



628 Hebron Avenue, Suite 400
 Glastonbury, CT 06033, USA.
 Tel: +1 (860) 368-3823
 Fax: +1 (860) 755-6876

DATE: Nov.17/11

V2500-A1 SERIES PROPULSION SYSTEM SERVICE BULLETIN

This document transmits the Revision 4 of Service Bulletin V2500-ENG-75-0001.

Document History

Service Bulletin Revision Status

Initial Issue	Apr.13/90.
Revision 1	Jan.18/91.
Revision 2	Nov.30/05.
Revision 3	Jul. 8/11.

Service Bulletin Revision 4

Remove	Incorporate	Reason for change
All Pages of the Service Bulletin.	Pages 1 to 12 of the Service Bulletin.	To update the Material Information.
All Pages of the Supplement.	Page 1 of the Supplement.	No change.

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CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
 If any have not been received please advise IAE International Aero Engines AG

IAE PROPRIETARY INFORMATION

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AIR – INTRODUCE A REVISED LPT ACC SUPPORT ASSEMBLY CONFIGURATION**1. Planning Information****A. Effectivity**

(1) Airbus A320

(a) V2500-A1 Engines prior to Serial No.V0073.

B. Concurrent Requirements

None.

C. Reason

(1) Condition

The current LP Turbine-ACC support assemblies configuration standard leads to long installation times.

(2) Background

This has been identified during engine build.

(3) Objective

The changes in configuration introduced by this bulletin are to ease assembly of the LP Turbine ACC system in order to reduce assembly time.

(4) Substantiation

Testing of the new ACC configuration was not required.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Affected (Refer to paragraph 1.0. Other Publications Affected).

(d) Repair Schemes

Affected (Refer to paragraph 1.C.(6) Supplemental Information).

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

(6) Supplemental Information

- (a) The Post-Service Bulletin configuration requires new assembly/disassembly procedures of ACC support assemblies on to/from the LPT cooling air duct assy.
- (b) The cleaning procedure for the Post-Service Bulletin configuration requires same standard practices to be used but support and half loop clamp will be cleaned in preassembled configuration.
- (c) The Post-Service Bulletin configuration requires inspection of the riveted connection.
- (d) The Post-Service Bulletin configuration requires a new repair scheme for replacement of rivets and riveted details.

D. Description

The changes introduced by this Service Bulletin are as follows:

The supports A/O and half loop clamps are preassembled with rivets at the front and rear ends.

Clip nuts are attached to the half loop clamps.

The supports have clip nuts at the front LP Turbine case attaching location.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

F. Approval

The part number changes and/or part modification described in Section 2 and 3 of this Service Bulletin has been shown to comply with the applicable Federal Aviation Regulations and is FAA-APPROVED for the engine model listed.

G. Manpower**(1) In Service**

Not applicable

(2) At Overhaul

The modified LPT ACC support assembly will take 20 minutes less to install.

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

H. Material Price and Availability

Modification kit not required; parts supplied as single line items.

For prices and availability of future spares refer to the Supplement of this Service Bulletin.

I. Tooling Price and Availability

Not applicable.

J. Industry Support Information

Not applicable.

K. Weight and Balance**(1) Weight Change**

None.

(2) Moment Arm

No effect.

(3) Datum

Engine front mount centerline (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) Internal Reference Nos. EC 87VM010, 88VM038, 87VM010-01 and 87VM010-02.
- (2) Engine Illustrated Parts Catalog, Chapter 75-24-49.
- (3) Aircraft Maintenance Manual, Chapter 75-24-49.
- (4) Engine Manual, Chapter 72-00-50.
- (5) ATA Locator - 75-24-49.

O. Other Publications Affected

- (1) Illustrated Parts Catalogue Chapter/Section 75-24-49, Figures 02, 03 and 04.
- (2) The V2500 Component Maintenance Manual, Tubes, Hoses and Ducts THD-V2500-1IA and THD-V2500-3IA, Chapter/Section 75-24-49 Disassembly/Assembly, will be revised to show the change introduced by this Service Bulletin.
- (3) V2500 Engine Manual, Chapter/Section 72-00-50 Removal 01 and Installation 07, will be revised to show the change introduced by this Service Bulletin.

P. Interchangeability of Parts

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

2. Material Information

A. The kit required consists of the following parts:

Not applicable.

B. Parts to be reworked

Not applicable.

C. New production parts:

Refer to the Supplement of this Service Bulletin

D. Redundant parts

None.

