	(1)(2)(B)
06-574	-	1	.Washer (CP1422)	-	K8831	(1)(2)(B)
06-576	-	1	.Clip (CP1422)	-	AS62404	(1)(2)(B)
06-580	-	1	.Nut (CP1422)	-	4W0001	(1)(2)(B)
06-581	-	1	.Bolt (CP1423)	-	4W0105	(1)(2)(B)
06-582	-	2	.Washer (CP1423)	-	K8831	(1)(2)(B)
06-584	-	1	.Clip (CP1423)	-	AS62404	(1)(2)(B)
06-588	-	1	.Nut (CP1423)	-	4W0001	(1)(2)(B)
07-110	-	1	.Nut	-	MS9201-04	(1)(2)(B)
07-141	-	1	.Bolt (CP1027)	-	4W0102	(1)(2)(B)
07-142	-	1	.Washer (CP1027)	-	5W1086	(1)(2)(B)
07-144	-	1	.Clip (CP1027)	-	400WSS4	(1)(2)(B)
07-148	-	1	.Nut (CP1027)	-	4W0043	(1)(2)(B)
07-149	-	1	.Bolt (CP1028)	-	4W0103	(1)(2)(B)
07-150	-	1	.Washer (CP1028)	-	5W1086	(1)(2)(B)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
07-152	-	1	.Clip (CP1028)	-	400WSS4	(1)(2)(B)
07-156	-	1	.Nut (CP1028)	-	4W0001	(1)(2)(B)
07-218	-	1	..Moisture Trap, Assy	-	5A0454	(B)
07-242	-	1	..Adaptor, Union Extended	-	5A9369	(B)
07-245	-	1	..Plug	-	MS9405-01	(B)
07-250	-	1	..Washer, Flat	-	MS9321-10	(B)
07-500	-	1	.Tube Assy	-	44456 or M1543-1 or 556-1 -15364 -100	(B)

For A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

75-32-49

03-549	-	1	.Bolt CP0590)	-	4W0103	(2)(B)
03-552	-	1	.Clip (CP0590)	-	400WSS4	(2)(B)
03-556	-	1	.Nut (CP0590)	-	4W0001	(2)(B)

For all Engines:

75-32-49

04-165	-	1	.Bolt (CP1409)	-	4W0115	(1)(2)(B)
04-166	-	2	.Washer (CP1409)	-	K8831	(1)(2)(B)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
04-168	-	1	.Clip (CP1409)	-	AS62404	(1)(2)(B)
04-170	-	1	.Spacer (CP1409)	-	UP10480	(1)(2)(B)
04-172	-	1	.Nut (CP1409)	-	4W0001	(1)(2)(B)
04-214	-	1	..Bracket, Inter Tube Support	-	UP11152	(B)
04-536	-	1	.Clip (CP1442)	-	AS62404	(1)(2)(B)
04-600	-	1	..Wire, Thrust	-	AS15777	(B)
04-601	-	1	..Nut, Tube Coupling	-	AS15701	(B)
04-602	-	1	..Ferrule, Assy Welding	-	AS15768	(B)
14-243	-	1	..Bushing	-	K12664	(B)
79-21-49						
10-157	-	1	.Bolt (CP6122)	-	4W0103	(1)(2)(B)
10-158	-	1	.Washer (CP6122)	-	K8831	(1)(2)(B)
10-160	-	1	.Clip (CP6122)	-	AS62412	(1)(2)(B)
10-164	-	1	.Nut (CP6122)	-	4W0001	(1)(2)(B)

E. Instruction disposition codes:

(1) This part is part of the modification group 01. To have interchangeability between the old and new standards, this part must be changed at the same time with the other parts of this modification group.

(2) This part is part of the modification group 02. To have interchangeability between the old and new standards, this part must be changed at the same time with the other parts of this modification group.

- (3) Refer to Appendix 5 of the Engine Illustrated Part Catalog.
- (A) Additional part.
- (B) Deleted part.
- (C) Alternative part.
- (S1) Old and new parts are not interchangeable.
- (1D) Quantity decreased from 2 to 1.
- (2D) Quantity increased from 1 to 2.
- (3D) This old part is transferred to ATA Chapter 75-32-49, Fig/Item No. 04-100 for configuration purposes only.
- (4D) The new part is transferred from ATA Chapter 73-22-49, Fig/Item No. 06-500 for configuration purposes only.

3. Accomplishment Instructions

A. Rework Instructions

- (1) None.

B. Assembly Instructions

PART 1 – Applicable for engines 'In Service'.

- (1) General

NOTE: IN ORDER TO REDUCE THE POTENTIAL FOR MULTIPLE ENGINE IN-FLIGHT SHUT DOWN, POWER LOSS, OR OTHER ANOMALIES DUE TO MAINTENANCE ERROR, IAE RECOMMENDS THAT OPERATORS AVOID PERFORMING MAINTENANCE ON MULTIPLE ENGINES INSTALLED ON THE SAME AIRCRAFT AT THE SAME TIME. IF IT IS NOT POSSIBLE TO AVOID MAINTENANCE ON MORE THAN ONE ENGINE AT THE SAME TIME, IAE RECOMMENDS THAT ADDITIONAL CONTROLS BE APPLIED IN ORDER TO ENSURE THAT MAINTENANCE TASKS HAVE BEEN COMPLETED AS DEFINED. MAINTENANCE GUIDELINES SHOULD BE REVISED WHERE POSSIBLE, TO PROMOTE THIS RECOMMENDATION.

WARNING: DO NOT TOUCH THE ENGINE COMPONENTS FOR A SHORT TIME AFTER THE ENGINE IS SHUT DOWN. THE COMPONENTS STAY HOT AND CAN CAUSE INJURY.

CAUTION: DO NOT BEND THE ELECTRICAL CABLE CONDUIT TOO MUCH WHEN YOU DISCONNECT/CONNECT THE ELECTRICAL CONNECTOR. THE CONDUIT CAN BE DAMAGED AND CAN CAUSE ELECTRICAL CIRCUIT DEFECTS.

CAUTION: MAKE SURE ELECTRICAL CONNECTORS DO NOT HAVE BENT PINS AND THAT THEY ARE CLEAN BEFORE YOU CONNECT THEM. DAMAGE OR CONTAMINATION OF THE ELECTRICAL CONNECTORS CAN CAUSE DAMAGE TO THE COMPONENTS.

- (a) Obey all the WARNINGS and CAUTIONS in the procedures that are referred to.

(b) Consumable Materials

- (i) Refer to the table that follows:

MAT NO.	DESIGNATION
V02-126	Lockwire
V02-274	Safety Cable
V02-275	Safety Cable

For the details of the consumable material given in the table above refer to the Overhaul Processes and Consumables Index.

- (ii) For further consumable materials refer also to the related Manual tasks given in this instruction.

- (c) Tools and Equipment

Refer to the related Manual tasks given in this instruction.
 - (d) Refer to the Aircraft Maintenance Manual, Chapter 70-23-11 for all torque procedures.
 - (e) Refer to the Aircraft Maintenance Manual, Chapter 70-23-15 for the connection of electrical plugs.
 - (f) Refer to the Aircraft Maintenance Manual, Chapter 70-40-11 for the use of locking devices.
- (2) Get access to the right area of the Low Pressure (LP) compressor/ intermediate case and High Pressure (HP) compressor case
- (a) Open the fan cowl doors (Refer to the Aircraft Maintenance Manual, Chapter 71-13-00).
 - (b) Open the thrust reverser halves (Refer to the Aircraft Maintenance Manual, Chapter 78-32-00).
- (3) Remove the burner to Engine Electronic Controller (EEC) pressure (Pb) sense line tube assemblies and the HP compressor stage 10 bleed air control tube assemblies
- (a) Remove the Pb sense line flexible tube (73-22-49, 07-500)(Refer to Figure 1)
 - (i) Disconnect the Pb sense line flexible tube (73-22-49, 07-500) from the EEC.
 - (ii) Disconnect the Pb sense line flexible tube (73-22-49, 07-500) from the Pb sense line tube assembly (73-22-49, 07-100).
 - (iii) Remove the old Pb sense line flexible tube (73-22-49, 07-500), P/N 44456 from the LP compressor/ intermediate case.
 - (b) Remove the Pb sense line tube assembly (73-22-49, 07-100)(Refer to Figure 2)
 - (i) Remove the old locknut (73-22-49, 07-110), P/N MS9201-04 that attaches the Pb sense line tube assembly (73-22-49, 07-100) to the support bracket assembly (73-22-49, 03-800).
 - (ii) Disconnect the Pb sense line tube assembly (73-22-49, 07-100) from the Pb sense line tube assembly (73-22-49, 06-500).

(iii) At the deleted clip position CP1027:

- (1) Remove the old bolt (73-22-49, 07-141), P/N 4W0102 and the old washer (73-22-49, 07-142), P/N 5W1086 that attach the clip (73-22-49, 07-144) to the bracket (73-22-49, 03-470).
- (2) Remove the old clip (73-22-49, 07-144), P/N 400WSS4 from the Pb sense line tube assembly (73-22-49, 07-100).
- (3) Remove the old nut (73-22-49, 07-148), P/N 4W0043 from the bracket (73-22-49, 03-470).

(iv) At the deleted clip position CP1028:

- (1) Remove the old bolt (73-22-49, 07-149), P/N 4W0103, the old washer (73-22-49, 07-150), P/N 5W1086 and the old nut (73-22-49, 07-156), P/N 4W0001 that attach the clip (73-22-49, 07-144) to the tube (73-22-49, 03-500).
- (2) Remove the old clip (73-22-49, 07-152), P/N 400WSS4 from the Pb sense line tube assembly (73-22-49, 07-100).

(v) Remove the old Pb sense line tube assembly (73-22-49, 07-100), P/N 5A8800 or P/N 6A8091 from the LP compressor/ intermediate case.

(c) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) from the LP compressor/ intermediate case (Refer to Figure 3, 4, 36, 37, 38 and 39)

(i) For V2500-A1 Engines:

- (1) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) from the HP compressor stage 10 solenoid valve (75-32-53, 01-400).
- (2) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) from the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

(3) At the revised clip position CP0590:

- A Remove the old bolt (75-32-49, 03-549), the two washers (75-32-49, 0-550) and the nut (75-32-49, 03-556) that attach the two clips (75-32-49, 03-552) and (75-23-48, 01-552) to the bracket (79-21-42, 01-090).
- B Remove the old clip (75-32-49, 03-552), P/N 400WSS4 from the tube (75-32-49, 03-500).

(4) At the clip position CP1029:

- A Remove the bolt (75-23-48, 01-557), the washer (75-23-48, 01-558), and the clip nut (75-23-48, 01-564) that attach the two clips (75-32-49, 03-568) and (75-23-48, 01-560) to the bracket (79-21-42, 01-084).
- B Remove the clip (75-32-49, 03-568) from the tube (75-32-49, 03-500).

(5) At the clip position CP1030:

- A Remove the bolt (75-23-48, 01-565), the washer (75-23-48, 01-566), and the clip nut (75-23-48, 01-572), that attach the two clips (75-32-49, 03-576) and (75-23-48, 01-568) to the bracket (75-23-48, 01-470).
- B Remove the clip (75-32-49, 03-576) from the tube (75-32-49, 03-500).

(6) At the clip position CP1024:

- A Remove the bolt (75-32-49, 03-557), the washer (75-32-49, 03-558) and the nut (75-32-49, 03-564) that attach the clip (75-32-49, 03-560) to the tube (75-23-48, 01-500).
- B Remove the clip (75-32-49, 03-560) from the tube (75-32-49, 03-500).

(7) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 5A9146 from the LP compressor/ intermediate case.

(ii) For V2500-A5 engines:

- (1) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) from the HP compressor stage 10 solenoid valve (75-32-53, 01-400).
- (2) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) from the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

- (3) For engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

A At the deleted clip position CP0590:

- 1 Remove the old bolt (75-32-49, 03-549), P/N 4W0104, the two old washers (75-32-49, 03-550), P/N 5W1086 and the old nut (75-32-49, 03-556), P/N 4W0001 that attach the clip (75-32-49, 03-552) to the bracket (79-21-42, 01-090).
- 2 Remove the old clip (75-32-49, 03-552), P/N 400WSS4 from the tube (75-32-49, 03-500).

B At the clip position CP1029:

- 1 Remove the bolt (75-32-49, 03-565), the washer (75-32-49, 03-566), and the clip nut (75-32-49, 03-571) that attach the clip (75-32-49, 03-568) to the bracket (79-21-42, 01-084).
- 2 Remove the clip (75-32-49, 03-568) from the tube (75-32-49, 03-500).

C At the clip position CP1030:

- 1 Remove the bolt (75-32-49, 03-573), the washer (75-32-49, 03-575), and the clip nut (75-32-49, 03-580), that attach the clip (75-32-49, 03-576), to the bracket (75-23-48, 01-470).
- 2 Remove the clip (75-32-49, 03-576) from the tube (75-32-49, 03-500).

D At the clip position CP1404:

- 1 Remove the bolt (71-51-41, 01-230) and the nut (71-51-41, 01-237) that attaches the clip (71-51-41, 01-233) to the tube (75-32-49, 03-500).

NOTE: Do not remove the clip (71-51-41, 01-233) from the harness (71-51-41, 01-005).

E At the clip position CP1403:

- 1 Remove the bolt (75-32-49, 03-581), the spacer (75-32-49, 03-586) and the nut (75-32-49, 03-588) that attach the clip (75-32-49, 03-584) to the bracket (75-32-53, 01-500).

2 Remove the clip (75-32-49, 03-584) from the tube (75-32-49, 03-500).

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F Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 6A6194 from the LP compressor/ intermediate case.

(4) For engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

A At the revised clip position CP0590:

1 Remove the bolt (75-32-49, 03-549) the two washers (75-32-49, 03-550) and the nut (75-32-49, 03-556), that attach the two clips (75-32-49, 03-552) and (75-23-48, 01-552) to the bracket (79-21-42, 01-090).

2 Remove the old clip (75-32-49, 03-552), P/N 400WSS4 from the tube (75-32-49, 03-500).

B At the clip position CP1029:

1 Remove the bolt (75-23-48, 01-577), the washer (75-23-48, 01-558), and the clip nut (75-23-48, 01-564) that attach the two clips (75-32-49, 03-568) and (75-23-48, 01-560) to the bracket (79-21-42, 01-084).

2 Remove the clip (75-32-49, 03-568) from the tube (75-32-49, 03-500).

C At the clip position CP1030:

1 Remove the bolt (75-23-48, 01-565), the washer (75-23-48, 01-565), and the clip nut (75-23-48, 01-572), that attach the two clips (75-32-49, 03-576) and (75-23-48, 01-568) to the bracket (75-23-48, 01-470).

2 Remove the clip (75-32-49, 03-576) from the tube (75-32-49, 03-500).

D At the clip position CP1024:

1 Remove the bolt (75-32-49, 03-557), the washer (75-32-49, 03-558) and the nut (75-32-49, 03-564) that attach the clip (75-32-49, 03-560) to the tube (75-23-48, 01-500).

2 Remove the clip (75-32-49, 03-560) from the tube (75-32-49, 03-500).

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E Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 5A9146 from the LP compressor/ intermediate case.

(d) Remove the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) from the LP compressor/ intermediate case (Refer to Figure 5, 6, 11, 12, 13 and 15)

(i) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) from the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500).

(ii) At the revised clip position CP0587:

(1) Remove the old bolt (73-22-49, 06-557), P/N 4W0119, the old washer (73-22-49, 06-558), P/N 5W1086, the old spacer (73-22-49, 06-562), P/N UP10482 or 5W1033 and the old nut (73-22-49, 06-564), P/N 4W0043 that attach the two clips (75-32-49, 04-128) and (73-22-49, 06-560) to the bracket (79-21-42, 01-350).

(2) Remove the clip (75-32-49, 04-128) from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-560) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-560) is transferred to the clip (75-32-49, 04-128) for configuration purposes only.

(iii) At the revised clip position CP0586:

(1) Remove the bolt (73-22-49, 03-149), the old washer (73-22-49, 03-150), P/N 5W1086 and the spacer (73-22-49, 03-154) that attach the five clips (73-22-49, 10-552) (75-32-49, 04-136) (73-22-49, 03-152) (75-32-49, 08-136) and (73-22-49, 06-552) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-552) (73-22-49, 03-152) and (75-32-49, 08-136) from the tubes (73-22-49, 10-500) (73-22-49, 03-100) and (75-32-49, 08-100).

(2) Remove the old clip (75-32-49, 04-136), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-552) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-552) is transferred to the clip (75-32-49, 04-136) for configuration purposes only.

(iv) At the revised clip position CP0584:

- (1) Remove the bolt (73-22-49, 03-141), the old washer (73-22-49, 03-142), P/N 5W1086 and the spacer (73-22-49, 03-146) that attach the five clips (73-22-49, 10-544), (75-32-49, 04-144), (73-22-49, 03-144), (75-32-49, 08-144) and (73-22-49, 06-544) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-544), (73-22-49, 03-144) and (75-32-49, 08-144) from the tubes (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (2) Remove the old clip (75-32-49, 04-144), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-544) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-544) is transferred to the clip (75-32-49, 04-144) for configuration purposes only.

(v) At the revised clip position CP0582:

- (1) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

Remove the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the five clips (73-22-49, 10-568), (75-32-49, 04-152), (73-22-49, 03-136), (75-32-49, 08-152) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-568), (73-22-49, 03-136) and (75-32-49, 08-152) from the tubes (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (2) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or Part 3 (SBE 75-0081) incorporated:

Remove the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the six clips (75-23-48, 02-183), (73-22-49, 10-568), (75-32-49, 04-152), (73-22-49, 03-136), (75-32-49, 08-152) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).

NOTE: Do not remove the four clips (75-23-48, 02-183), (73-22-49, 10-568), (73-22-49, 03-136) and (75-32-49, 08-152) from the tubes (75-23-48, 02-100), (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (3) Remove the old clip (75-32-49, 04-152), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-536) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-536) is transferred to the clip (75-32-49, 04-152) for configuration purposes only.

- (vi) At the revised clip position CP1409:

- (1) Remove the bolt (75-32-49, 04-165), the two washers (75-32-49, 04-166), the spacer (75-32-49, 04-170) and the nut (75-32-49, 04-172) that attach the four clips (75-32-49, 04-168), (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) to the tube (79-22-49, 04-100).

NOTE: Do not remove the three clips (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) from the tubes (75-32-49, 10-100), (36-11-47, 02-500) and (75-32-49, 11-500).

- (2) Remove the old clip (75-32-49, 04-168), P/N AS62404 from the tube (75-32-49, 04-100).

NOTE: The bolt (75-32-49, 04-165), the two washers (75-32-49, 04-166), the spacer (75-32-49, 04-170) and the nut (75-32-49, 04-172) are transferred to the bolt (73-22-49, 06-665), the two washers (73-22-49, 06-666), the spacer (73-22-49, 06-670) and the nut (73-22-49, 06-672) for configuration purposes only.

- (vii) At the deleted clip position CP1441:
- (1) Remove the old bolt (73-22-49, 03-188), P/N 4W0102, the old washer (73-22-49, 03-189), P/N K8831 and the old nut (73-22-49, 03-195), P/N 4W0001 that attach the clip (73-22-49, 03-191) to the tube (75-32-49, 04-100).
 - (2) Remove the old clip (73-22-49, 03-191), P/N AS62404 from the tube (73-22-49, 03-100).
- (viii) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100), P/N 6A6222 from the LP compressor/intermediate case.
- (e) Remove the Pb sense line tube assembly (73-22-49, 05-500) from the High Pressure (HP) compressor case (Refer to Figure 9, 41, 42 and 43)
- (i) For V2500-A1 Engines:
- (1) Disconnect the Pb sense line tube assembly (73-22-49, 05-500) from the Pb sense line tube assembly (73-22-49, 05-100).
 - (2) Disconnect the Pb sense line tube assembly (73-22-49, 05-500) from the Pb sense line tube assembly (73-22-49, 06-100).
 - (3) At the clip position CP6095:
 - A Remove the bolt (73-22-49, 05-525), the two washers (73-22-49, 05-526), the spacer (73-22-49, 05-530) and the nut (73-22-49, 05-532) that attach the four clips (73-22-49, 05-528), (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583) to the tube (75-32-49, 16-100).
- NOTE: Do not remove the three clips (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583).
- (4) At the deleted clip position CP6122:
 - A Remove the old bolt (79-21-49, 10-157), P/N 4W0103, the old washer (79-21-49, 10-158), P/N K8831 and the old nut (79-21-49, 10-164), P/N 4W0001 that attach the clip (79-21-49, 10-160) to the tube (75-32-49, 14-100).
 - B Remove the old clip (79-21-49, 10-160), P/N AS62412 from the oil tube assembly (79-21-49, 10-100).

(5) At the clip position CP5766:

- A Remove the bolt (73-11-49, 19-173), the two washers (73-11-49, 19-174) and the nut (73-11-49, 19-180) that attach the two clips (73-11-49, 19-176) and (71-51-41, 01-275) to the tube (73-22-49, 05-500).

(6) At the clip position CP5648:

- A Remove the bolt (73-11-49, 16-157), the three spacers (73-11-49, 16-161), (73-11-49, 16-162), (73-11-49, 16-163) and the nut (73-11-49, 16-164) that attach the five clips (71-52-41, 01-270), (73-22-49, 05-568), (73-11-49, 16-160), (75-23-48, 03-168) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

NOTE: Do not remove the four clips (71-52-41, 01-270), (73-11-49, 16-160), (75-23-48, 03-168) and (75-22-49, 05-552) from the bracket (79-21-49, 13-070).

- B Remove the clip (73-22-49, 05-568) from the tube (73-22-49, 05-500).

(7) At the clip position CP5647:

- A Remove the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558), the spacer (73-22-49, 05-562) and the clip nut (73-22-49, 05-564) that attach the three clips (75-23-48, 03-176), (73-22-49, 05-560) and (75-22-49, 05-544) to the bracket (72-41-00, 03-550).

NOTE: Do not remove the clips (75-22-49, 05-544) and 75-23-48, 03-176) from the bracket (72-41-00, 03-550).

- B Remove the clip (73-22-49, 05-560) from the tube (73-22-49, 05-500).

(8) Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6203 from the High Pressure (HP) compressor case.

(ii) For V2500-A5 Engines:

- (1) Disconnect the Pb sense line tube assembly (73-22-49, 05-500) from the Pb sense line tube assembly (73-22-49, 05-300).
- (2) Disconnect the Pb sense line tube assembly (73-22-49, 05-500) from the Pb sense line tube assembly (73-22-49, 06-100).

- (3) For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

A At the clip position CP6095:

- 1** Remove the bolt (73-22-49, 05-525), the two washers (73-22-49, 05-526), the spacer (73-22-49, 05-530) and the nut (73-22-49, 05-532) that attach the four clips (73-22-49, 05-528), (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583) to the tube (75-32-49, 16-100).

NOTE: Do not remove the three clips (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583).

- 2** Remove the clip (73-22-49, 05-528) from tube (73-22-49, 05-500).

B At the deleted clip position CP6122:

- 1** Remove the old bolt (79-21-49, 10-157), P/N 4W0103, the old washer (79-21-49, 10-158), P/N K8831 and the old nut (79-21-49, 10-164), P/N 4W0001 that attach the clip (79-21-49, 10-160) to the tube (75-32-49, 14-100).

- 2** Remove the old clip (79-21-49, 10-160), P/N AS62412 from the oil tube assembly (79-21-49, 10-100).

C At the clip position CP5766:

- 1** Remove the bolt (73-11-49, 19-173), the two washers (73-11-49, 19-174) and the nut (73-11-49, 19-180) that attach the two clips (73-11-49, 19-176) and (71-51-41, 01-275) to the tube (73-22-49, 05-500).

D At the clip position CP5648:

- 1** Remove the bolt (73-11-49, 16-157), the two washers (73-11-19, 16-158), the spacer (73-11-49, 16-161), the spacer (73-11-49, 16-162) and the nut (73-11-49, 16-164) that attach the four clips (71-52-41, 01-270), (73-22-49, 05-568), (73-11-49, 16-160) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

NOTE: Do not remove the three clips (71-52-41, 01-270), (73-11-49, 16-160) and (75-22-49, 05-552) from the bracket (79-21-49, 13-070).

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2 Remove the clip (73-22-49, 05-568) from the tube (73-22-49, 05-500).

E At the clip position CP5647:

1 Remove the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558) and the clip nut (73-22-49, 05-564) that attach the two clips (73-22-49, 05-560) and (75-22-49, 05-544) to the bracket (72-41-00, 03-550).

NOTE: Do not remove the clip (75-22-49, 05-544) from the bracket (72-41-00, 03-550).

2 Remove the clip (73-22-49, 05-560) from the tube (73-22-49, 05-500).

F At the clip position CP6107:

1 Remove the bolt (71-51-41, 02-779), the washer (71-51-41, 02-780) and the nut (71-51-41, 02-786) that attach the clip (71-51-41, 02-782) to the tube (73-22-49, 05-500).

G Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6236 from the High Pressure (HP) compressor case.

(4) For Engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

A At the clip position CP6095:

1 Remove the bolt (73-22-49, 05-525), the washer (73-22-49, 05-526), the spacer (73-22-49, 05-530) and the nut (73-22-49, 05-532) that attach the four clips (73-22-49, 05-528), (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583) to the tube (75-32-49, 16-100).

NOTE: Do not remove the three clips (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583).

2 Remove the clip (73-22-49, 05-528) from the tube (73-22-49, 05-500).

B At the deleted clip position CP6122:

- 1 Remove the old bolt (79-21-49, 10-157), P/N 4W0103, the old washer (79-21-49, 10-158), P/N K8831 and the old nut (79-21-49, 10-164), P/N 4W0001 that attach the clip (79-21-49, 10-160) to the tube (75-32-49, 14-100).
- 2 Remove the old clip (79-21-49, 10-160), P/N AS62412 from the oil tube assembly (79-21-49, 10-100).

C At the clip position CP5766:

- 1 Remove the bolt (73-11-49, 19-173), the two washers (73-11-49, 19-174) and the nut (73-11-49, 19-180) that attach the two clips (73-11-49, 19-176) and (71-51-41, 01-275) to the lug on tube (73-22-49, 05-500).

D At the clip position CP5648:

- 1 Remove the bolt (73-11-49, 16-157), the two washers (73-11-19, 16-158), the three spacers (73-11-49, 16-161), (73-11-49, 16-162), (73-11-49, 16-163) and the nut (73-11-49, 16-164) that attach the five clips (71-52-41, 01-270), (73-11-49, 05-568), (73-11-49, 16-160), (73-23-48, 03-168) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

NOTE: Do not remove the four clips (71-52-41, 01-270), (73-11-49, 16-160), (73-23-48, 03-168) and (75-22-49, 05-552) from the bracket (79-21-49, 13-070).

- 2 Remove the clip (73-22-49, 05-568) from the tube (73-22-49, 05-500).

E At the clip position CP5647:

- 1 Remove the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558), the spacer (73-22-49, 05-562) and the clip nut (73-22-49, 05-564) that attach the three clips (75-23-48, 03-176), (73-22-49, 05-560) and (75-22-49, 05-544) to the bracket (72-41-00, 03-550).

NOTE: Do not remove the clips (75-23-48, 03-176) and (75-22-49, 05-544) from the bracket (72-41-00, 03-550).

- 2 Remove the clip (73-22-49, 05-560) from the tube (73-22-49, 05-500).

- (5) Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6235 from the High Pressure (HP) compressor case.
- (f) Remove the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100) from the HP compressor case (Refer to Figure 10, 40, 41, 42 and 43)
- (i) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100) from the HP compressor stage 10 bleed valve (75-32-54, 01-500).
- (ii) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100) from the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500).
- (iii) At the clip position CP5397:
- (1) Remove the bolt (75-32-49, 14-189), the two washers (75-32-49, 14-190) and the clip nut (75-32-49, 14-196) that attach the clip (75-32-49, 14-192) to the bracket (75-32-54, 01-395).
- (2) Remove the clip (75-32-49, 14-192) from the tube (75-32-49, 14-100).
- (iv) At the clip position CP5450:
- (1) Remove the bolt (74-21-43, 02-101), the washer (74-21-43, 02-102) and the clip nut (74-21-43, 02-108) that attach the two clips (74-21-43, 01-104) and (75-32-49, 14-544) to the bracket (75-00-49, 01-545).
- NOTE: Do not remove the clip (74-21-43, 02-104) from the bracket (75-00-49, 01-545)
- (2) Remove the clip (75-32-49, 14-544) from the tube (75-32-49, 14-100).
- (v) At the clip position CP5675:
- (1) Remove the bolt (75-32-49, 14-173), the washer (75-32-49, 14-174), the spacer (75-32-49, 14-179) and the clip nut (75-32-49, 14-180) that attach the two clips (75-32-49, 14-176) and (75-32-49, 14-15-120) to the bracket (75-00-49, 01-090).
- NOTE: Do not remove the clip (75-32-49, 15-120) from the bracket (75-00-49, 01-190).

- (2) Remove the clip (75-32-49, 14-176) from the tube (75-32-49, 14-100).

(vi) At the clip position CP5643:

- (1) Remove the bolt (75-32-49, 13-149), the washers (75-32-49, 13-150) and the nut (75-32-49, 13-156) that attach the two clips (75-32-49, 14-128) and (75-32-49, 13-152) to the bracket (72-41-00, 03-320).

NOTE: Do not remove the clip (75-32-49, 13-152) from the bracket (72-41-00, 03-320).

- (2) Remove the clip (75-32-49, 14-128) from the bracket (72-41-00, 03-320).

(vii) At the clip position CP5641:

- (1) Remove the bolt (75-32-49, 13-173), the two washers (75-32-49, 13-174), the spacer (75-32-49, 13-178) and the nut (75-32-49, 13-180) that attach the three clips (71-52-43, 01-570), (75-32-49, 14-168) and (75-32-49, 13-176) to the bracket (72-41-00, 03-360).

NOTE: Do not remove the two clips (75-52-43-01-570) and (75-32-49, 13-176) from the bracket (72-41-00, 03-360).

- (2) Remove the clip (75-32-49, 14-168) from the tube (75-32-49, 14-100).

(viii) At the clip position CP6124:

- (1) Remove the bolt (73-11-49, 19-525), the washer (73-11-49, 19-526) and the nut (73-11-49, 19-532) that attach the clip (73-11-49, 19-528) to the tube (75-32-49, 14-100).

NOTE: Do not remove the clip (73-11-49, 19-528) from the tube (73-11-49, 19-500).

(ix) At the clip position CP6123:

- (1) Remove the bolt (73-11-49, 19-589), the two washers (73-11-49, 19-590) and the nut (73-11-49, 19-596) that attach the two clips (73-11-49, 19-592) and (71-51-41, 07-100) to the tube (75-32-49, 14-100).

NOTE: Do not remove the clip (73-11-49, 19-592) from tube (73-11-49, 19-500) and the clip (71-51-41, 07-100) from the EEC harness (71-51-41, 01-005).

- (x) At the deleted clip position CP6122:
 - (1) Remove the old bolt (79-21-49, 10-157), P/N 4W0103, the old washer (79-21-49, 10-158), P/N K8831 and the old nut (79-21-49, 10-164), P/N 4W0001 that attach the clip (79-21-49, 10-160) to the tube (75-32-49, 14-100).
 - (2) Remove the old clip (79-21-49, 10-160), P/N AS62412 from the oil tube assembly (79-21-49, 10-100).
 - (xi) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A6199 from the HP compressor case
 - (g) Remove the Pb sense line tube assembly (73-22-49, 06-100) and HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) from the LP compressor/ intermediate case (Refer to Figure 6, 7, 8, 14, 15 and 16)
 - (i) Disconnect the Pb sense line tube assembly (73-22-49, 06-100) from the bifurcation panel.
 - (ii) Disconnect the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) from the bifurcation panel.
 - (iii) At the revised clip position CP1426:
 - (1) Remove the bolt (73-22-49, 02-578), the washer (73-22-49, 02-579), the old spacer (73-22-49, 02-583), P/N UP10479, the old washer (73-22-49, 02-579), P/N K8831 and the nut (73-22-49, 02-585) that attach the three clips (73-22-49, 10-136), (73-22-49, 02-581) and (73-22-49, 06-128) to the raceway (71-51-50, 01-500).
- NOTE:** Do not remove the two clips (73-22-49, 10-136) and (73-22-49, 02-581) from the two tubes (73-22-49, 10-100) and (73-22-49, 02-500).
- (2) Remove the old clip (73-22-49, 06-128), P/N AS62404 from the tube (73-22-49, 06-100).
 - (3) Install the bolt (73-22-49, 02-578), the washer (73-22-49, 02-579) and the nut (73-22-49, 02-585) that attach the two clips (73-22-49, 10-136) and (73-22-49, 02-581) to the raceway (71-51-50, 01-500).
 - (4) Torque the nut to between 36 and 45 lbf in. (4 and 5 Nm).

(iv) At the revised clip position CP1442:

- (1) Remove the bolt (71-51-41, 02-787), the washer (71-51-41, 02-788) and the nut (71-51-49, 02-794) that attach the two clips (75-32-49, 04-536) and (71-51-41, 02-790) to the raceway (71-51-50, 01-500).

NOTE: Do not remove the clip (71-51-41, 02-790) from the harness (71-51-41, 01-005).

- (2) Remove the old clip (75-32-49, 04-536), P/N AS62404 from the tube (75-32-49, 04-500).

(v) At the revised clip position CP1418:

- (1) Remove the bolt (75-32-49, 04-591), the washer (75-32-49, 04-592), the spacer (75-32-49, 04-596) and the nut (75-32-49, 04-598) that attach the four clips (75-32-49, 04-594), (75-32-49, 10-568), (36-11-47, 01-528) and (73-22-49, 06-184) to the tube (75-32-49, 01-500).

NOTE: Do not remove the two clips (75-32-49, 10-568) and (36-11-47, 01-528) from the two tubes (75-32-49, 10-500) and (36-11-47, 01-500).

- (2) Remove the old clip (75-32-49, 04-594), P/N AS62404 from the tube (75-32-49, 04-500).
- (3) Remove the old clip (73-22-49, 06-184), P/N AS62404 from the tube (73-22-49, 06-100).

(vi) At the revised clip position CP1420:

- (1) For V2500-A1 Engines:

A Remove the bolt (75-32-49, 04-173), the two washers (75-32-49, 04-174), the spacer (75-32-49, 04-178) and the nut (75-32-49, 04-180) that attach the four clips (79-21-49, 04-552), (73-22-49, 06-192), (75-32-49, 10-576) and (75-32-49, 04-176) to the tube (36-11-47, 01-500).

NOTE: Do not remove the two clips (73-22-49, 06-192) and (75-32-49, 10-576) from the two tube (73-22-49, 06-100) and (75-32-49, 04-500).

B Remove the clip (75-32-49, 04-176) from the tube (75-32-49, 04-500).

C Remove the old clip (73-22-49, 06-192), P/N AS62404 from the tube (73-22-49, 06-100).

(2) For V2500-A5 Engines:

- A** Remove the bolt (75-32-49, 04-541), the two washers (75-32-49, 04-542), the spacer (75-32-49, 04-546) and the nut (75-32-49, 04-548) that attach the four clips (79-21-49, 04-552), (73-22-49, 06-192), (75-32-49, 10-576) and (75-32-49, 04-544) to the tube (36-11-47, 01-500).

NOTE: Do not remove the two clips (73-22-49, 06-192) and (75-32-49, 10-576) from the two tube (73-22-49, 06-100) and (75-32-49, 04-500).

- B** Remove the clip (75-32-49, 04-544) from the tube (75-32-49, 04-500).

- C** Remove the old clip (73-22-49, 06-192), P/N AS62404 from the tube (73-22-49, 06-100).

