



AIR - HPT/LPT ACC SYSTEM - IMPROVED CONNECTION OF THE ACC ACTUATOR AND THE STATOR ROD
- CATEGORY CODE 4 - MOD.ENG-75-0009

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engine serial numbers prior to V0107 which have not incorporated Service Bulletin V2500-ENG-72-0074.

B. Reason

(1) Condition

Existing bushing tolerances may result in difficulty during installation of the ACC actuator clevis.

(2) Background

New parts for connection of the ACC actuator and the stator rod have been provided. A stepped reamer bolt replaces one of two bushes.

(3) Objective

To ease installation of the ACC actuator clevis by replacing connecting parts for the connection of the ACC actuator clevis and stator rod.

(4) Substantiation

Substantiation is analytically completed to have no effect on durability and strength.

(5) Effects of Bulletin on the following shop functions:

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

(6) Supplemental Information

- (a) The Post-Service Bulletin configuration requires revision of the manuals to add the new Removal/Installation procedure for Post-Service Bulletin configuration to the existing procedures. Affected manuals are as follows:

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Aircraft Maintenance Manual
Chapter/Section 75-24-52 Removal/Installation

Engine Manual
Chapter/Section 72-00-40 Removal/Installation

(b) Dimensional and visual inspection for stepped are of 5W2093 Bolt introduced by this Service Bulletin will be added in the Inspection/Check of Engine Manual.

(c) This Service Bulletin is not effective for any engines that have accomplished V2500 Service Bulletin No.V2500-ENG-72-0074.

C. Description

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

(a) 5W2093 Bolt superseded old NAS6704DU20 Bolt.

(b) One of two 5W2061 Bushes (75-24-51, 01-555) is reduced.

D. Approval

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

E. Compliance

Category Code 4

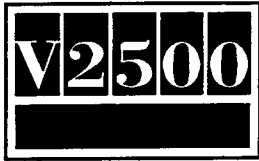
Accomplish at the first visit of an engine or a module to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action or the reason for engine removal.

F. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In Service	TOTAL 1 hour 23 minutes
(a) To gain access	
(i) Open fan cowl doors	17 minutes
(ii) Open 'C' ducts	18 minutes
TOTAL	35 minutes

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- (b) To embody
- (i) Remove the bush 5 minutes
 - (ii) Install new bolt.. .. 3 minutes
- TOTAL 8 minutes

- (c) To return to flyable status
- (i) Close 'C' duct 21 minutes
 - (ii) Close fan cowls 19 minutes
- TOTAL 40 minutes

(2) At Overhaul Not applicable

G. Material – Price and Availability

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

H. Tooling – Price and Availability

The following tool is required to accomplish Sub-Division 2 of this Bulletin.

Tool No.	Qty	Description	Function	Avail.
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New tools required:

IAE1J13504	1	Puller	Remove Bushes	(1)
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(1) Indicates that the Tool Design Aperture Cards will be available from IAE.

I. Weight and Balance

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

J. Electrical Load Data

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



K. References

(1) Internal Reference No.

89VJ016

(2) Other References

Aircraft Maintenance Manual; 71-13-00 Maintenance Practices, 78-32-00 Maintenance Practices and 75-24-52 Removal/Installation

V2500 Engine Manual; 70-00-40 Removal/Installation

V2500 Service Bulletin; V2500-ENG-72-0074

L. Other Publications Affected

(1) V2500 Illustrated Parts Catalog, 75-24-51

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2. Accomplishment Instructions

A. Prerequisite Instructions

- (1) open the Fan Cowls. (Refer to TASK 71-13-00-010-010, Aircraft Maintenance Manual).
- (2) Open the Thrust Reverser halves. (Refer to TASK 78-32-00-010-010, Aircraft Maintenance Manual).