E. Parts affected by this Service Bulletin:

75-24-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
02-490	3A1749	1	.Support, Assy	3A0564	(A)(S1)(1D)
02-590	--	1	..Clamp, A/O Half Loop	3A0948	(B)
02-560	3A1742	1	..Clamp, A/O Half Loop	--	
02-450	--	10	.Nut, Option	776440	(F)
02-497	4W0043	10	..Nut, A/O Self Locking	--	(C)
02-080	--	4	.Nut, Option	776440	(F)
02-495	ST1300-14	2	..Rivet, Blind	--	(C)
02-460	--	10	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
02-460	4W0101	8	.Bolt, Machine Double Hex Hd	--	(C)
02-720	3A1752	1	.Support, Assy	3A0580	(A)(S1)(1D)
02-750	3A1742	1	..Clamp, A/O Half Loop	--	
02-770	--	1	..Clamp, A/O Half Loop	3A0948	(B)
02-670	--	10	.Nut, Option	776440	(F)
02-735	4W0043	10	..Nut, A/O Self Locking	--	(C)
02-730	ST1300-14	2	..Rivet, Blind	--	(C)
02-680	--	10	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
02-680	4W0101	8	.Bolt, Machine Double Hex Hd	--	(C)
03-490	3A1762	1	.Support, Assy	3A0573	(A)(S1)(1D)
03-590	--	1	..Clamp, A/O Half Loop	3A0948	(B)
03-560	3A1742	1	..Clamp, A/O Half Loop	--	
03-450	--	10	..Nut, Option	776440	(F)

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Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 15.119(b)(3).

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
03-507	4W0043	10	..Nut, A/O Self Locking	--	(C)
03-080	--	4	..Nut, Option	776440	(F)
03-505	ST1300-14	2	..Rivet, Blind	--	(C)
03-460	--	10	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
03-460	4W0101	8	.Bolt, Machine Double Hex Hd	--	(C)
03-720	3A1759	1	.Support, Assy	3A0677	(A)(S1)
03-770	--	1	.Clamp, A/O Half Loop	3A0948	(B)
03-740	3A1742	1	.Clamp, A/O Half Loop	--	
03-670	--	10	.Nut, Option	776440	(F)
03-727	4W0043	10	..Nut, A/O Self Locking	--	(C)
03-080	--	4	..Nut, Option	776440	(F)
03-725	ST1300-14	2	..Rivet, Blind	--	(C)
03-680	--	10	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
03-680	4W0101	8	.Bolt, Machine Double Hex Hd	--	(C)
04-010	3A1745	1	.Support, Assy	3A0568	(A)(C) (S1)(1D)
04-280	--	2	.Clamp, A/O Half Loop	3A0948	(B)
04-200	3A1742	1	.Clamp, A/O Half Loop	--	
04-215	3A1744	1	.Clamp, A/O Half Loop	--	(E)
04-230	--	20	..Nut, Option	776440	(F)
04-115	4W0043	18	..Nut, A/O Self Locking	--	(C)
04-070	--	2	..Nut, Option	776440	(F)
R 04-110	ST1300-14	4	..Rivet, Blind	--	(C)
04-240	--	20	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
04-240	4W0101	16	Bolt, Machine Double Hex Hd	--	(C)
04-410	3A1755	1	.Support, Assy	3A0577	(A)(S1)(1D)
04-680	--	2	.Clamp, A/O Half Loop	3A0948	(B)
04-610	3A1742	1	.Clamp, A/O Half Loop	--	
04-620	3A1744	1	.Clamp, A/O Half Loop	--	(E)
04-630	--	20	..Nut, Option	766440	(F)
04-597	4W0043	18	..Nut, A/O Self Locking	--	(C)
04-470	--	2	..Nut, Option	776440	(F)
04-595	ST1300-14	4	..Rivet, Blind	--	(C)
04-640	--	20	.Bolt, Machine Double Hex Hd	MS9696-06	(F)
04-640	4W0101	16	.Bolt, Machine Double Hex Hd	--	(C)

F. Instructions disposition codes:

(A) Old Part is not longer available for sale.

(B) Part is available for sale until stock is exhausted.

(C) New Part currently available for sale.

(E) Old Part is not longer available for sale. New part belongs to the new support assembly, and are available for sale as a single line item.

(F) Old Part is available for other applications.

(S1) Parts are interchangeable as a set by Support/Bracket Location.

(1D) Old Part can not be reworked.

