P U B L I C A T I O N T R A N S M I T T A L

RR-DERBY

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DATER Mar. 5/99

V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 4 to Service Bulletin EV2500-75-0060 and Revision 4 to the Supplement

Document History

Service Bulletin Revision Status		Supplement Revision Status	
Initial Issue	May 15/96	Initial Issue	May 15/96
Revision 1	Nov.1/96	Revision 1	Nov.1/96
Revision 2	Oct.31/97	Revision 2	Oct.31/97
Revision 3	Dec.19/97	Revision 3	Dec.19/97

Bulletin Revision 4

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 21 of the Service Bulletin	To format SB to latest standards.

Supplement Revision 4

Remove	Incorporate	Reason for change
All pages	Page 1	To format SB to latest standards.

V2500-ENG-75-0060

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise Publication Services, Rolls-Royce plc, Derby, England

LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 4 to the Bulletin and Revision 4 to the Supplement are as follows:

	Page	Revision Number	Revision Date
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	Supplement		
R	1	4	Mar.5/99

AIR-ACTIVE CLEARANCE CONTROL SYSTEM - INTRODUCTION OF REVISED (ACC) MOUNTING BRACKET AND LINK ASSEMBLIES WITH SLOTTED ENTRY BEARINGS

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No.V10271

(2) Airbus A320

V2500-A1 Engines prior to Serial No.V0362

V2527-A5, V2527E-A5 Engines Engines prior to Serial No.V10271

(3) Airbus A321

V2530-A5, V2533-A5 Engines Engines prior to Serial No.V10271

B. Concurrent Requirements

None.

C. Reason

(1) Problem

High replacement rates of the mounting links and brackets for the active clearance control (ACC), have resulted in operators being dissatisfied. Operators have requested a more cost effective method of replacement.

The premature wear can be caused by increased ACC system vibration.

(2) Evidence

Operator experience has shown that the spherical bearings wear out after approximately 3000 hours. Current replacement of the bearing requires complete removal of the bracket or link assembly.

(3) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis.

(4) Objective

Incorporation of this Service Bulletin (Modification) is to improve maintainability.

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Affected.

(c) Overhaul

Affected.

(d) Repair Schemes

Affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The ACC bracket and link assemblies have been revised, the changes are as follows:

(a) To allow the replacement of worn bearings without the complete removal of the bracket or link assembly, the entry spherical bearings are now slotted.

E. Compliance

Category Code 5

Accomplish when the engine is disassembled sufficiently to allow access to all the affected subassemblies (i.e. modules, accessories, components, build groups).

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

In service

Not applicable.

At overhaul

2 Hours 27 Minutes

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

H. Material Price and Availability

(1) Modification kit MKV601201 is necessary to embody this Service Bulletin.

(2) This modification kit is available to all affected customers at 50 percent discount for a specified period.

(3) Customers must submit a Purchase Order for the applicable quantity of kits. The Purchase Order must give the Serial Number of all the affected engines and the IAE Tracking No. S305UI, must be given on all correspondences.

Purchase Orders must be sent to:

IAE Spares Division

400 Main Street M/S 121-10

East Hartford CT 06108

USA

(4) IAE spares department will advise customers about delivery schedules after Purchase Orders have been received.

The discounted kits will be available from Mar. 1/98 to Mar. 1/00.

(5) For prices and availability of future spares see Supplement to this Bulletin.

I. Tooling Price and Availability

(1) Swaging Tool for P2500 bearing assembly, available from:

Rexnord Corp

71 Narrow Lane

Aylestone

Leicester LE2 8NA

UK

(2) Swaging Tool for VTB12350E bearing assembly, available from:

Arger Enterprises Inc

350 South Rock Boulevard

Reno

Nevada 89502

USA

or

Bristol Fasteners (Europe) Ltd

Marston Lane

Hine Heath

Shrewsbury

Shropshire SY4 4LZ

UK

(3) Trepanning Cutter - IAE 3R19072

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) Airbus A319/A320/A321 Aircraft Maintenance Manual (AMM), Chapter/Section 75-24-51, Removal/Installation.

