AIR - HP COMPRESSOR STAGE-7 BLEED VALVES - INTRODUCTION OF CHEVRON SEALS - CATEGORY CODE 4 - MOD.ENG-75-0053

1. Planning Information

A. Effectivity

(1) Aircraft:
(a) Airbus A320.
(b) Airbus A321.
(c) Boeing-Douglas MD-90.

(2) Engines:
(a) V2500-A1 Engines prior to Serial No. V0362.
(b) V2522-A5 Engines prior to Serial No. V10117.
(c) V2524-A5 Engines prior to Serial No. V10117.
(d) V2527-A5 Engines prior to Serial No. V10117.
(e) V2527E-A5 Engines prior to Serial No. V10117.
(f) V2530-A5 Engines prior to Serial No. V10117.
(g) V2525-D5 Engines prior to Serial No. V20026.
(h) V2528-D5 Engines prior to Serial No. V20026.

B. Concurrent Requirements

None.

C. Reason

Problem

The valves of the HP Compressor bleed-valves can stick on in-service engines.

(2) Evidence

Dry contamination of the triple seals in the valve body and piston can cause the valves to stick. When the valves stick in the closed position, it can be difficult to start the engine. If the valves stick in the open position it can result in an EGT shift and a loss of the EGT margin.

(3) Substantiation

Contamination and vibration tests have been successfully carried out on the changes introduced by this Service Bulletin.

(4) Objective

The purpose of this Service Bulletin is to improve unit reliability.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) This Service Bulletin contains the installation of Stage-7 bleed valves for the HP Compressor which embody the dunlop modification E592, the changes are as follows:

(a) To prevent the valves sticking a new chevron seal is installed on the Stage-7 bleed valves.

(b) Units that embody this Service Bulletin will be identified by the Type Number AC69924.

E. Compliance

Category Code 4.

Accomplish at the first at the first visit of an engine or module to a maintenance base that can comply with the accomplishment instructions. Accomplish regardless of the planned maintenance or the reason for engine removal.

F. Approval

The part number changes and/or part modification are given in Sections 2 and 3 of this Service Bulletin. They comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine models listed.

G. Manpower

Estimate of man-hours necessary to embody this Service Bulletin in full:

(1) In Service

(a)	To get access:	35 Minutes
(b)	To embody:	Refer to the Dunlop Service Bulletin 75-30
(c)	To return the aircraft ser iceable status:	40 Minutes
	Total:	1 Hour 15 Minutes

(2) At Overhaul

(a)	To embody:	Refer to the Dunlop Service Bulletin 75-30

H. Material - Price and Availability

A modification kit is not necessary.

I. Tooling - Price and Availability

Special tools are not necessary.

J. Weight and Balance

(1) Weight Change

None.

(2) Moment arm

Not affected.

(3) Datum

Engine front mount centreline (Power Plant Station (PPS) 100).

K. Electrical Load Data

The aircraft electrical load is not affected by this Service Bulletin.

L. References

(1) Internal Reference No.

EC94VR047

(2) Other References

A320/A321 Aircraft Maintenance Manual (AMM), TASKS: 71-00-00-710-017; 71-13-00-010-010; 71-13-00-410-010; 73-32-00-010-010; 73-32-410-010; 75-32-52-000-010; 75-32-52-000-011; 75-32-52-000-012; 75-32-52-400-010; 75-32-52-400-011 and 75-32-52-400-012.

MD-90 Aircraft Maintenance Manual (AMM), Chapter/Sections: 71-00-00, Adjustment/Test; 71-13-00, Maintenance Practices; 75-33-52, Removal/ Installation and 78-32-00, Maintenance Practices.

Dunlop Service Bulletin 75-30.

IAE V2500 Service Bulletin:

ENG 75-0040 AIR - HP COMPRESSOR STAGE-7 AND STAGE-10 BLEED VALVES - INTRODUCTION OF AN IMPROVED CENTER BUSH.

Airbus modification 26873 and Airbus Service Bulletin A320-75-1003. (V2500-A1, V2527 and V2530-A5 only).

M. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC), Chapter/Section 75-32-52.

2. Material Information

A. Kits necessary for this Service Bulletin:

None.

B. Parts affected by this Service Bulletin:

NEW PART No. (ATA No.)	QTY	EST'D UNIT PRICE ($)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
AC69924 (75-32-52)	3		.Bleed valve Stage-7, HP Compressor	AC69859 (01-100)	(A)(B)(1D) (S1)

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For actual prices, refer to IAE Price Catalog or contact IAE's spare parts sales department.

C. Instruction disposition codes:

(1) (A) New part is available.

(2) (B) Old part is not available.

(3) (1D) Old part can be reworked and re-identified with the new part number.

(4) (S1) New part can replace the old part but the old part cannot replace the new part.

3. Accomplishment Instructions

A. Rework Instructions

(1) For the correct rework instructions refer to the the vendor Service Bulletin at 1.L.(3).

B. Assembly Instructions

(1) Job Set-up Instructions

(a) On the aircraft panel 115VU, put a warning notice to tell persons not to start the engine.

(b) Make sure that the engine has been stopped for at least 15 Minutes.

(c) On the aircraft panel 50VU, make sure that the ENG FADEC GND PWR push button switch is set to OFF and install a warning notice.

(d) Open the left and right fan cowl doors. (Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASK 71-13-00-010-010).

or

(e) Open the upper and lower fan cowl doors. (Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section 71-13-00, Maintenance Practices).

(f) Open the left and right thrust reverser halves. (Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASK 78-32-00-010-010).

or

(g) Open the upper and lower thrust reverser halves. (Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section 78-32-00 Maintenance Practices).

(2) Remove the three Stage-7 bleed valves from the HP Compressor.

(a) Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASKS 75-32-52-000-010, 75-32-52-000-011 and 75-32-52-000-012.

or

(b) Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Sections 75-32-52, Removal/Installation.

(3) Rework the Stage-7 bleed valves. (Refer to the vendor Service Bulletin at 1.L.(3)).

(4) Install the three Stage-7 bleed valves on the HP Compressor.

(a) Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASKS 75-32-52-400-010, 75-32-52-400-011 and 75-32-52-400-012.

or

(b) Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Sections 75-33-52, Removal/Installation.

(5) Job Close-out Instructions

(a) Close the left and right thrust reverser halves. (Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASK 78-32-00-410-010).

or

(b) Close the upper and lower thrust reverser halves. (Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section 78-32-00 Maintenance Practices).

(c) Close the left and right fan cowl doors. (Refer to the A320/A321 Aircraft Maintenance Manual (AMM), TASK 71-13-00-410-010).

or

(d) Close the upper and lower fan cowl doors. (Refer to the MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section 71-13-00, Maintenance Practices).

(e) Remove the warning notices from the aircraft panels 50VU and 115VU.