3. Accomplishment Instructions

A. Rework Instructions

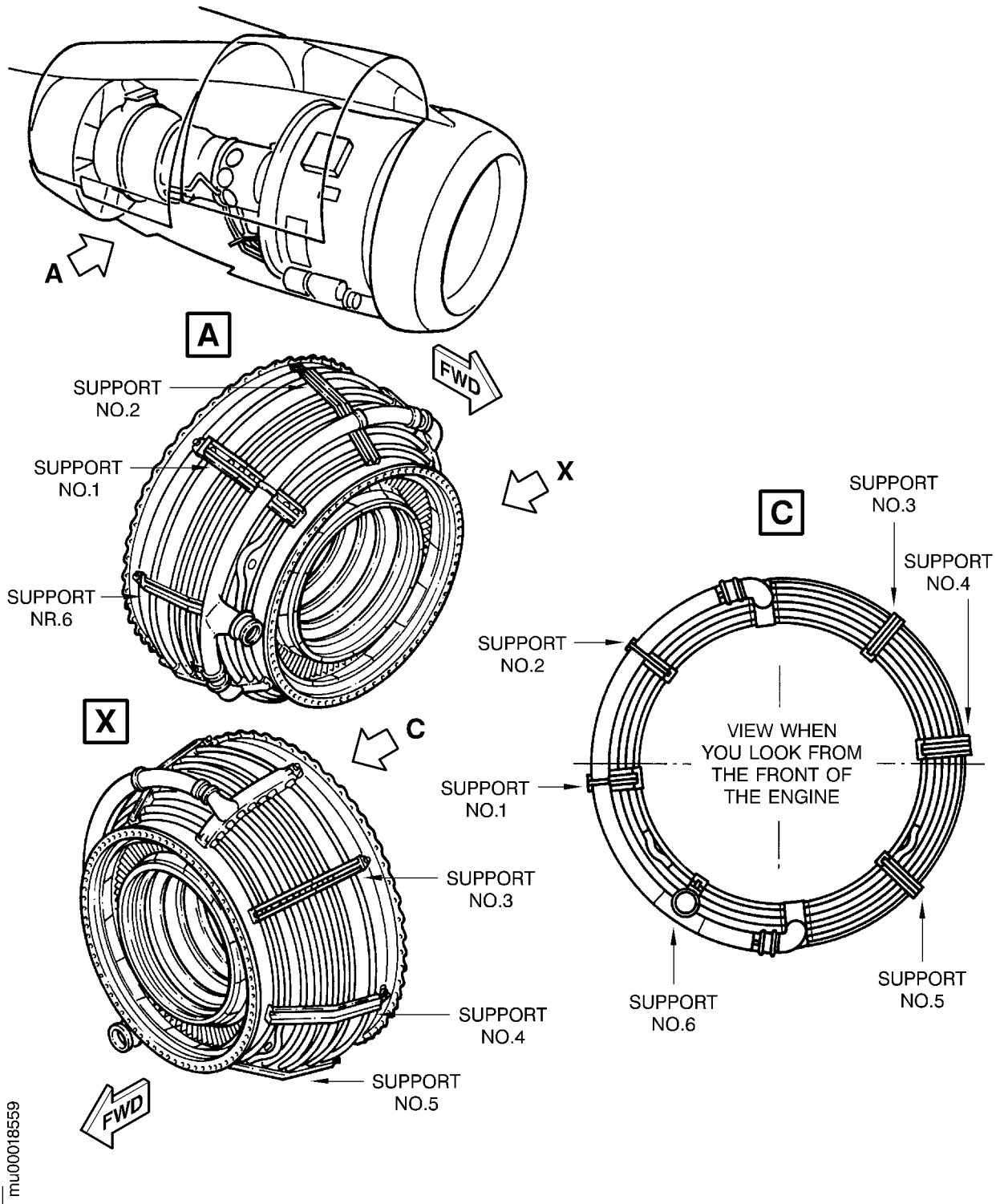
Not applicable.

B. Assembly Instructions

For assembly instructions refer to the Component Maintenance Manual Pub.Ref.No. THD-V2500-1IA for A1/A5 Engines and Pub.Ref. No. THD-V2500-3IA for D5 Engines.