B. Replacement Instructions, refer to Figure 1.

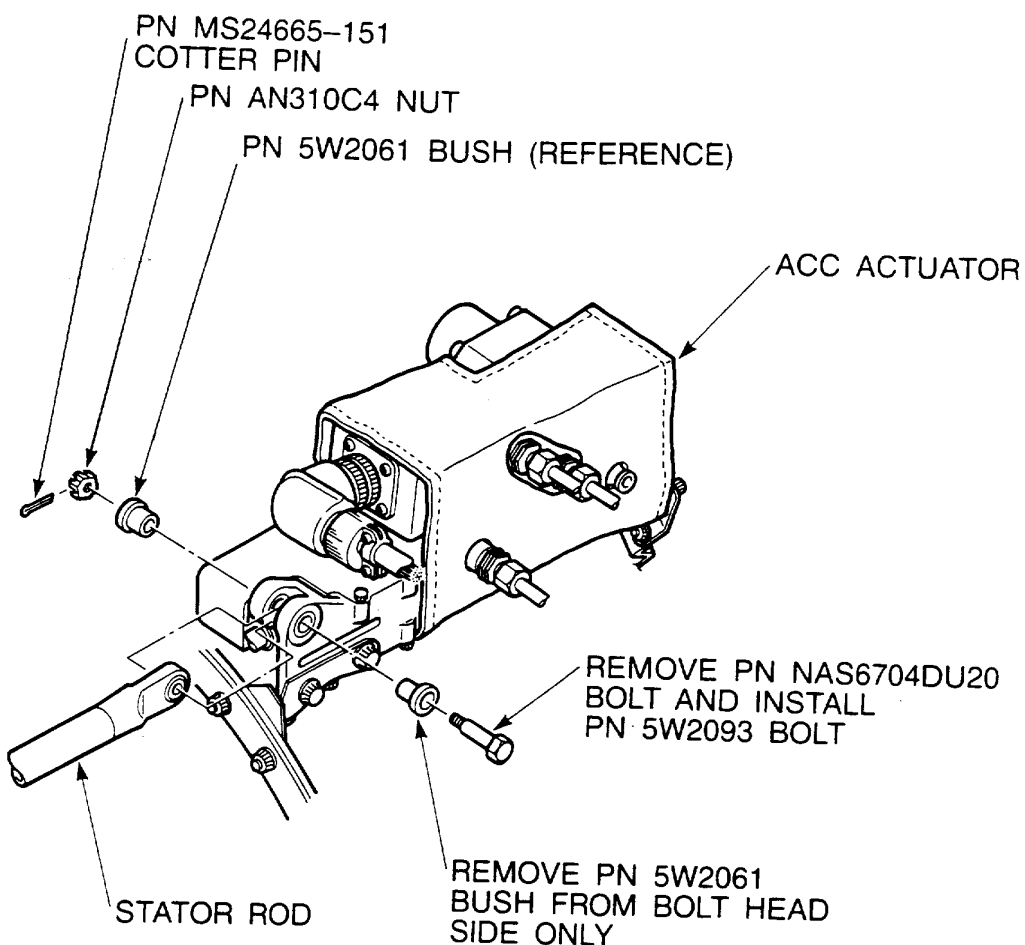
- (1) Disconnect 5W8232 or 5W2096 Stator Rod from the ACC actuator.
 - (a) Remove MS24665-151 Cotter Pin, AN310C4 Nut and NAS6704DU20 Bolt.
- (2) Remove 5W2061 Bush from the ACC actuator.
 - (a) Draw the bush using the Puller, IAE1J13504.
- (3) Put the stator rod between the clevis of the ACC actuator.
- (4) Connect the stator rod.
 - (a) Align the holes of the stator rod and the clevis of ACC actuator. Install 5W2093 Bolt and AN310C4 nut.
 - (b) Torque the Nut to 32.5 to 42.5 lbfin (3,67 to 4,8 Nm).
 - (c) safety the nut with a new MS24665-151 Cotter Pin.

C. Postrequisite Instructions

- (1) Close the Thrust Reverser Halves. (refer to TASK 78-32-00-410-010, Aircraft Maintenance Manual).
- (2) Close the Fan Cowls. (Refer to TASK 71-13-00-410-010, Aircraft Maintenance manual).

D. Recording Instructions

- (1) A record of accomplishment is required.



Replacement of bolt and removal of bush
Fig.1

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Printed in Great Britain

3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
5W2093 (75-24-51)	1	14.50	Bolt, reamer	NAS6704DU 20 (01-505)	(S1)(A)
5W2061 (75-24-51)	1	21.00	Bush	5W2061 (01-555)	(S1)(B)

C. Instruction/Disposition Code Statements:

- (A) New part is currently available.
- (B) Quantity of part number 5W2061 decreased from 2 to 1.
- (S1) New part incorporation and part removal should be accomplished as a set.

D. Expendables required to incorporate this Bulletin

MS24665-151 1 Pin, Cotter
(75-24-51)

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

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