(vii) Remove the old Pb sense line tube assembly (73-22-49, 06-100), P/N 6A6211 from the LP compressor/ intermediate case

(viii) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500), P/N 6A6223 from the LP compressor/ intermediate case

(4) Remove the old support bracket assembly (Refer to Figure 1 and 2)

- (a) Disconnect the P 2.5 air flexible tube (73-22-49, 11-500) from the P 2.5 air tube assembly (73-22-49, 11-100).
- (b) Disconnect the P 4.9 air flexible tube (73-22-49, 04-100) from the P 4.9 air tube assembly (73-22-49, 03-500).
- (c) Remove the locknut (73-22-49, 11-110) that attach the P 2.5 air tube assembly (73-22-49, 11-500) to the support bracket assembly (73-22-49, 03-800).
- (d) Remove the locknut (73-22-49, 03-510) that attach the P 4.9 air tube assembly (73-22-49, 03-500) to the support bracket assembly (73-22-49, 03-800).
- (e) At the clip position CP1007:
- Remove the bolt (71-51-44, 01-190), the washer (71-51-44, 01-191), the nut (71-51-44, 01-197) and the clip (71-51-44, 01-193) from the support bracket assembly (73-22-49, 03-800).
- (f) Disconnect the harness (71-51-42, 01-005) from the harness (71-51-44, 01-005).

- (g) Remove the four bolts (71-51-44, 01-022) and the four nuts (71-51-44, 01-020) that attach the harness (71-51-44, 01-005) to the support bracket assembly (73-22-49, 03-800).
 - (h) Remove the bolt (73-22-49, 03-804) and the nut (73-22-49, 03-801) that attach the support bracket assembly (73-22-49, 03-800) to Flange FC.
 - (i) Remove the two bolts (73-22-49, 03-805), the two washers (73-22-49, 03-806) and the two nuts (73-22-49, 03-808) that attach the support bracket assembly (73-22-49, 03-800) to bracket (71-51-49, 01-370) on Flange FB.
 - (j) Remove the old support bracket assembly (73-22-49, 03-800), P/N 6A7420 from the High Pressure (HP) compressor case.
- (5) Install the new support bracket assembly (Refer to Figure 17 and 27)
- (a) Install the two new bolts (73-22-49, 08-847), P/N 4W0102 and the two new nut (73-22-49, 08-846), P/N 4W0001 that attach the new bracket (73-22-49, 03-848), P/N 6A9098 to the new support bracket assembly (73-22-49, 03-800), P/N 6A9096.
 - (b) Torque the two nuts to between 36 and 45 lbf in. (4 and 5 Nm).
 - (c) Install the two bolts (73-22-49, 03-805), the two washers (73-22-49, 03-806) and the two nuts (73-22-49, 03-808) that attach the new support bracket assembly (73-22-49, 03-800), P/N 6A9096 to the bracket (71-51-49, 01-370) on Flange FB.
 - (d) Torque the bolts to between 85 and 105 lbf in. (10 to 12 Nm).
 - (e) Install the bolt (73-22-49, 03-804) and the nut (73-22-49, 03-801) that attach the support bracket assembly (73-22-49, 03-800) and bracket (71-51-41, 05-820) to Flange FC at bolt hole position 20.
 - (f) Connect the harnesses (71-51-42, 01-005) and (71-51-44, 01-005) to the support bracket assembly (73-22-49, 03-800).
 - (g) At the clip position CP1007:

Install the bolt (71-51-44, 01-190), the washer (71-51-44, 01-191), the Nut (71-51-44, 01-0197) and the Clip (71-51-44, 01-193) to the support bracket assembly (73-22-49, 03-800).

Torque the bolt to between 36 and 45lbf in. (4 and 5 Nm).
 - (h) Install the locknut (73-22-49, 03-510) that attach the P 4.9 air tube assembly (73-22-49, 03-500) to the support bracket assembly (73-22-49, 03-800).

Torque the locknut to between 58 and 62 lbf in. (6,5 and 7,0 Nm).

- (i) Install the locknut (73-22-49, 11-110) that attach the P 2.5 air tube assembly (73-22-49, 11-500) to the support bracket assembly (73-22-49, 03-800).

Torque the locknut to between 38 and 42 lbf in. (4,3 and 4,7 Nm).

- (j) Connect the P 4.9 air flexible tube

- (i) Connect the P 4.9 air flexible tube (73-22-49, 04-100) to the P 4.9 air tube assembly (73-22-49, 03-500).

- (ii) Torque the nut to between 159 and 177 lbf in. (18 and 20 Nm).

- (iii) Safety the nut with lockwire (Material No. V02-126).

- (k) Connect the P 2.5 air flexible tube

- (i) Connect the P 2.5 air flexible tube (73-22-49, 11-500) to the P 2.5 air tube assembly (73-22-49, 11-100).

- (ii) Torque the nut to between 142 and 150 lbf in. (16 and 17 Nm).

- (iii) Safety the nut with lockwire (Material No. V02-126).

- (6) Install the bracket for CP1481 (Refer to Figure 18)

- (a) Remove the bolt (71-51-41, 05-824) and the nut (71-51-41, 05-821) that attach the bracket (71-51-41, 05-820) to the rear face of the flange FC at the bolt hole position 21.

- (b) Put and hold the new bracket (73-22-49, 07-800), P/N 5W8351 in position on the front face of the flange FC at the bolt hole positions 21 and 22.

- (c) Loosely install the bolt (71-51-41, 05-824) and the nut (71-51-41, 05-821) that attach the bracket (71-51-41, 05-820) and the bracket (73-22-49, 07-800) to the flange FC at the bolt hole position 21.

- (d) Loosely install the new bolt (73-22-49, 07-801), P/N 4W0164 and the new nut (73-22-49, 07-802), P/N 4W0002 that attach the bracket (73-22-49, 07-800) to the flange FC at the bolt hole position 22.

- (e) Torque the nut to between 36 and 45 lbf in. (4 and 5 Nm).

- (7) Install the Pb sense line tube assemblies and the HP compressor stage 10 bleed air control tube assemblies
- (a) Install the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) to the LP compressor/ intermediate case (Refer to Figure 23, 25, 31, 32 and 33)
- (i) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500), P/N 6A9041 to the tube (75-32-49, 04-100).

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (ii) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) to the bifurcation panel.

NOTE: The position for the tube (75-32-49, 04-500) on the bifurcation panel is interchanged with the position of the removed tube (73-22-49, 06-100).

- (iii) Install the two bolts (75-32-49, 04-514) and the two nuts (75-32-49, 04-510) that attach the tube (75-32-49, 04-500) to the bifurcation panel.

- (iv) At the revised clip position CP1431:

- (1) Remove the bolt (75-32-49, 10-581), the washer (75-32-49, 10-582) and the nut (75-32-49, 10-588) that attach the two clips (75-32-49, 10-584) and (36-11-47, 01-536) to the tube (79-22-49, 04-100).
- (2) Install the new clip (75-32-49, 04-656), P/N AS624046 to the tube (75-32-49, 04-500).

Install the bolt (75-32-49, 10-581), the washer (75-32-49, 10-582), the new washer (75-32-49, 10-582), P/N K8831 and the nut (75-32-49, 10-588) that attach the three clips (75-32-49, 10-584), (36-11-47, 01-536) and (75-32-49, 04-656) to the tube (79-22-49, 04-100).

- (v) At the revised clip position CP1418:

NOTE: The routing of the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) and new Pb sense line tube assembly (73-22-49, 06-100) is interchanged.

- (1) Install the clip (75-32-49, 04-594) to the tube (75-32-49, 04-500).

(vi) At the revised clip position CP1420:

NOTE: The routing of the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) and new Pb sense line tube assembly (73-22-49, 06-100) is interchanged.

(1) For V2500-A1 Engines:

Install the clip (75-32-49, 04-176) to the tube (75-32-49, 04-500).

(2) For V2500-A5 Engines:

Install the clip (75-32-49, 04-544) to the tube (75-32-49, 04-500).

(vii) Torque the coupling nuts of tube (75-32-49, 04-100) to between 159 and 177 lbf in. (18 and 20 Nm).

(viii) Safety the coupling nuts of tube (75-32-49, 04-100) with safety cable (Material No. V02-274 or V02-275).

(ix) Torque the nuts at the clip position CP1431 to between 36 and 45 lbf in. (4 and 5 Nm).

(b) Install the new Pb sense line tube assembly (73-22-49, 06-100) to the LP compressor/ intermediate case (Refer to Figure 24, 25, 32, 33 and 34)

(i) Connect the new Pb sense line air control tube assembly (73-22-49, 06-100), P/N 6A9040 to the bifurcation panel.

NOTE: The position for tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

(ii) Install the two bolts (73-22-49, 06-106) and the two nuts (73-22-49, 06-102) that attach the tube (73-22-49, 06-100) to the bifurcation panel.

(iii) At the introduced clip position CP1480:

(1) Install the new clip (73-22-49, 10-160), P/N AS62404 to the tube (73-22-49, 10-100).

(2) Install the new bolt (73-22-49, 10-157), P/N 4W0102 or 4W0342, the new washer (73-22-49, 10-158), P/N K8831 and the new nut (73-22-49, 10-164), P/N 4W0001 that attach the clip (73-22-49, 10-160) to the tube (73-22-49, 06-100).

(iv) At the revised clip position CP1418:

NOTE: The routing of the new Pb sense line tube assembly (73-22-49, 06-100) and the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) is interchanged.

- (1) Install the new clip (73-22-49, 06-184), P/N AS62406 to the tube (73-22-49, 06-100).
- (2) Install the bolt (75-32-49, 04-591), the washer (75-32-49, 04-592), the spacer (75-32-49, 04-596) and the nut (75-32-49, 04-598) that attach the four clips (73-22-49, 06-184), (75-32-49, 10-568), (36-11-47, 01-528) and (75-32-49, 04-594) to the tube (75-32-49, 01-500).

(v) At the revised clip position CP1420:

NOTE: The routing of the new Pb sense line tube assembly (73-22-49, 06-100) and the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) is interchanged.

(1) For V2500-A1 Engines:

- A** Install the new clip (73-22-49, 06-192), P/N AS62406 to the tube (73-22-49, 06-100).
- B** Install the bolt (75-32-49, 04-173), the two washers (75-32-49, 04-174), the spacer (75-32-49, 04-178) and the nut (75-32-49, 04-180) that attach the four clips (79-21-49, 04-552), (75-32-49, 04-176), (75-32-49, 10-576) and (73-22-49, 06-192) to the tube (36-11-47, 01-500).

(2) For V2500-A5 Engines:

- A** Install the new clip (73-22-49, 04-544), P/N AS62406 to the tube (73-22-49, 06-100).
- B** Install the bolt (75-32-49, 04-541), the two washers (75-32-49, 04-542), the spacer (75-32-49, 04-546) and the nut (75-32-49, 04-548) that attach the four clips (79-21-49, 04-552), (75-32-49, 04-544), (75-32-49, 10-576) and (73-22-49, 06-192) to the tube (36-11-47, 01-500).

(vi) Torque the nuts at the clip positions CP1480, CP1418 and CP1420 to between 36 and 45 lbf in. (4 and 5 Nm).

- (vii) Install the vented plug assembly (73-22-49, 06-264) to the tube (73-22-49, 06-100).
 - (1) Connect the new vented plug assembly (73-22-49, 06-264), P/N 6A7398, to the water trap of the tube (73-22-49, 06-100).
 - (2) Torque the vented plug assembly (73-22-49, 06-264) to between 283 and 310 lbf in. (32 and 35 Nm).
 - (3) Safety the vented plug assembly (73-22-49, 06-264) with safety cable (Material No. V02-274 or V02-275).
- (c) Install the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100) to the HP compressor case (Refer to Figure 35, 40, 41 and 43)
 - (i) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A9044 to the tube (75-32-49, 04-500).

NOTE: The position of tube (75-32-49, 04-500) on the bifurcation panel is interchanged with the position of the removed tube (73-22-49, 06-100).
 - (ii) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A9044 to the bleed valve (75-32-54, 01-500).
 - (iii) At the clip position CP 6123:
 - (1) Install the bolt (73-11-49, 19-589), the two washers (73-11-49, 19-590) and the nut (73-11-49, 19-596) that attach the two clips (73-11-49, 19-592) and (71-51-41, 07-100) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (iv) At the clip position CP6124:
 - (1) Install the bolt (73-11-49, 19-525), the washer (73-11-49, 526) and the nut (73-11-49, 19-532) that attach the clip (73-11-49, 19-528) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (v) At the clip position CP5641:
 - (1) Install the clip (75-32-49, 14-168) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).

- (2) Install the bolt (75-32-49, 13-173), the two washers (75-32-49, 13-174), the spacer (75-32-49, 13-178) and the nut (75-32-49, 13-180) that attach the three clips (71-52-43, 01-570), (75-32-49, 14-168) and (75-32-49, 13-176) to the bracket (72-41-00, 03-360).
- (vi) At the clip position CP5643:
 - (1) Install the clip (75-32-49, 14-128) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (2) Install the bolt, (75-32-49, 13-149), the two washers (75-32-49, 13-150) and the nut (75-32-49, 13-156) that attach the two clips (75-32-49, 14-128) and (75-32-49, 13-152) to the bracket (72-341-00, 03-320).
- (vii) At the clip position CP5675:
 - (1) Install the clip (75-32-49, 14-176) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (2) Install the bolt (75-32-49, 14-173), the washer (75-32-49, 14-174), the spacer (75-32-49, 14-179) and the clip nut (75-32-49, 14-180) that attach the two clips (75-32-49, 14-176) and (75-32-49, 15-120) to the bracket (75-00-49, 01-090).
- (viii) At the clip position CP5450:
 - (1) Install the clip (75-32-49, 14-544) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (2) Install the bolt (74-21-43, 02-101), the washer (74-21-43, 02-102) and the clip nut (74-21-43, 02-108) that attach the two clips (74-21-43, 02-104) and (75-32-49, 14-544) to the bracket (75-00-49, 01-545).
- (ix) At the clip position CP5397:
 - (1) Install the clip (75-32-49, 14-192) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100).
 - (2) Install the bolt (75-32-49, 14-189), the washer (75-32-49, 14-190) and the clip nut (75-32-49, 14-196) that attach the clip (75-32-49, 14-192) to the bracket (75-32-54, 01-395).
- (x) Torque the coupling nuts of tube (75-32-49, 14-100) to between 159 and 177 lbf in. (18 and 20 Nm).
- (xi) Safety the coupling nuts of tube (75-32-49, 14-100) with safety cable (Material No. V02-274 or V02-275).

(xii) Torque the nuts at the clip positions CP6123, CP6124, CP5641, CP5643, CP5675, CP5450 and CP5397 to between 36 and 45 lbf in. (4 and 5 Nm).

(d) Install the Pb sense line tube assembly (73-22-49, 05-500) to the HP compressor case (Refer to Figure 26, 34, 41, 42 and 44)

(i) For V2500-A1 Engines:

(1) Connect the new Pb sense line tube assembly (73-22-49, 05-500), P/N 6A9123 to the tube (73-22-49, 06-100).

NOTE: The position of tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

(2) Connect the Pb sense line tube assembly (73-22-49, 05-500) to the tube (73-22-49, 05-100).

(3) At the revised clip position CP6094:

A Remove the bolt (71-52-43, 01-518) and the nut (71-52-43, 01-525) that attach the clip (36-11-47, 01-152) to the tube (75-32-49, 16-100).

B The bolt (71-52-43, 01-518) and the nut (71-52-43, 01-525) will be reidentified to the bolt (36-11-47, 01-149) and the nut (36-11-47, 01-156).

C Install the new clamp (73-22-49, 05-536), P/N TA025022-04 to the Pb sense line tube assembly (73-22-49, 05-500).

D Install the bolt (36-11-47, 01-149), the two new washers (36-11-47, 01-150), P/N K8831 and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) and the clamp (73-22-49, 05-536) to the tube (75-32-49, 16-100).

(4) At the clip position CP6095:

A Install the clip (73-22-49, 05-528) on the Pb sense line tube assembly (73-22-49, 05-500).

B Install the bolt (73-22-49, 05-525), the two washers (73-22-49, 05-526), the spacer (73-22-49, 05-530) and the nut (73-22-49, 05-532) that attach the four clips (73-22-49, 05-528), (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583) to tube (73-22-49, 05-500).

(5) At the clip position CP6112:

- A Install the bolt (71-52-41, 01-450), the washer (71-52-41, 01-452), the spacer (71-52-41, 01-455) and the nut (71-52-41, 01-457) that attach the clip (71-52-41, 01-453) to the Pb sense line tube assembly (73-22-49, 05-500).

(6) At the clip position CP5766:

- A Install the bolt (73-11-49, 19-173), the two washers (73-11-49, 19-174) and the nut (73-11-49, 19-180) that attach the two clips (73-11-49, 19-176) and (71-51-41, 01-275) to the PB sense line tube assembly (73-22-49, 05-500).

(7) At the clip position CP5648:

- A Install the clip (73-22-49, 05-568) to the Pb sense line tube assembly (73-22-49, 05-500).

- B Install the bolt (73-11-49, 16-157), the three spacers (73-11-49, 16-161), (73-11-49, 16-162), (73-11-49, 16-163) and the nut (73-11-49, 16-164) that attach the five clips (71-52-41, 01-270), (73-11-49, 05-568), (73-11-49, 16-160), (73-23-48, 03-168) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

(8) At the clip position CP5647:

- A Install the clip (73-22-49, 05-560) to the Pb sense line tube assembly (73-22-49, 05-500).

- B Install the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558), the spacer (73-22-49, 05-562) and the clip nut (73-22-49, 05-564) that attach the three clips (75-23-48, 03-176), (73-22-49, 05-560) and (75-22-49, 05-554) to the bracket (72-41-00, 03-550).

(9) Torque the coupling nuts of tube (73-22-49, 05-500) to between 159 and 177 lbf in. (18 and 20 Nm).

(10) Safety the coupling nuts of tube (73-22-49, 05-500) with safety cable (Material No. V02-274 or V02-275).

(11) Torque the nuts at the clip positions CP6094, CP6095, CP6112, CP5766, CP5648 and CP5647 to between 36 and 45 lbf in. (4 and 5 Nm).

(ii) For V2500-A5 Engines:

- (1) Connect the new Pb sense line tube assembly (73-22-49, 05-500), P/N 6A9043 to the tube (73-22-49, 06-100).

NOTE: The position of tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

- (2) Connect the Pb sense line tube assembly (73-22-49, 05-500) to the tube (73-22-49, 05-300).

- (3) At the revised clip position 6094

A Remove the bolt (36-11-47, 01-149), the washer (36-11-47, 01-150) and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) to the tube (75-32-49, 16-100).

B Install the new clamp (73-22-49, 05-536), P/N TA025022-04 to the Pb sense line tube assembly (73-22-49, 05-500).

C Install the bolt (36-11-47, 01-149), the washer (36-11-47, 01-150), the new washer (36-11-47, 01-150), P/N K8831 and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) and the clamp (73-22-49, 05-536) to the tube (75-32-49, 16-100).

- (4) At the clip position CP6095:

A Install the clip (73-22-49, 05-528) on the Pb sense line tube assembly (73-22-49, 05-500).

B Install the bolt (73-22-49, 05-525), the two washers (73-22-49, 05-526), the spacer (73-22-49, 05-530) and the nut (73-22-49, 05-532) that attach the four clips (73-22-49, 05-528), (36-11-47, 01-160), (79-22-49, 03-160) and (71-71-49, 02-583) to tube (73-22-49, 05-500).

- (5) At the clip position CP6112:

A Install the bolt (71-52-41, 01-450), the washer (71-52-41, 01-452), the spacer (71-52-41, 01-455) and the nut (71-52-41, 01-457) that attach the clip (71-52-41, 01-453) to the Pb sense line tube assembly (73-22-49, 05-500).

(6) At the clip position CP5766:

- A Install the bolt (73-11-49, 19-173), the two washers (73-11-49, 19-174) and the nut (73-11-49, 19-180) that attach the two clips (73-11-49, 19-176) and (71-51-41, 01-275) to the PB sense line tube assembly (73-22-49, 05-500).

(7) At the clip position CP5648:

- A For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

1 Install the clip (73-22-49, 05-568) to the Pb sense line tube assembly (73-22-49, 05-500).

2 Install the bolt (73-11-49, 16-157), the two washers (73-11-49, 16-158), the spacers (73-11-49, 16-161), (73-11-49, 16-162) and the nut (73-11-49, 16-164) that attach the four clips (71-52-41, 01-270), (73-11-49, 05-568), (73-11-49, 16-160) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

- B For Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

1 Install the clip (73-22-49, 05-568) to the Pb sense line tube assembly (73-22-49, 05-500).

2 Install the bolt (73-11-49, 16-157), the two washers (73-11-49, 16-158), the spacer (73-11-49, 16-161), (73-11-49, 16-162), (73-11-49, 16-163) and the nut (73-11-49, 16-164) that attach the five clips (71-52-41, 01-270), (73-11-49, 05-568), (73-11-49, 16-160), (75-23-48, 03-168) and (75-22-49, 05-552) to the bracket (79-21-49, 13-070).

(8) At the clip position CP5647:

- A For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

1 Install the clip (73-22-49, 05-560) to the Pb sense line tube assembly (73-22-49, 05-500).

2 Install the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558) and the clip nut (73-22-49, 05-564) that attach the two clips (73-22-49, 05-560) and (75-22-49, 05-554) to the bracket (72-41-00, 03-550).

- R
R
- B For Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:
- R
R
- 1 Install the clip (73-22-49, 05-560) to the Pb sense line tube assembly (73-22-49, 05-500).
- R
R
R
R
R
- 2 Install the bolt (73-22-49, 05-557), the washer (73-22-49, 05-558), the spacer (73-22-49, 05-562) and the clip nut (73-22-49, 05-564) that attach the three clips (75-23-48, 03-176), (73-22-49, 05-560) and (75-22-49, 05-554) to the bracket (72-41-00, 03-550).
- (9) Additional for Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:
- At the clip position CP6107:
- A Install the bolt (71-51-41, 02-779), the two washers (71-51-41, 02-780) and the nut (71-51-41, 02-786) that attach the clip (71-51-41, 02-782) to the Pb sense line tube assembly (73-22-49, 05-500).
- (10) Torque the coupling nuts of tube (73-22-49, 05-500) to between 159 and 177 lbf in. (18 and 20 Nm).
- (11) Safety the coupling nuts of tube (73-22-49, 05-500) with safety cable (Material No. V02-274 or V02-275).
- (12) Torque the nuts at the clip positions that follows to between 36 and 45 lbf in. (4 and 5 Nm).
- A For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:
- CP6094, CP6095, CP6112, CP5766, CP5648, CP5647 and CP6107.
- B For Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:
- CP6094, CP6095, CP6112, CP5766, CP5648 and CP5647.
- (e) Install the new Pb sense line tube assembly (73-22-49, 06-500) to the LP compressor/ intermediate case (Refer to Figure 20, 21, 24, 30, 31 and 32)
- (i) Connect the new Pb sense line air control tube assembly (73-22-49, 06-500), P/N 6A9045 to the tube (73-22-49, 07-100).
- (ii) Connect the Pb sense line tube assembly (73-22-49, 06-500) to the tube (73-22-49, 06-100).

(iii) At the clip position CP0584:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 06-500) is interchanged.

- (1) Install the new clip (73-22-49, 06-544), P/N AS62406 to the tube (73-22-49, 06-500).
- (2) Install the bolt (73-22-49, 03-141), the new washer (73-22-49, 03-142), P/N K8831 and the spacer (73-22-49, 03-146) that attach the five clips (73-22-49, 06-544), (73-22-49, 10-544), (73-22-49, 03-144), (75-32-49, 08-144) and (75-32-49, 04-144) to the duct (79-21-42, 01-400).

(iv) At the clip position CP0582:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 06-500) is interchanged.

- (1) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:
 - A Install the new clip (73-22-49, 06-536), P/N AS62406 to the tube (73-22-49, 06-500).
 - B Install the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the five clips (75-32-49, 04-152), (75-32-49, 08-152), (73-22-49, 03-136), (73-22-49, 10-568) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).
- (2) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:
 - A Install the new clip (73-22-49, 06-536), P/N AS62406 to the tube (73-22-49, 06-500).
 - B Install the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the two spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the six clips (75-32-49, 04-152), (75-32-49, 08-152), (73-22-49, 03-136), (73-22-49, 10-568), (73-22-49, 06-536) and (75-23-48, 02-183) to the duct (79-21-42, 01-400).

(v) At the revised clip position CP1409:

NOTE: The new Pb sense line tube assembly (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

- (1) Install the new clip (73-22-49, 06-668), P/N AS62406 to the tube (73-22-49, 06-500).
- (2) Install the bolt (73-22-49, 06-665), the two washers (73-22-49, 06-666) the spacer (73-22-49, 06-670) and the nut (73-22-49, 06-672) that attach the four clips (73-22-49, 06-668), (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) to the tube (79-22-49, 04-100).

(vi) At the revised clip position CP1442:

NOTE: The new Pb sense line tube assembly (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

- (1) Install the new clip (73-22-49, 06-660), P/N AS62406 to the tube (73-22-49, 06-500).
- (2) Install the bolt (71-51-41, 02-787), the washer (71-51-41, 02-788) and the nut (71-51-49, 02-794) that attach the two clips (73-22-49, 06-660) and (71-51-41, 02-790) to the raceway (71-51-50, 01-500).

(vii) Torque the coupling nut of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).

(viii) Safety the coupling nut of tube (75-32-49, 06-500) with safety cable (Material No. V02-274 or V02-275).

(ix) Torque the nuts at the clip positions 0584, 0582, 1409 and 1442 to between 36 and 45 lbf in. (4 and 5 Nm).

(f) Install the Pb sense line tube assembly (73-22-49, 07-100) to the LP compressor/ intermediate case (Refer to Figure 17, 18, 19, 20, 27 and 30)

(i) Connect the new Pb sense line tube assembly (73-22-49, 07-100), P/N 6A9039 to the P3-union on the EEC and to the tube (73-22-49, 06-500).

NOTE: The tube (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

(ii) At the introduced clip position CP1482:

- (1) Install the new clip (73-22-49, 07-256), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the new bolt (73-22-49, 07-253), P/N 4W0102, the new washer (73-22-49, 07-254), P/N K8831 and the new nut (73-22-49, 07-260), P/N 4W0001 that attach the clip (73-22-49, 07-256) to the bracket (73-22-49, 03-848).

(iii) At the introduced clip position CP1481:

- (1) Install the new clip (73-22-49, 07-264), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the new bolt (73-22-49, 07-261), P/N 4W0102, the new washer (73-22-49, 07-262), P/N K8831 and the new nut (73-22-49, 07-268), P/N 4W0001 that attach the clip (73-22-49, 07-264) to the bracket (73-22-49, 07-800).

(iv) At the revised clip position CP1017:

- (1) Remove the bolt (71-51-41, 02-087), the old washer, P/N 8831 or 5W1086, the spacer (71-51-41, 02-092) and the nut (71-51-41, 02-094) that attach the clip (71-51-41, 02-090) to the tube (79-22-49, 10-100).

- (2) Install the new clip (73-22-49, 07-272), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the bolt (71-51-41, 02-087), the spacer (71-51-41, 02-092) and the nut (71-51-41, 02-094) that attach the two clips (71-51-41, 02-090) and (73-22-49, 07-272) to the tube (79-22-49, 10-100).

(v) At the revised clip position CP0586:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 07-100) is interchanged.

- (1) Install the new clip (73-22-49, 07-280), P/N AS62406 to the tube (73-22-49, 07-100).

- (2) Install the bolt (73-22-49, 03-149), the new washer (73-22-49, 03-150), P/N K8831 and the spacer (73-22-49, 03-154) that attach the five clips (73-22-49, 07-280) (73-22-49, 10-552) (73-22-49, 03-152) (75-32-49, 08-136) and (75-32-49, 04-136) to the duct (79-21-42, 01-400).

- (vi) Torque the coupling nut of the flexible tube (73-22-49, 07-100) to between 142 and 150 lbf in. (16 and 17 Nm).
 - (vii) Torque the coupling nut of the rigid tube (73-22-49, 07-100) to between 159 and 177 lbf in. (18 and 20 Nm).
 - (viii) Safety the coupling nut of tube (73-22-49, 07-100) with safety cable (Material No. V02-274 or V02-275).
 - (ix) Torque the nuts at the clip positions 1482, 1481, 1017 and 0586 to between 36 and 45 lbf in. (4 and 5 Nm).
- (g) Install the revised clip position CP0587 (Refer to Figure 19):

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (i) Install the new bolt (75-32-49, 04-125), P/N 4W0103, the new washer (75-32-49, 04-126), P/N 5W1086 and the new nut (75-32-49, 04-132), P/N 400WSS4 or AS62404 that attach the clip (75-32-49, 04-128) to the bracket (79-21-42, 01-350).
 - (ii) Torque the bolt to between 36 and 45 lbf in. (4 and 5 Nm).
- (h) Install the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) to the LP compressor/ intermediate case (Refer to Figure 28 and 29)
- (i) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

- (1) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 6A9042 to the valve (75-32-53, 01-400) and to the tube (75-32-49, 04-100).

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (2) At the clip position CP1024:
 - A Install the clip (75-32-49, 03-560) on the HP stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt (75-32-49, 03-557), the washer (75-32-49, 03-558) and the nut (75-32-49, 03-564) that attach the clip to the tube (75-23-48, 01-500).

- (3) At the clip position CP1030:
- A Install the clip (75-32-49, 03-576) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt (75-32-49, 03-573), the washer (75-32-49, 03-575) and the clip nut (75-32-49, 03-580) that attach the clip (75-32-49, 03-576) to the bracket (75-32-48, 01-470).
- (4) At the clip position CP1029:
- A Install the clip (75-32-49, 03-568) on the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt (75-32-49, 03-565), the washer (75-32-49, 03-566) and the clip nut (75-32-49, 03-571) that attach the clip (75-32-49, 03-568) to the bracket (79-21-42, 01-184).
- (5) At the revised clip position CP0590:
- A Install the bolt (75-32-49, 03-549), the two washers (75-32-49, 03-550) and the nut (75-32-49, 03-556) that attach the clip (75-23-48, 01-552) to the bracket (79-21-42, 01-190).
- (6) Torque the coupling nuts of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).
- (7) Safety the coupling nuts of tube (75-32-49, 06-500) with safety cable (Material No. V02-274 or V02-275).
- (8) Torque the nuts at the clip positions CP1024, CP1030, CP1029 and CP0590 to between 36 and 45 lbf in. (4 and 5 Nm).
- (ii) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:
- (1) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 6A9042 to the valve (75-32-53, 01-400) and to the tube (75-32-49, 04-100).

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (2) At the clip position CP1403:
 - A Install the clip (75-32-49, 03-584) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt ((75-32-49, 581), the spacer (75-32-49, 03-586) and the nut (75-32-49, 03-588) that attach the clip (75-32-49, 03-584) to the bracket (75-32-53, 01-500).
- (3) At the clip position CP1404:
 - A Install the bolt (71-51-41, 01-230) and the nut (71-51-41, 01-237) that attach the clip (71-51-41, 01-233) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
- (4) At the clip position CP1030:
 - A Install the clip (75-32-49, 03-576) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt (75-32-49, 03-573), the washer (75-32-49, 03-575) and the clip nut (75-32-49, 03-580) that attach the clip (75-32-49, 03-576) to the bracket (75-23-48, 01-470).
- (5) At the clip position CP1029:
 - A Install the clip (75-32-49, 03-568) to the HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500).
 - B Install the bolt (75-32-49, 03-565), the washer (75-32-49, 03-566) and the clip nut (75-32-49, 03-571) that attach the clip (75-32-49, 03-568) to the bracket (79-21-42, 01-084).
- (6) Torque the coupling nuts of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).
- (7) Safety the coupling nuts of tube (75-32-49, 06-500) with safety cable (Material No.V02-274 or V02-275).
- (8) Torque the nuts at the clip positions CP1403, CP1404, CP1030 and CP1029 to between 36 and 45 lbf in. (4 and 5 Nm).
- (8) Make sure that the work area is clean and clear of tools, equipment and other unwanted materials.

- (9) Do an Operational Test of the EEC (Refer to the Aircraft Maintenance Manual, Chapter 73-22-34).
- (10) Do an Operational Test of the FADEC System (Refer to the Aircraft Maintenance Manual, Chapter 73-22-00)
- (11) Do a Test No. 3 – Idle Leak Check (Refer to the Aircraft Maintenance Manual, Chapter 71-00-00).
- (12) Do a Test No. 6 – EEC System Idle Check (Refer to the Aircraft Maintenance Manual, Chapter 71-00-00).
- (13) Close the access to the right area of the Low Pressure (LP) compressor/ intermediate case and High Pressure (HP) compressor case
 - (a) Close the thrust reverser halves (Refer to the Aircraft Maintenance Manual, Chapter 78-32-00 Opening/Closing).
 - (b) Close the fan cowl doors (Refer to the Aircraft Maintenance Manual, Chapter 71-13-00).

PART 2 – Applicable for engines 'At Overhaul'.

(1) General

CAUTION: DO NOT BEND THE ELECTRICAL CABLE CONDUIT TOO MUCH WHEN YOU DISCONNECT/CONNECT THE ELECTRICAL CONNECTOR. THE CONDUIT CAN BE DAMAGED AND CAN CAUSE ELECTRICAL CIRCUIT DEFECTS.

CAUTION: MAKE SURE ELECTRICAL CONNECTORS DO NOT HAVE BENT PINS AND THAT THEY ARE CLEAN BEFORE YOU CONNECT THEM. DAMAGE OR CONTAMINATION OF THE ELECTRICAL CONNECTORS CAN CAUSE DAMAGE TO THE COMPONENTS.

(a) Obey all the WARNINGS and CAUTIONS in the procedures that are referred to.

(b) Consumable Materials

(i) Refer to the table that follows:

COMAT NO.	DESIGNATION
02-126	Lockwire
02-274	Safety Cable Kits
02-275	Safety Cable Kits

For the details of the consumable material given in the table above refer to the Overhaul Processes and Consumables Index.

- (c) Tools and Equipment
 - (i) For further tools and equipment refer to the related Manual tasks given in this instruction.
 - (d) Refer to the Standard Practices/Processes Manual, Chapter 70-41-01 for all torque procedures.
 - (e) Refer to the Standard Practices/Processes Manual, Chapter 70-42-05 for the uses of lockwire.
 - (f) Refer to the Standard Practices/Processes Manual, Chapter 70-43-01 for the connection of electrical plugs.
- (2) Get access to the right area of the Low Pressure (LP) compressor/intermediate case and High Pressure (HP) compressor case.
- (3) Remove the burner to Engine Electronic Controller (EEC) pressure (Pb) sense line tube assemblies and the HP compressor stage 10 bleed air control tube assemblies
- (a) Remove the old Pb sense line flexible tube (73-22-49, 07-500), P/N 44456 from the LP compressor/intermediate case (Refer to Engine Manual, Chapter 72-00-32)(Refer to Figure 1).
 - (b) Remove the old Pb sense line tube assembly (73-22-49, 07-100), P/N 6A8091 from the LP compressor/intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (3)(b)(i) of this Service Bulletin)(Refer to Figure 2).
 - (i) Remove the old locknut (73-22-49, 07-110), P/N MS9201-04 that attach the Pb sense line tube assembly (73-22-49, 07-100) to the support bracket assembly (73-22-49, 03-800).
 - (ii) At the deleted clip position CP1027:
 - (1) Remove the old bolt (73-22-49, 07-141), P/N 4W0102 and the old washer (73-22-49, 07-142), P/N 5W1086 that attach the clip (73-22-49, 07-144) to the bracket (73-22-49, 03-470).
 - (2) Remove the old clip (73-22-49, 07-144), P/N 400WSS4 from the Pb sense line tube assembly (73-22-49, 07-100).
 - (3) Remove the old nut (73-22-49, 07-148), P/N 4W0043 from the bracket (73-22-49, 03-470).

(iii) At the deleted clip position CP1028:

- (1) Remove the old bolt (73-22-49, 07-149), P/N 4W0103, the old washer (73-22-49, 07-150), P/N 5W1086 and the old nut (73-22-49, 07-156), P/N 400WSS4 that attach the clip (73-22-49, 07-144) to the tube (73-22-49, 03-500).
- (2) Remove the old clip (73-22-49, 07-152), P/N 400WSS4 from the Pb sense line tube assembly (73-22-49, 07-100).

(c) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500) (Refer to Engine Manual, Chapter 72-00-32) (Refer to Figure 3 and 4).