(6) Test

(1) Do a test of the three Stage-7 bleed valves of the HP Compressor, refer to:

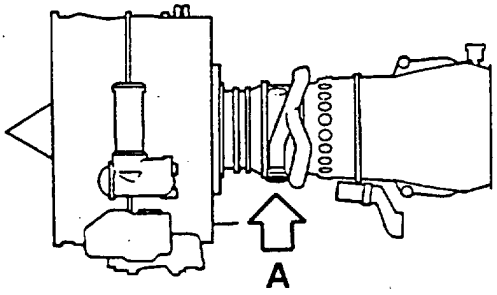
(a) The A320/A321 Aircraft Maintenance Manual (AMM), TASK 71-00710-017

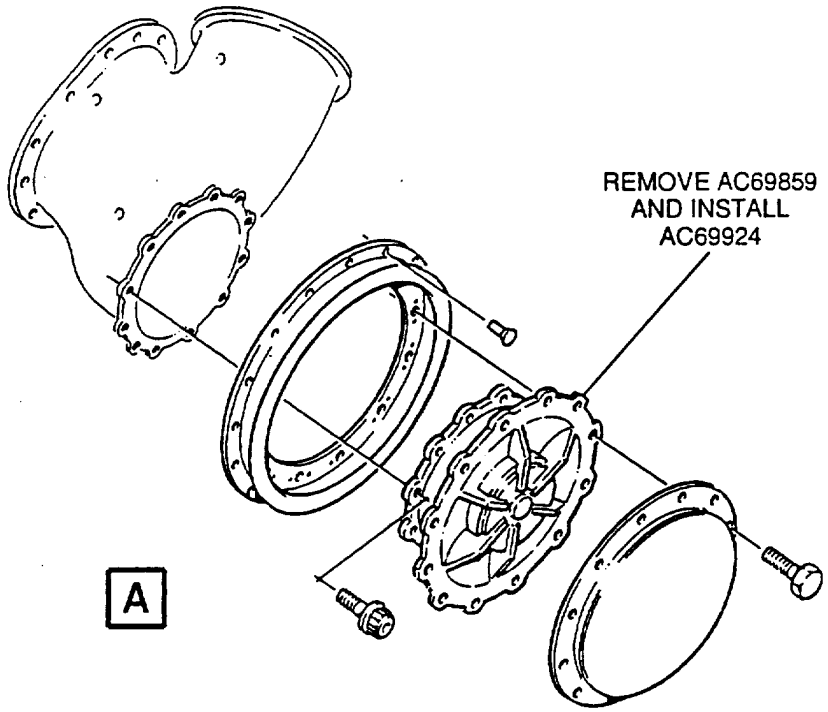
or

(b) The MD-90 Aircraft Maintenance Manual (AMM), TASK 71-00-00, Adjustment/Test.

C. Recording Instructions

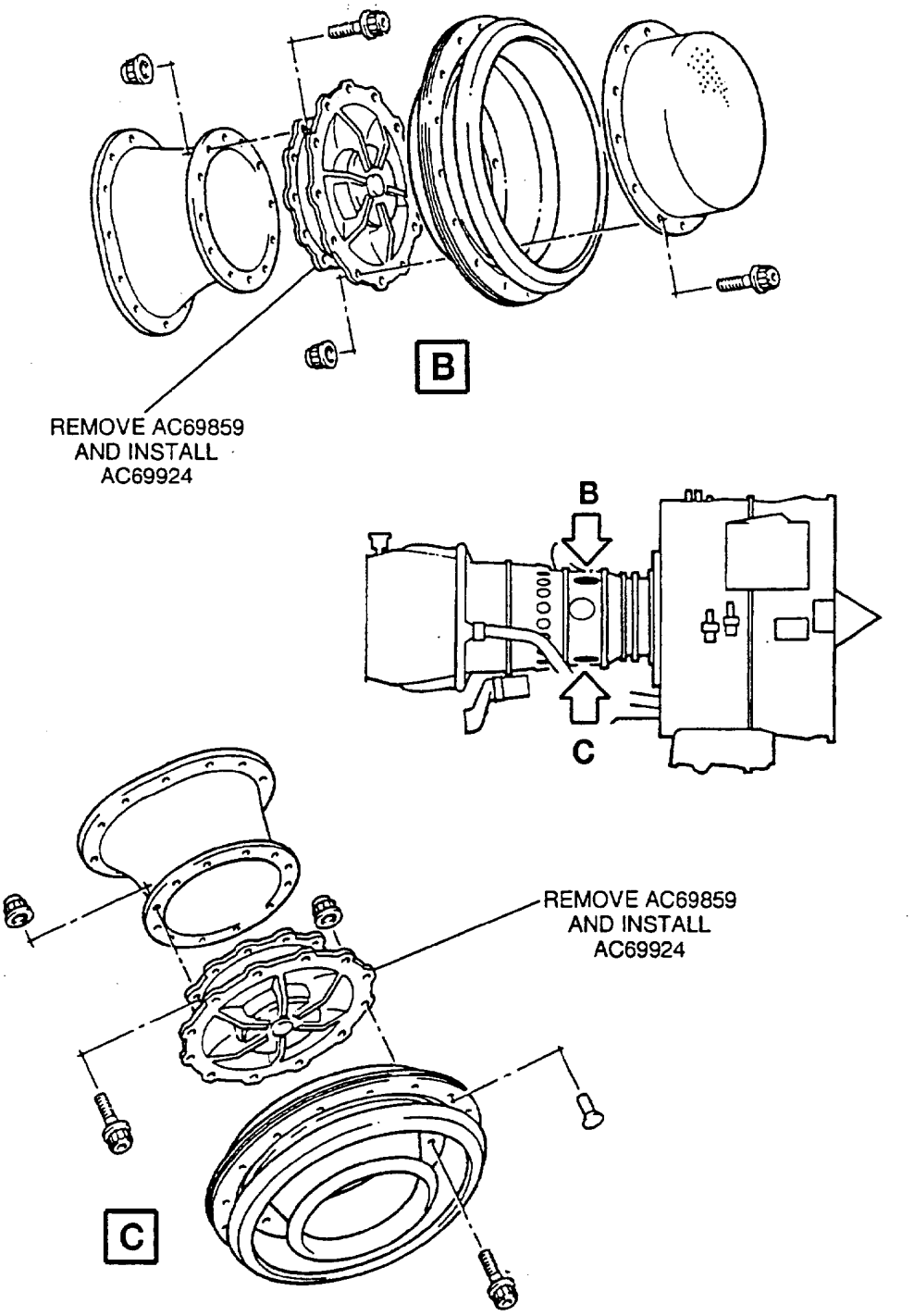
A record of accomplishment is necessary.