(2) A1/A5 Engine Manual (EM), Chapter/Section 72-00-40, Installation-10 Config-01 and -02.

(3) Standard Practices Manual (SPM).

(4) Internal Reference Nos. - 96VR012, 96VR012A.

(5) ATA Locator - 72-40-00.

M. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC) Chapter/Sections 72-40-00, 75-24-47 and 75-24-51.

(2) A320 Aircraft Maintenance Manual (AMM), Chapter/Section 75-24-51, Removal/Installation.

(3) A1/A5 Engine Manual (EM), Chapter/Section 72-00-40, Installation-10.

(4) A1/A5 Component Maintenance Manual (CMM), Miscellaneous Mechanical, Chapter/Section 75-24-47.

N. Interchangeability of Parts

Not affected.

2. Material Information

A. Kits necessary for this Service Bulletin:

Modification Kit MKV601201

B. Parts affected by this Service Bulletin:

72-40-00

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
05500	6A6487	1	.Bracket,valve ACC assy of	-	5W2099	(A)(B)(S1)
05505	VTB12350E	1	..Bearing,assy	-	-	(A)(C)(E)(F)
or						
05505	P25000	Ref	..Bearing,asy	-	-	(A)(C)(E)(F)
05507	VTB12351	1	...Bearing,spherical	-	-	(A)(C)(E)
or						
05507	P25001	Ref	...Bearing,spherical	-	-	(A)(C)(E)
05570	6A6489	1	Bracket - assy of	-	5W2237	(A)(B)(S1)
05582	VTB12350E	1	..Bearing,assy	-	-	(A)(C)(E)(F)
or						
05582	P25000	Ref	..Bearing,assy	-	-	(A)(C)(E)(F)
05584	VTB12351	1	...Bearing,spherical	-	-	(A)(C)(E)
or						
05584	P25001	Ref	...Bearing,spherical	-	-	(A)(C)(E)

75-24-47

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01500	6A6486	1	.Bracket,valve ACC assembly of	-	5W2098	(A)(B) (S1)
01530	VTB12350E	1	..Bearing,assy	-	-	(A)(C) (E)(F)
or						
01530	P25000	Ref	..Bearing,assy	-	-	(A)(C) (E)(F)
01532	VTB12351	1	...Bearing,spherical	-	-	(A)(C) (E)
or						
01532	P25001	Ref	...Bearing,spherical	-	-	(A)(C) (E)

75-24-51

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01485	6A6491	1	.Rod stator, assy of	-	5W2096	(A)(B) (S1)
01820	VTB12350E	2	..Bearing,assy	-	-	(A)(C) (E)(F)
or						
01820	P25000	Ref	..Bearing,assy	-	-	(A)(C) (E)(F)
01822	VTB12351	2	...Bearing,spherical	-	-	(A)(C) (E)
or						
01822	P25001	Ref	...Bearing,spherical	-	-	(A)(C) (E)
02100	6A6490	1	.Link - assy of	-	5W2239	(A)(B) (S1)
02180	VTB12350E	2	..Bearing,assy	-	-	(A)(C) (E)(F)
or						
02180	P25000	Ref	..Bearing,assy	-	-	(A)(C) (E)(F)
02182	VTB12351	2	...Bearing,spherical	-	-	(A)(C) (E)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
or						
02182	P25001	Ref	...Bearing,spherical	-	-	(A)(C)(E)
02250	6A6488	1	.Link - assy of	-	5W2235	(A)(B)(S1)
02330	VTB12350E	1	..Bearing,assy	-	-	(A)(C)(E)(F)
or						
02330	P25000	Ref	..Bearing,assy	-	-	(A)(C)(E)(F)
02332	VTB12351	1	...Bearing,spherical	-	-	(A)(C)(E)
or						
02332	P25001	Ref	...Bearing,spherical	-	-	(A)(C)(E)

C. Instructions disposition codes:

(A) New part is available.

(B) Old part is not available.