R (i) For V2500-A1 Engines and for V2500-A5 Engines which have SB ENG
R 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

R Remove the old HP compressor stage 10 bleed air control tube
assembly (75-32-49, 03-500), P/N 5A9146 from the LP compressor/
intermediate case.

R (ii) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE
R 75-0081) incorporated:

Remove the old HP compressor stage 10 bleed air control tube
assembly (75-32-49, 03-500), P/N 6A6194 from the LP compressor/
intermediate case.

(d) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100), P/N 6A6222 from the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (3)(d)(i) of this Service Bulletin) (Refer to Figure 5, 6, 11, 12, 13 and 15).

(i) At the revised clip position CP0587:

- (1) Remove the old bolt (73-22-49, 06-557), P/N 4W0119, the old washer (73-22-49, 06-557), P/N 5W1086, the old spacer (73-22-49, 06-562), P/N UP10482 or 5W1033 and the old nut (73-22-49, 06-564), P/N 4W0043 that attach the two clips (75-32-49, 04-128) and (73-22-49, 06-560) to the bracket (79-21-42, 01-350).
- (2) Remove the clip (75-32-49, 04-128) from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-560) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-560) is transferred to the clip (75-32-49, 04-128) for configuration purposes only.

(ii) At the revised clip position CP0586:

- (1) Remove the bolt (73-22-49, 03-149), the old washer (73-22-49, 03-150), P/N 5W1086 and the spacer (73-22-49, 03-154) that attach the five clips (73-22-49, 10-552) (75-32-49, 04-136) (73-22-49, 03-152) (75-32-49, 08-136) and (73-22-49, 06-552) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-552) (73-22-49, 03-152) and (75-32-49, 08-136) from the tubes (73-22-49, 10-500) (73-22-49, 03-100) and (75-32-49, 08-100).

- (2) Remove the old clip (75-32-49, 04-136), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-552) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-552) is transferred to the clip (75-32-49, 04-136) for configuration purposes only.

(iii) At the revised clip position CP0584:

- (1) Remove the bolt (73-22-49, 03-141), the old washer (73-22-49, 03-142), P/N 5W1086 and the spacer (73-22-49, 03-146) that attach the five clips (73-22-49, 10-544), (75-32-49, 04-144), (73-22-49, 03-144), (75-32-49, 08-144) and (73-22-49, 06-544) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-544), (73-22-49, 03-144) and (75-32-49, 08-144) from the tubes (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (2) Remove the old clip (75-32-49, 04-144), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-544) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-544) is transferred to the clip (75-32-49, 04-144) for configuration purposes only.

(iv) At the revised clip position CP0582:

- (1) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

Remove the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the five clips (73-22-49, 10-568), (75-32-49, 04-152), (73-22-49, 03-136), (75-32-49, 08-152) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).

NOTE: Do not remove the three clips (73-22-49, 10-568), (73-22-49, 03-136) and (75-32-49, 08-152) from the tubes (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (2) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:

Remove the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the six clips (75-23-48, 02-183), (73-22-49, 10-568), (75-32-49, 04-152), (73-22-49, 03-136), (75-32-49, 08-152) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).

NOTE: Do not remove the four clips (75-23-48, 02-183), (73-22-49, 10-568), (73-22-49, 03-136) and (75-32-49, 08-152) from the tubes (75-23-48, 02-100), (73-22-49, 10-500), (73-22-49, 03-100) and (75-32-49, 08-100).

- (3) Remove the old clip (75-32-49, 04-152), P/N 400WSS4 from the tube (75-32-49, 04-100).

NOTE: Do not remove the clip (73-22-49, 06-536) from the tube (73-22-49, 06-500).

NOTE: The clip (73-22-49, 06-536) is transferred to the clip (75-32-49, 04-152) for configuration purposes only.

(v) At the revised clip position CP1409:

- (1) Remove the bolt (75-32-49, 04-165), the two washers (75-32-49, 04-166), the spacer (75-32-49, 04-170) and the nut (75-32-49, 04-172) that attach the four clips (75-32-49, 04-168), (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) to the tube (79-22-49, 04-100).

NOTE: Do not remove the three clips (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) from the tubes (75-32-49, 10-100), (36-11-47, 02-500) and (75-32-49, 11-500).

- (2) Remove the old clip (75-32-49, 04-168), P/N AS62404 from the tube (75-32-49, 04-100).

NOTE: The bolt (75-32-49, 04-165), the two washers (75-32-49, 04-166), the spacer (75-32-49, 04-170) and the nut (75-32-49, 04-172) are reidentified to the bolt (73-22-49, 06-665), the two washers (73-22-49, 06-666) the spacer (73-22-49, 06-670) and the nut (73-22-49, 06-672).

(vi) At the deleted clip position CP1441:

- (1) Remove the old bolt (73-22-49, 03-188), P/N 4W0102, the old washer (73-22-49, 03-189), P/N K8831 and the old nut (73-22-49, 03-195), P/N 4W0001 that attach the clip (73-22-49, 03-191) to the tube (75-32-49, 04-100).
- (2) Remove the old clip (73-22-49, 03-191), P/N AS62404 from the tube (73-22-49, 03-100).

(e) Remove the Pb sense line tube assembly (73-22-49, 05-500)(Refer to Engine Manual, Chapter 72-00-40)(Refer to Figure 9).

(i) For V2500-A1 Engines:

Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6203 from the High Pressure (HP) compressor case.

(ii) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6236 from the High Pressure (HP) compressor case.

- (iii) For V2500-A5 Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

Remove the old Pb sense line tube assembly (73-22-49, 05-500), P/N 6A6235 from the High Pressure (HP) compressor case.

- (f) Remove the old HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A6199 from the HP compressor case (Refer to Engine Manual, Chapter 72-00-40 and to step (3)(f)(i) of this Service Bulletin)(Refer to Figure 10).

- (i) At the deleted clip position CP6122:

- (1) Remove the old bolt (79-21-49, 10-157), P/N 4W0103, the old washer (79-21-49, 10-158), P/N K8831 and the old nut (79-21-49, 10-164), P/N 4W0001 that attach the clip (79-21-49, 10-160) to the tube (75-32-49, 14-100).
- (2) Remove the old clip (79-21-49, 10-160), P/N AS62412 from the oil tube assembly (79-21-49, 10-100).

- (g) Remove the old Pb sense line tube assembly (73-22-49, 06-100), P/N 6A6211 and old HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500), P/N 6A6223 from the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (3)(g)(i) of this Service Bulletin)(Refer to Figure 6, 7, 8, 14, 15 and 16).

- (i) At the revised clip position CP1426:

- (1) Remove the bolt (73-22-49, 02-578), the washer (73-22-49, 02-579), the old spacer (73-22-49, 02-583), P/N AS62404, the old washer (73-22-49, 02-579), P/N K8831 and the nut (73-22-49, 02-585) that attach the three clips (73-22-49, 10-136), (73-22-49, 02-581) and (73-22-49, 06-128) to the raceway (71-51-50, 01-500).

NOTE: Do not remove the two clips (73-22-49, 10-136) and (73-22-49, 02-581) from the two tubes (73-22-49, 10-100) and (73-22-49, 02-500).

- (2) Remove the old clip (73-22-49, 06-128), P/N AS62404 from the tube (73-22-49, 06-100).
- (3) Install the bolt (73-22-49, 02-578), the washer (73-22-49, 02-579) and the nut (73-22-49, 02-585) that attach the two clips (73-22-49, 10-136) and (73-22-49, 02-581) to the raceway (71-51-50, 01-500).
- (4) Torque the nut to between 36 and 45 lbf in. (4 and 5 Nm).

(ii) At the revised clip position CP1442:

- (1) Remove the bolt (71-51-41, 02-787), the washer (71-51-41, 02-788) and the nut (71-51-49, 02-794) that attach the two clips (75-32-49, 04-536) and (71-51-41, 02-790) to the raceway (71-51-50, 01-500).

NOTE: Do not remove the clip (71-51-41, 02-790) from the harness (71-51-41, 01-005).

- (2) Remove the old clip (75-32-49, 04-536), P/N AS62404 from the tube (75-32-49, 04-500).

(iii) At the revised clip position CP1418:

- (1) Remove the bolt (75-32-49, 04-591), the washer (75-32-49, 04-592), the spacer (75-32-49, 04-596) and the nut (75-32-49, 04-598) that attach the four clips (75-32-49, 04-594), (75-32-49, 10-568), (36-11-47, 01-528) and (73-22-49, 06-184) to the tube (75-32-49, 01-500).

NOTE: Do not remove the two clips (75-32-49, 10-568) and (36-11-47, 01-528) from the two tubes (75-32-49, 10-500) and (36-11-47, 01-500).

- (2) Remove the old clip (75-32-49, 04-594), P/N AS62404 from the tube (75-32-49, 04-500).
- (3) Remove the old clip (73-22-49, 06-184), P/N AS62404 from the tube (73-22-49, 06-100).

(iv) At the revised clip position CP1420:

- (1) For V2500-A1 Engines:

- A** Remove the bolt (75-32-49, 04-173), the two washers (75-32-49, 04-174), the spacer (75-32-49, 04-178) and the nut (75-32-49, 04-180) that attach the four clips (79-21-49, 04-552), (73-22-49, 06-192), (75-32-49, 10-576) and (75-32-49, 04-176) to the tube (36-11-47, 01-500).

NOTE: Do not remove the two clips (73-22-49, 06-192) and (75-32-49, 10-576) from the two tube (73-22-49, 06-100) and (75-32-49, 04-500).

- B** Remove the clip (75-32-49, 04-176) from the tube (75-32-49, 04-500).

- C** Remove the old clip (73-22-49, 06-192), P/N AS62404 from the tube (73-22-49, 06-100).

(2) For V2500-A5 Engines:

- A** Remove the bolt (75-32-49, 04-541), the two washers (75-32-49, 04-542), the spacer (75-32-49, 04-546) and the nut (75-32-49, 04-548) that attach the four clips (79-21-49, 04-552), (73-22-49, 06-192), (75-32-49, 10-576) and (75-32-49, 04-544) to the tube (36-11-47, 01-500).

NOTE: Do not remove the two clips (73-22-49, 06-192) and (75-32-49, 10-576) from the two tube (73-22-49, 06-100) and (75-32-49, 04-500).

- B** Remove the clip (75-32-49, 04-544) from the tube (75-32-49, 04-500).

- C** Remove the old clip (73-22-49, 06-192), P/N AS62404 from the tube (73-22-49, 06-100).

(4) Remove the old support bracket assembly (Refer to Engine Manual, Chapter 72-00-32 and to step (4)(a) of this Service Bulletin)(Refer to Figure 1 and 2)

- (a) Disconnect the P 2.5 air flexible tube (73-22-49, 11-500) from the P 2.5 air tube assembly (73-22-49, 11-100).
- (b) Disconnect the P 4.9 air flexible tube (73-22-49, 04-100) from the P 4.9 air tube assembly (73-22-49, 03-500).
- (c) Remove the locknut (73-22-49, 11-110) that attach the P 2.5 air tube assembly (73-22-49, 11-500) to the support bracket assembly (73-22-49, 03-800).
- (d) Remove the locknut (73-22-49, 03-510) that attach the P 4.9 air tube assembly (73-22-49, 03-500) to the support bracket assembly (73-22-49, 03-800).
- (e) Disconnect the harnesses (71-51-42, 01-005) and (71-51-44, 01-005) from the support bracket assembly (73-22-49, 03-800).
- (f) Remove the old support bracket assembly (73-22-49, 03-800), P/N 6A7420 from the High Pressure (HP) compressor case.

(5) Install the new support bracket assembly (Refer to Engine Manual, Chapter 72-00-32 and to step (5)(a) of this Service Bulletin)(Refer to Figure 17 and 27)

- (a) Install the two new bolts (73-22-49, 08-847), P/N 4W0102 and the two new nut (73-22-49, 08-846), P/N 4W0001 that attach the new bracket (73-22-49, 03-848), P/N 6A9098 to the new support bracket assembly (73-22-49, 03-800), P/N 6A9096.

- (b) Torque the two nuts to between 36 and 45 lbf in. (4 and 5 Nm).
 - (c) Install the new support bracket assembly (73-22-49, 03-800), P/N 6A9096 to the High Pressure (HP) compressor case .
 - (d) Connect the harnesses (71-51-42, 01-005) and (71-51-44, 01-005) to the support bracket assembly (73-22-49, 03-800) .
 - (e) Install the locknut (73-22-49, 03-510) that attach the P 4.9 air tube assembly (73-22-49, 03-500) to the support bracket assembly (73-22-49, 03-800) .
 - (f) Install the locknut (73-22-49, 11-110) that attach the P 2.5 air tube assembly (73-22-49, 11-500) to the support bracket assembly (73-22-49, 03-800).
 - (g) Connect the P 4.9 air flexible tube (73-22-49, 04-100) to the P 4.9 air tube assembly (73-22-49, 03-500).
 - (h) Connect the P 2.5 air flexible tube (73-22-49, 11-500) to the P 2.5 air tube assembly (73-22-49, 11-100).
- (6) Install the bracket for CP1481 (Refer to Figure 18)
- (a) Remove the bolt (71-51-41, 05-824) and the nut (71-51-41, 05-821) that attach the bracket (71-51-41, 05-820) to the rear face of the flange FC at the bolt hole position 21.
 - (b) Put and hold the new bracket (73-22-49, 07-800), P/N 5W8351 in position on the front face of the flange FC at the bolt hole positions 21 and 22.
 - (c) Loosely install the bolt (71-51-41, 05-824) and the nut (71-51-41, 05-821) that attach the bracket (71-51-41, 05-820) and the bracket (73-22-49, 07-800) to the flange FC at the bolt hole position 21.
 - (d) Loosely install the new bolt (73-22-49, 07-801), P/N 4W0164 and the new nut (73-22-49, 07-802), P/N 4W0002 that attach the bracket (73-22-49, 07-800) to the flange FC at the bolt hole position 22.
 - (e) Torque the nut to between 36 and 45 lbf in. (4 and 5 Nm).

- (7) Install the Pb sense line tube assemblies and the HP compressor stage 10 bleed air control tube assemblies
- (a) Install the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500), P/N 6A9041 to the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (7)(a)(i) of this Service Bulletin)(Refer to Figure 23, 25, 31, 32 and 33).
- (i) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500), P/N 6A9041 to the tube (75-32-49, 04-100).

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (ii) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) to the bifurcation panel.

NOTE: The position for the tube (75-32-49, 04-500) on the bifurcation panel is interchanged with the position of the removed tube (73-22-49, 06-100).

- (iii) Install the two bolts (75-32-49, 04-514) and the two nuts (75-32-49, 04-510) that attach the tube (75-32-49, 04-500) to the bifurcation panel.

- (iv) At the revised clip position CP1431:

- (1) Remove the bolt (75-32-49, 10-581), the washer (75-32-49, 10-582) and the nut (75-32-49, 10-588) that attach the two clips (75-32-49, 10-584) and (36-11-47, 01-536) to the tube (79-22-49, 04-100).
- (2) Install the new clip (75-32-49, 04-656), P/N AS624046 to the tube (75-32-49, 04-500).

Install the bolt (75-32-49, 10-581), the washer (75-32-49, 10-582), the new washer (75-32-49, 10-582), P/N K8831 and the nut (75-32-49, 10-588) that attach the three clips (75-32-49, 10-584), (36-11-47, 01-536) and (75-32-49, 04-656) to the tube (79-22-49, 04-100).

- (v) At the revised clip position CP1418:

NOTE: The routing of the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) and new Pb sense line tube assembly (73-22-49, 06-100) is interchanged.

- (1) Install the clip (75-32-49, 04-594) to the tube (75-32-49, 04-500).

(vi) At the revised clip position CP1420:

NOTE: The routing of the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) and new Pb sense line tube assembly (73-22-49, 06-100) is interchanged.

(1) For V2500-A1 Engines:

Install the clip (75-32-49, 04-176) to the tube (75-32-49, 04-500).

(2) For V2500-A5 Engines:

Install the clip (75-32-49, 04-544) to the tube (75-32-49, 04-500).

(vii) Torque the coupling nuts of tube (75-32-49, 04-100) to between 159 and 177 lbf in. (18 and 20 Nm).

(viii) Safety the coupling nuts of tube (75-32-49, 04-100) with safety cable (CoMat 02-274 or CoMat 02-275).

(ix) Torque the nuts at the clip position CP1431 to between 36 and 45 lbf in. (4 and 5 Nm).

(b) Install the new Pb sense line tube assembly (73-22-49, 06-100) to the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (7)(b)(i) of this Service Bulletin)(Refer to Figure 24, 25, 32, 33 and 34).

(i) Connect the new Pb sense line air control tube assembly (73-22-49, 06-100), P/N 6A9040 to the bifurcation panel.

NOTE: The position for tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

(ii) Install the two bolts (73-22-49, 06-106) and the two nuts (73-22-49, 06-102) that attach the tube (73-22-49, 06-100) to the bifurcation panel.

(iii) At the introduced clip position CP1480:

(1) Install the new clip (73-22-49, 10-160), P/N AS62404 to the tube (73-22-49, 10-100).

(2) Install the new bolt (73-22-49, 10-157), P/N 4W0102 or 4W0342, the new washer (73-22-49, 10-158), P/N K8831 and the new nut (73-22-49, 10-164), P/N 4W0001 that attach the clip (73-22-49, 10-160) to the tube (73-22-49, 06-100).

(iv) At the revised clip position CP1418:

NOTE: The routing of the new Pb sense line tube assembly (73-22-49, 06-100) and the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) is interchanged.

- (1) Install the new clip (73-22-49, 06-184), P/N AS62406 to the tube (73-22-49, 06-100).
- (2) Install the bolt (75-32-49, 04-591), the washer (75-32-49, 04-592), the spacer (75-32-49, 04-596) and the nut (75-32-49, 04-598) that attach the four clips (73-22-49, 06-184), (75-32-49, 10-568), (36-11-47, 01-528) and (75-32-49, 04-594) to the tube (75-32-49, 01-500).

(v) At the revised clip position CP1420:

NOTE: The routing of the new Pb sense line tube assembly (73-22-49, 06-100) and the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-500) is interchanged.

(1) For V2500-A1 Engines:

- A** Install the new clip (73-22-49, 06-192), P/N AS62406 to the tube (73-22-49, 06-100).
- B** Install the bolt (75-32-49, 04-173), the two washers (75-32-49, 04-174), the spacer (75-32-49, 04-178) and the nut (75-32-49, 04-180) that attach the four clips (79-21-49, 04-552), (75-32-49, 04-176), (75-32-49, 10-576) and (73-22-49, 06-192) to the tube (36-11-47, 01-500).

(2) For V2500-A5 Engines:

- A** Install the new clip (73-22-49, 06-544), P/N AS62406 to the tube (73-22-49, 06-100).
- B** Install the bolt (75-32-49, 04-541), the two washers (75-32-49, 04-542), the spacer (75-32-49, 04-546) and the nut (75-32-49, 04-548) that attach the four clips (79-21-49, 04-552), (75-32-49, 04-544), (75-32-49, 10-576) and (73-22-49, 06-192) to the tube (36-11-47, 01-500).

(vi) Torque the nuts at the clip positions CP1480, CP1418 and CP1420 to between 36 and 45 lbf in. (4 and 5 Nm).

- (vii) Install the vented plug assembly (73-22-49, 06-264) to the tube (73-22-49, 06-100).
- (1) Connect the new vented plug assembly (73-22-49, 06-264), P/N 6A7398, to the water trap of the tube (73-22-49, 06-100).
 - (2) Torque the vented plug assembly (73-22-49, 06-264) to between 283 and 310 lbf in. (32 and 35 Nm).
 - (3) Safety the vented plug assembly (73-22-49, 06-264) with safety cable (CoMat 02-274 or 02-275).
- (c) Install the HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100) to the HP compressor case (Refer to Engine Manual, Chapter 72-00-40 and to step (7)(c)(i) of this Service Bulletin)(Refer to Figure 35).
- (i) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A9044 to the tube (75-32-49, 04-500).
- NOTE:** The position of tube (75-32-49, 04-500) on the bifurcation panel is interchanged with the position of the removed tube (73-22-49, 06-100).
- (ii) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 14-100), P/N 6A9044 to the bleed valve (75-32-54, 01-500).
 - (iii) Install the bolts, the washer, the nuts, the clipnuts and the clips at the clip positions CP6123, CP6124, CP5641, CP5643, CP5675, CP5450 and CP5397.
 - (iv) Torque the coupling nuts of tube (75-32-49, 14-100) to between 159 and 177 lbf in. (18 and 20 Nm).
 - (v) Safety the coupling nuts of tube (75-32-49, 14-100) with safety cable (CoMat 02-274 or CoMat 02-275).
 - (vi) Torque the nuts at the clip positions CP6123, CP6124, CP5641, CP5643, CP5675, CP5450 and CP5397 to between 36 and 45 lbf in. (4 and 5 Nm).

- (d) Install the Pb sense line tube assembly (73-22-49, 05-500) to the HP compressor case (Refer to Engine Manual, Chapter 72-00-40 and to step (7)(d)(i) of this Service Bulletin)(Refer to Figure 26 and 34).

(i) For V2500-A1 Engines:

- (1) Connect the new Pb sense line tube assembly (73-22-49, 05-500), P/N 6A9123 to the tube (73-22-49, 06-100).

NOTE: The position of tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

- (2) Connect the Pb sense line tube assembly (73-22-49, 05-500) to the tube (73-22-49, 05-100).

- (3) At the revised clip position CP6094:

A Remove the bolt (71-52-43, 01-518) and the nut (71-52-43, 01-525) that attach the clip (36-11-47, 01-152) to the tube (75-32-49, 16-100).

B The bolt (71-52-43, 01-518) and the nut (71-52-43, 01-525) will be reidentified to the bolt (36-11-47, 01-149) and the nut (36-11-47, 01-156)

C Install the new clamp (73-22-49, 05-536), P/N TA025022-04 to the Pb sense line tube assembly (73-22-49, 05-500).

D Install the bolt (36-11-47, 01-149), the two new washers (36-11-47, 01-150), P/N K8831 and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) and the clamp (73-22-49, 05-536) to the tube (75-32-49, 16-100).

- (4) Install the bolts, the washer, the nuts, the clipnuts and the clips at the clip positions 6095, 6112, 5766, 5648 and 5647.

- (5) Torque the coupling nuts of tube (73-22-49, 05-500) to between 159 and 177 lbf in. (18 and 20 Nm).

- (6) Safety the coupling nuts of tube (73-22-49, 05-500) with safety cable (CoMat 02-274 or CoMat 02-275).

- (7) Torque the nuts at the clip positions CP6094, CP6095, CP6112, CP5766, CP5648 and CP5647 to between 36 and 45 lbf in. (4 and 5 Nm).

(ii) For V2500-A5 Engines:

- (1) Connect the new Pb sense line tube assembly (73-22-49, 05-500), P/N 6A9043 to the tube (73-22-49, 06-100).

NOTE: The position of tube (73-22-49, 06-100) on the bifurcation panel is interchanged with the position of the removed tube (75-32-49, 04-500).

- (2) Connect the Pb sense line tube assembly (73-22-49, 05-500) to the tube (73-22-49, 05-300).

- (3) At the revised clip position CP6094:

A Remove the bolt (36-11-47, 01-149), the washer (36-11-47, 01-150) and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) to the tube (75-32-49, 16-100).

B Install the new clamp (73-22-49, 05-536), P/N TA025022-04 to the Pb sense line tube assembly (73-22-49, 05-500).

C Install the bolt (36-11-47, 01-149), the washer (36-11-47, 01-150), the new washer (36-11-47, 01-150), P/N K8831 and the nut (36-11-47, 01-156) that attach the clip (36-11-47, 01-152) and the clamp (73-22-49, 05-536) to the tube (75-32-49, 16-100).

- (4) Install the bolts, the washer, the nuts, the clipnuts and the clips at the clip positions that follows:

A For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

CP6095, CP6112, CP5766, CP5648, CP5647 and CP6107.

B For Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

CP6095, CP6112, CP5766, CP5648 and CP5647.

- (5) Torque the coupling nuts of tube (73-22-49, 05-500) to between 159 and 177 lbf in. (18 and 20 Nm).

- (6) Safety the coupling nuts of tube (73-22-49, 05-500) with safety cable (CoMat 02-274 or CoMat 02-275).

- (7) Torque the nuts at the clip positions that follows to between 36 and 45 lbf in. (4 and 5 Nm).

A For Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

CP6094, CP6095, CP6112, CP5766, CP5648, CP5647 and CP6107.

B For Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

CP6094, CP6095, CP6112, CP5766, CP5648 and CP5647.

- (e) Install the new Pb sense line tube assembly (73-22-49, 06-500) to the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (7)(e)(i) of this Service Bulletin)(Refer to Figure 20, 21, 24, 30, 31 and 32).

(i) Connect the new Pb sense line air control tube assembly (73-22-49, 06-500), P/N 6A9045 to the tube (73-22-49, 07-100).

(ii) Connect the Pb sense line tube assembly (73-22-49, 06-500) to the tube (73-22-49, 06-100).

(iii) At the revised clip position CP0584:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 06-500) is interchanged.

(1) Install the new clip (73-22-49, 06-544), P/N AS62406 to the tube (73-22-49, 06-500).

(2) Install the bolt (73-22-49, 03-141), the new washer (73-22-49, 03-142), P/N K8831 and the spacer (73-22-49, 03-146) that attach the five clips (73-22-49, 06-544), (73-22-49, 10-544), (73-22-49, 03-144), (75-32-49, 08-144) and (75-32-49, 04-144) to the duct (79-21-42, 01-400).

(iv) At the revised clip position CP0582:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 06-500) is interchanged.

(1) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

A Install the new clip (73-22-49, 06-536), P/N AS62406 to the tube (73-22-49, 06-500).

- B** Install the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the five clips (75-32-49, 04-152), (75-32-49, 08-152), (73-22-49, 03-136), (73-22-49, 10-568) and (73-22-49, 06-536) to the duct (79-21-42, 01-400).
- (2) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or Part 3 (pre SBE 75-0081) incorporated:
- A** Install the new clip (73-22-49, 06-536), P/N AS62406 to the tube (73-22-49, 06-500).
- B** Install the bolt (73-22-49, 03-133), the washer (73-22-49, 03-134) and the two spacers (73-22-49, 03-138) and (73-22-49, 03-139) that attach the six clips (75-32-49, 04-152), (75-32-49, 08-152), (73-22-49, 03-136), (73-22-49, 10-568), (73-22-49, 06-536) and (75-23-48, 02-183) to the duct (79-21-42, 01-400).
- (v) At the clip position CP1409:
- NOTE:** The new Pb sense line tube assembly (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).
- (1) Install the new clip (73-22-49, 06-668), P/N AS62406 to the tube (73-22-49, 06-500).
- (2) Install the bolt (73-22-49, 06-665), the two washers (73-22-49, 06-666) the spacer (73-22-49, 06-670) and the nut (73-22-49, 06-672) that attach the four clips (73-22-49, 06-668), (75-32-49, 10-184), (36-11-47, 02-560) and (75-32-49, 11-560) to the tube (79-22-49, 04-100).
- (vi) At the revised clip position CP1442:
- NOTE:** The new Pb sense line tube assembly (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).
- (1) Install the new clip (73-22-49, 06-668), P/N AS62406 to the tube (73-22-49, 06-500).
- (2) Install the bolt (71-51-41, 02-787), the washer (71-51-41, 02-788) and the nut (71-51-49, 02-794) that attach the two clips (73-22-49, 06-668) and (71-51-41, 02-790) to the raceway (71-51-50, 01-500).
- (vii) Torque the coupling nut of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).

- (viii) Safety the coupling nut of tube (75-32-49, 06-500) with safety cable (CoMat 02-274 or CoMat 02-275).
- (ix) Torque the nuts at the clip positions CP0584, CP0582, CP1409 and CP1442 to between 36 and 45 lbf in. (4 and 5 Nm).
- (f) Install the Pb sense line tube assembly (73-22-49, 07-100) to the LP compressor/ intermediate case (Refer to Figure 17, 18, 19, 20, 27 and 30).
- (i) Connect the new Pb sense line tube assembly (73-22-49, 07-100), P/N 6A9039 to the EEC and to the tube (73-22-49, 06-500).

NOTE: The tube (73-22-49, 06-500) use the same routing as the removed HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100).

- (ii) At the introduced clip position CP1482:

- (1) Install the new clip (73-22-49, 07-256), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the new bolt (73-22-49, 07-253), P/N 4W0102, the new washer (73-22-49, 07-254), P/N K8831 and the new nut (73-22-49, 07-250), P/N 4W0001 that attach the clip (73-22-49, 07-256) to the bracket (73-22-49, 03-848).

- (2) Install the new clip (73-22-49, 07-256), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the new bolt (73-22-49, 07-253), P/N 4W0102, the new washer (73-22-49, 07-254), P/N K8831 and the new nut (73-22-49, 07-250), P/N 4W0001 that attach the clip (73-22-49, 07-256) to the bracket (73-22-49, 03-848).

- (iii) At the introduced clip position CP1481:

- (1) Install the new clip (73-22-49, 07-264), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the new bolt (73-22-49, 07-261), P/N 4W0102, the new washer (73-22-49, 07-262), P/N K8831 and the new nut (73-22-49, 07-268), P/N 4W0001 that attach the clip (73-22-49, 07-264) to the bracket (73-22-49, 07-800).

- (iv) At the clip position CP1017:

- (1) Remove the bolt (71-51-41, 02-087), the old washer (71-51-41, 02-088), P/N K8831 or 5W1086, the spacer (71-51-41, 02-092) and the nut (71-51-41, 02-094) that attach the clip (71-51-41, 02-090) to the tube (79-22-49, 10-100).

R
R

R

- (2) Install the new clip (73-22-49, 07-264), P/N AS62406 to the Pb sense line tube assembly (73-22-49, 07-100).

Install the bolt (71-51-41, 02-087), the spacer (71-51-41, 02-092) and the nut (71-51-41, 02-094) that attach the two clips (71-51-41, 02-090) and (73-22-49, 07-264) to the tube (79-22-49, 10-100).

- (v) At the revised clip position CP0586:

NOTE: The routing of the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) and new Pb sense line tube assembly (73-22-49, 07-100) is interchanged.

- (1) Install the new clip (73-22-49, 07-280), P/N AS62406 to the tube (73-22-49, 07-100).
- (2) Install the bolt (73-22-49, 03-149), the new washer (73-22-49, 03-150), P/N K8831 and the spacer (73-22-49, 03-154) that attach the five clips (73-22-49, 07-280) (73-22-49, 10-552) (73-22-49, 03-152) (75-32-49, 08-136) and (75-32-49, 04-136) to the duct (79-21-42, 01-400).

- (vi) Torque the coupling nuts of tube (73-22-49, 07-100) to between 159 and 177 lbf in. (18 and 20 Nm).
- (vii) Safety the coupling nuts of tube (73-22-49, 07-100) with safety cable (CoMat 02-274 or CoMat 02-275).
- (viii) Torque the nuts at the clip positions CP1482, CP1481, CP1017 and CP0586 to between 36 and 45 lbf in. (4 and 5 Nm).

- (g) Install the revised clip position CP0587:

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (i) Install the new bolt (75-32-49, 04-125), P/N 4W0103, the new washer (75-32-49, 04-126), P/N 5W1086 and the new nut (75-32-49, 04-132), P/N 400WSS4 or AS62404 that attach the clip (75-32-49, 04-128) to the bracket (79-21-42, 01-350).
- (ii) Torque the bolt to between 36 and 45 lbf in. (4 and 5 Nm).

(h) Install the HP compressor stage 10 bleed air control tube assembly (75-32-49, 04-100) to the LP compressor/ intermediate case (Refer to Engine Manual, Chapter 72-00-32 and to step (7)(h)(i) of this Service Bulletin)(Refer to Figure 28 and 29).

(i) For V2500-A1 Engines and V2500-A5 Engines which have SB ENG 79-0088 Part 2 or 3 (pre SBE 75-0081) incorporated:

- (1) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 6A9042 to the valve (75-32-53, 01-400) and to the tube (75-32-49, 04-100).

NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (2) Install the bolts, the washer, the nuts, the clipnuts and the clips at the clip positions CP1024, CP1030, CP1029 and CP0590.
- (3) Torque the coupling nuts of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).
- (4) Safety the coupling nuts of tube (75-32-49, 06-500) with safety cable (CoMat 02-274 or CoMat 02-275).
- (5) Torque the nuts at the clip positions CP1024, CP1030, CP1029 and CP0590 to between 36 and 45 lbf in. (4 and 5 Nm).

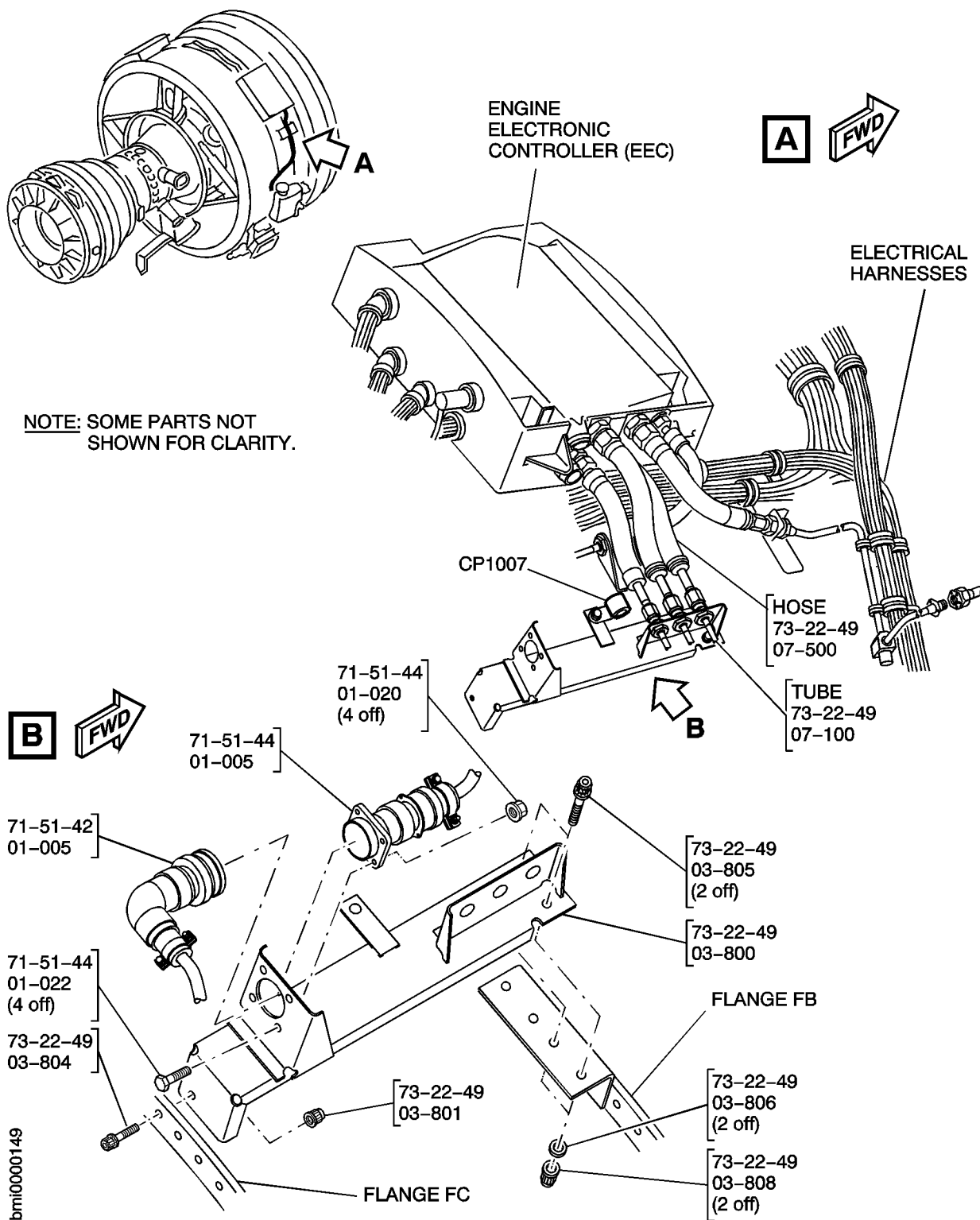
(ii) For V2500-A5 Engines which have SB ENG 79-0088 Part 1 (SBE 75-0081) incorporated:

- (1) Connect the new HP compressor stage 10 bleed air control tube assembly (75-32-49, 03-500), P/N 6A9042 to the valve (75-32-53, 01-400) and to the tube (75-32-49, 04-100).