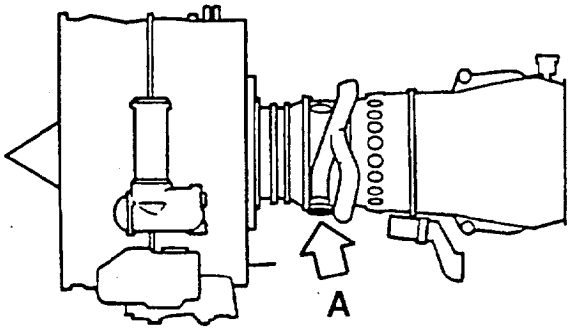


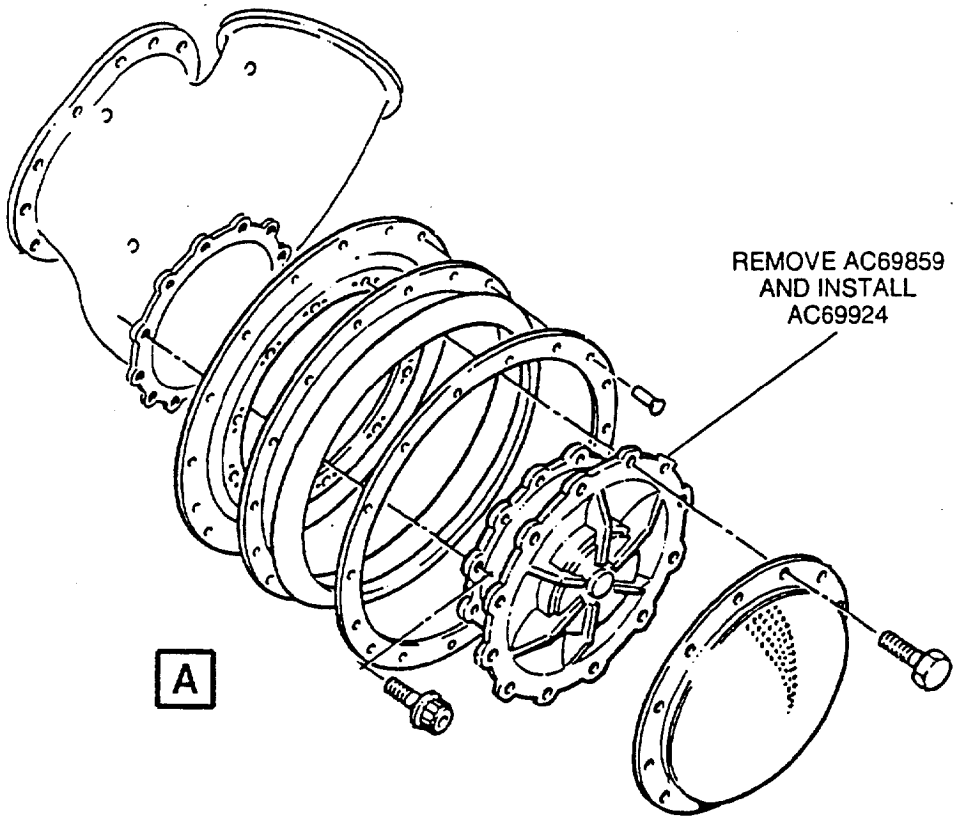
ded0002902

Location of the LH Stage-7 bleed valves - A1 Engines
Fig.1



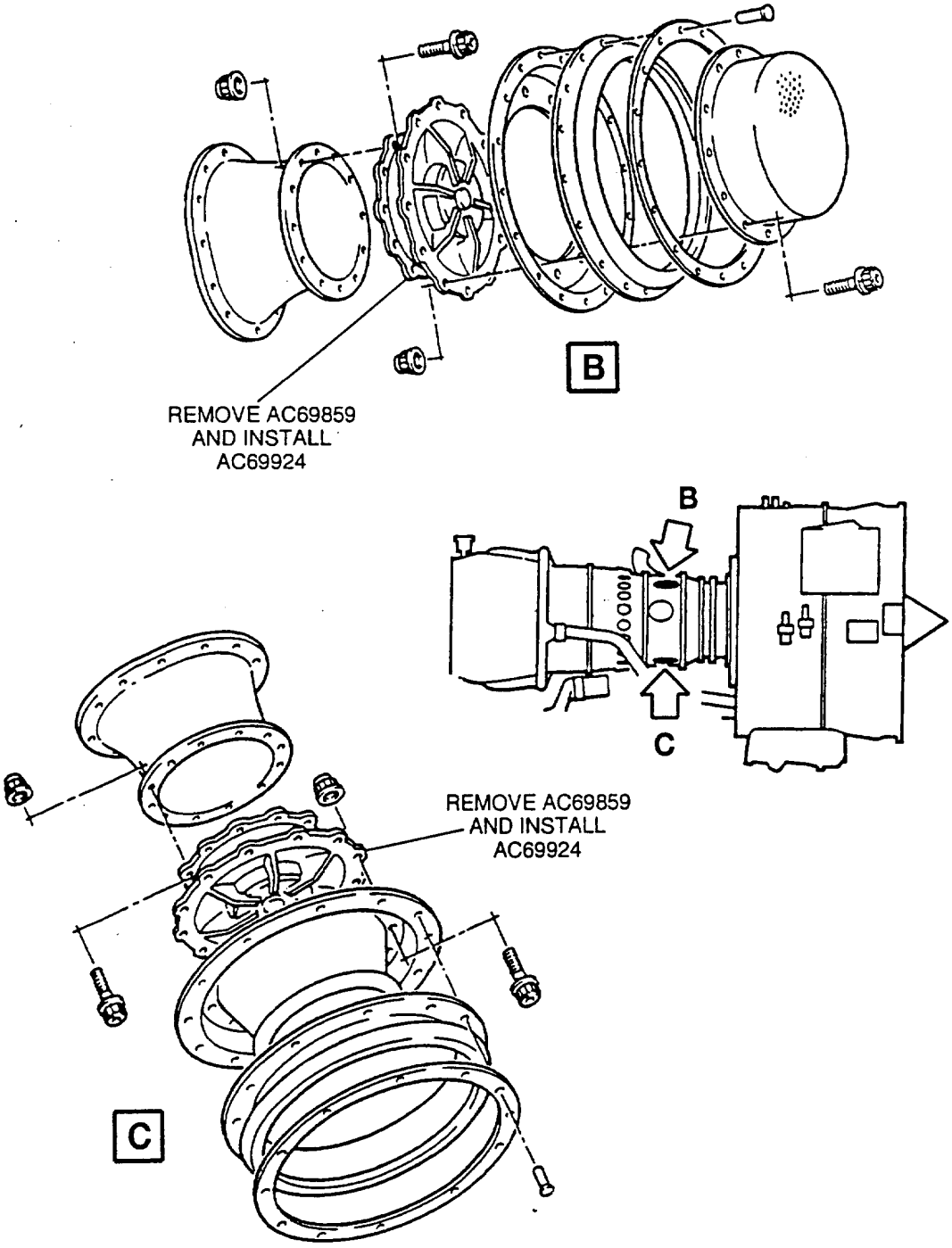
Location of the RH Stage-7 bleed valves - A1 Engines
Fig.2