C. Recording Instructions

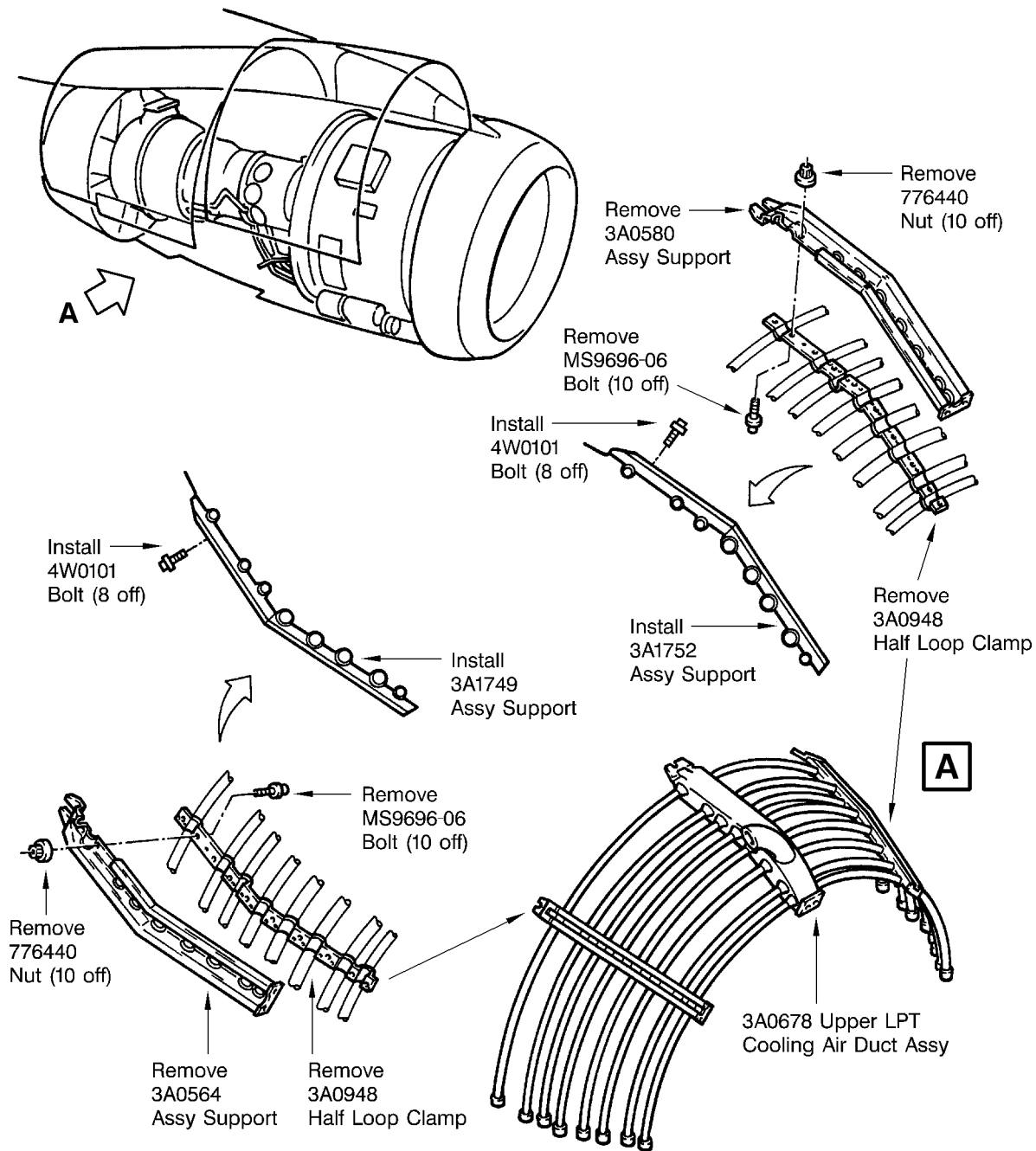
A record of accomplishment is required.