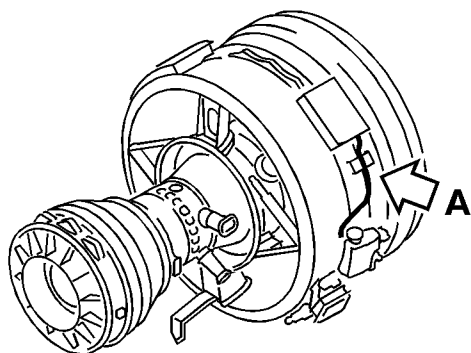
NOTE: The tube hardware is not changed with this Service Bulletin. The tube is transferred from (73-22-49, 06-500) to (75-32-49, 04-100) for configuration purposes only.

- (2) Install the bolts, the washer, the nuts, the clipnuts and the clips at the clip positions CP1403, CP1404, CP1030 and CP1029.
- (3) Torque the coupling nuts of tube (75-32-49, 06-500) to between 159 and 177 lbf in. (18 and 20 Nm).
- (4) Safety the coupling nuts of tube (75-32-49, 06-500) with safety cable (CoMat 02-274 or CoMat 02-275).

- (5) Torque the nuts at the clip positions CP1403, CP1404, CP1030, CP1029 and CP0590 to between 36 and 45 lbf in. (4 and 5 Nm).
- (8) Make sure that the work area is clean and clear of tools, equipment and other unwanted materials.
- C. Recording Instructions
- (1) A record of accomplishment is required.

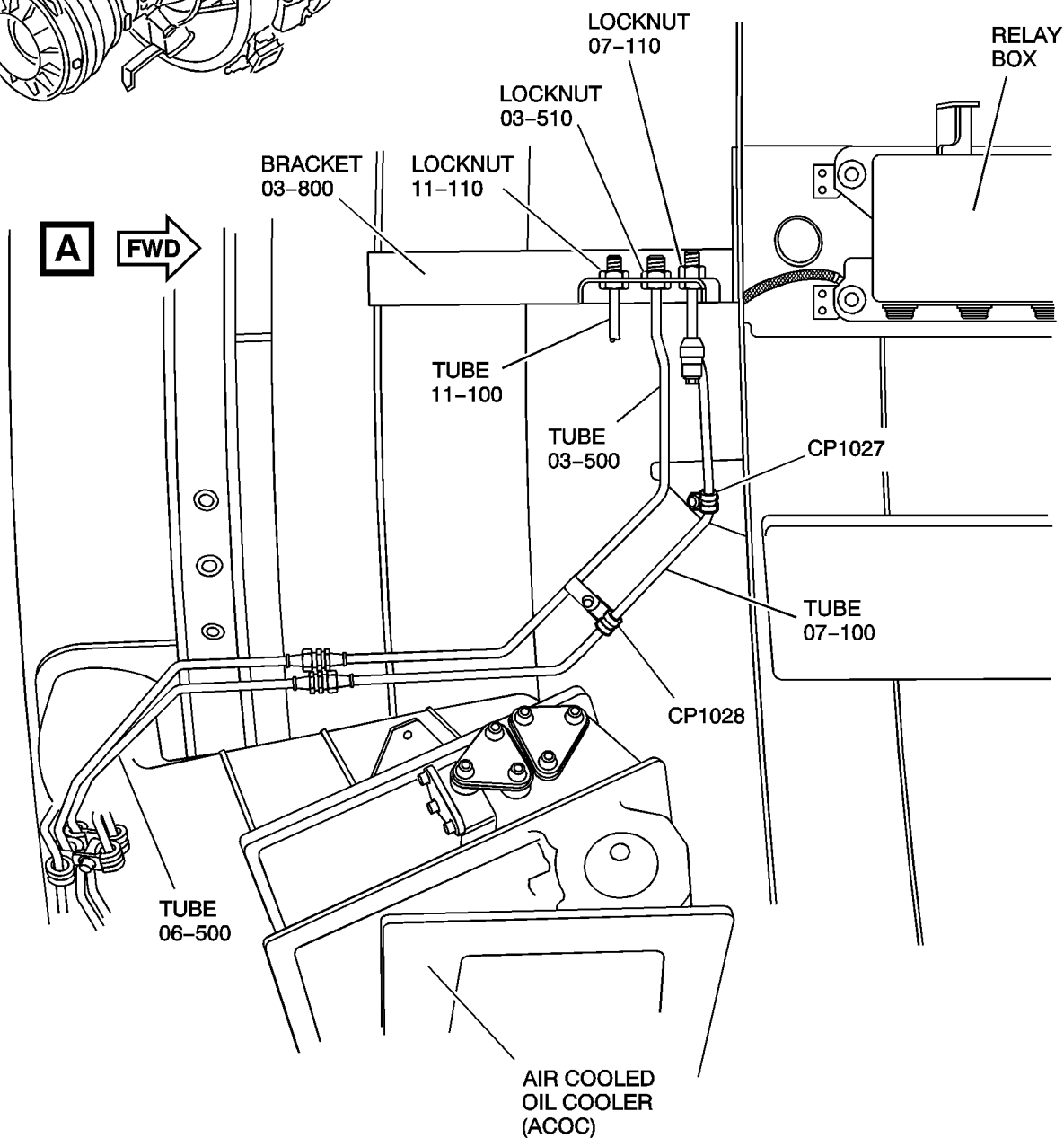


Removal of Pb sense line tube assembly
Figure 1



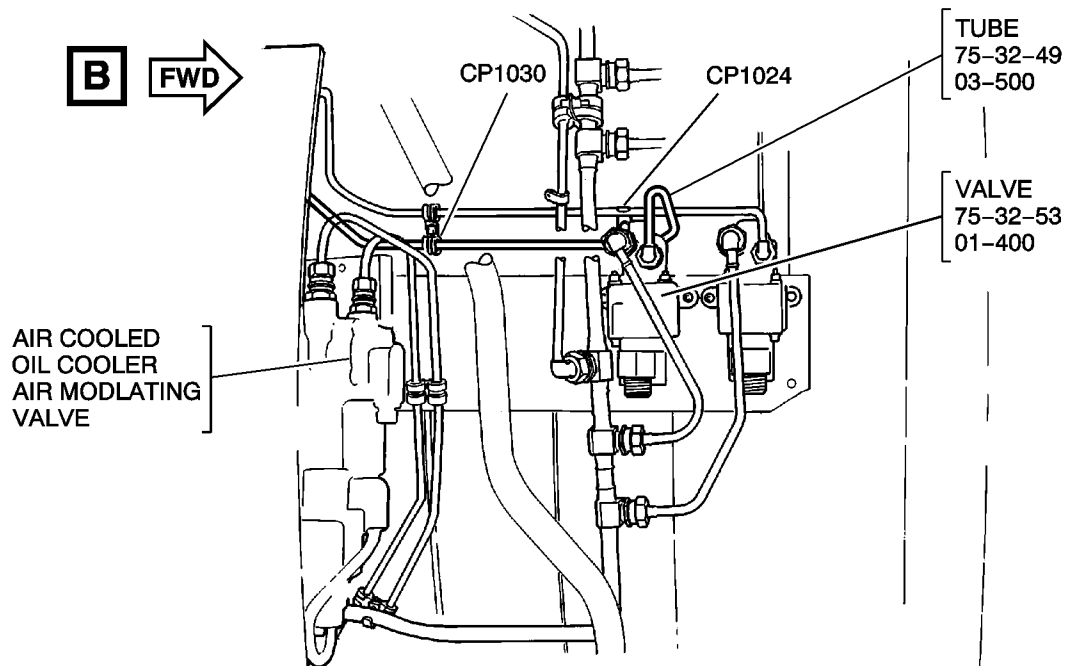
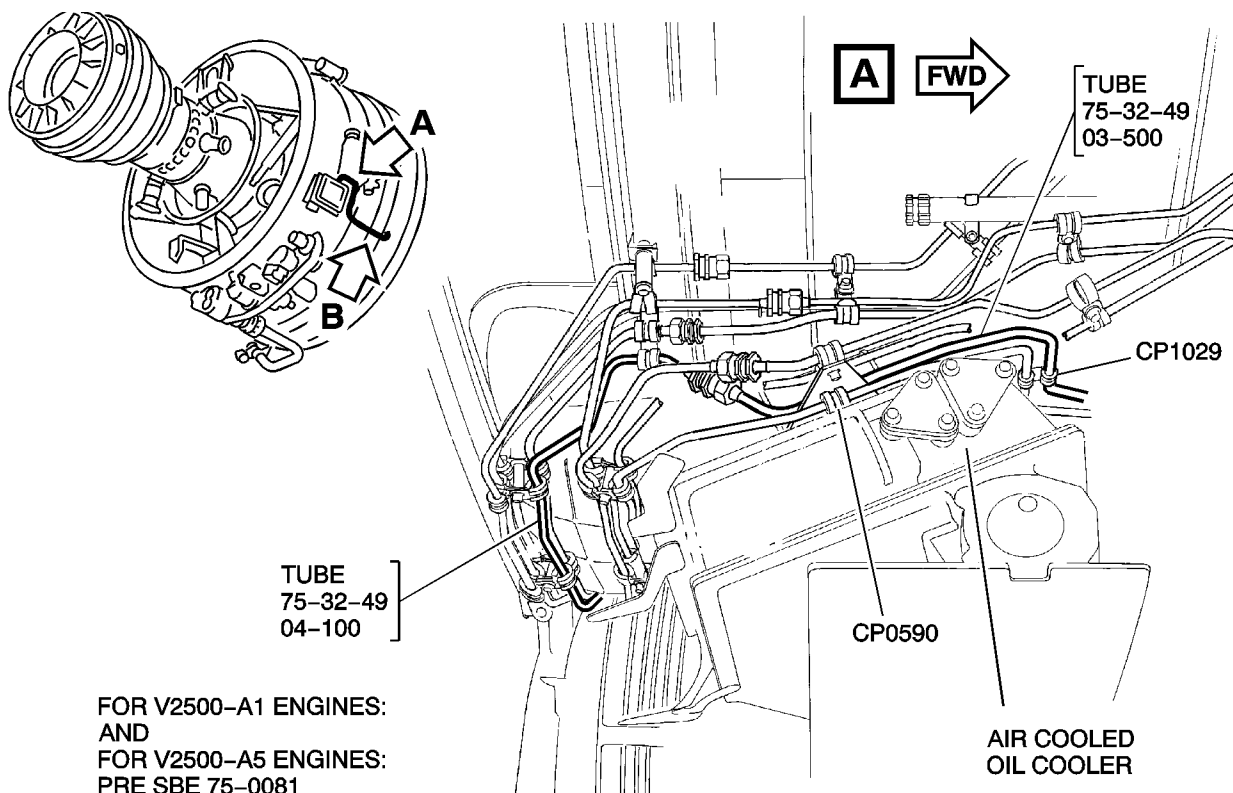
NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

NOTE: ALL EIPC FIG/ITEM NUMBERS ARE 73-22-49.

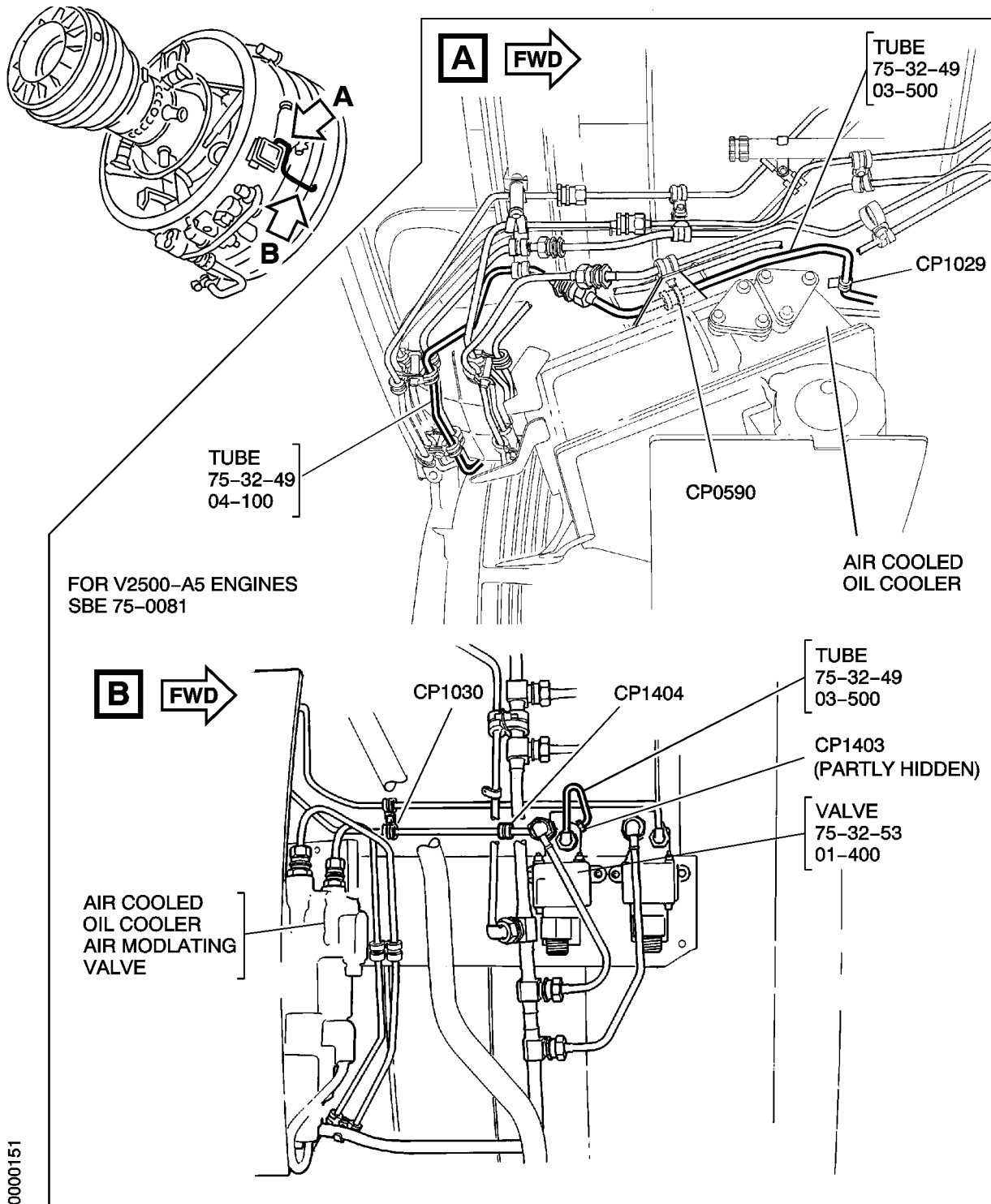


bmi0000148

Removal of Pb sense line tube assembly
Figure 2

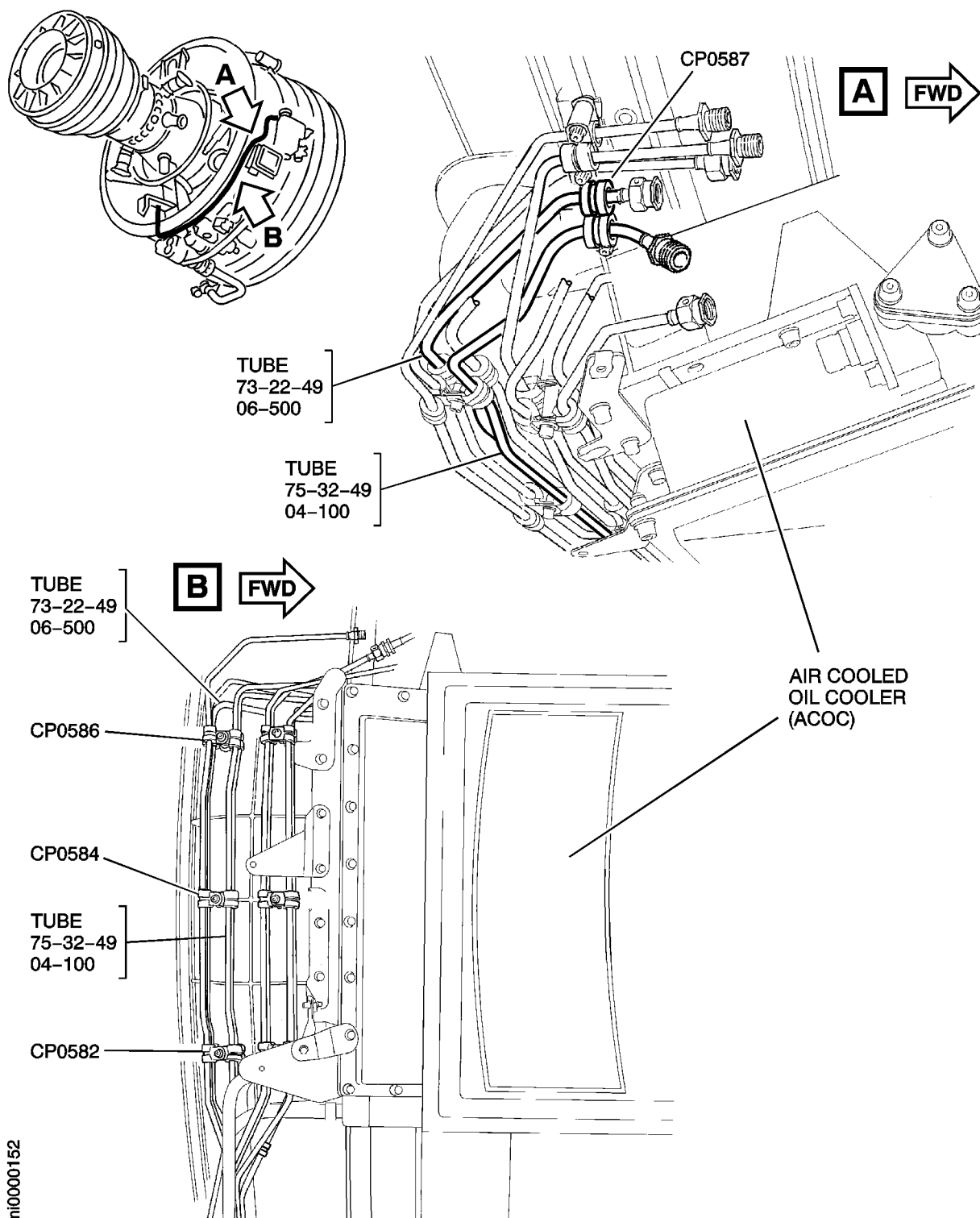


Removal of HP compressor stage 10 bleed air control tube assembly
Figure 3



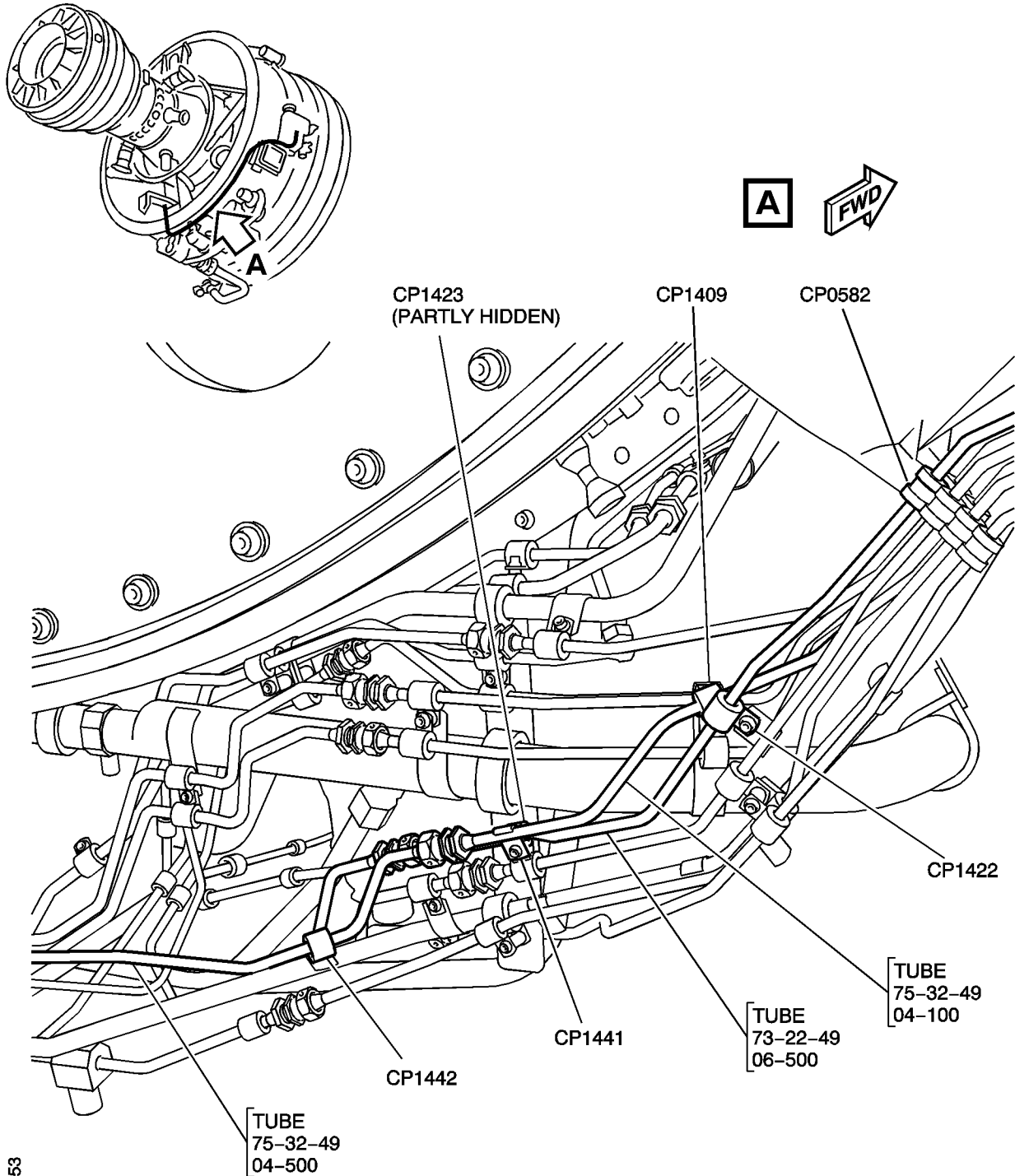
bmi0000151

Removal of HP compressor stage 10 bleed air control tube assembly
Figure 4



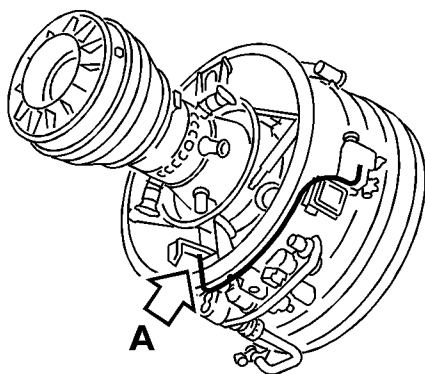
Printed in Great Britain

Removal of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 5

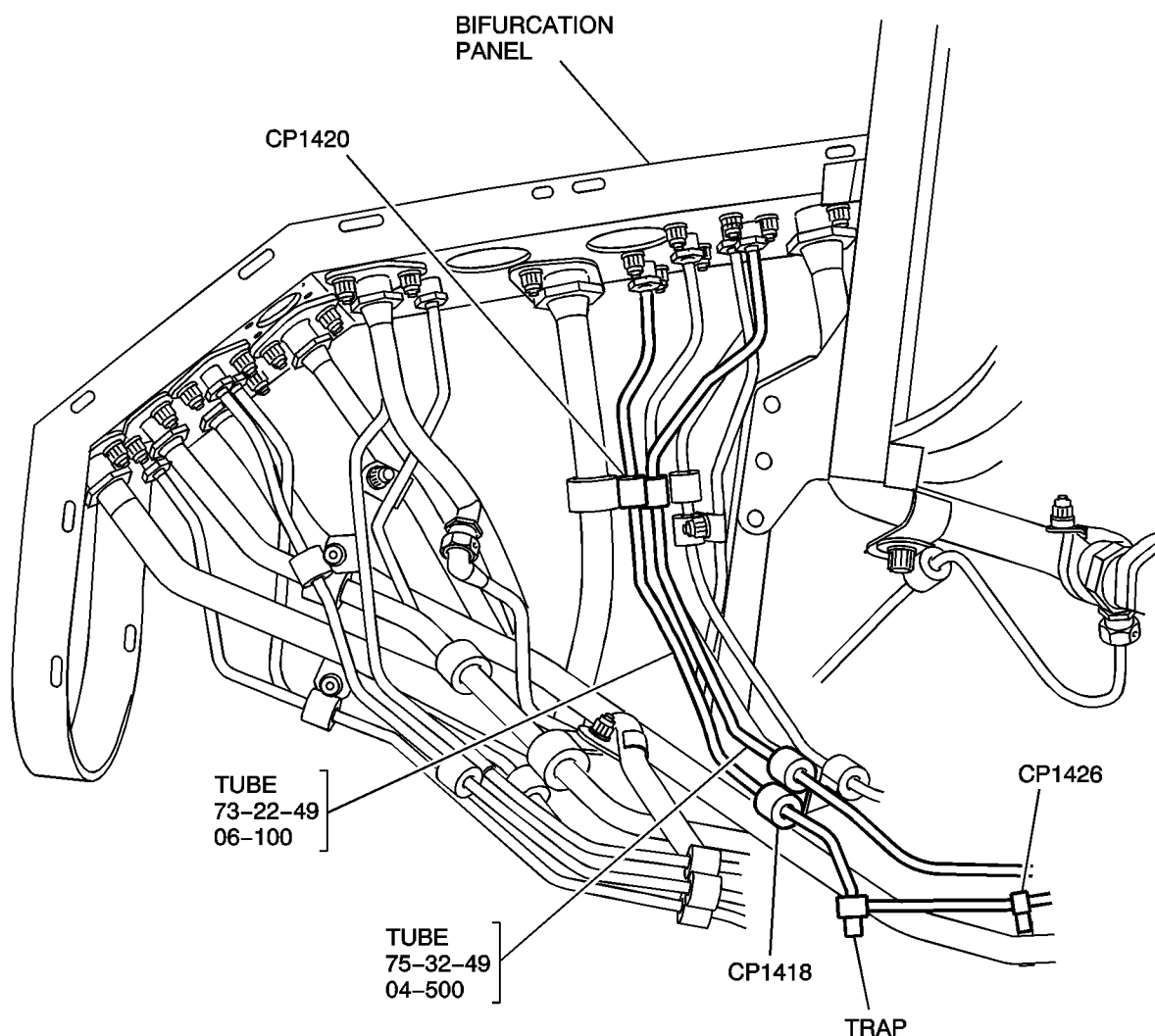


bmi0000153

Removal of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 6

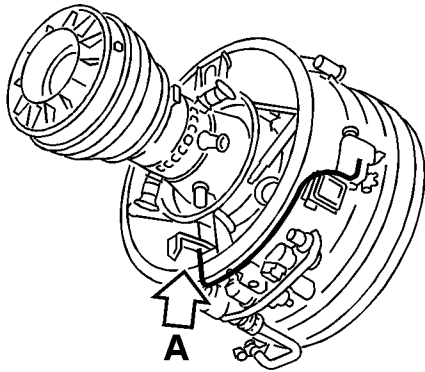


NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

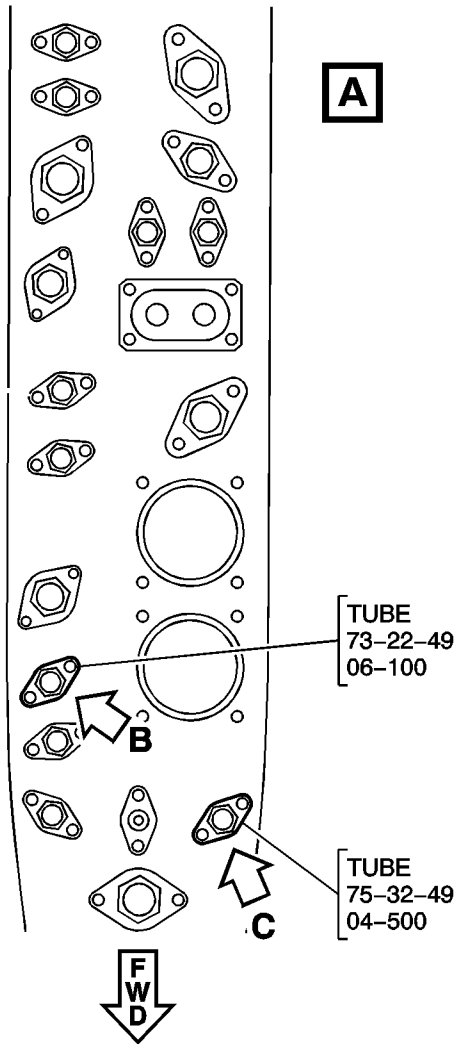


bmi0000154

Removal of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 7

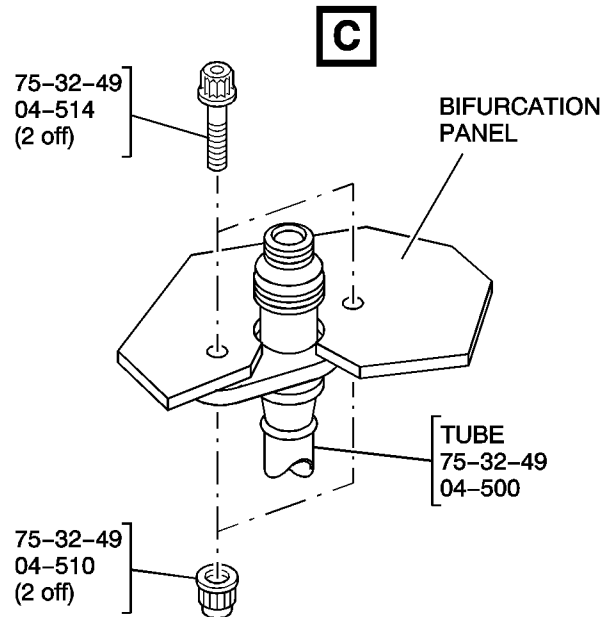
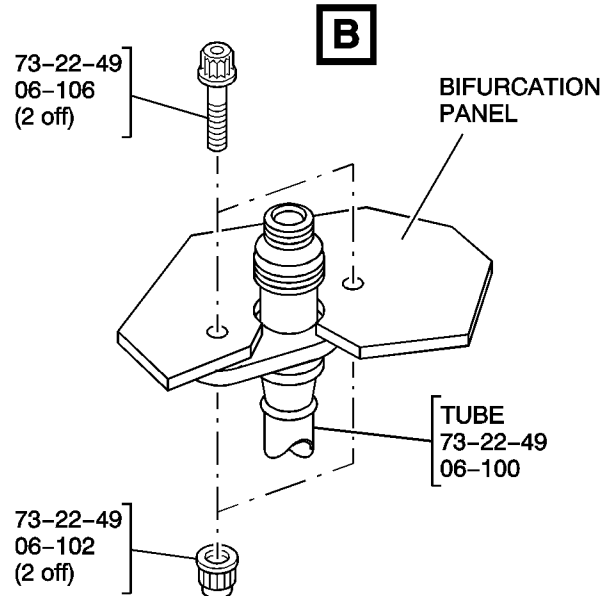