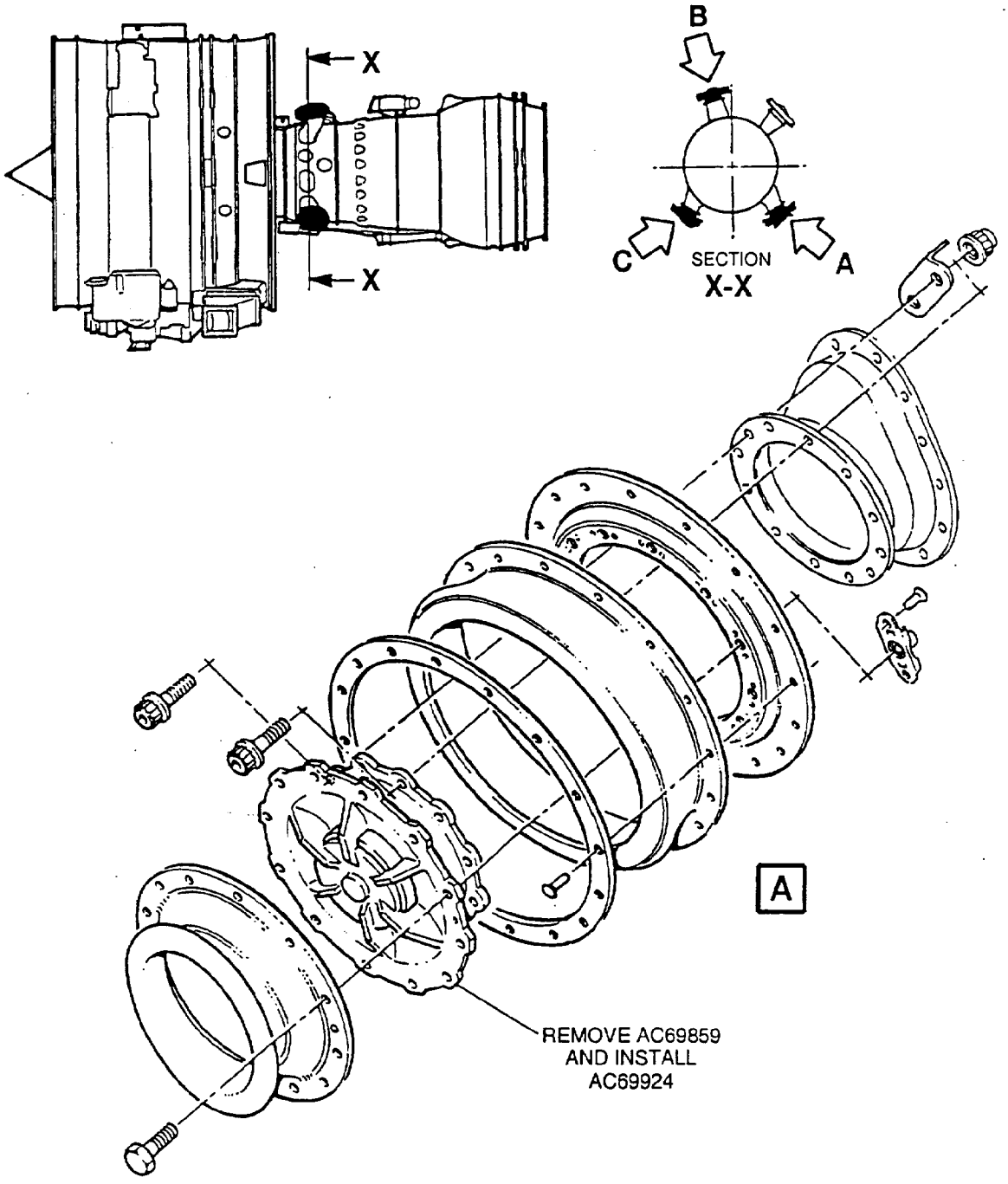


ded0002904

Location of the LH Stage-7 bleed valves - A5 Engines
Fig.3

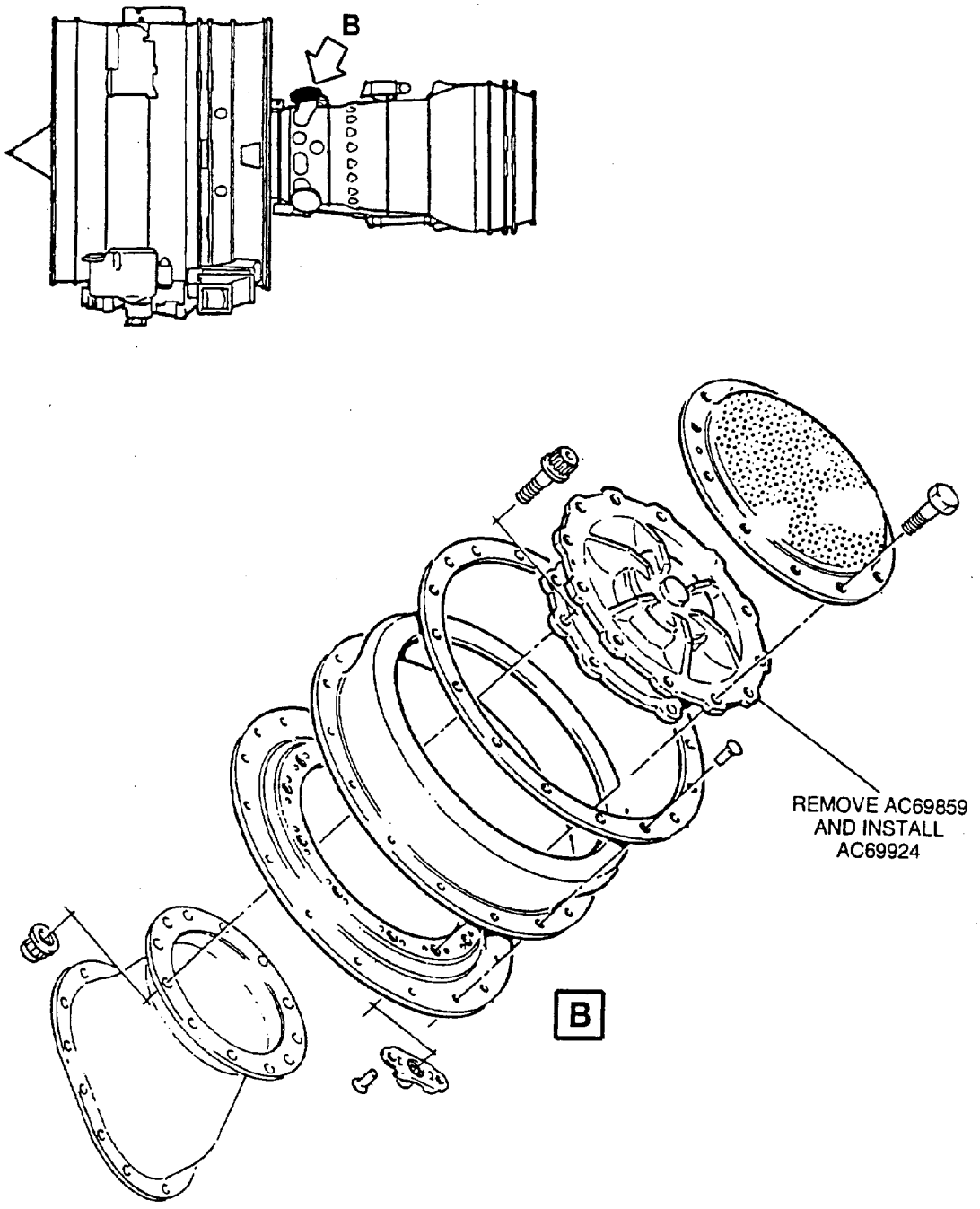


Location of the RH Stage-7 bleed valves - A5 Engines
Fig.4

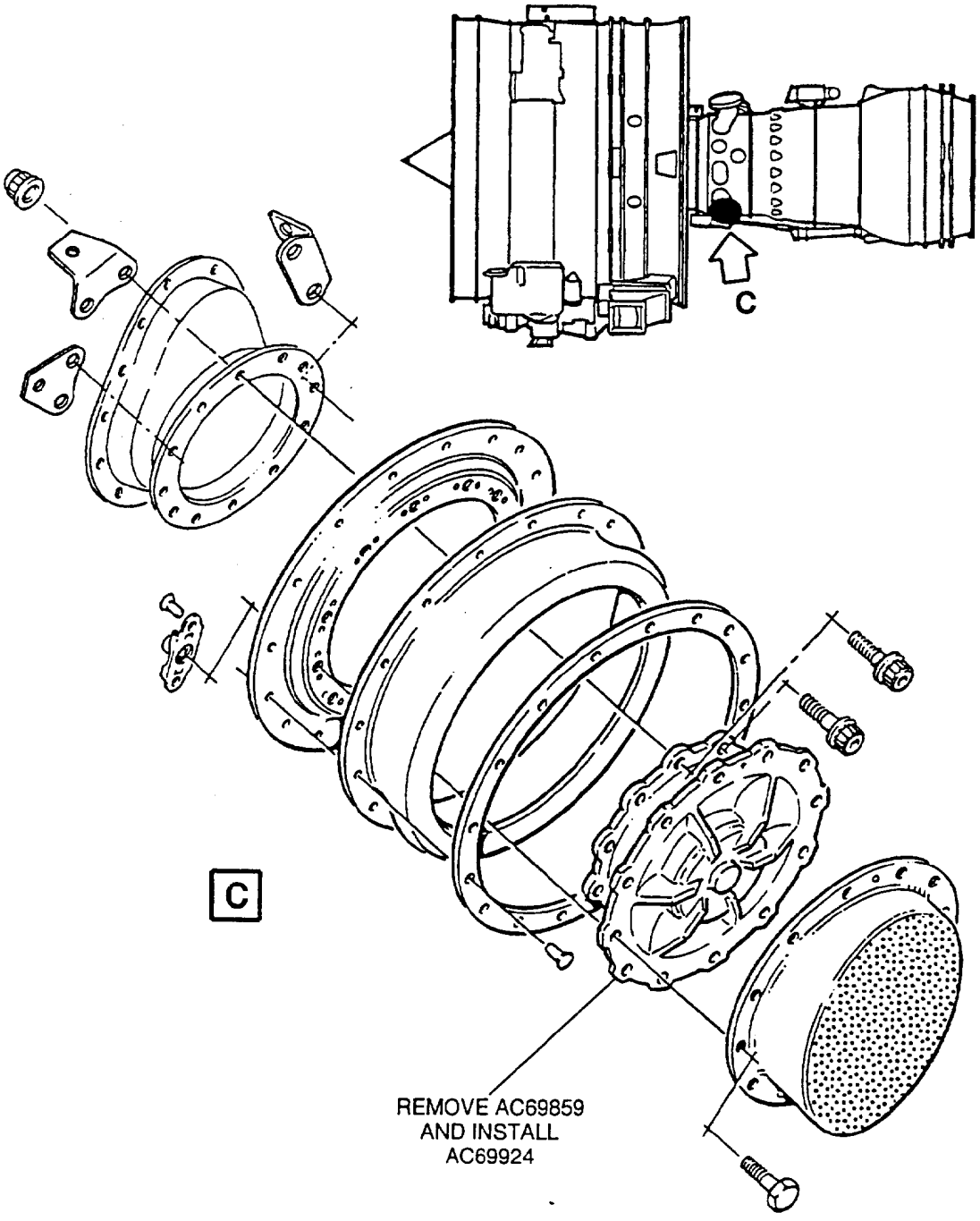


ded0002906

Location of the Stage-7 bleed valves - D5 Engines - View A
Fig.5



Location of the Stage-7 bleed valves - D5 Engines - View B
Fig.6



ded0002908

Location of the Stage-7 bleed valves - D5 Engines - View C
Fig.7

Printed in Great Britain

DUNLOP EQUIPMENT DIVISION

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

1. **Planning Information**

A. Effectivity

(1) Aircraft
- (a) Airbus A320
- (b) Airbus A321
- (c) McDonnell Douglas MD90

(2) Engines
- (a) V2500-A1
- (b) V2500-A5
- (c) V2500-D5

(3) Units affected
Dunlop HP 7 Bleed Valve AC69859 Mod 1 and AC69924 Mod 1.

B. Reason

(1) Condition
Valve sticking of HP compressor bleed valves has occurred in service.

(2) Background
Dry contamination of the triple seals in the valve body and piston may cause valve sticking. When the valve sticks in the closed position, starting may be difficult. Valve sticking in the open position may result in EGT shift and loss of surge margin.

(3) Objective
Incorporation of the changes introduced by this Service Bulletin (Dunlop Mod E592 Rev 2) are designed to improve unit reliability.
Note:- This re-issue of SB 75-30 at Revision 1 incorporates Dunlop Mod E592 Issue 2 which modifies the Piston 'Chevron' Seal included in Mod Kit ACO47197