(C) Additional.

(E) Alternative.

(F) New part will not be available as a spare to replace stock.

(S1) Old and new parts are fully interchangeable.

3. Accomplishment Instructions

A. Rework Instructions

(1) Consumable Materials

CoMat 06-022 - Fluorescent penetrant

(2) Standard Equipment

Chemical Cleaning Equipment

Penetrant Crack Test Equipment

Press

Standard Workshop Equipment

Vertical Milling Machine

Vibro Engraving Equipment

Workshop Inspection Equipment

(3) Rework the parts that follow:

5W2099 Bracket, Valve ACC, Assembly, (72-40-00, Fig/Item 05-500)

5W2237 Bracket, Assembly, (72-40-00, Fig/Item 05-570)

PROCEDURE	RELATED DATA
(a) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(b) Do a local penetrant crack test of the area(s) adjacent to the bearing	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(c) Remove the bearing (Method 1)	
(i) Install the bracket assemblies in the vertical milling machine	Use a vertical milling machine with standard workshop equipment (Refer to Figure 2)

(ii) Machine the lip of the bearing to be removed	If necessary use an IAE trepanning cutter or suitable equivalent, with a vertical milling machine (Refer to Figure 2) CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.
(iii) Remove the bearing	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the bracket assembly is held correctly (Refer to Figure 2).

(d) Remove the bearing (Method 2)

CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.

(i) Carefully press out the applicable bearing from the bracket assembly	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the bracket assembly is held correctly (Refer to Figure 2).
(e) Polish out any remaining scratches from the bearing location hole	Use standard workshop equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-35-03-300-501).
(f) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(g) Do a local penetrant crack test of the bearing location hole	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(h) Visually examine and measure the dimensions of the bearing location hole	Use workshop inspection equipment (Refer to Figure 2).
(i) If the bearing location is too large, reject the part.	

(i) Install the new bearing.

NOTE: Before you install the bearing assembly, you must remove the ball bearing and keep it safe.

(i) Install the new bearing in the bracket assemblies	For part number 5W2099 use VTB12350E bearing assembly 05-505 or P25000 bearing assembly 05-505. For part number 5W2237 use VTB12350E bearing assembly 05-582 or P25000 bearing assembly 05-582 (Refer to Figure 2).
(j) Swage the new bearing in to the bracket assemblies	Use a swaging tool available from the bearing supplier (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 2).
(k) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(l) Do a local penetrant crack test of the bearing and location area(s)	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(m) Visually examine the bracket assemblies	Make sure the bearing is located correctly. (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 2).
(n) Install the ball bearing and examine the movement of the ball in the bearing	Make sure the movement is smooth (Refer to Figure 2).
(o) Safety the ball in the bearing	CAUTION: DO NOT USE METALLIC TIES. THESE CAN DAMAGE THE BEARING COMPONENTS. Use string or equivalent equipment.

(p) Cancel the old part number and identify with the new part number	Use vibro-engraving equipment (Refer to the Standard Practices Manual (SPM), TASK 70-409-00-400-501, SUBTASK 70-09-00-400-001).

Old Part No.	New Part No.
5W2099	6A6487
5W2237	6A6489

(4) Rework the parts that follow:

5W20998 Bracket, Valve ACC, Assembly, (75-24-47, Fig/Item 01-500)

PROCEDURE	RELATED DATA
(a) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(b) Do a local penetrant crack test of the area(s) adjacent to the bearing	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(c) Remove the bearing (Method 1)	
(i) Install the bracket assemblies in the vertical milling machine	Use a vertical milling machine with standard workshop equipment (Refer to Figure 4)
(ii) Machine the lip of the bearing to be removed	If necessary use an IAE trepanning cutter or suitable equivalent, with a vertical milling machine (Refer to Figure 4) CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.
(iii) Remove the bearing	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the bracket assembly is held correctly (Refer to Figure 4).
(d) Remove the bearing (Method 2)	

CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.