VIEW WHEN YOU LOOK ON THE BOTTOM OF THE BIFURCATION PANEL

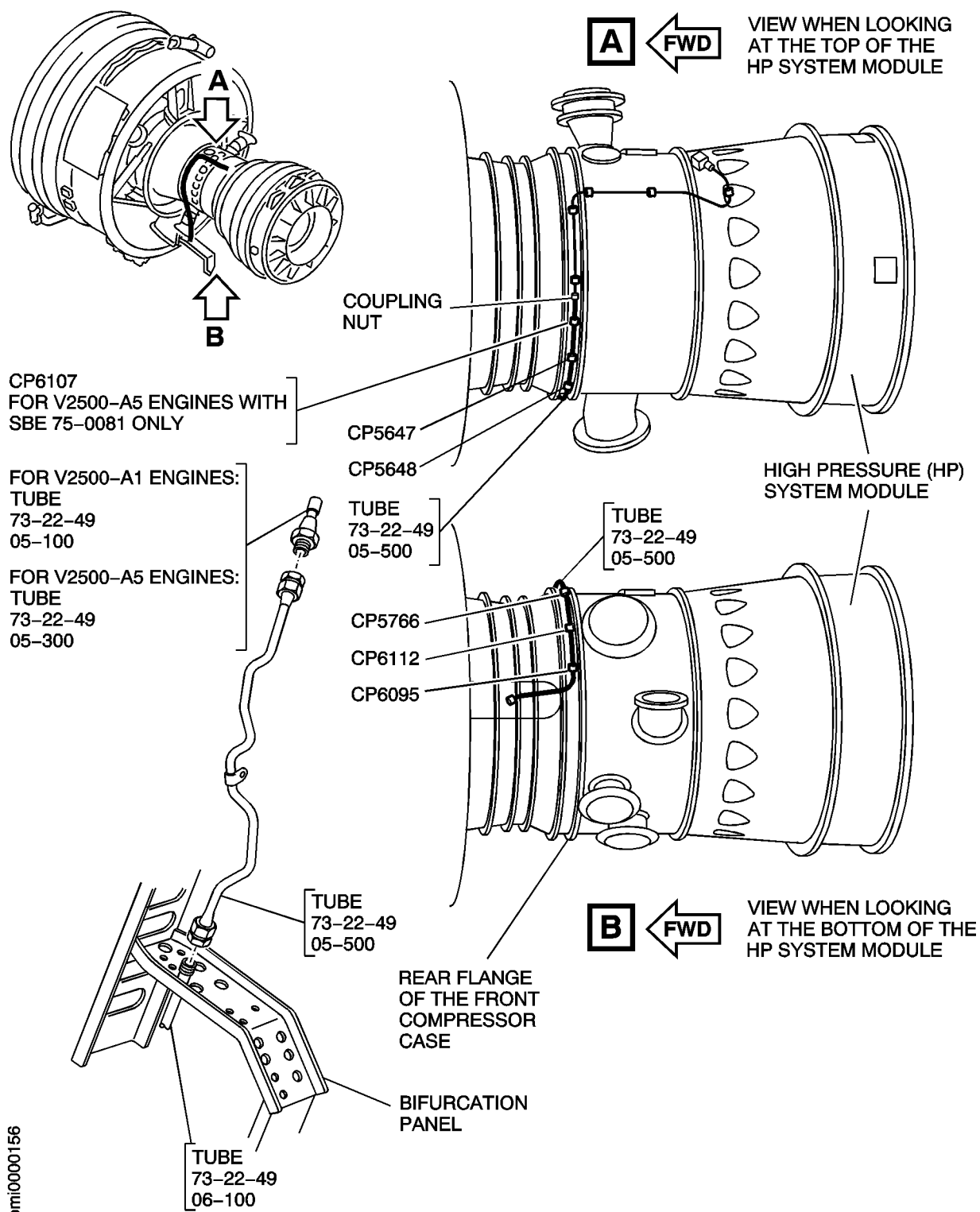


bmi0000155

NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

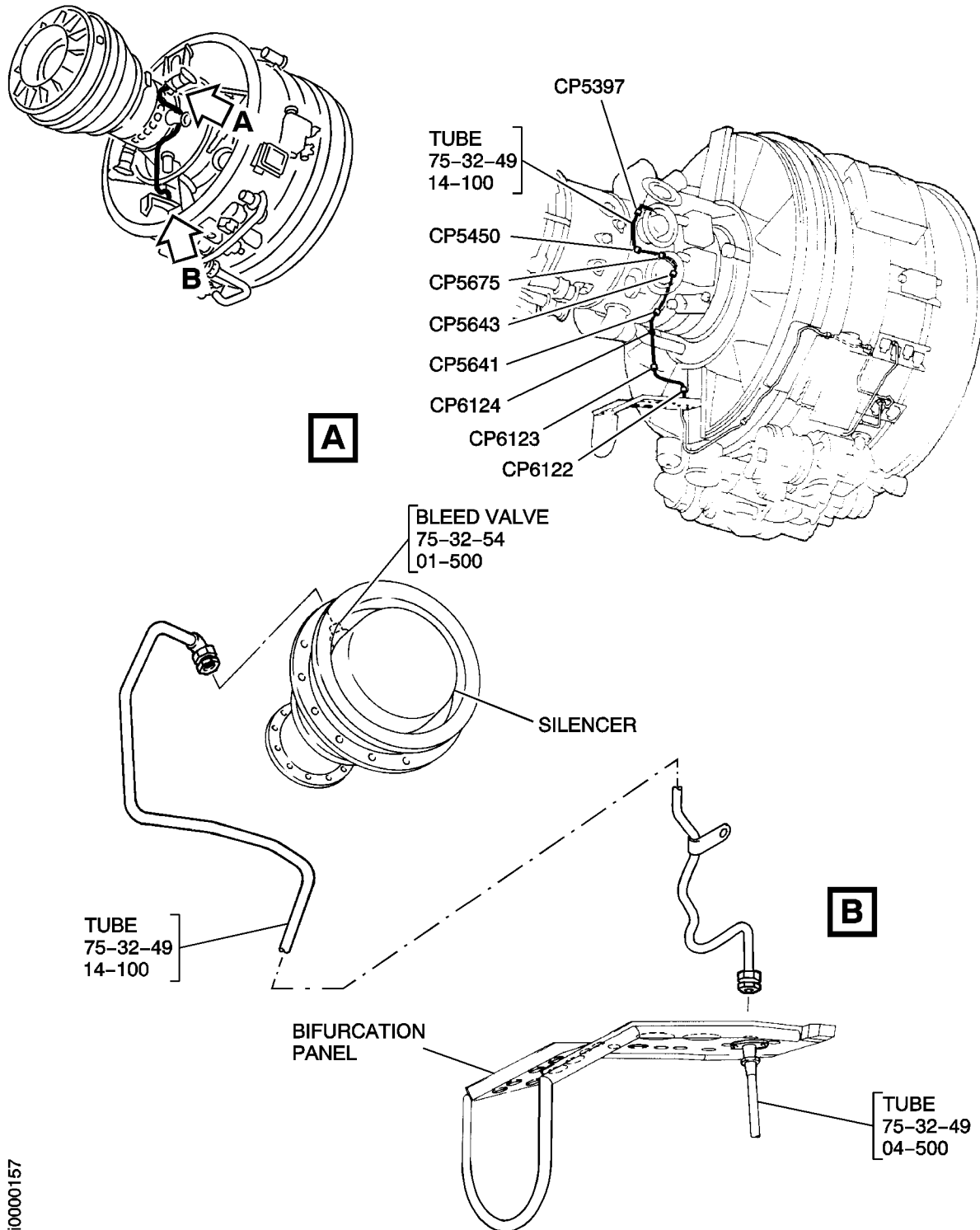


Bifurcation Panel
Figure 8



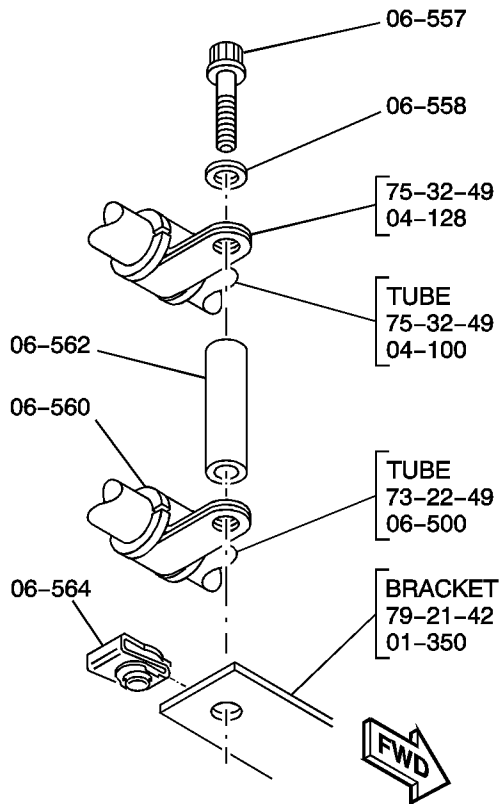
Printed in Great Britain

Removal of Pb sense line tube assembly
Figure 9



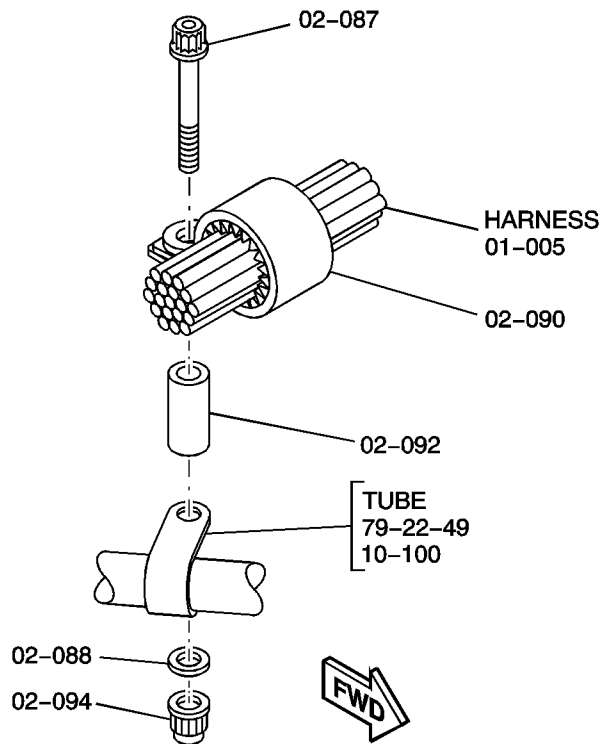
bmi0000157

Removal of HP compressor stage 10 bleed air control tube assembly
Figure 10



CLIP POSITION 0587
BEFORE ALTERATION

NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 73-22-49
UNLESS IDENTIFIED
DIFFERENTLY.

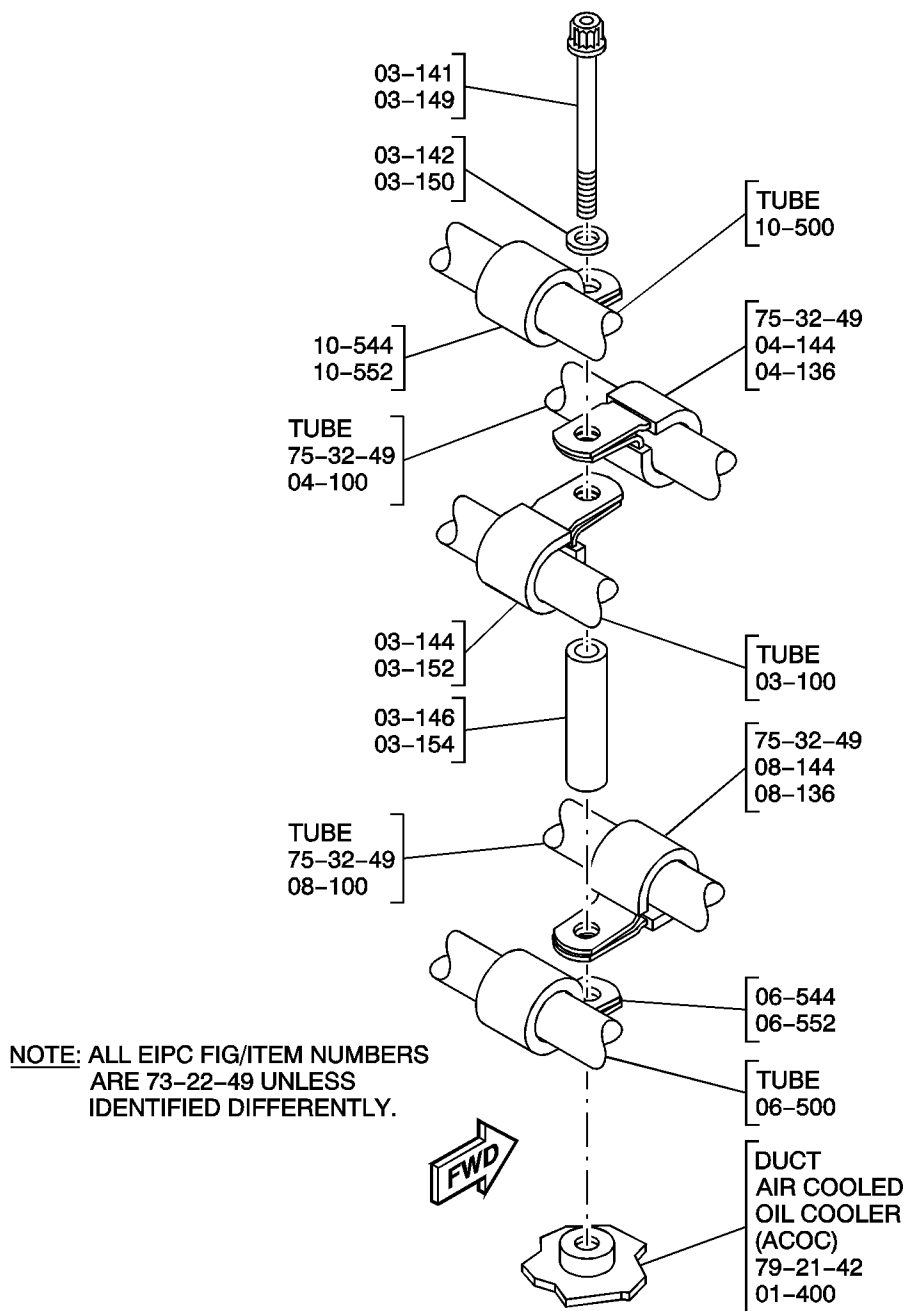


CLIP POSITION 1017
BEFORE ALTERATION

NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 71-51-41
UNLESS IDENTIFIED
DIFFERENTLY.

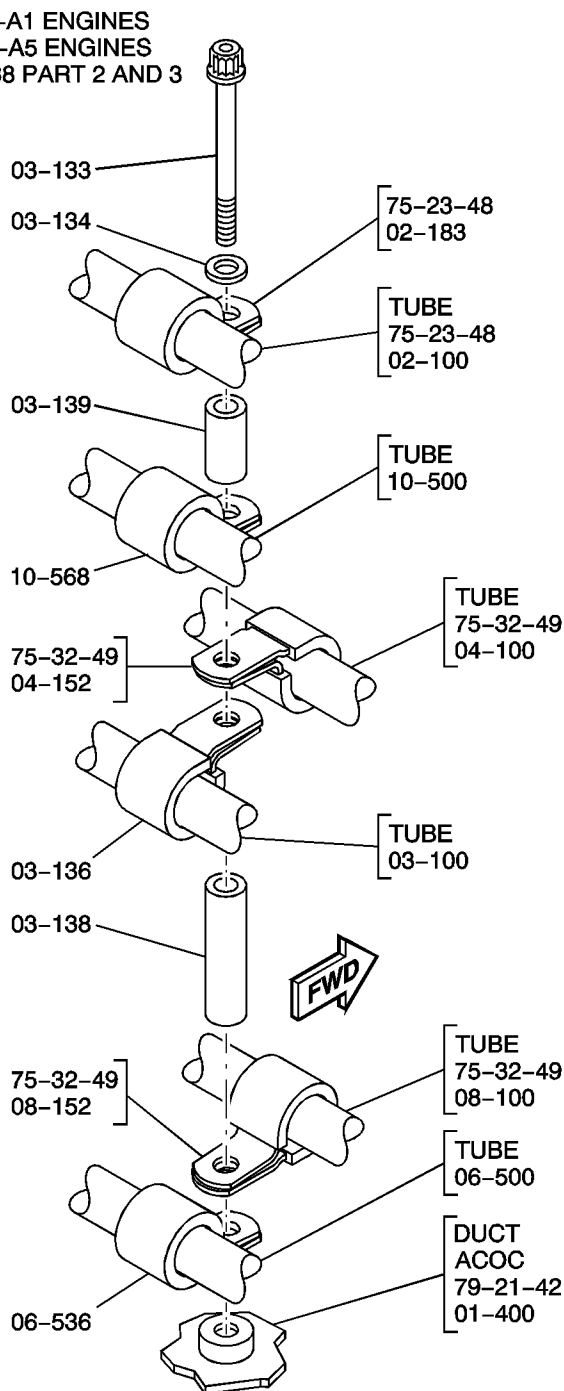
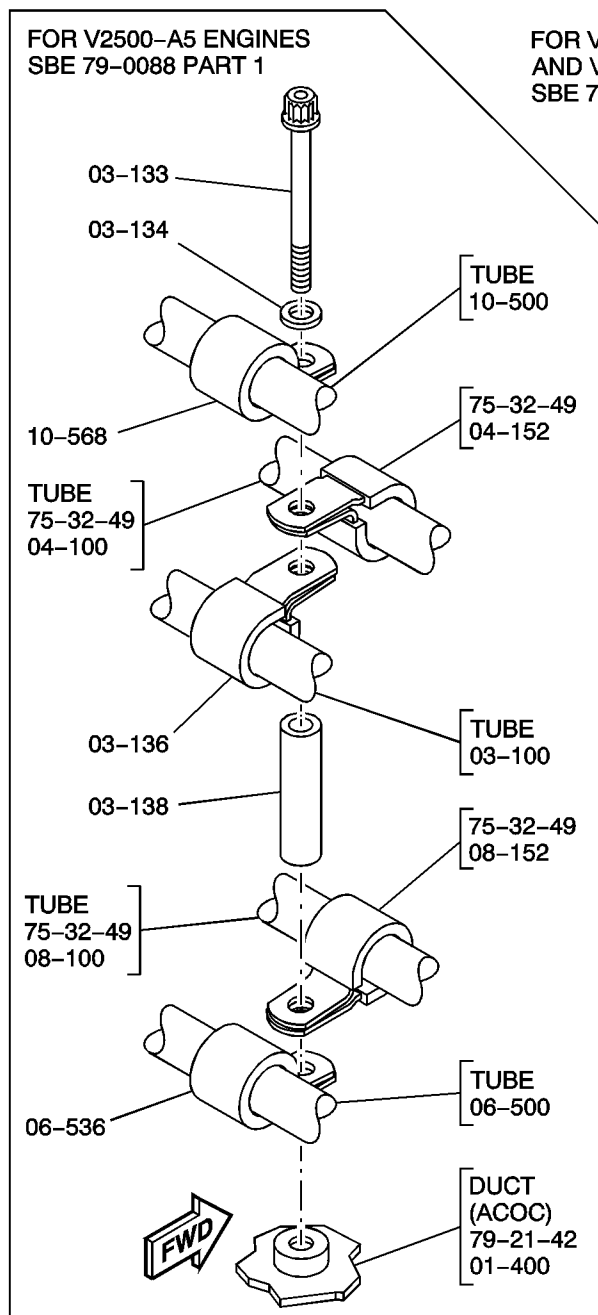
Clip positions CP0587 and CP1017
Figure 11

bmi0000158



CLIP POSITION 0584 AND 0586
BEFORE ALTERATION

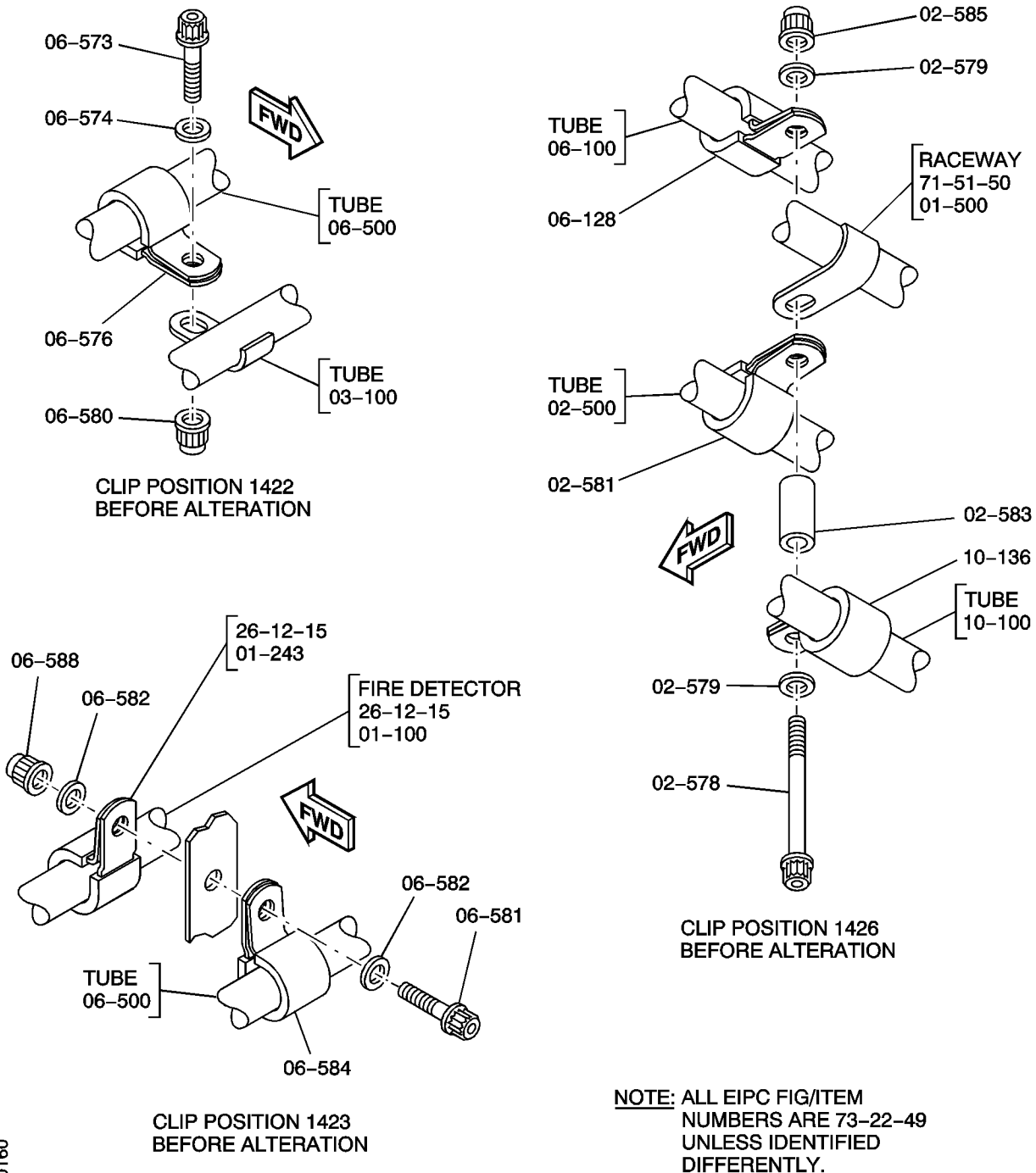
Clip positions CP0584 and CP0586
Figure 12



NOTE: ALL EIPC FIG/ITEM NUMBERS
ARE 73-22-49 UNLESS
IDENTIFIED DIFFERENTLY.

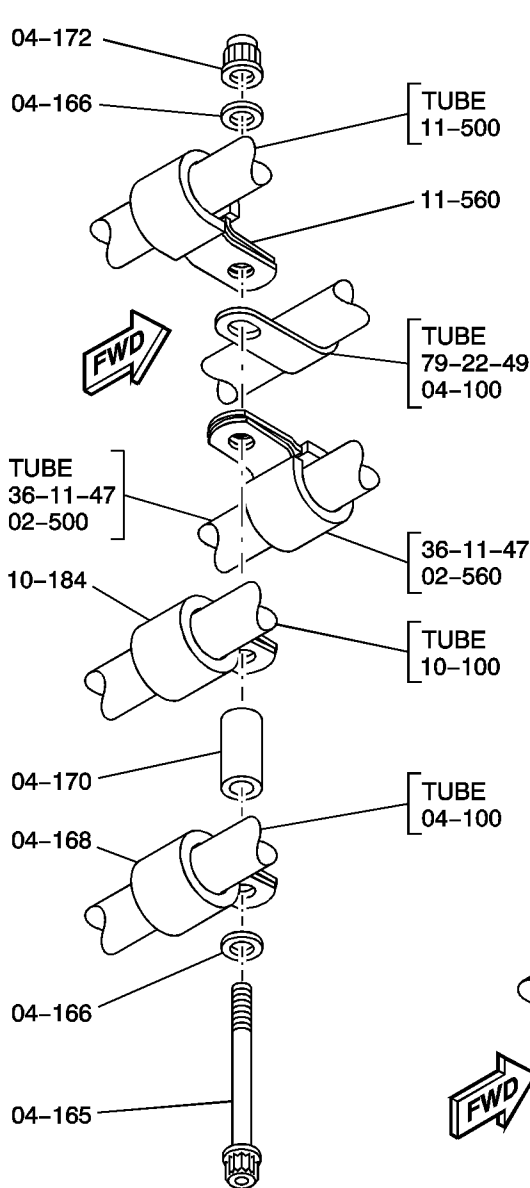
CLIP POSITION 0582
BEFORE ALTERATION

Clip position CP0582
Figure 13



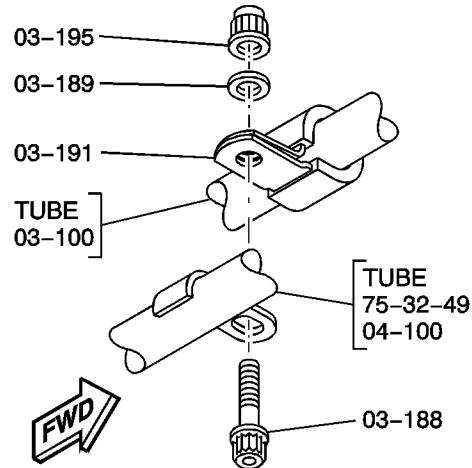
bmi0000160

Clip positions CP1422, CP1423 and CP1426
Figure 14



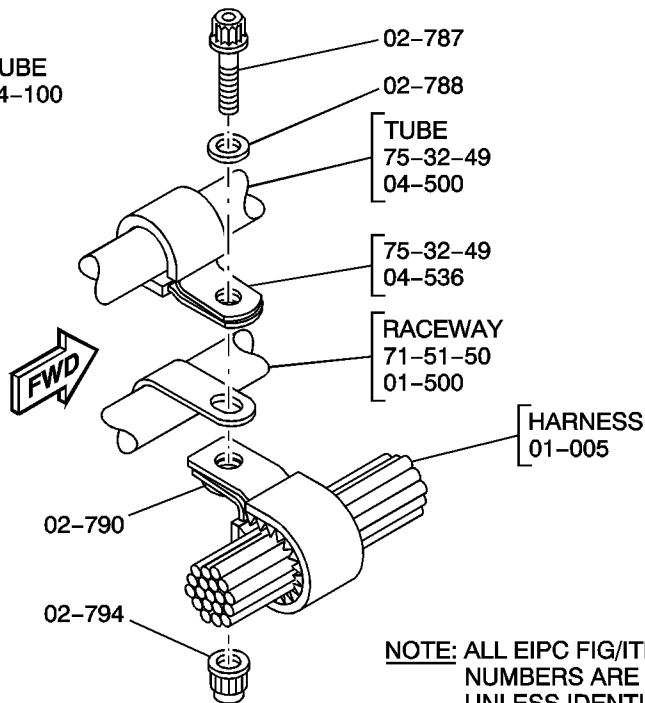
CLIP POSITION 1409
BEFORE ALTERATION

NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 75-32-49
UNLESS IDENTIFIED
DIFFERENTLY.



CLIP POSITION 1441
BEFORE ALTERATION

NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 73-22-49
UNLESS IDENTIFIED
DIFFERENTLY.



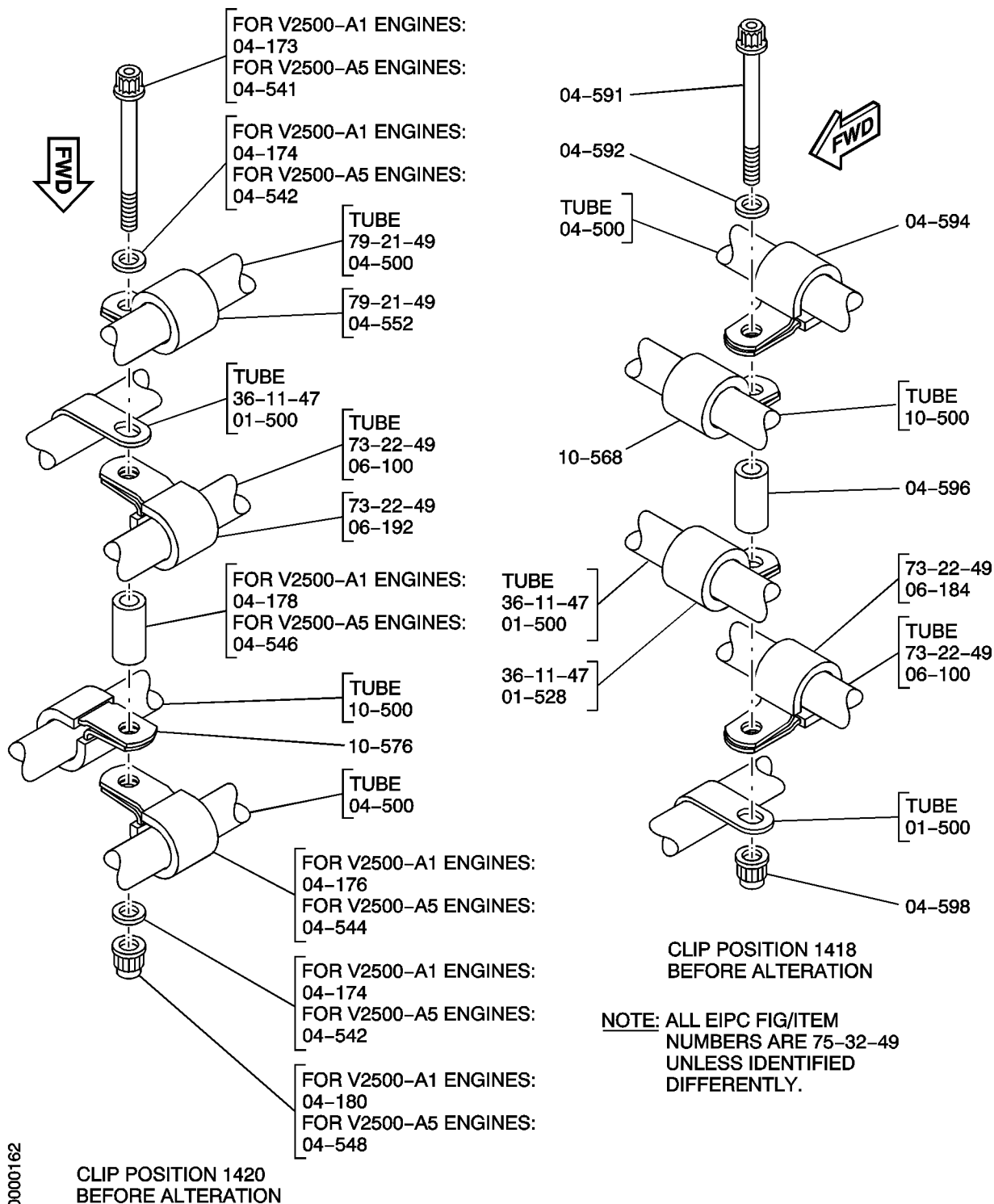
CLIP POSITION 1442
BEFORE ALTERATION

NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 71-51-41
UNLESS IDENTIFIED
DIFFERENTLY.

Clip positions CP1409, CP1441 and CP1442
Figure 15

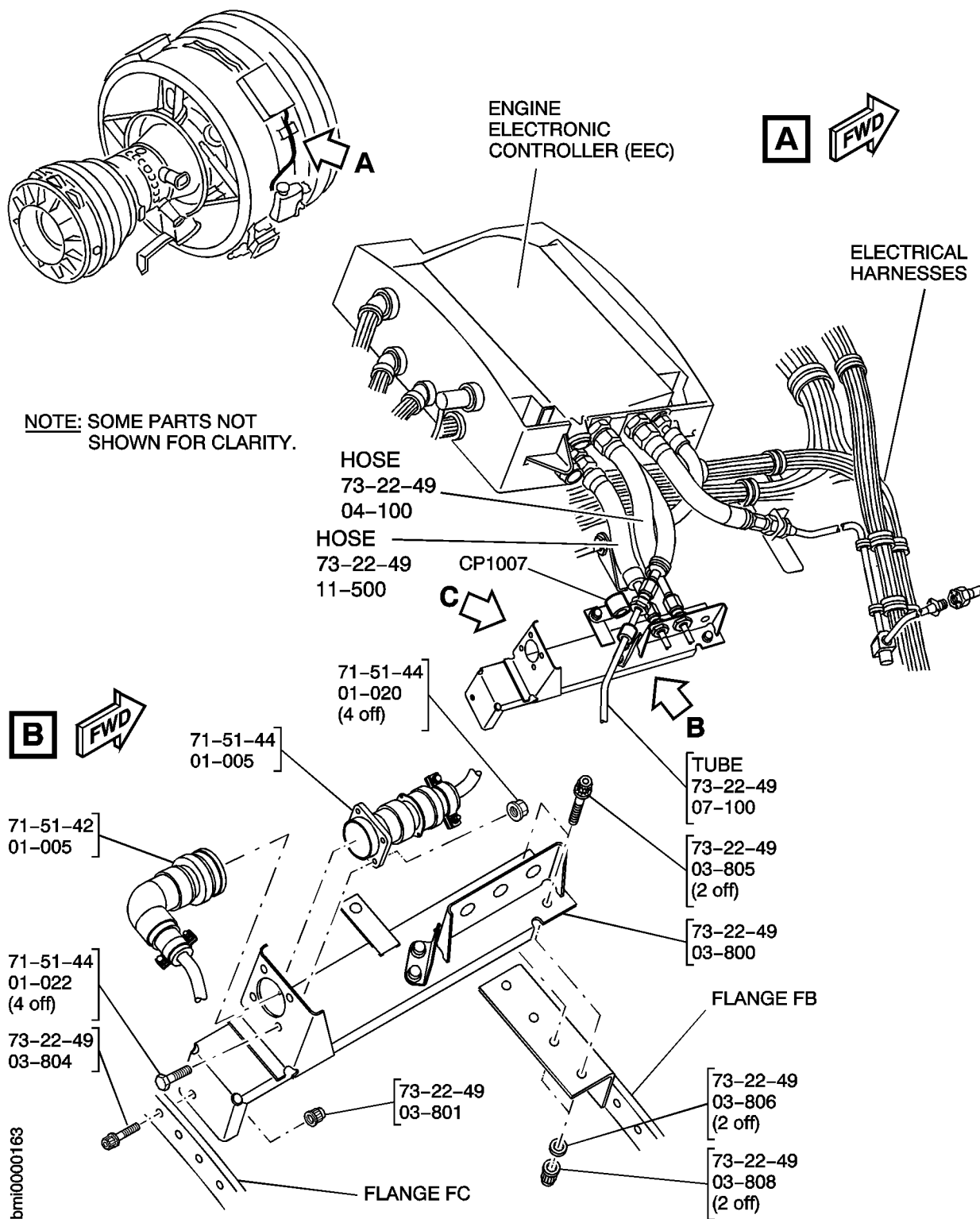
bmi0000161

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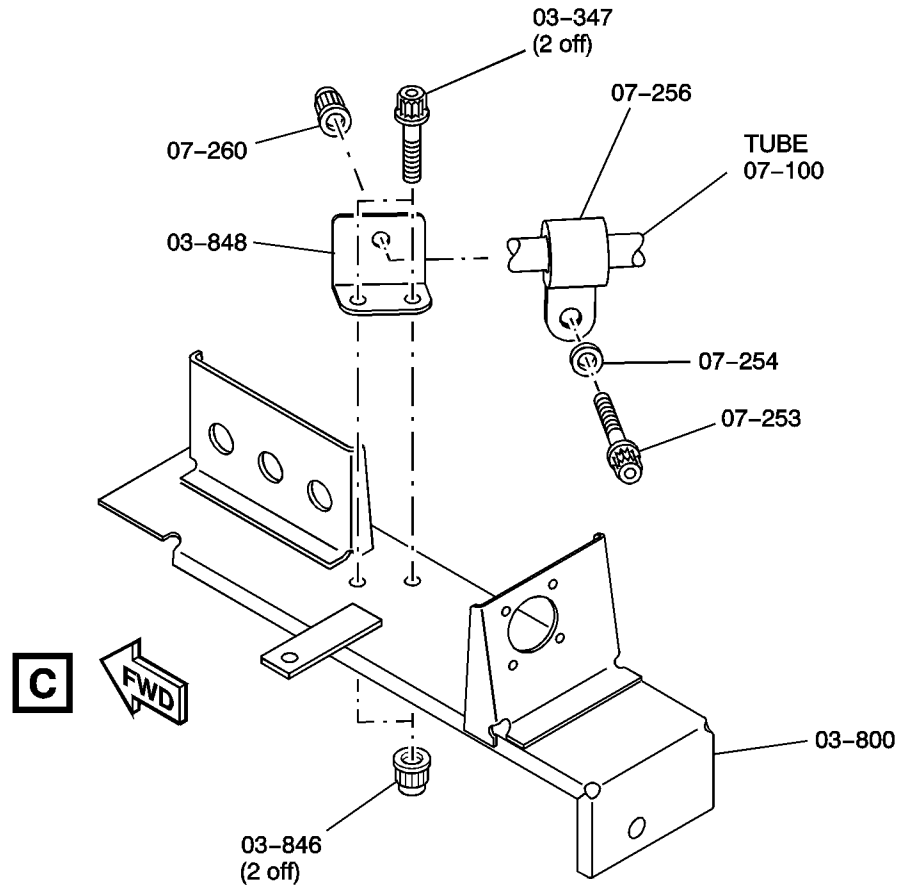


bmi0000162

Clip positions CP1418 and CP1420
Figure 16



Installation of support bracket assembly
Figure 17 sheet 1



CLIP POSITION 1482

NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

NOTE: ALL EIPC FIG/ITEM NUMBERS ARE 73-22-49 UNLESS IDENTIFIED DIFFERENTLY.