(4) Substantiation
HP compressor stage 7 bleed valves incorporating the chevron design carbon /nimonic triple seals successfully completed contamination and vibration testing, to demonstrate the integrity of the new seals.

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

C. Description

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

HP7 Bleed Valve AC69859 Mod 1

Disassembly of HP7 Bleed Valve
Replacement of Piston Triple Seal Assembly DAS2485-1256 by a new 'Chevron' Seal Assembly ACO47190 Issue 2.
Replacement of Body Triple Seal Assembly DAS2505-1225 by a new 'Chevron' Seal Assembly ACO47189 Issue 1.
Renewal of Nut AS20625.
Assembly and Re-identification of the modified Bleed Valve as **AC69924 Mod 2.**

HP7 Bleed Valve AC69924 mod 1

Disassembly of HP7 Bleed Valve
Replacement of Piston 'Chevron' Seal Assembly ACO47190 Issue 1 by a new 'Chevron' Seal Assembly ACO47190 Issue 2.
Renewal of Nut AS20625.
Assembly and Re-identification of the modified Bleed Valve as **AC69924 Mod 2.**

(2) Refer to figure 1 for pre and post mod configuration of the Bleed Valve

D. Approval

This Service Bulletin No AC69859, AC69924 SB 75-30 Revision 1 (MOD E592 Issue 2) (IAE SB V2500-ENG-75-0053 Rev 1) was technically agreed by IAE on 28th April 1995.
The part number changes and / or part modifications described in this bulletin have been shown to comply with the appropriate Federal Aviation Regulations and are FAA approved for those units Listed in this bulletin.

