



SERVICE BULLETIN

AIR - ENGINE - HP/LP ACTIVE CLEARANCE CONTROL DUCTS - TO PROVIDE A FRONT DUCT COVER ASSEMBLY FOR CONTROLLED SERVICE USE - NOT APPLICABLE - MOD.ENG-75-0025

1. Planning Information

A. Effectivity

(1) Aircraft: Airbus A320

(2) Engine: V2500-A1 Engines, Serial No.s V0011, V0049, V0046, V0058, V0064, V0074, V0082, V0085, V0089, V0100, V0108, V0114, V0116 through V0120 and V0122 through V0179.

B. Reason

To provide a Front Duct Cover Assembly (Restrictor Plate), for the Active Clearance Control (ACC) Valve, that reduces the HPT ACC cooling air to the HPT Case. The Restrictor Plate is provided for specified new engines before the first flight, to reduce the Stage 1 HPT Blade rub which has shown to decrease the EGT margin. Heavy Stage 1 HPT Blade rub was found because of the current schedule in the Electronic Engine Control. This schedule will be changed in a future revision to the Electronic Engine Control, at which time the Restrictor Plate will be removed.

C. Compliance

Category Code

Not Applicable

This Service Bulletin is released for purposes of controlled service introduction.

D. Approval

The requirements specified in Paragraph 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. References

(1) Internal Reference No.

90VA145

(2) Other References

V2500-ENG-75-0025



International Aero Engines

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V2500 Aircraft Maintenance Manual

V2500 Standard Practices Manual

Printed in Great Britain

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2. Accomplishment Instructions

A. Pre-requisite Instructions

- (1) On aircraft panel 115VU, put a warning notice to tell the persons not to start the engine.
- (2) On the aircraft panel 50VU, make sure that the 'ON' legend on the ENG FADEC GND PWR push button switch is OFF and install a warning notice.
- (3) Open the Fan Cowls by the use of the approved procedure in Reference (1), Chapter/Section 71-13-00, (TASK 71-13-00-010-010).
- (4) Open the Thrust Reverser Halves by the use of the approved procedure in Reference (1), Chapter/Section 78-32-00, (TASK 78-32-00-010-010).

B. Action

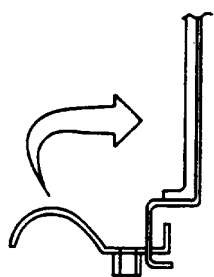
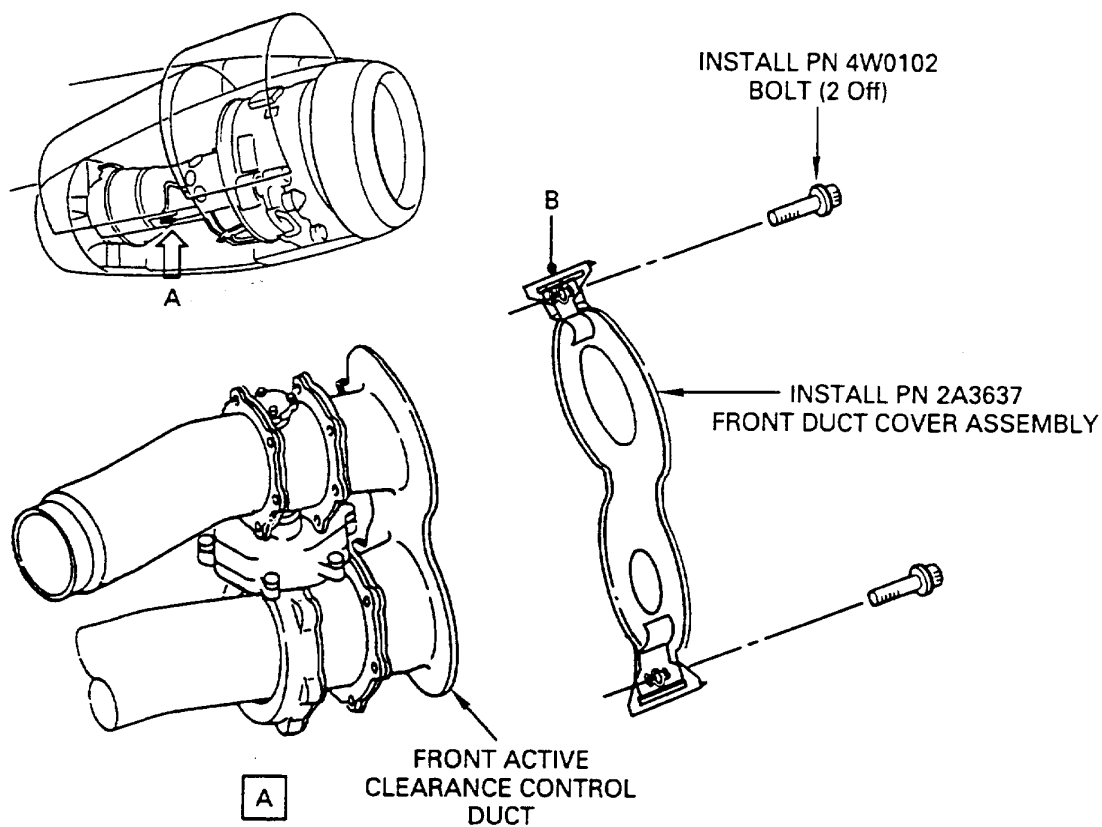
- (1) Locate the Front Active Clearance Control Duct. Refer to Figure 1.
- (2) Install the new 2A3637 Front Duct Cover Assembly (1 off) on the front flange of the Front Active Clearance Control Duct. Refer to Figure 1.
- (3) Lubricate the threads of the 4W0102 Bolts (2 off) with CoMat 10-039 Engine Oil.
- (4) Install the 4W0102 Bolts in the Front Duct Cover Assembly and tighten with your fingers. Refer to Figure 1.
- (5) Torque the Bolts to 36 - 45 lbfin (4,0 - 5,0 Nm) by the approved procedure in Reference (2), Chapter/Section 70-41-00, Torque Tightening Technique.

C. Post-requisite Instructions

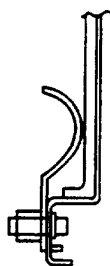
- (1) Close the Thrust Reverser Halves by the use of the approved procedure in Reference (1), Chapter/Section 78-32-00, (TASK 78-32-00-410-010).
- (2) Close the Fan Cowls by the use of the approved procedure in Reference (1), Chapter/Section 71-13-00, (TASK 71-13-00-410-010).
- (3) Remove the warning notice(s).

D. Recording instructions

- (1) A record of accomplishment is necessary.



B
BEFORE BOLT
INSTALLATION



B
AFTER BOLT
INSTALLATION

B5009

Location of the front duct cover assembly
Fig.1

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3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
2A3637 (75-24-47)	1	-	Cover Assembly, Duct Front	- (01-070)	(A)
4W0102 (72-45-23)	2	-	Bolt Option Consisting of:	- (01-075)	(A)
AS21407			Bolt		
MS9556-05			Bolt		

C. Consumables Required to Incorporate this Bulletin:

CoMat 10-039 Engine Oil

D. Instruction/Disposition Code Statements:

(A) New part is currently available.

NOTE: The estimated 1991 unit price 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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