Installation of bracket and clip position CP1482
Figure 17 sheet 2

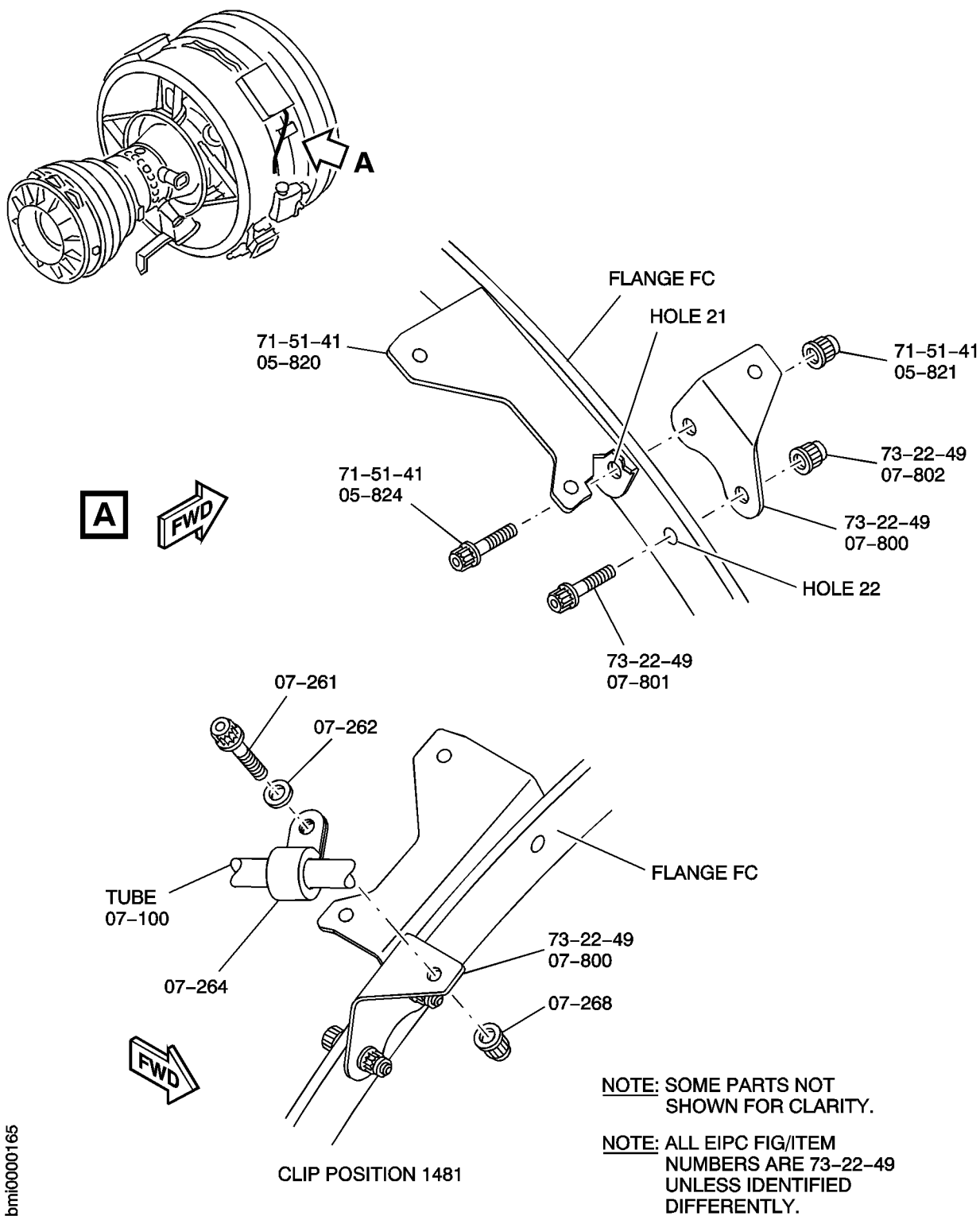
Aug. 8/07
May. 5/08 Revision 2

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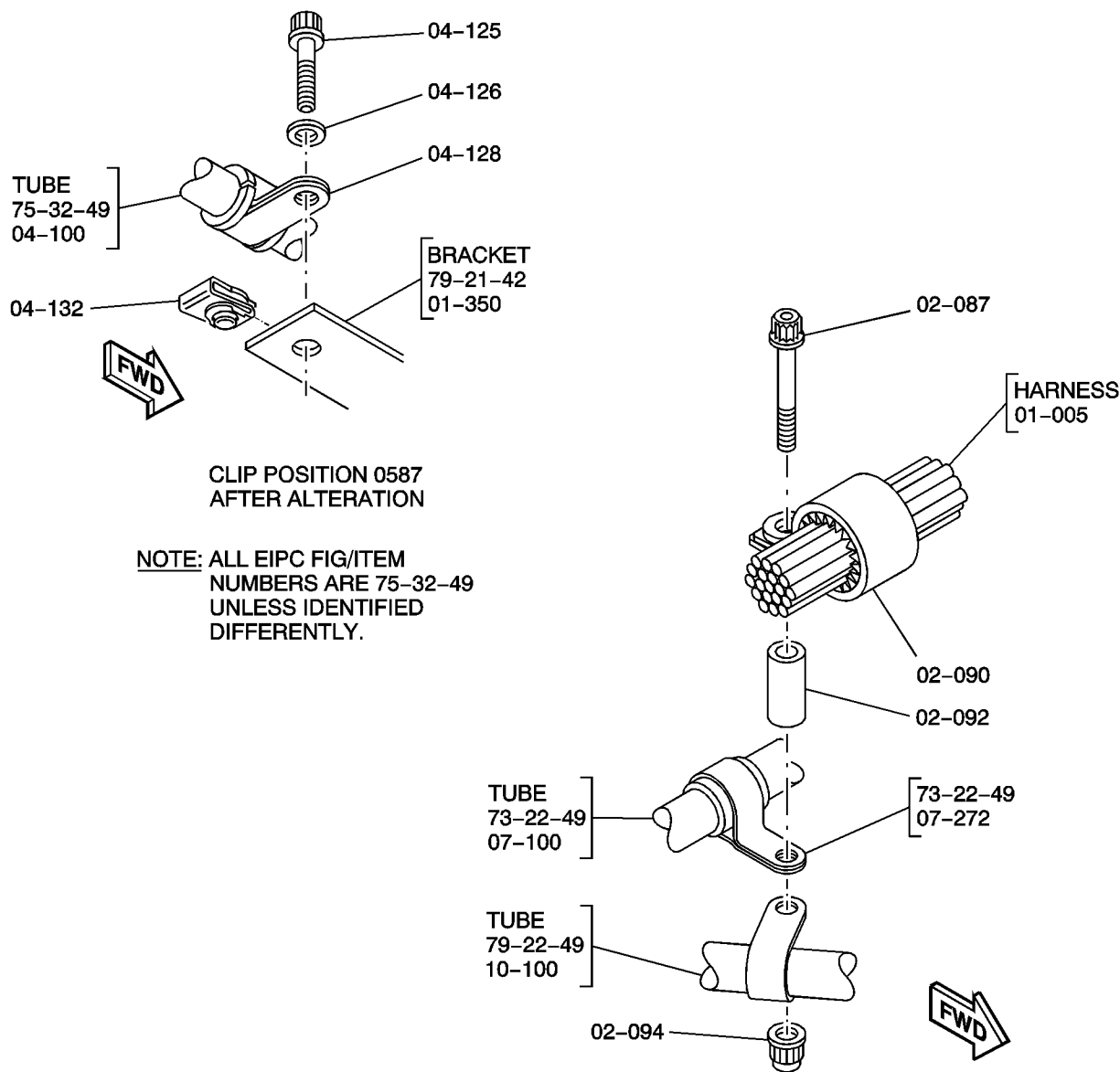
© Rolls-Royce plc

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

bmi0000164

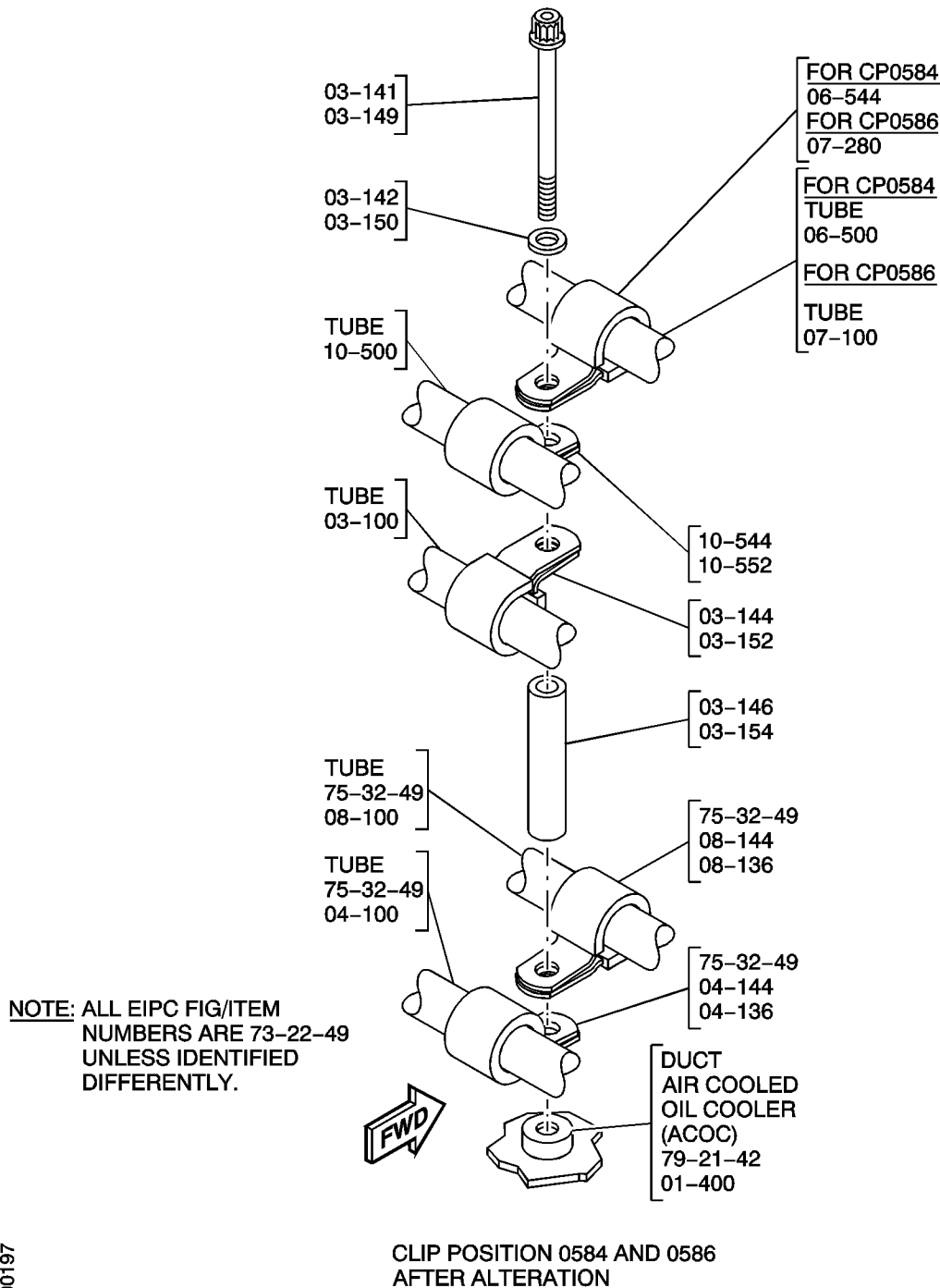


Installation of bracket and clip positions CP1481
Figure 18

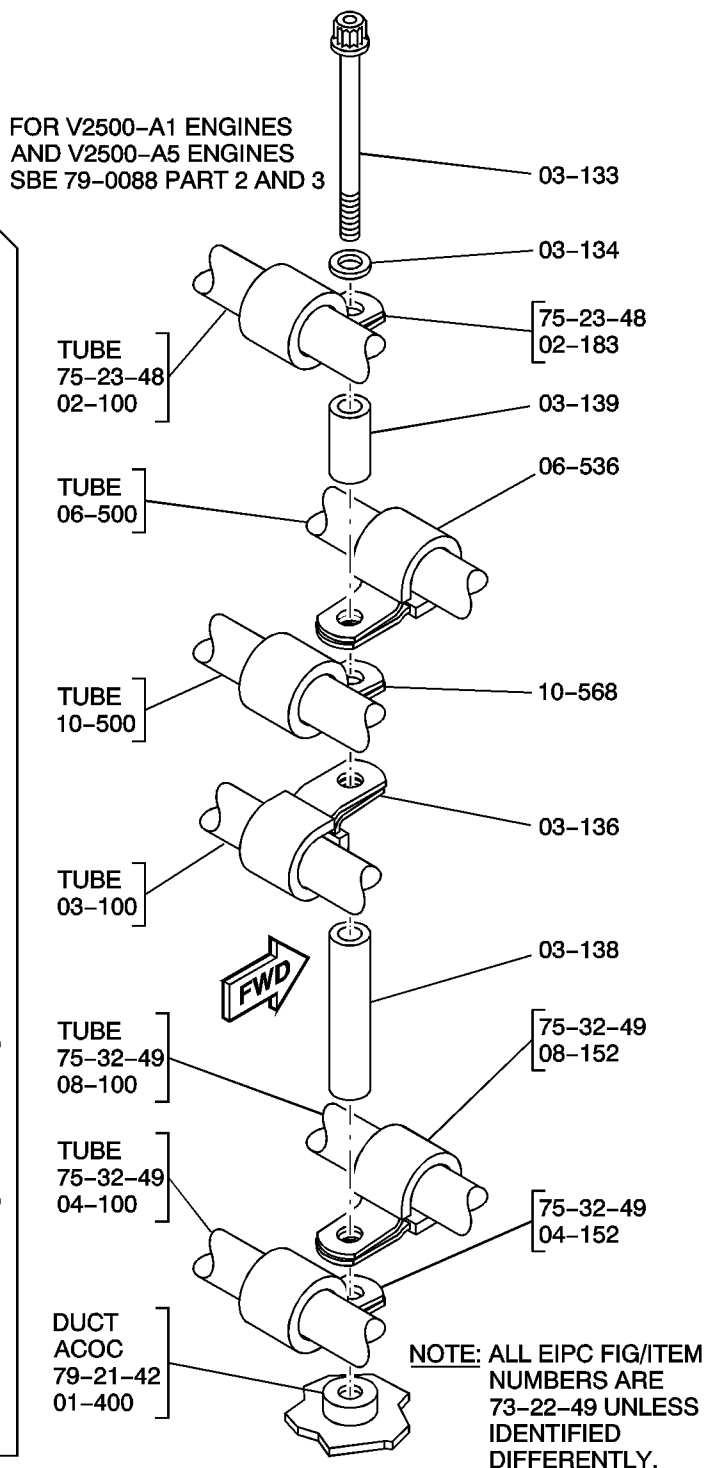
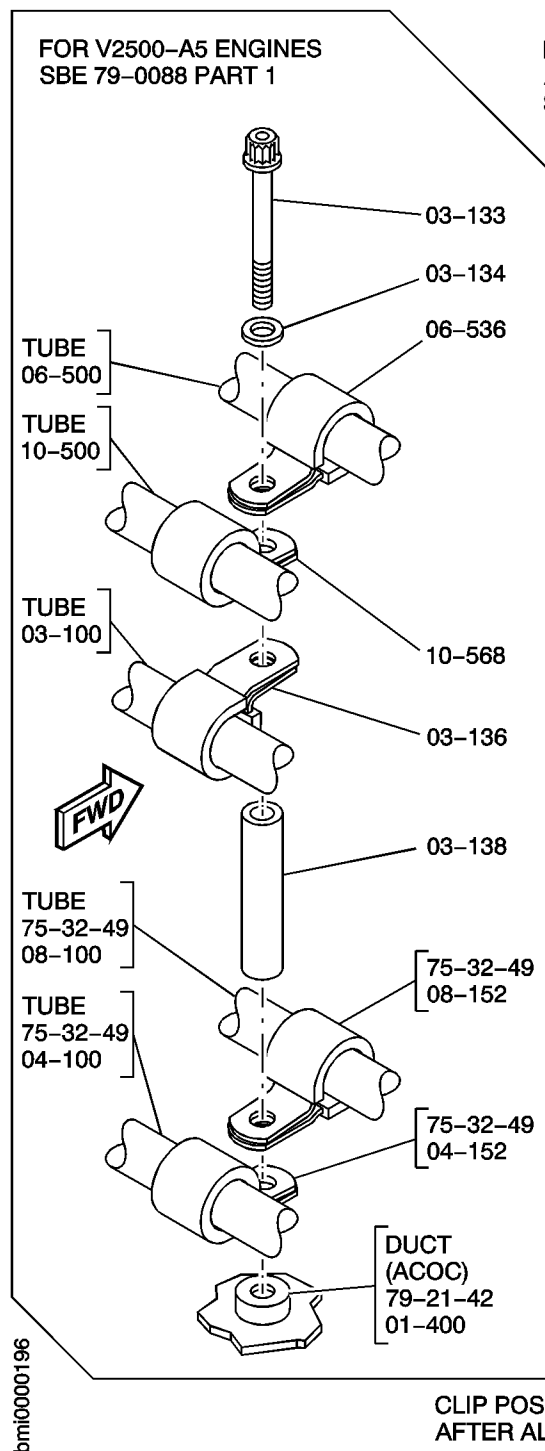


bmi0000166

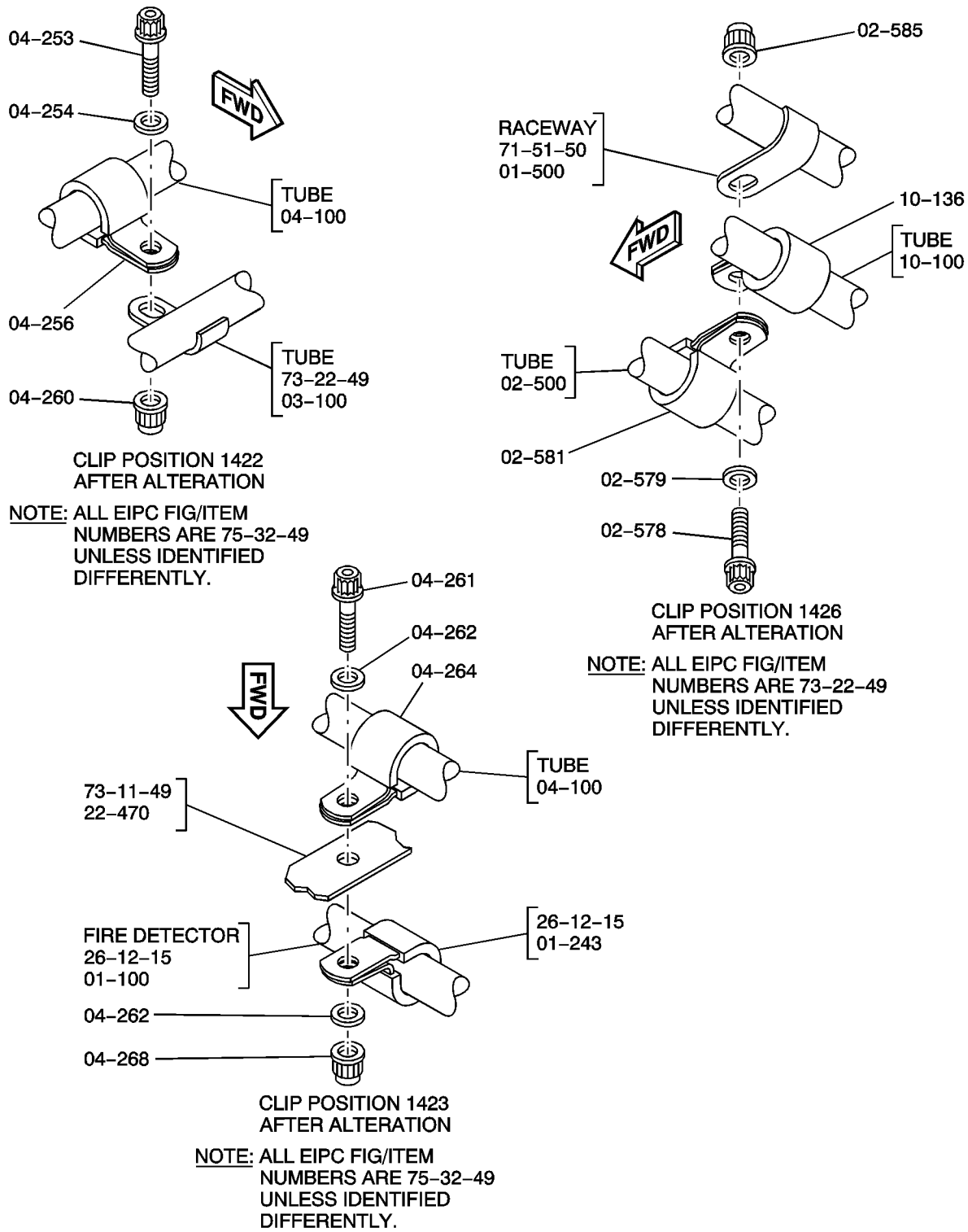
Clip positions CP0587 and CP1017
Figure 19



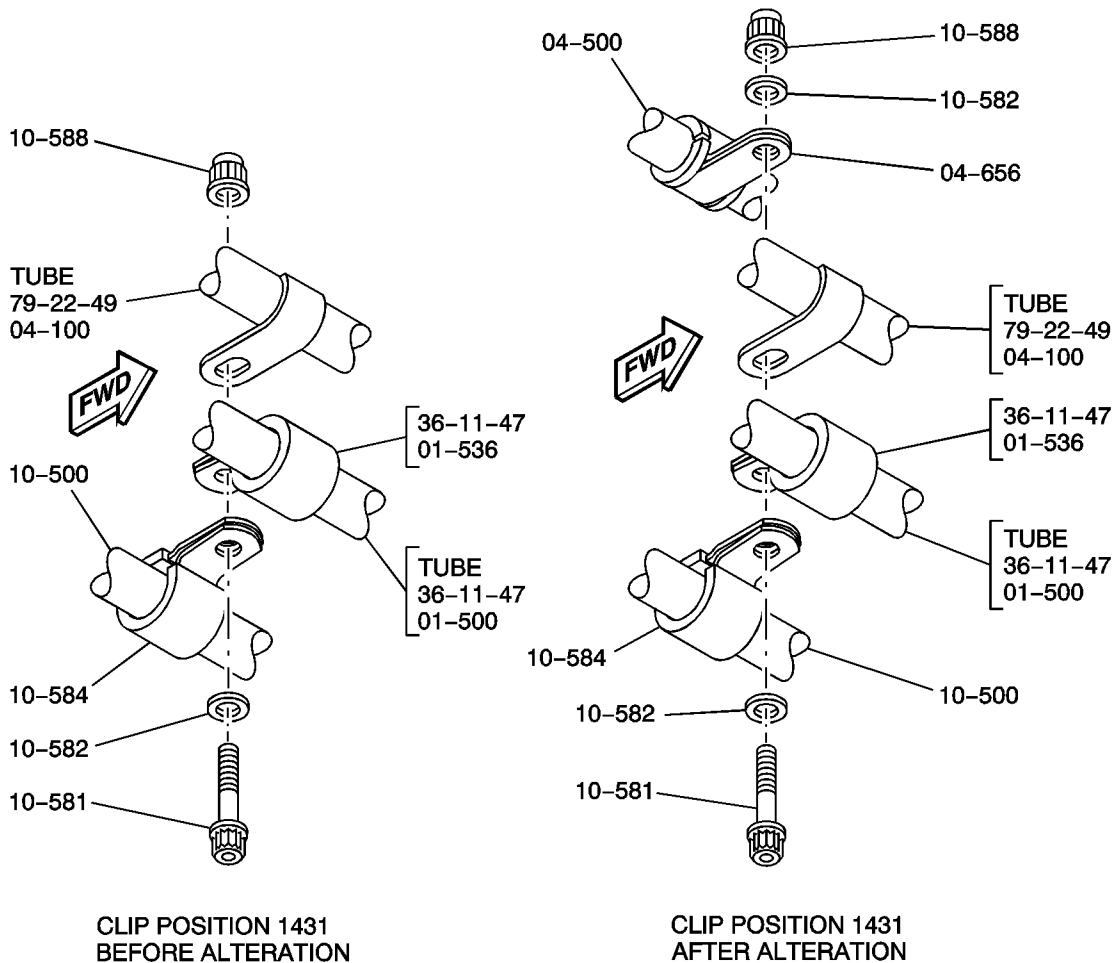
Clip positions CP0584 and CP0586
Figure 20



Clip position CP0582
Figure 21



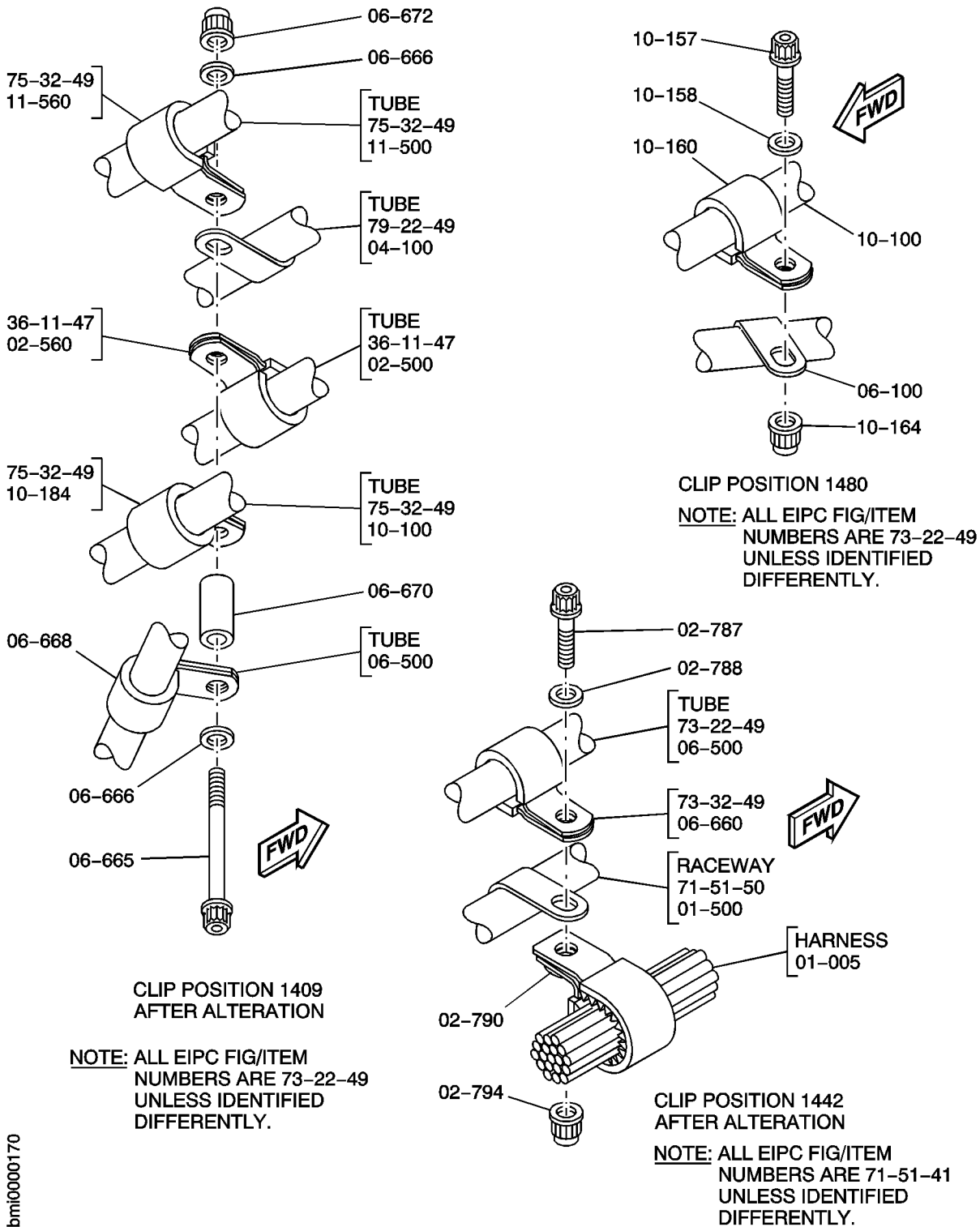
Clip positions CP1422, CP1423 and CP1426
Figure 22



NOTE: ALL EIPC FIG/ITEM
NUMBERS ARE 75-32-49
UNLESS IDENTIFIED
DIFFERENTLY.

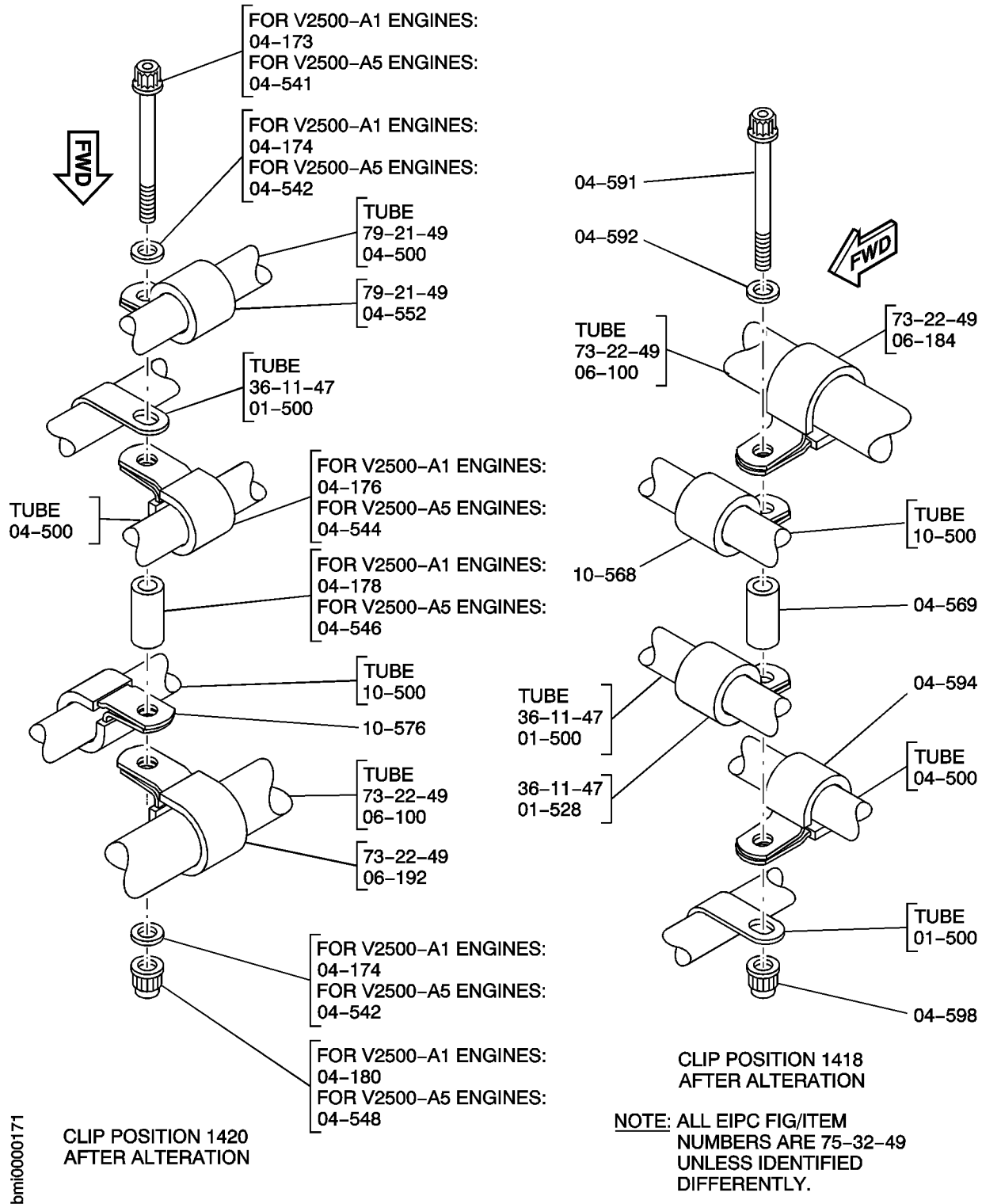
bmi0000169

Clip position CP1431
Figure 23

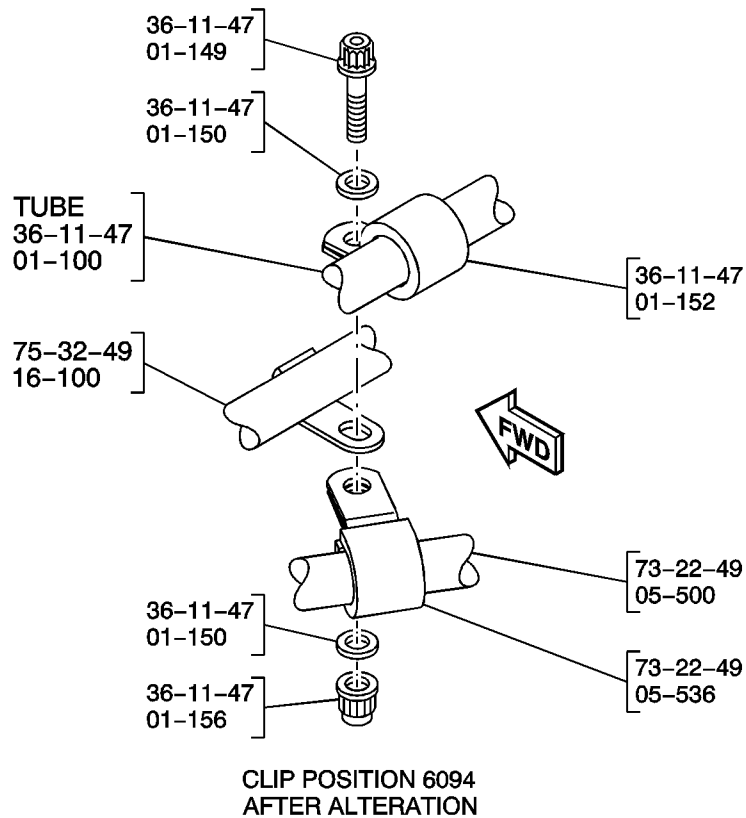
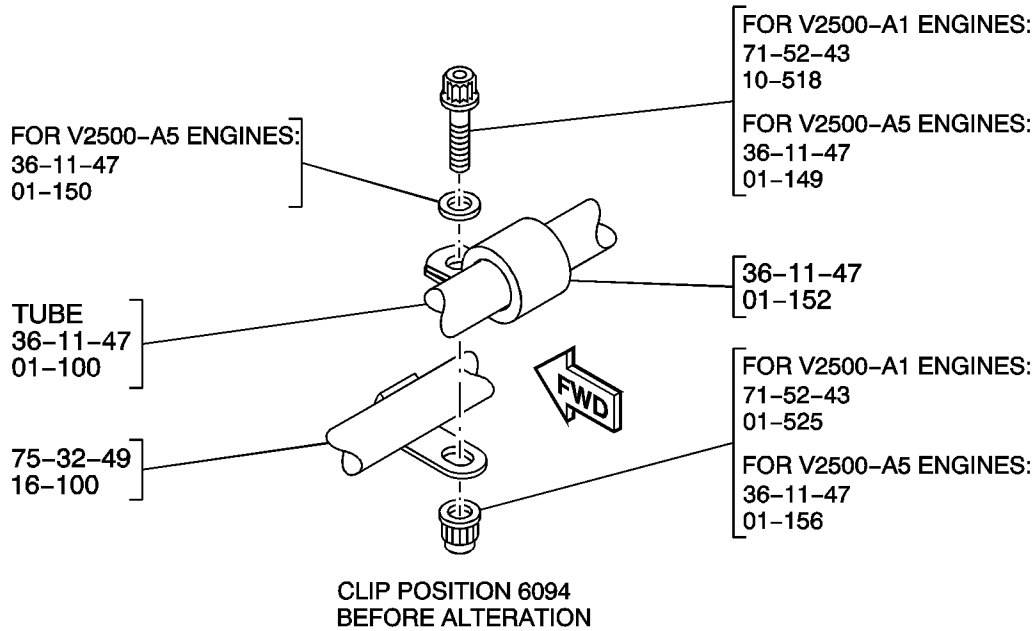


Clip positions CP1409, CP1442 and CP1480
 Figure 24

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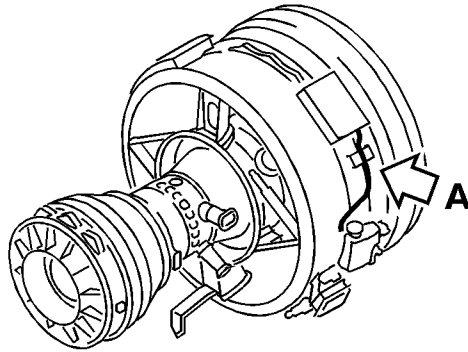