E. Compliance

Category 4
Accomplish at the first visit of an engine or 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

Modification & Rework 20 man minutes

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

G. Materials - Price and Availability

Dunlop will supply a modification kit PN ACO47197 Issue 2 to permit accomplishment of this Service Bulletin. Further information on the Price and Availability of the modification kit can be obtained on request to:-

Dunlop Equipment Division. Holbrook Lane, Foleshill, Coventry CV6 4AA. England
Tel. (01203) 668614 Fax.(01203) 668776 Telex 31677 Sita.CVTDLCR
Attention of Mr. Ray Latham

H. Tooling - Price and Availability

The following tools are required to accomplish this Service Bulletin.

Tool No	Qty	Description	Function
Acratork Model A	One	Torque Spanner $^3/_8$ in square drive range 4 to 20 Nm	To torque load Nut AS20625
Britool AB312	One	Torque Socket $^3/_8$ in square drive	To hold Nut AS20625
Britool AB437	One	Torque Socket $^3/_8$ in square drive	To hold Bolt A10419E
Britool A70	One	'T' handle $^3/_8$ in square drive	For use with Torque Sockets

Note:1 Equivalent alternatives may be used for listed items.
Note:2 Tooling is commercially available.

I. Weight and Balance

(1) Weight change ..... None
(2) Moment Arm..... No Effect
(3) Datum..... Engine Front Mount Centreline (Power Plant Station (PPS) 100)

J. Electrical Load Data

Not affected.

K. References

IAE EC 94VR047, EC 94VR047A, 94VR047B
IAE Service Bulletin V2500-ENG-75-0053 Rev 1
Dunlop Component Maintenance Manual (CMM) 75-32-52 (HP7 Bleed Valve)

L. Publications Affected

Dunlop Component Maintenance Manual (CMM) 75-32-52 to be revised.

M Family Tree Charts

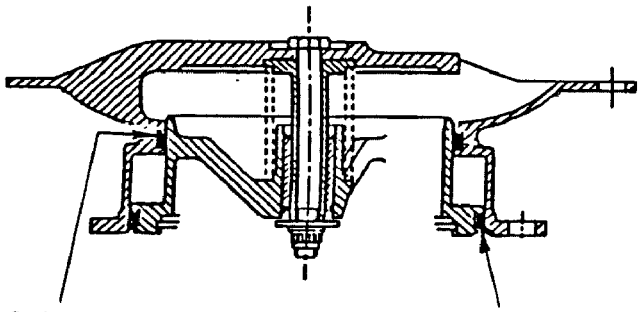
Not applicable.

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

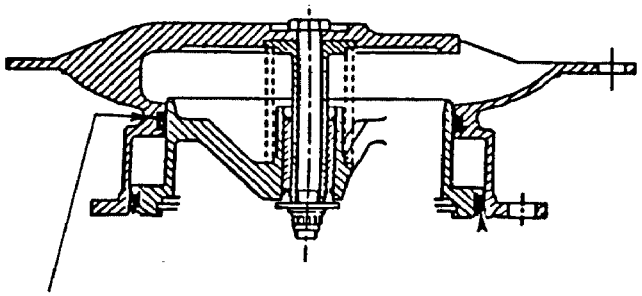
HP7 Bleed Valve AC69859 Mod 1



Carbon Body Seal
DAS 2505-1225

Carbon Piston Seal
DAS2485-1256

HP7 Bleed Valve AC69924 Mod 1

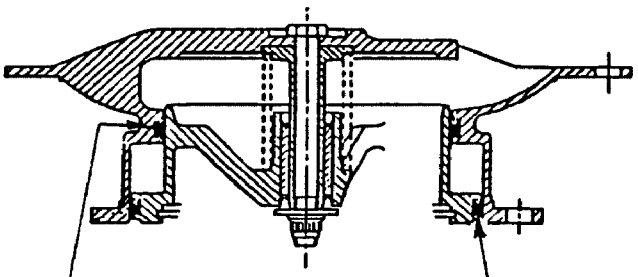


Chevron Body Seal
ACO47189 Issue 1

Chevron Piston Seal
ACO47190 Issue 1

Pre Mod E592 Issue 2

HP7 Bleed Valve AC69924 Mod 2



Chevron Body Seal
ACO47189 Issue 1

Chevron Piston Seal
ACO47190 Issue 2

Post Mod E592 Issue 2

Figure 1 Pre and Post Mod Configuration of HP7 Bleed Valve

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

2. **Accomplishment Instructions**

A. General. These instructions detail the partial rework of HP7 Bleed Valves P/N AC69859 Mod 1 and P/N AC69924 Mod 1 and their re-identification as **AC69924 Mod 2**.

B Disassembly Instructions. (Refer to Figure 2).

HP 7 Bleed Valve P/N AC69859 Mod 1 and P/N AC69924 Mod 1

(1) Using the Britool A70, AB312 and AB437 Tools remove the PN AS20625 Nut, the PN ACO45619 Washer and the PN A10419E Bolt. Discard the PN AS20625 Nut.

(2) Remove the PN AC69328 Piston complete with the PN ACO45615 Valve Stem and PN ACO45616 Spring.

HP 7 Bleed Valve P/N AC69859 Mod 1 Only

(3a) Remove the PN DAS2485-1256 Carbon Triple Seal Assembly from the Piston. Discard the PN DAS2485-1256 Carbon Triple Seal Assembly

(4a) Remove the PN DAS2505-1225 Carbon Triple Seal Assembly from the Bleed Valve Body. Discard the PN DAS2505-1225 Carbon Triple Seal Assembly.

HP 7 Bleed Valve P/N AC69922 Mod 1 Only

(3b) Remove the PN ACO47190 Issue 1 Chevron Seal Assembly from the Piston. Discard the PN ACO47190 Issue 1 Chevron Seal Assembly

(4b) No further disassembly is required. **Do Not Remove** the PN ACO47189 Issue 1 Chevron Seal Assembly from the Body unless it is unserviceable.

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

C Inspection, Cleaning, Modification

(1) Visually examine the removed metal components and the chamber of the Bleed Valve for signs of surface corrosion, damage, distortion and surface deposits.
Polish out light surface corrosion, damage or surface deposits with a smooth hone or grade 00 carborundum cloth.
Reject a metal component with corrosion or damage that is not removed by polishing.

(2) Examine threads for burrs and thread strip. Reject any defective component.

(3) If required clean the metal components with Trichloroethane 1:1:1 BS4487 (O.T.620) in accordance with the data given in IAE Standard Practices Manual SPP-V2500-11A.
Note: All non-metallic (carbon etc) components must be removed before cleaning with Trichloroethane or other chlorinated solvents.

WARNING: TRICHLOROETHANE 1:1:1 IS A HAZARDOUS MATERIAL, BEFORE YOU USE IT MAKE SURE THAT YOU KNOW THE SAFETY PRECAUTIONS AND FIRST AID INSTRUCTIONS ON:-
- THE LABEL ON THE CONTAINER IT WAS SUPPLIED IN.
- ITS MATERIAL SAFETY DATA SHEET.
- YOUR LOCAL SAFETY REGULATIONS.