(i) Carefully press out the applicable bearing from the bracket assembly	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the bracket assembly is held correctly (Refer to Figure 4).
(e) Polish out any remaining scratches from the bearing location hole	Use standard workshop equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-35-03-300-501).
(f) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(g) Do a local penetrant crack test of the bearing location hole	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(h) Visually examine and measure the dimensions of the bearing location hole	Use workshop inspection equipment (Refer to Figure 4).
(i) If the bearing location is too large, reject the part.	
(i) Install the new bearing.	

NOTE: Before you install the bearing assembly, you must remove the ball bearing and keep it safe.

(i) Install the new bearing in the bracket assemblies	For part number 5W20998 use VTB12350E bearing assembly 01-530 or P25000 bearing assembly 01-530 (Refer to Figure 4).
(j) Swage the new bearing in to the bracket assemblies	Use a swaging tool available from the bearing supplier (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 4).

(k) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(l) Do a local penetrant crack test of the bearing and location area(s)	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(m) Visually examine the bracket assemblies	Make sure the bearing is located correctly. (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 4).
(n) Install the ball bearing and examine the movement of the ball in the bearing	Make sure the movement is smooth (Refer to Figure 4).
(o) Safety the ball in the bearing	CAUTION: DO NOT USE METALLIC TIES. THESE CAN DAMAGE THE BEARING COMPONENTS. Use string or equivalent equipment.
(p) Cancel the old part number and identify with the new part number	Use vibro-engraving equipment (Refer to the Standard Practices Manual (SPM), TASK 70-409-00-400-501, SUBTASK 70-09-00-400-001). Old Part No. 5W2098 — New Part No. 6A6486

(5) Rework the parts that follow:

5W2096 Rod, Stator Assembly, (75-24-51, Fig/Item 01-485)

5W2239 Link Assembly, (75-24-51, Fig/Item 02-100)

5W2235 Link Assembly, (75-24-51, Fig/Item 02-250)

PROCEDURE	RELATED DATA
(a) Chemically clean the stator rod assembly and link assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).

(b) Do a local penetrant crack test of the area(s) adjacent to the bearing	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(c) Remove the bearing (Method 1)	
(i) Install the stator rod assembly or link assemblies in the vertical milling machine	Use a vertical milling machine with standard workshop equipment (Refer to Figure 2 or 3)
(ii) Machine the lip of the bearing(s) to be removed	If necessary use an IAE trepanning cutter or suitable equivalent, with a vertical milling machine (Refer to Figure 2 or 3) CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.
(iii) Remove the bearing	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the bracket assembly is held correctly (Refer to Figure 2 or 3).
(d) Remove the bearing (Method 2)	

CAUTION: BE CAREFUL WHEN YOU PRESS OUT THE BEARING. DO NOT DAMAGE THE LOCATION HOLE OF THE BEARING.

(i) Carefully press out the applicable bearing from the stator rod assembly or link assemblies	Use a press with standard workshop equipment. Use a pressure of 15 psi (1 bar) (100 kPa). Make sure the assemblies are held correctly (Refer to Figure 2 or 3).
(e) Polish out any remaining scratches from the bearing location hole(s)	Use standard workshop equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-35-03-300-501).
(f) Chemically clean the stator rod and link assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).

(g) Do a local penetrant crack test of the stator rod and link assemblies	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	
(h) Visually examine and measure the dimensions of the bearing location hole	Use workshop inspection equipment (Refer to Figure 2 or 3).
(i) If the bearing location is too large, reject the part.	
(i) Install the new bearing.	
NOTE: Before you install the bearing assembly, you must remove the ball bearing and keep it safe.	
(i) Install the new bearing in the stator rod or link assemblies	For part number 5W2096 use VTB12350E bearing assembly 01-820 or P25000 bearing assembly 01-820 (Refer to Figure 2 and 3). For part number 5W2239 use VTB12350E bearing assembly 02-180 or P25000 bearing assembly 02-180 (Refer to Figure 2 and 3). For part number 5W2235 use VTB12350E bearing assembly 02-330 or P25000 bearing assembly 02-330 (Refer to Figure 2 and 3).
(j) Swage the new bearing(s) in to the stator rod and link assemblies	Use a swaging tool available from the bearing supplier (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 2 or 3).
(k) Chemically clean the bracket assemblies	Use chemical cleaning equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-11-26-300-503).
(l) Do a local penetrant crack test of the bearing and location area(s)	Use CoMat 06-022 fluorescent penetrant, with crack test equipment. (Refer to the Standard Practices Manual (SPM), TASK 70-23-05-230-501).
(i) If cracks are found, reject the part(s).	