Clip positions CP1418 and CP1420
Figure 25



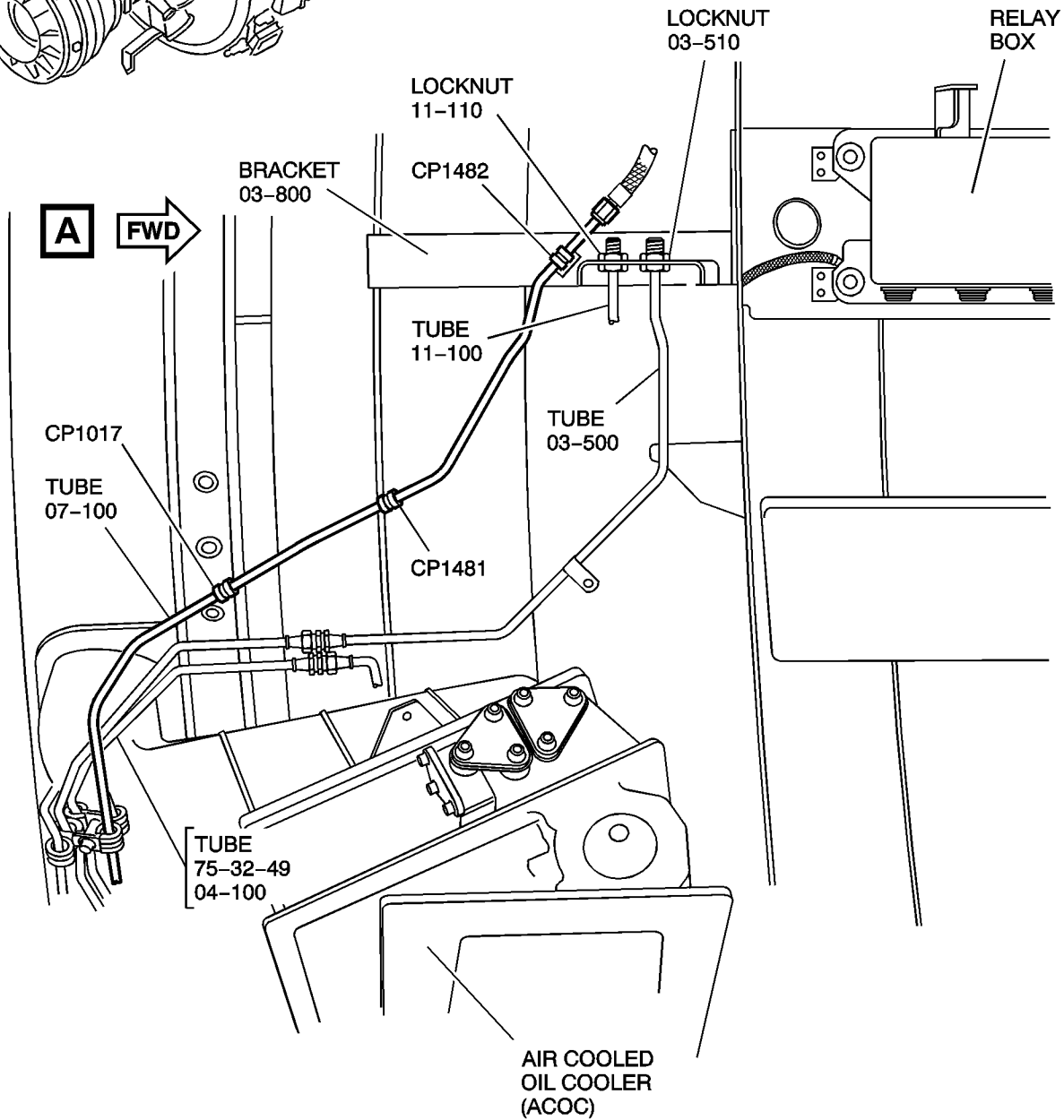
Clip position CP6094
Figure 26

bmi0000172



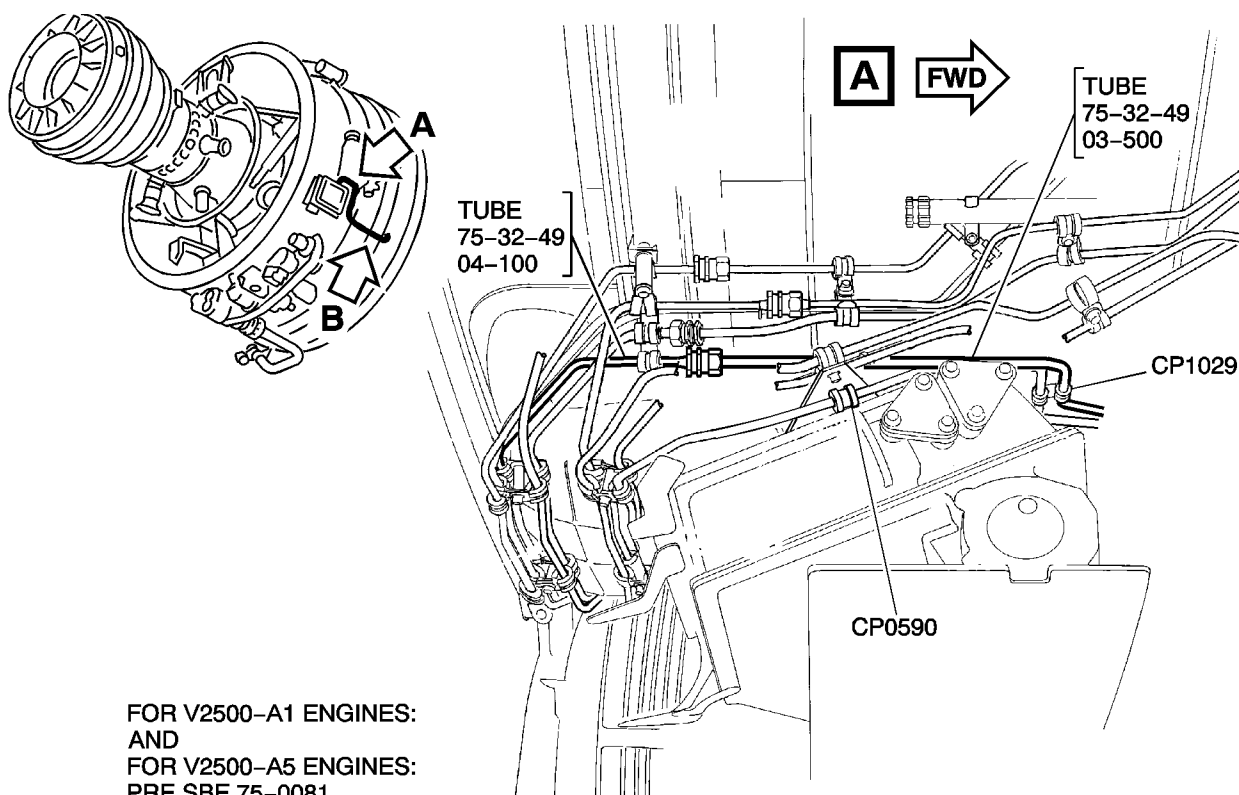
NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

NOTE: ALL EIPC FIG/ITEM NUMBERS ARE 73-22-49.

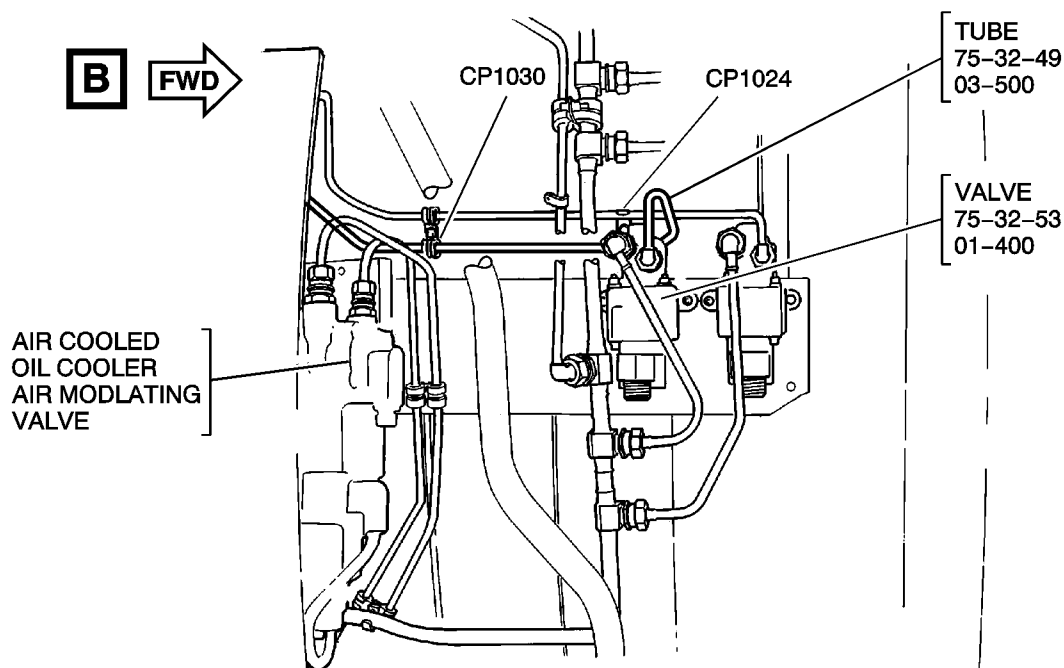


bmi0000173

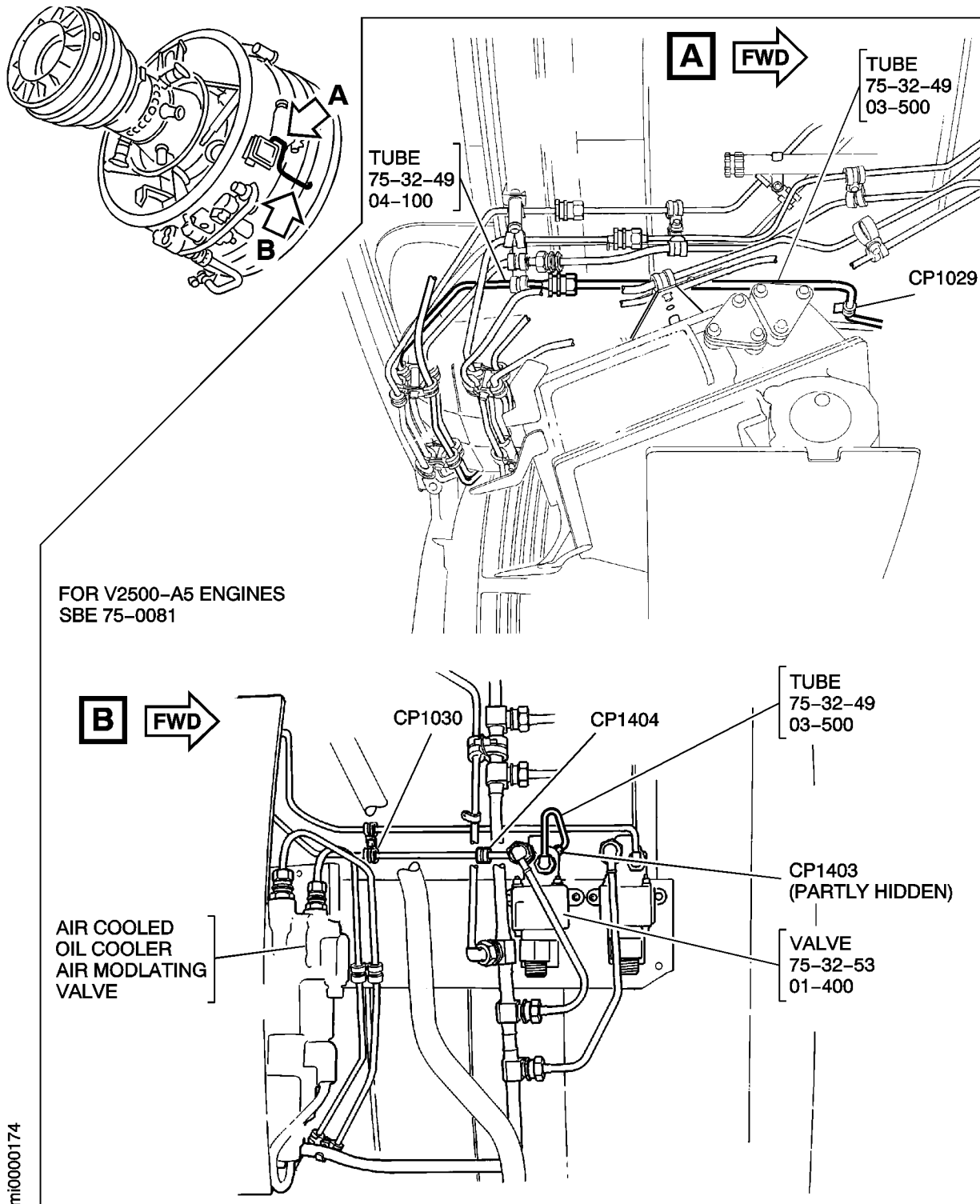
Installation of Pb sense line tube assembly
Figure 27



Printed in Great Britain

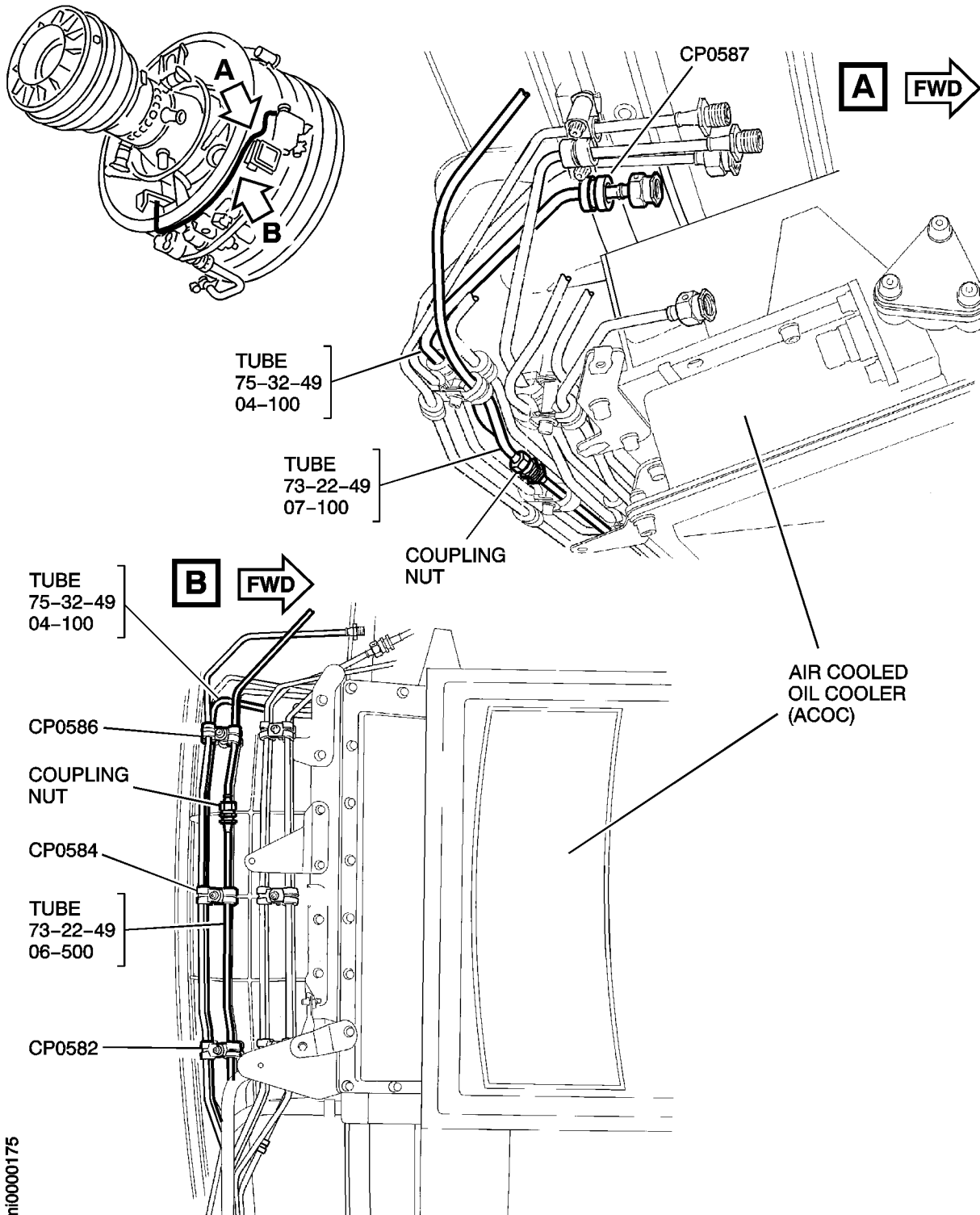


Installation of HP compressor stage 10 bleed air control tube assembly
Figure 28



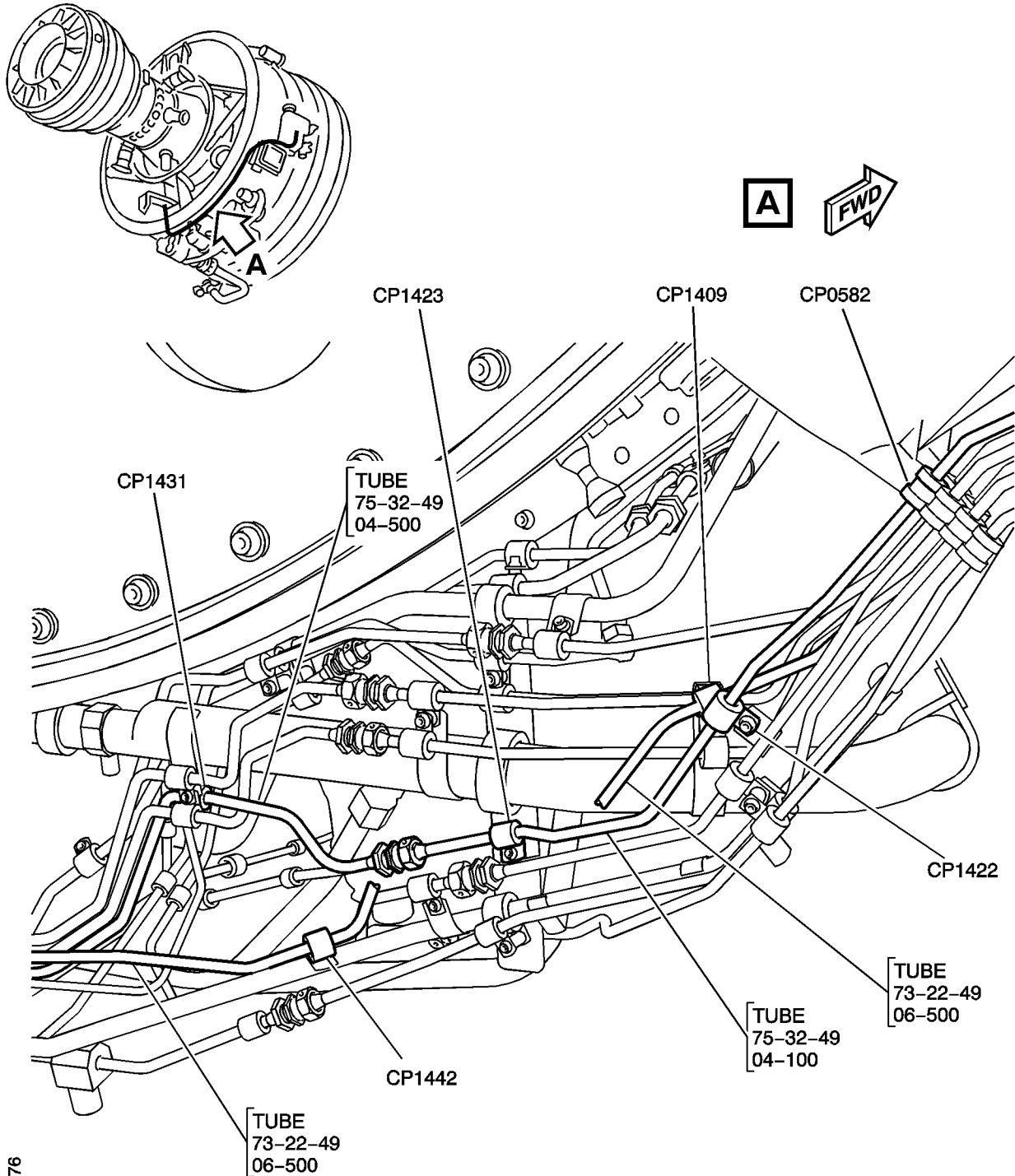
bmi0000174

Installation of HP compressor stage 10 bleed air control tube assembly
Figure 29



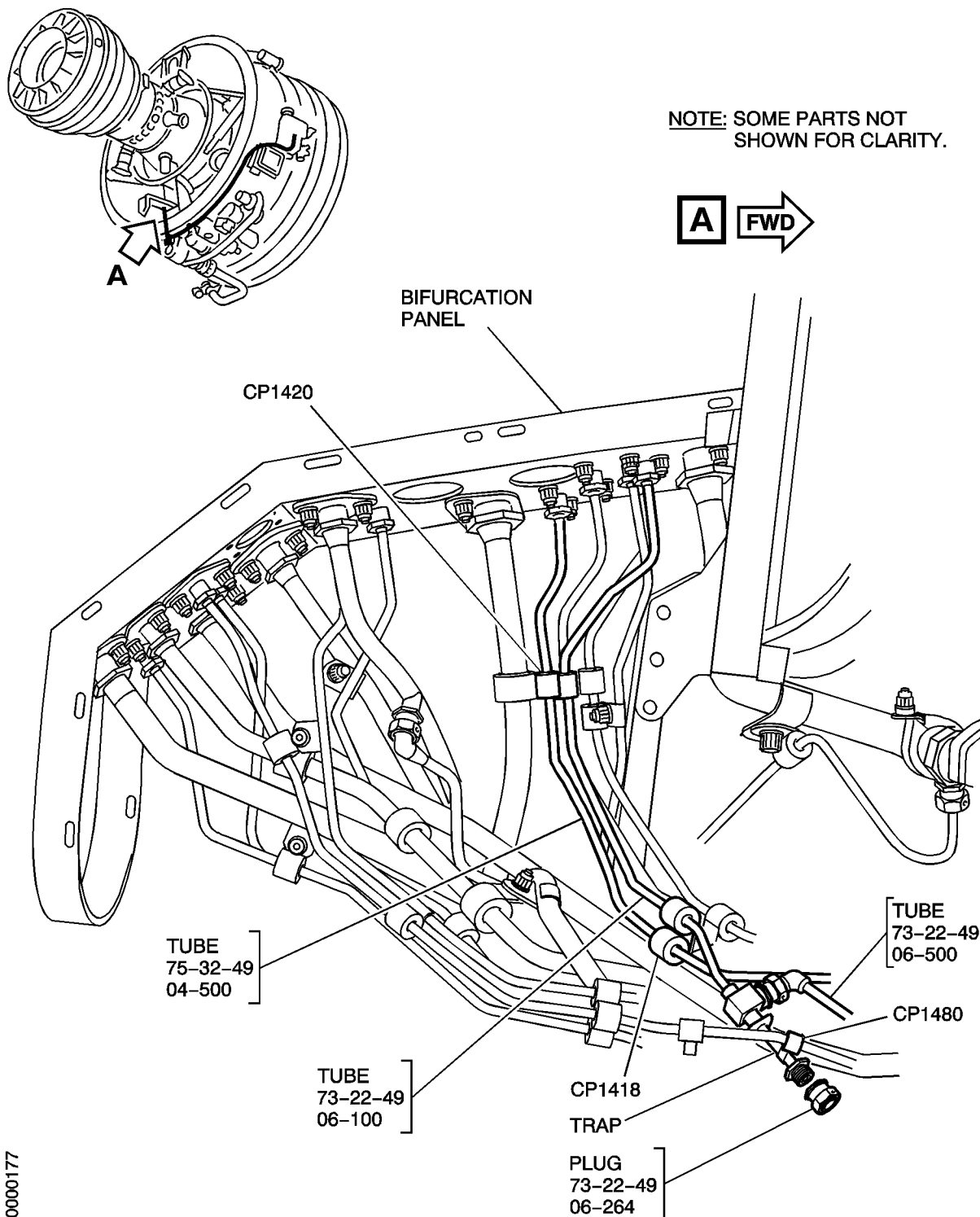
Printed in Great Britain

Installation of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 30



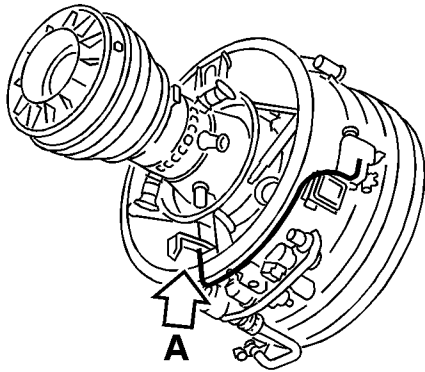
bmi0000176

Installation of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 31

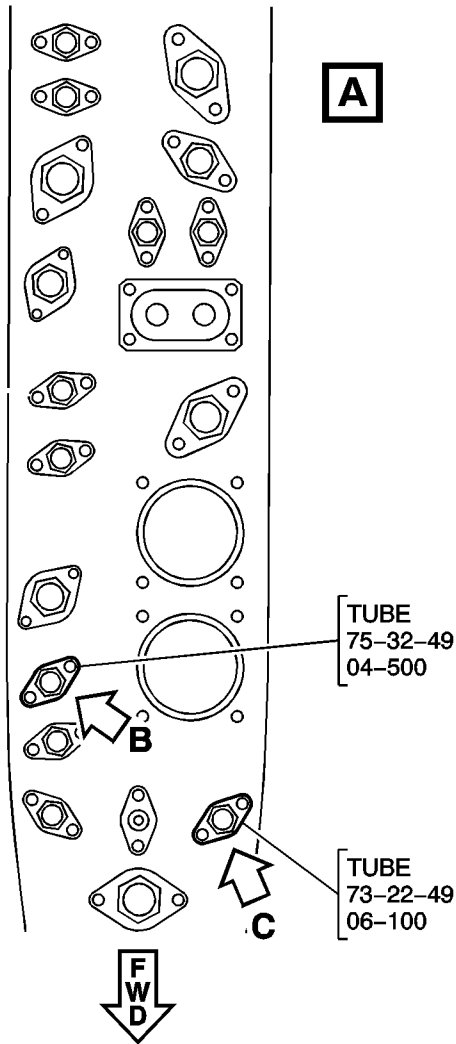


bmi0000177

Installation of Pb sense line tube assembly and HP compressor stage 10 bleed air control tube assembly
Figure 32

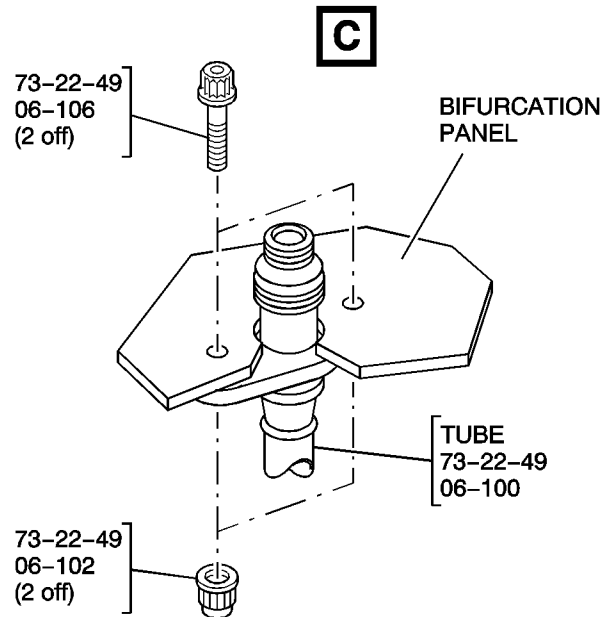
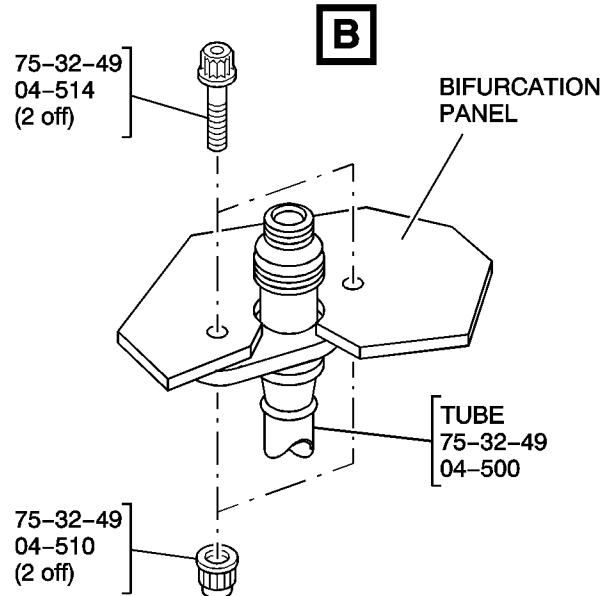


VIEW WHEN YOU LOOK ON THE BOTTOM OF THE BIFURCATION PANEL

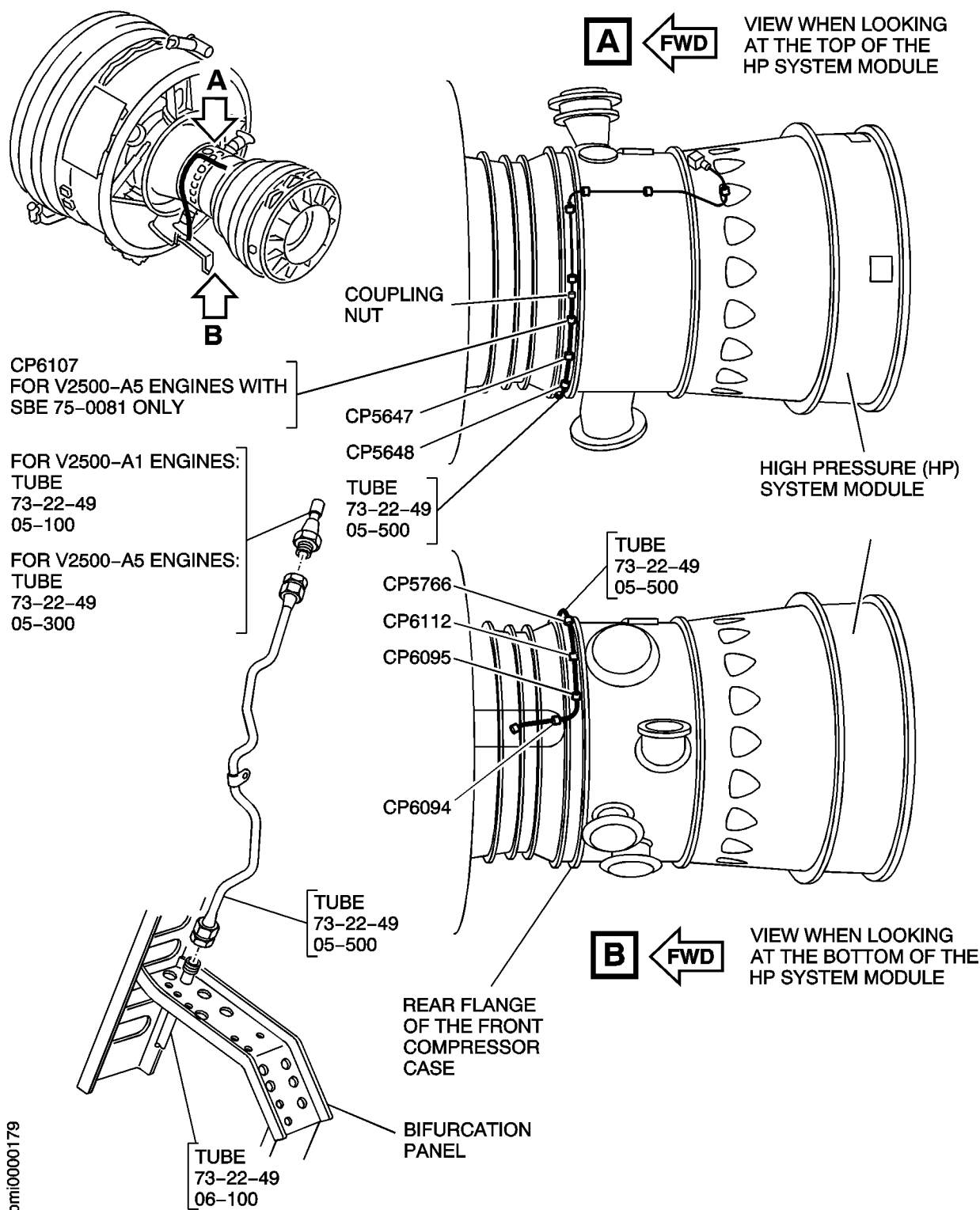


bmi0000178

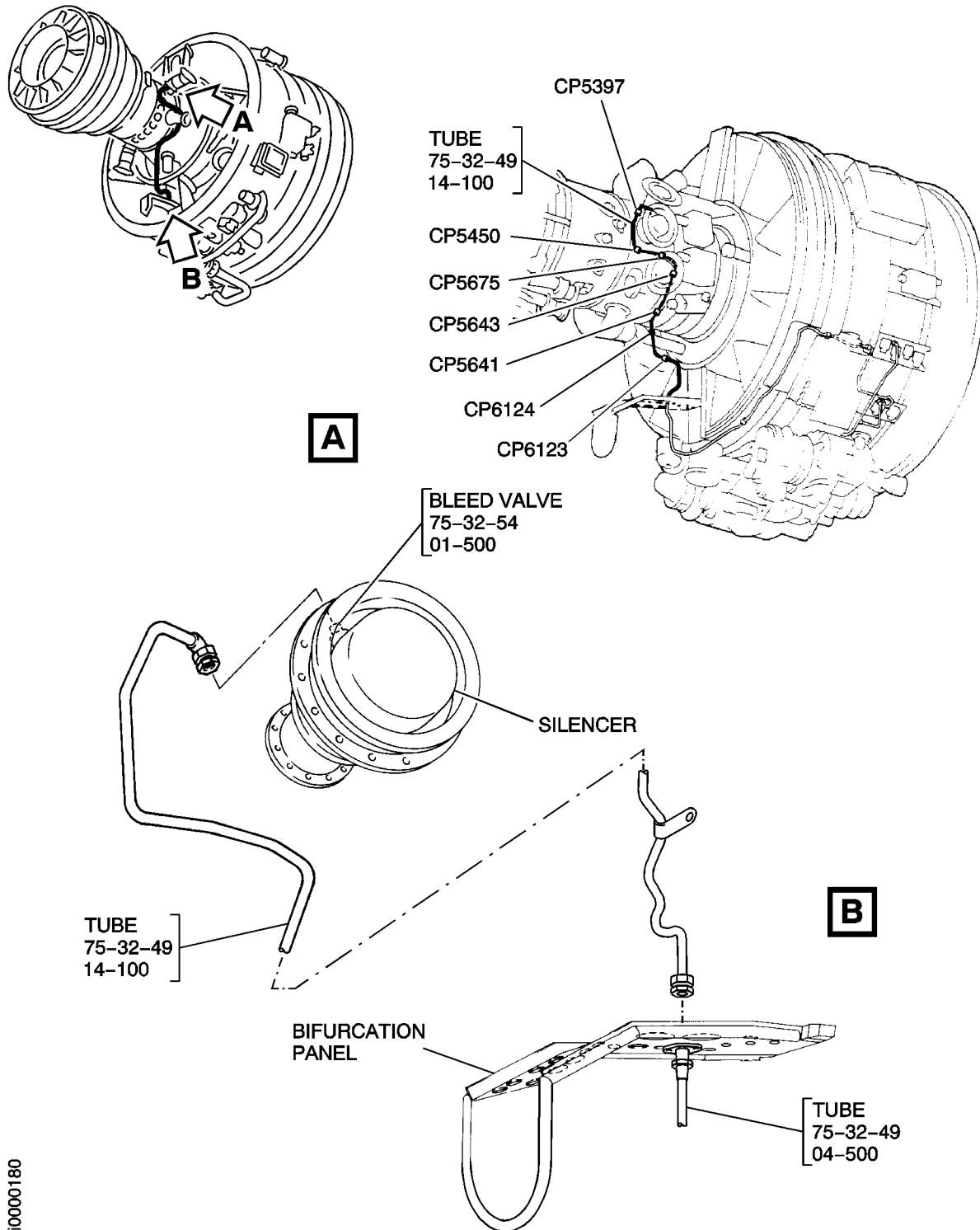
NOTE: SOME PARTS NOT SHOWN FOR CLARITY.