CAUTION TRICHLOROETHANE AND OTHER CHLORINATED SOLVENTS CAN COMBINE WITH SMALL AMOUNTS OF MOISTURE TO MAKE HYDROCHLORIC ACID AND CAUSE CORROSION.
AFTER CLEANING THE METAL COMPONENTS DRY THEM AT A CONTROLLED TEMPERATURE OF 80 to 85 deg C (185 to 194 deg. F) TO REMOVE ALL SIGNS OF THE SOLVENT USED.

CAUTION TRICHLOROETHANE AND OTHER CHLORINATED SOLVENTS CAN CAUSE SEVERE DAMAGE TO CARBON SEALING RINGS. MAKE SURE THAT CARBON SEALING RINGS DO NOT COME INTO CONTACT WITH CHLORINATED SOLVENTS.

CAUTION CARBON SEALING RINGS ARE EASILY DAMAGED.
BE CAREFUL WHEN HANDLING AND INSTALLING CARBON SEALING RINGS

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

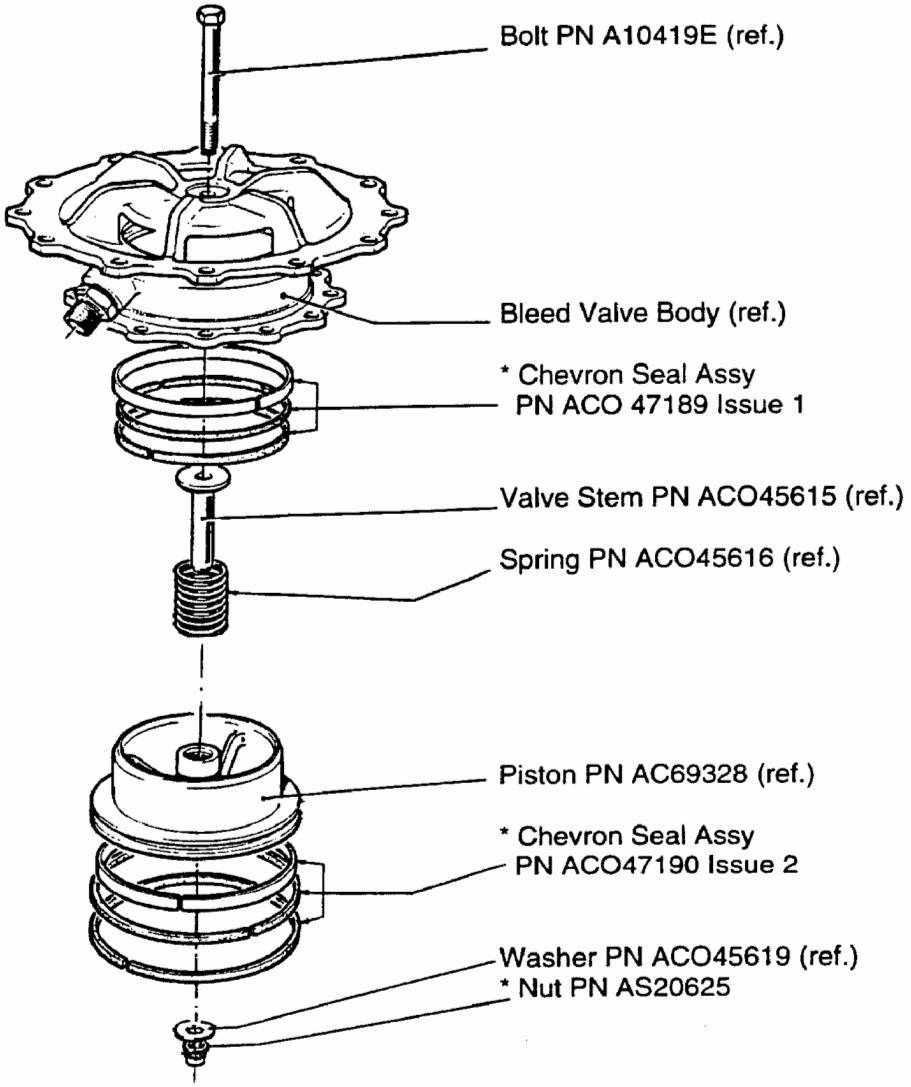


Figure 2 Exploded View of Bleed Valve P/N **AC69924 Mod 2**
(* Denotes Items contained in Mod Kit PN ACO47197 Issue 2)

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

D Fitment Instructions. (Refer to Figure 2)

HP 7 Bleed Valve P/N AC69859 Mod 1 Only

(1) Install a new PN ACO47189 Issue 1 Chevron design carbon / nimonic Triple Seal Assembly in the Bleed Valve Body.
Make sure the ring gaps are equispaced around the circumference.

HP 7 Bleed Valve P/N AC69859 Mod 1 and P/N AC69924 Mod 1.

(2) Install the PN A10419E Bolt through the Bleed Valve Body.

(3) Install the PN ACO45615 Valve Stem over the Bolt and locate the Valve Stem flange in the recess in the Bleed Valve Body.

(4) Install the PN ACO45616 Spring on the Valve Stem.

(5) Install a new PN ACO47190 Issue 2 Chevron design carbon / nimonic Triple Seal Assembly on the PN AC69328 Piston.
Make sure the ring gaps are equispaced around the circumference

(6) Install the Piston over the Valve Stem.

(7) Make sure the Chevron design carbon / nimonic Triple Seal Assemblies in the Piston and Valve body are not damaged during assembly.

(8) Install the PN ACO45619 Washer on the Bolt.

(9) Lubricate the threads of the Bolt with a minimum amount of "Threadgard" and install a new PN AS20625 Nut on the Bolt.

(10) Using the Acratork Model A, Britool AB312 and AB437 Tools torque tighten the PN AS20625 Nut to 8,5/9,0 Nm (75/80 lbf in.) plus the torque required to overcome the lock properties of the Nut.

(11) Use a vibro-etch tool to reidentify the HP7 Bleed Valve adjacent to the existing part number and mod number on the Bleed Valve body.

Existing Part Number	Renumber
AC69859 Mod 1	**AC69924 Mod 2**
AC69924 Mod 1	**AC69924 Mod 2**

E Complete the tests detailed in VCMM 75-32-52, TESTING AND FAULT ISOLATION.

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

F For units reoperated in the field, verify the valve operation using the following procedure.

(1) Fixtures, Tools, Test and Support Equipment. (refer to Figure 3).

Reference	Designation
AC69572	Stage 7 Solenoid Valve.
No Specific	Torque Wrench; range 0 to 250 lbf.in.
No Specific	Air tube suitable for connecting between the Bleed Valve and the Solenoid Valve.
IAE2R18900	Bleed System Test Set.