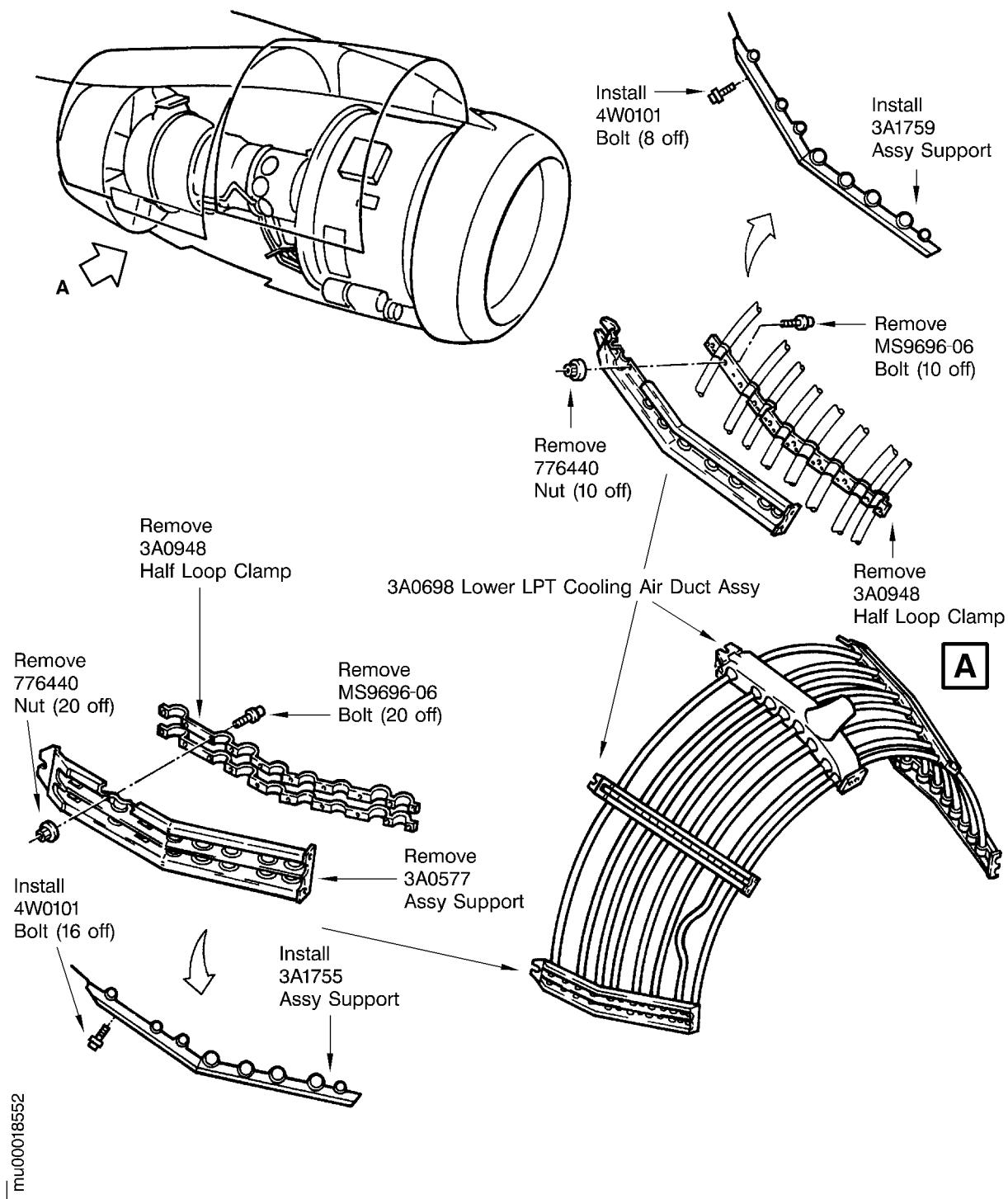
Location of LP Turbine Support Assemblies
Fig.1