Bifurcation Panel
Figure 33

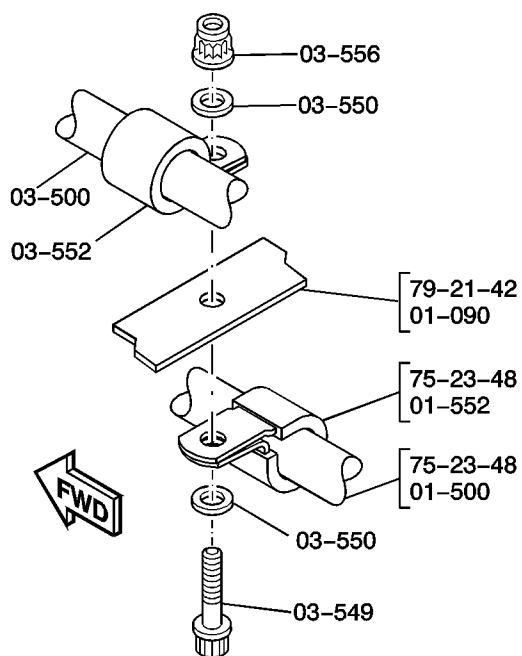


Installation of Pb sense line tube assembly
Figure 34

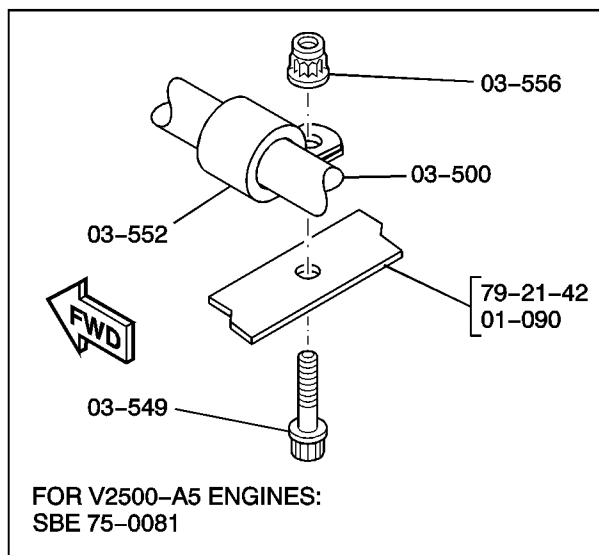


bmi0000180

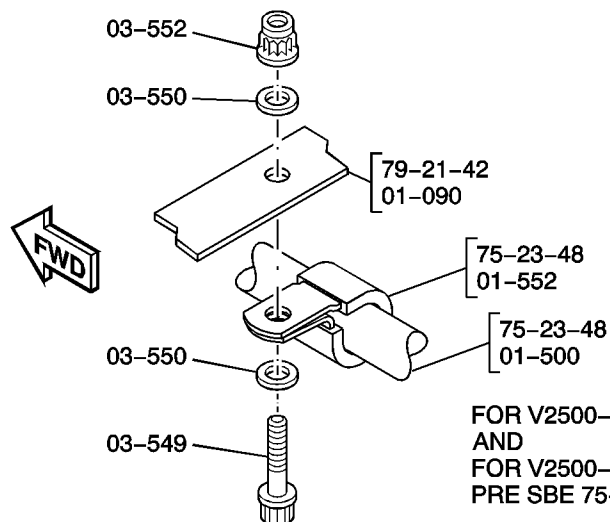
Installation of HP compressor stage 10 bleed air control tube assembly
Figure 35



FOR V2500-A1 ENGINES:
AND
FOR V2500-A5 ENGINES:
PRE SBE 75-0081



CLIP POSITION CP0590 BEFORE ALTERATION

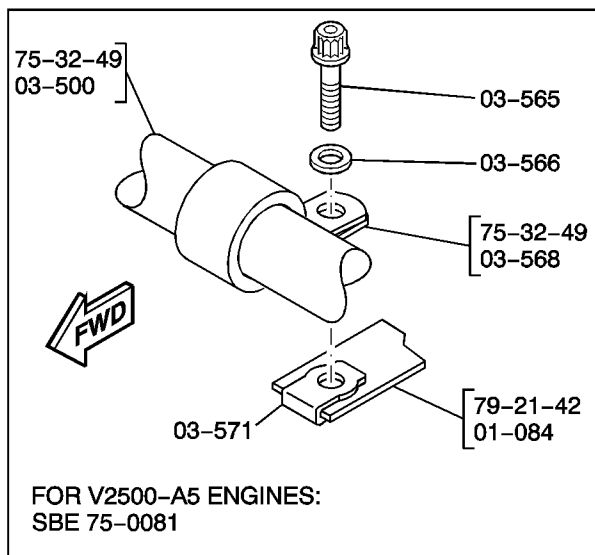
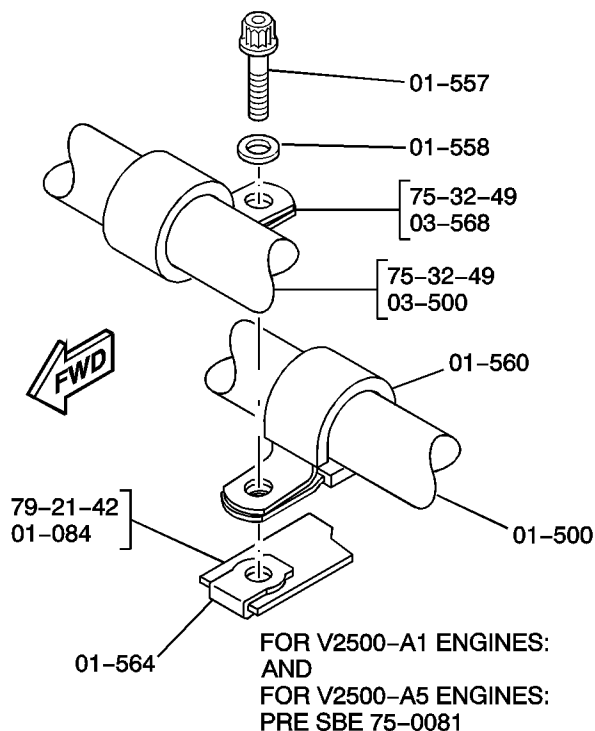


FOR V2500-A1 ENGINES:
AND
FOR V2500-A5 ENGINES:
PRE SBE 75-0081

NOTE: ALL IPC FIG/ITEM
NUMBERS ARE 75-32-49
UNLESS IDENTIFIED
DIFFERENTLY.

CLIP POSITION CP0590 AFTER ALTERATION

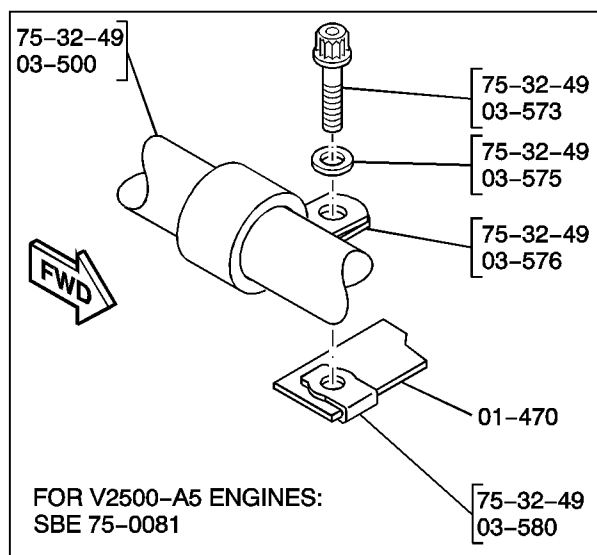
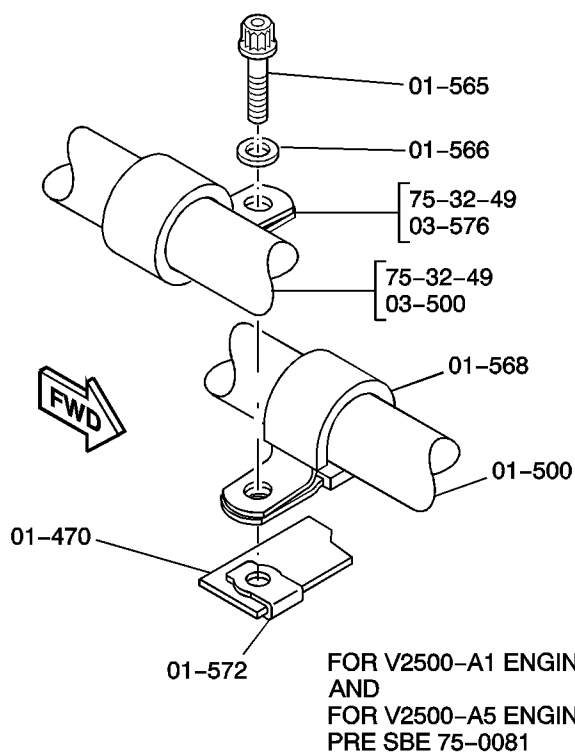
Clip position CP0590
Figure 36



NOTE: ALL IPC FIG/ITEM
NUMBERS ARE 75-23-48
UNLESS IDENTIFIED
DIFFERENTLY.

CLIP POSITION CP1029

Clip position CP1029
Figure 37

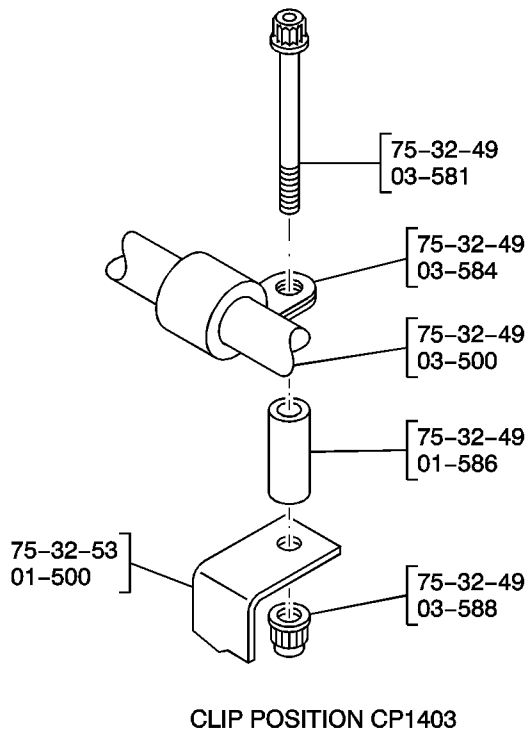
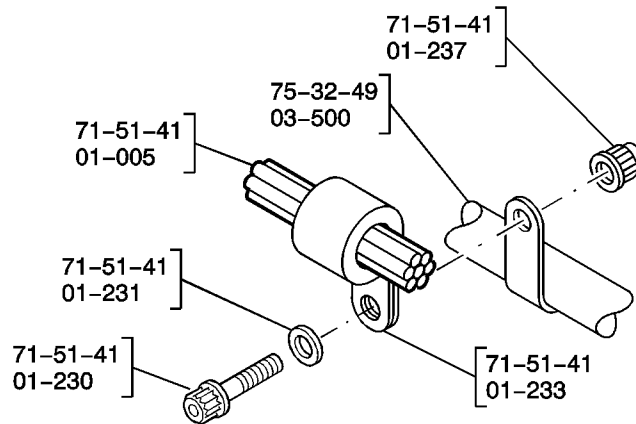
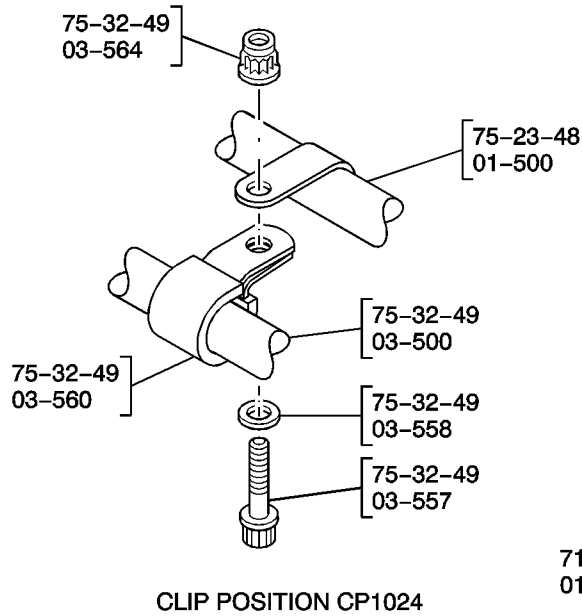


NOTE: ALL IPC FIG/ITEM
NUMBERS ARE 75-23-48
UNLESS IDENTIFIED
DIFFERENTLY.

CLIP POSITION CP1030

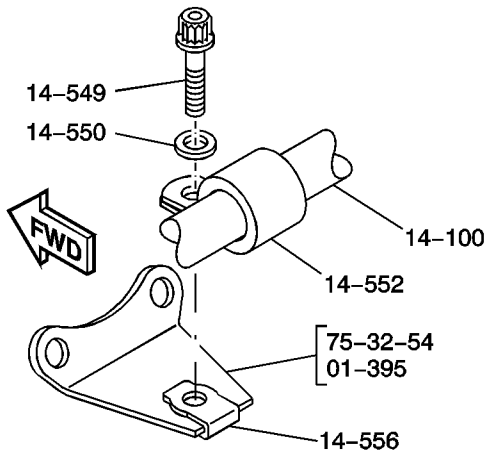
Clip position CP1030
Figure 38

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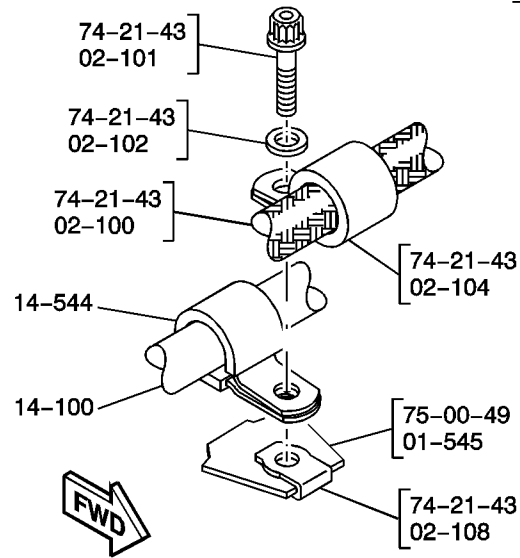
Clip positions CP1403, CP1404 and CP1024
Figure 39

bmi0000203

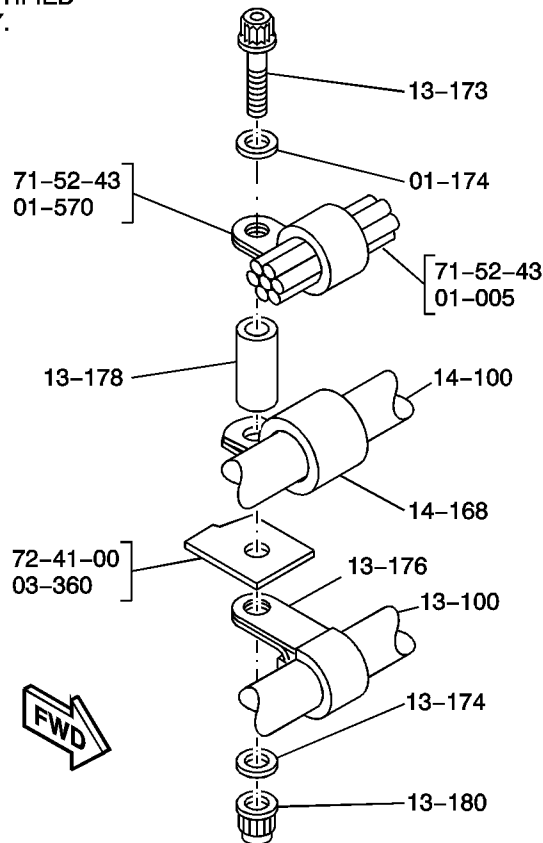


CLIP POSITION CP5397

NOTE: ALL IPC FIG/ITEM NUMBERS ARE 75-32-49 UNLESS IDENTIFIED DIFFERENTLY.



CLIP POSITION CP5450

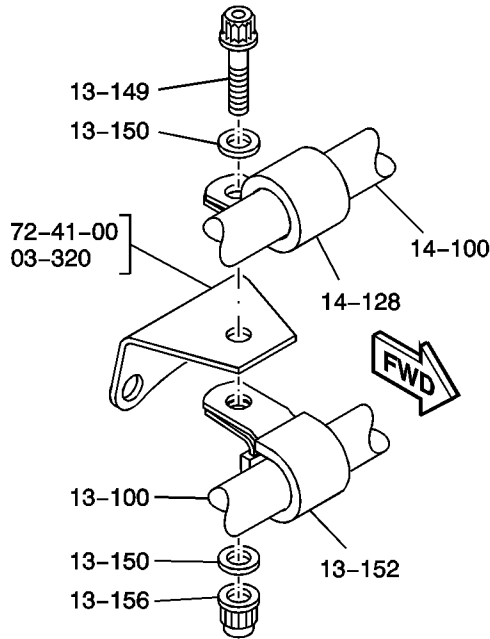


CLIP POSITION CP5641

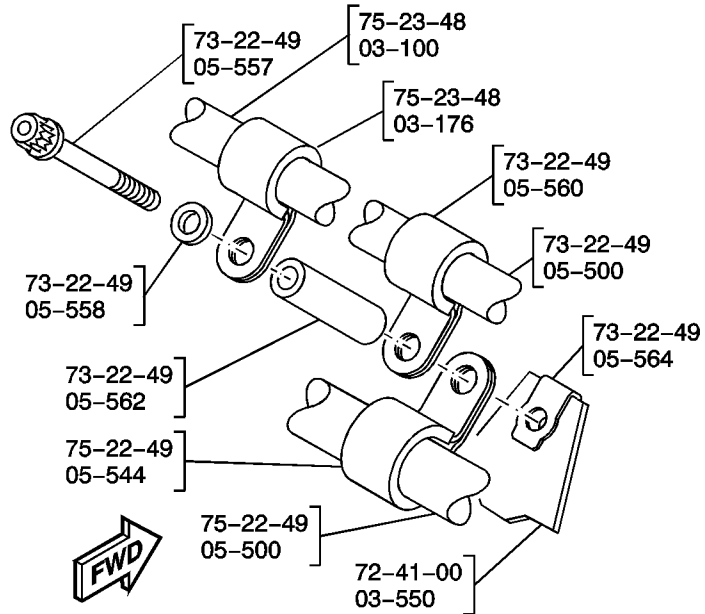
Clip positions CP5397, CP5450 and CP5641
Figure 40

bmi0000204

Printed in Great Britain

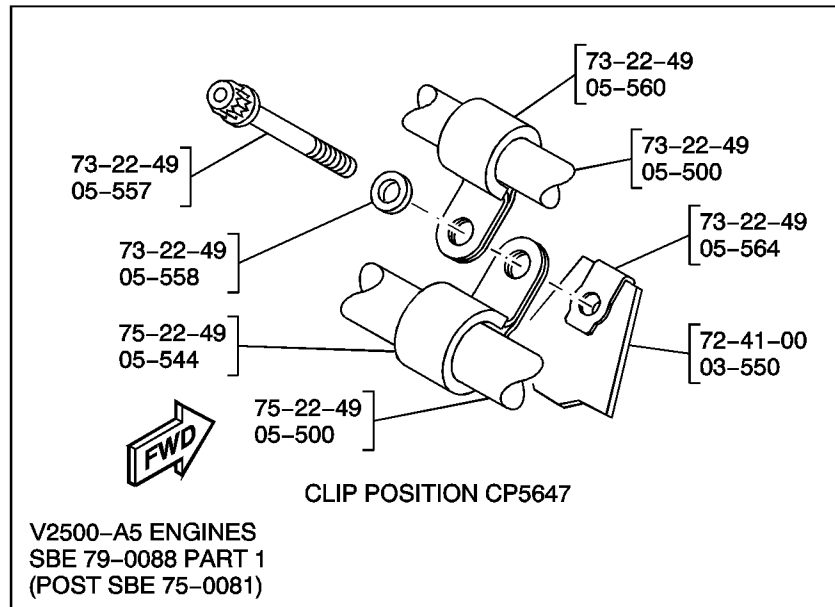


CLIP POSITION CP5643



CLIP POSITION CP5647
FOR V2500-A1 ENGINES
AND V2500-A5 ENGINES
SBE 79-0088 PART 2 AND 3
(PRE SBE 75-0081)

NOTE: ALL IPC FIG/ITEM
NUMBERS ARE 75-32-49
UNLESS IDENTIFIED
DIFFERENTLY.

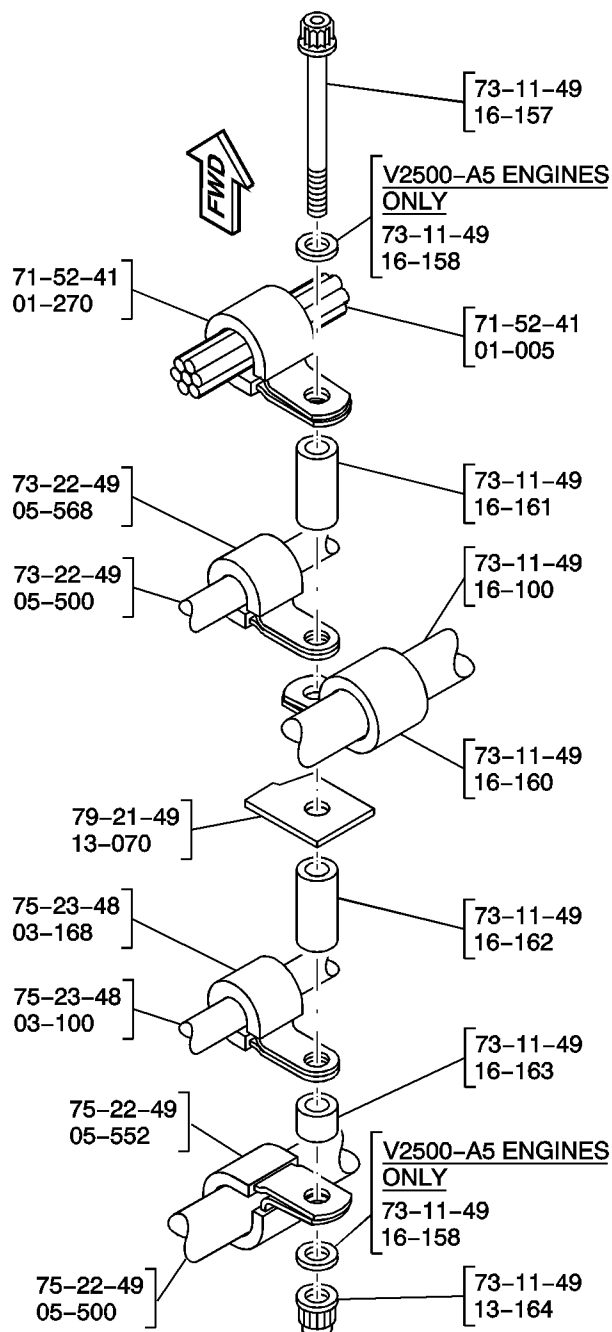
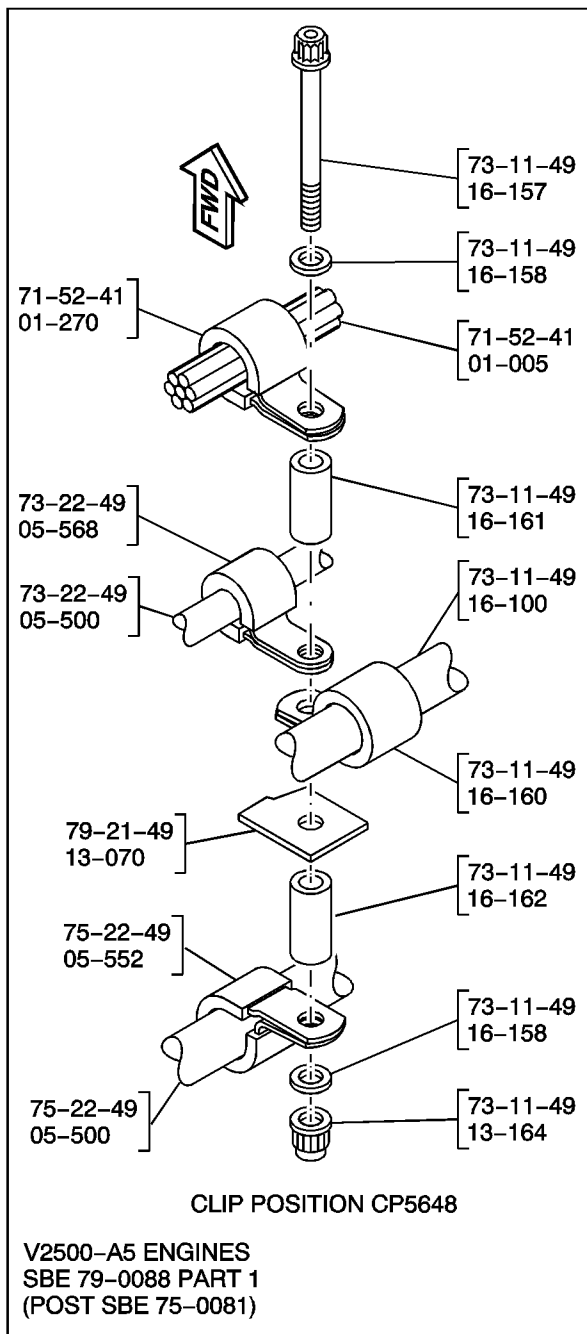


CLIP POSITION CP5647

V2500-A5 ENGINES
SBE 79-0088 PART 1
(POST SBE 75-0081)

Clip positions CP5643 and CP5647
Figure 41, Sheet 1

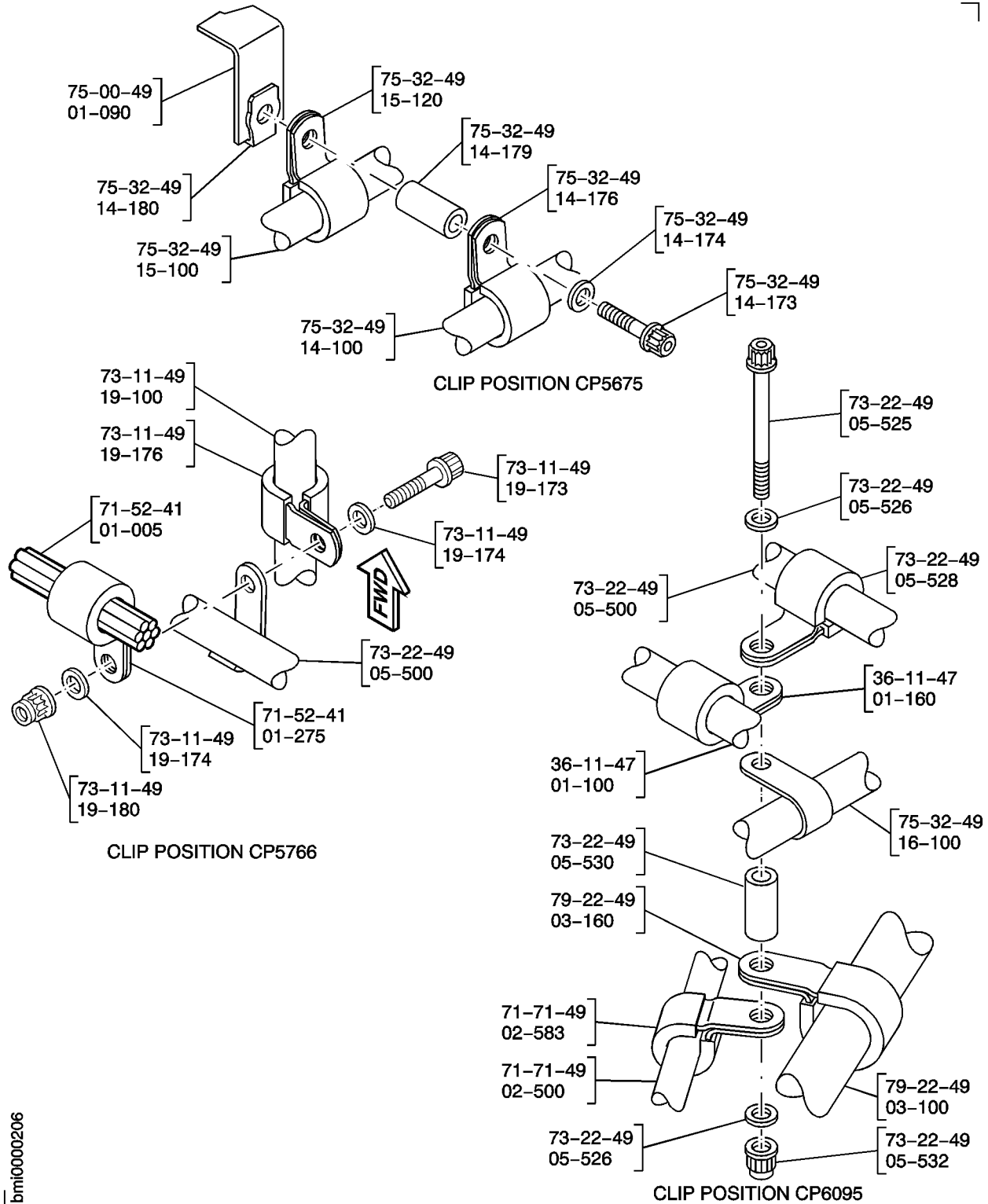
R



bmi0000241

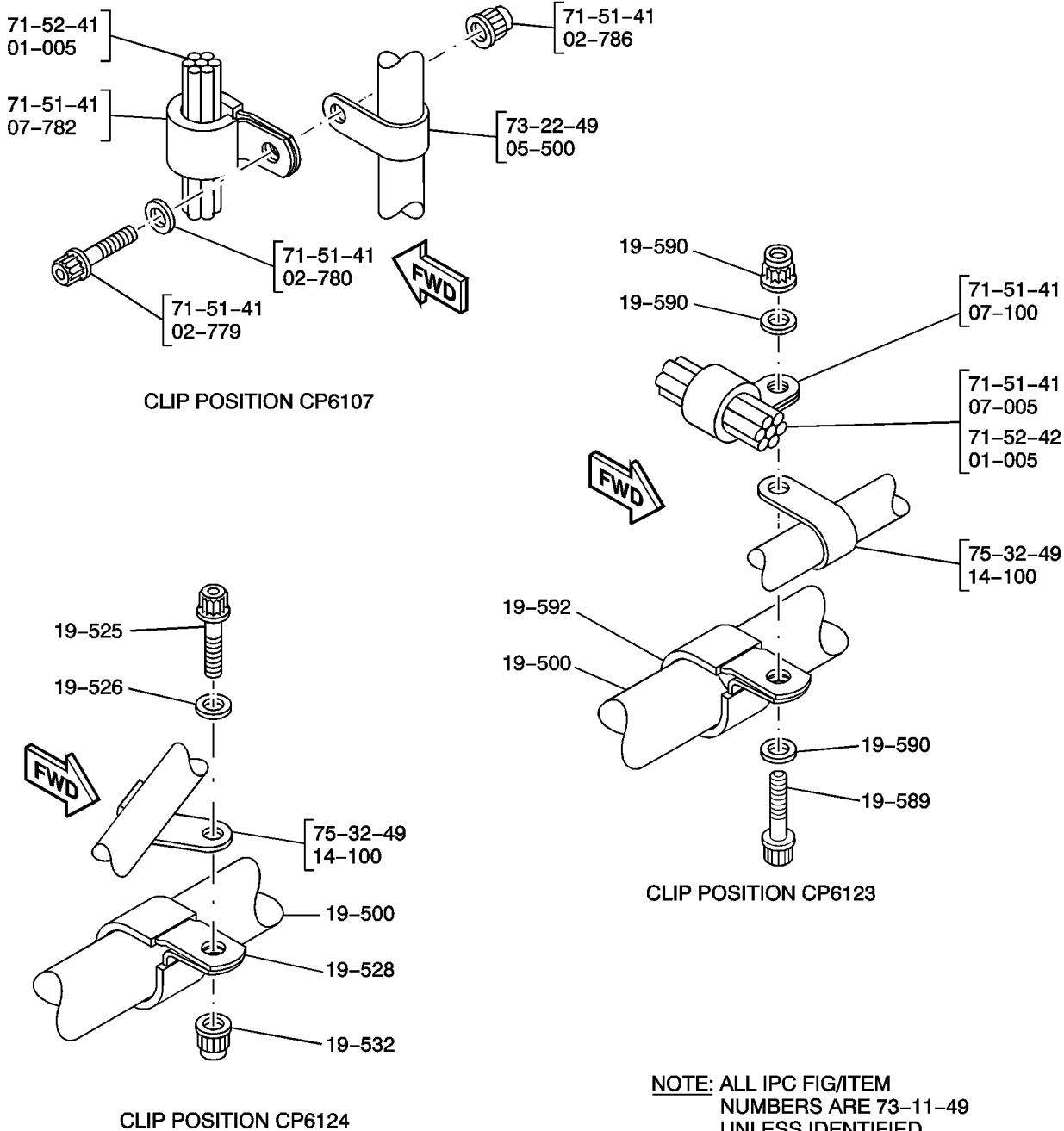
R
R

Clip position CP5648
Figure 41, Sheet 2



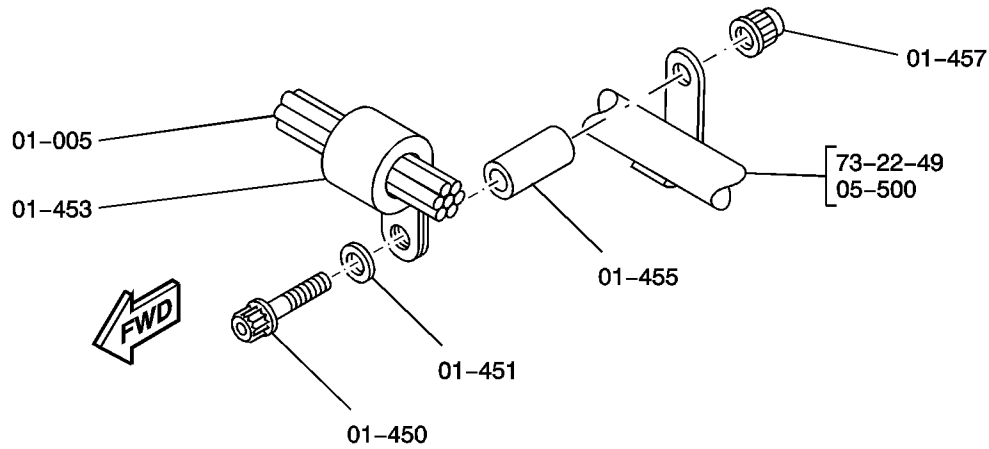
Clip positions CP5675, CP5766 and CP6095
Figure 42

FOR V2500-A5 ENGINES WITH SBE 75-0081 ONLY:



Clip positions CP6107, CP6123 and CP6124
Figure 43

bmi0000207



CLIP POSITION CP6112

NOTE: ALL IPC FIG/ITEM
NUMBERS ARE 71-52-41
UNLESS IDENTIFIED
DIFFERENTLY.

bmi0000208

Clip position CP6112
Figure 44

ENGINE FUEL AND CONTROL – FUEL SYSTEM AIR TUBE – INTRODUCTION OF RE-ROUTED BURNER TO
ENGINE ELECTRONIC CONTROLLER (EEC) PRESSURE (PB) SENSE LINE TUBE ASSEMBLIES

SUPPLEMENT – PRICES AND AVAILABILITY

The prices (if shown) are for estimating purposes only and as such are given in good faith, without commercial liability for advanced planning purposes only. Refer to IAE Spares and/or current price catalogue for current prices.

1. Modification Kit:

	Part No.	Description	Unit Price US Dollars
R	MKVA173019801	Modification Kit	13,850.00
R	MKVA573019801	Modification Kit	13,140.00

2. New Production Parts:

	Part No.	Description	Unit Price US Dollars
R	5W8351	Bracket	130.00
R	6A6212	Tube assembly	655.00
R	6A7398	Plug assembly	235.00
R	6A9039	Tube assembly	4,450.00
R	6A9040	Tube assembly	2,570.00
R	6A9041	Tube assembly	1,050.00
R	6A9042	Tube assembly	1,040.00
R	6A9043	Tube assembly	686.00
R	6A9044	Tube assembly	1,400.00
R	6A9045	Tube assembly	678.00
R	6A9096	Bracket	793.00
R	6A9098	Bracket	121.00
R	6A9123	Tube assembly	727.00

3. Tools

None.