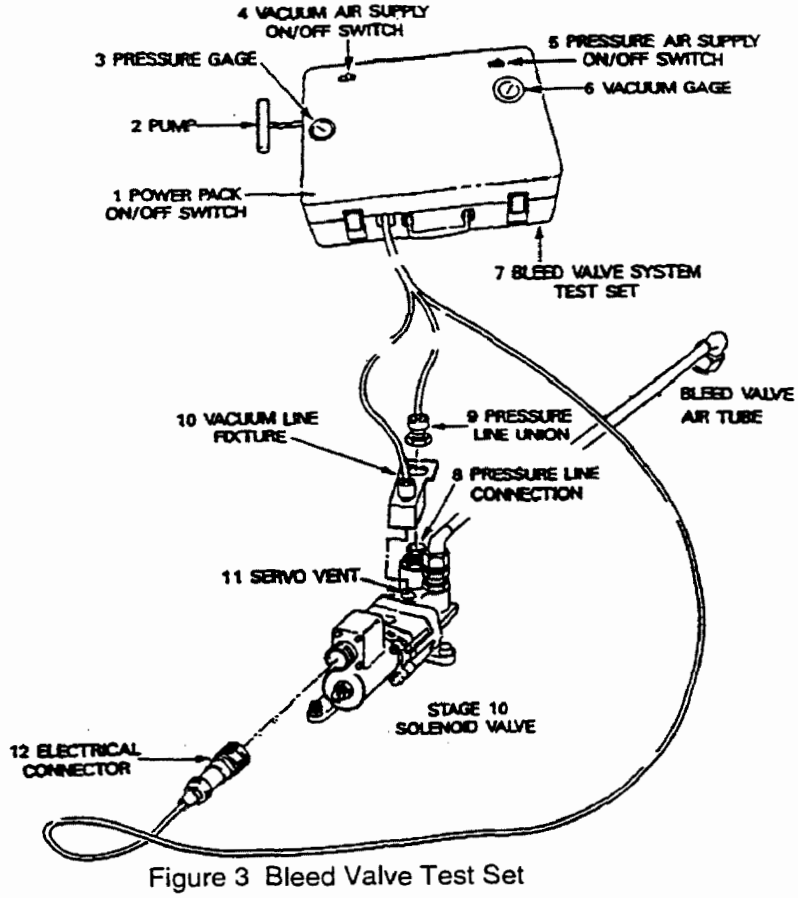


Figure 3 Bleed Valve Test Set

(2) On a suitable workbench, connect an air tube between the Stage 7 Bleed Valve union and the P/N AC69572 Stage 7 Solenoid Valve outlet union. Torque the connectors to 204 to 221 lbf. in. (2,30 to 2,50 mdaN).

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

(3) Install the P/N IAE2R18900 Bleed Valve Test Set to the P/N AC69572 Stage 7 Solenoid Valve as follows. (refer to Figure 3 for item numbers quoted).

(a) Install the vacuum line fixture (10) on to the pressure line connection (8) and the servo vent (11).

(b) Install the pressure line union (9) to the pressure line connection (8).

(c) Torque the pressure line union (9) to 204 to 221 lbf. in. (2,30 to 2,50 mdaN). Make sure the vacuum fixture (10) seals down over the servo vent (11).

(d) Connect the electrical connector (12) to the P/N AC69572 Stage 7 Solenoid Valve

(4) Test the Stage 7 Bleed Valve as follows. (refer to Figure 3 for item numbers quoted).

(a) Make sure the vacuum gauge (6) and the pressure gauge (3) read zero and the vacuum air supply switch (4) and the pressure air supply switch (5) are both in the OFF position.

(b) Prime the test set with the pump (2) until the pressure gauge (3) reads 30 psig (207 KPa) and the vacuum gauge (6) reads -8 psig (-55 KPa).

(c) Turn the power pack switch (1) to the ON position.

(d) Turn the pressure air supply switch (5) to the ON position.

(e) Turn the vacuum air supply switch (4) to the ON position and verify the bleed valve closes.

(f) Turn the power pack switch (1) to the OFF position and verify the valve closes.

(g) If the bleed valve fails the test, check for correct assembly of the bleed valve.

(h) Repeat the tests in paragraphs (a) thru (f).

(I) If the bleed valve fails the test again, replace the solenoid valve.

(j) Repeat the tests in paragraphs (a) thru (f).

(k) If the bleed valve fails the test again, reject the bleed valve.

(l) Disconnect the bleed valve from the test set.

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

G Recording Instructions.
A record of Accomplishment is required

3. Material Information

A The type of equipment affected by this mod is:-

Unit.	**Type No.**
HP compressor stage 7 bleed valve.	AC69859 Mod 1 or AC69924 Mod 1

B Modification Items associated with this Bulletin
The following modification kit is required to accomplish this modification:-
MODIFICATION KIT Part Number ACO47197 Issue 2

Modification Kit ACO47197 Issue 2		
Kit Item Part Number	Qty per Kit	Keyword
AS20625	One	NUT
ACO47189 issue 1	One	SEAL Assembly Body (Chevron design))
ACO47190 issue 2	One	SEAL Assembly Piston (Chevron design)

Notes:- DSR = Dunlop Stores Reference
Unit AC69924 Mod 1 is already fitted with Chevron Body Seal P/N ACO47189 Iss. 1

C Parts Affected by this Bulletin

New PN	Quantity Per Unit	Keyword	Old PN	Instructions / Dispositions
AC69924 Mod State 2	RF	Valve Assy Bleed HP7	**AC69859 Mod State 1**	Rework Old Part Number Unit and Re-identify to the New Part Number and Mod State
ACO47189 Issue 1	1	Seal Assy Chevron (Body Seal)	DAS 2505-1225	Old Part is to be Discarded
ACO47190 Issue 2	1	Seal Assy Chevron (Piston Seal)	DAS 2485-1256	Old Part is to be Discarded

New PN	Quantity Per Unit	Keyword	Old PN	Instructions / Dispositions
AC69924 Mod State 2	RF	Valve Assy Bleed HP10	**AC69924 Mod State 1**	Rework Mod State 1 Unit and Re-identify to the New Mod State
ACO47190 Issue 2	1	Seal Assy Chevron (Piston Seal)	ACO47190 Issue 1	Old Part is to be Discarded

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group

SERVICE BULLETIN

SB Number 75-30 (Revision 1)
Power Plant Air Compressor Control
Introduction of HP7 Bleed Valve AC69924 Mod 2 with Chevron Seals in lieu and by conversion of AC69859 & AC69924 Mod 1
DUNLOP MODIFICATION E592 (Issue 2) (IAE SB V2500-ENG-75- 0053 Rev 1)

4 **Additional Information for Operators**

A HP7 Bleed Valve AC69254 (pre mod E586 Dunlop SB75-28 refers) is unaffected by this Service Bulletin.
Operators who wish to have Bleed Valve AC69254 modified up to AC69924 Mod 2 standard will need to incorporate the new p/n part introduced by Dunlop mod E586 (SB75-28 refers) to take the unit to PN AC69859 standard before they can incorporate this Service Bulletin.

B The new p/n part introduced by Dunlop mod E586 is Carbon Split Bush PN ACO47056 (post mod E586) in lieu of Carbon Split Bush PN ACO45618 (pre mod E586).

Printed in England
A Division of Dunlop Limited. Registered in England No. 995293. Registered Office, Silvertown House, Vincent Square, London SW1P 2PL.
A member of the BTR Group