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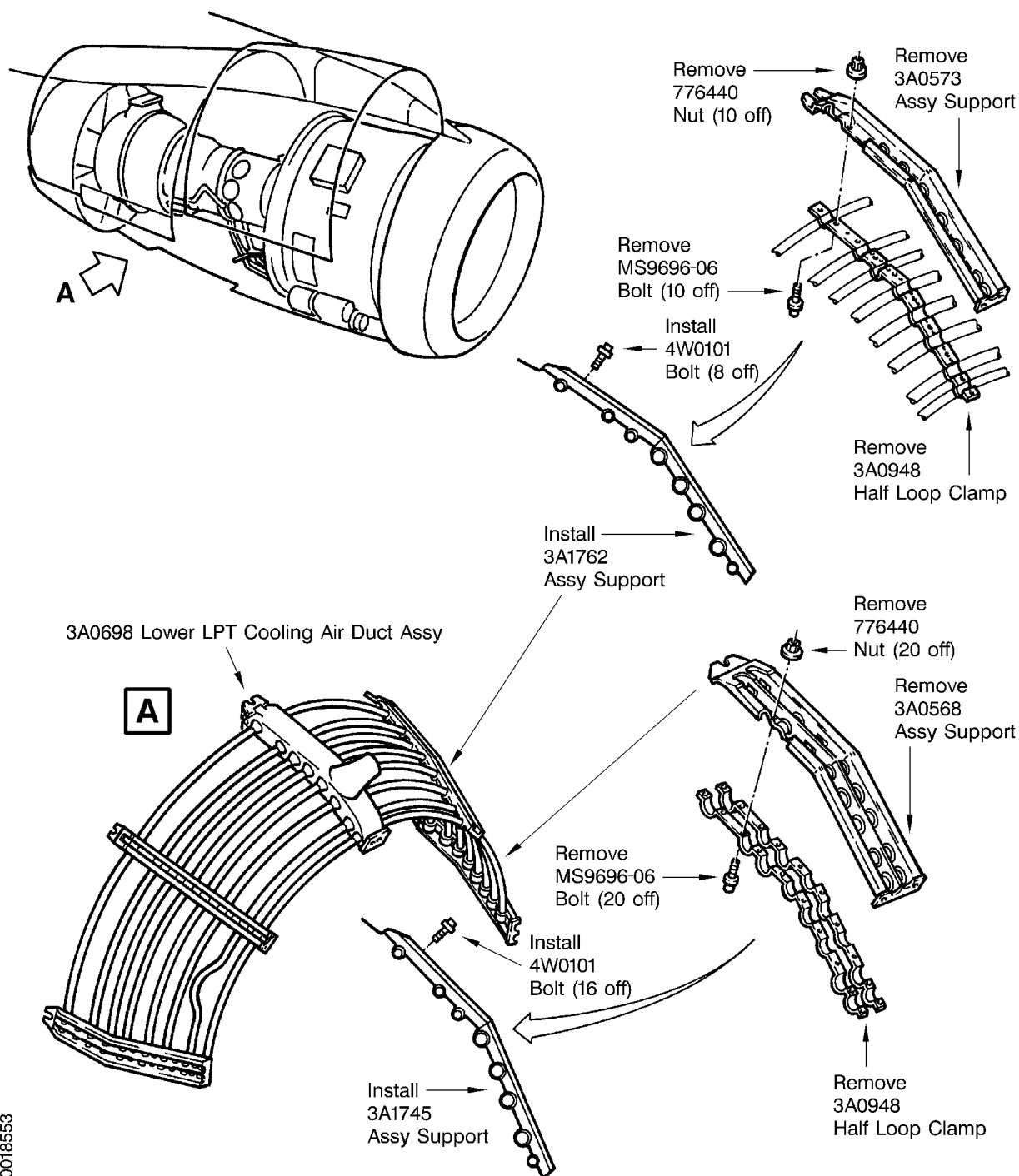
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Removal and Installation of Support Assemblies
Fig.2



Removal and Installation of Support Assemblies
Fig.3 (sheet 1 of 2)



Removal and Installation of Support Assemblies
Fig.3 (sheet 2 of 2)

AIR – INTRODUCE A REVISED LPT ACC SUPPORT ASSEMBLY CONFIGURATIONSUPPLEMENT – PRICES AND AVAILABILITY

The prices 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:

Not applicable.

2. Parts required:

Part No.	Description	Unit Price US Dollars
3A1749	Support, Assy	2,361.00
3A1742	Clamp, A/O Half Loop	1,565.00
4W0043	Nut, A/O Self Locking	5.01
ST1300-14	Rivet, Blind	10.90
4W0101	Bolt, Machine, Dbl Hx Hd	13.60
3A1752	Support, Assy	1,914.00
3A1759	Support, Assy	2,337.00
3A1745	Support, Assy	3,685.00
3A1744	Clamp, A/O Half Loop	931.00
3A1755	Support, Assy	3,270.00
3A1762	Support, Assy	2,642.00
3A0948	Clamp, A/O Half Loop	408.00

Parts are currently available for sale.



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- General quality rating of this Service Bulletin	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Quality rating of the Accomplishment Instructions	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Quality rating of the Illustration	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Is this Service Bulletin easy to understand ?	<input type="checkbox"/> Yes		<input type="checkbox"/> No		

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<input type="checkbox"/> 1.F.	<input type="checkbox"/> 1.N.	<input type="checkbox"/> 2.F.	<input type="checkbox"/> Close the Access
<input type="checkbox"/> 1.G.	<input type="checkbox"/> 1.O.		<input type="checkbox"/> Log Book Entry
<input type="checkbox"/> 1.H.	<input type="checkbox"/> 1.P.		

Explanatory notes:

Operator:	Overhaul Site:
Name/Title:	Date:

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