(m) Visually examine the stator rod and link assemblies	Make sure the bearing is located correctly. (Refer to the Standard Practices Manual (SPM), TASK 70-42-06-400-501, SUBTASK 70-42-06-400-004).(Refer to Figure 2 or 3).
(n) Install the ball bearing(s) and examine the movement of the ball in the bearing(s)	Make sure the movement is smooth (Refer to Figure 2 or 3).
(o) Safety the ball in the bearing	CAUTION: DO NOT USE METALLIC TIES. THESE CAN DAMAGE THE BEARING COMPONENTS. Use string or equivalent equipment.
(p) Cancel the old part number and identify with the new part number	Use vibro-engraving equipment (Refer to the Standard Practices Manual (SPM), TASK 70-409-00-400-501, SUBTASK 70-09-00-400-001).

Old Part No.	New Part No.
5W2096	6A6491
5W2239	6A6490
5W2235	6A6488

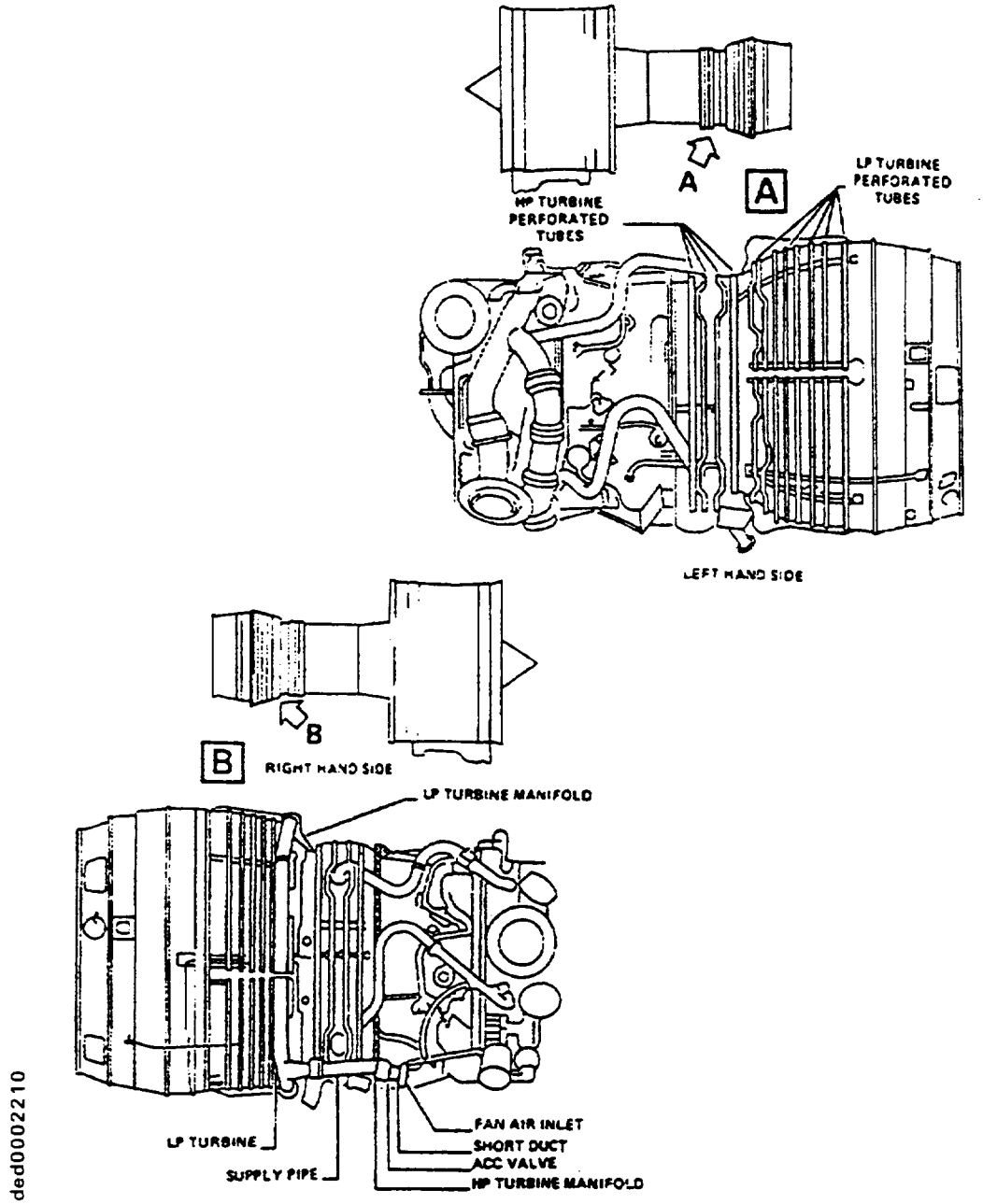
B. Assembly Instructions

(1) For the correct removal/installation procedures refer to the

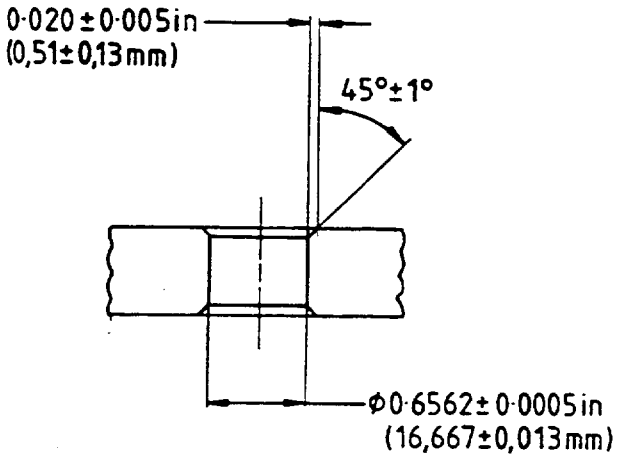
(a) Airbus A319/A320/A321 Aircraft Maintenance Manual (AMM), Chapter/Section 75-24-41, Removal/Installation.

C. Recording Instructions

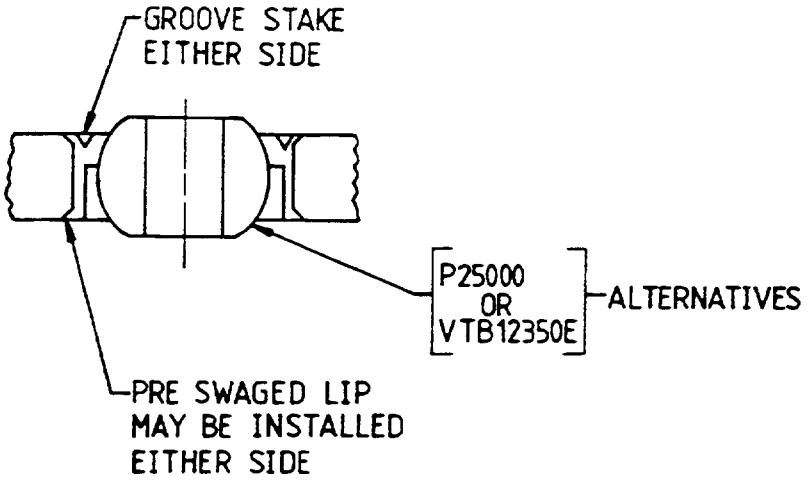
(1) A record of accomplishment is necessary.



General View
Figure 1



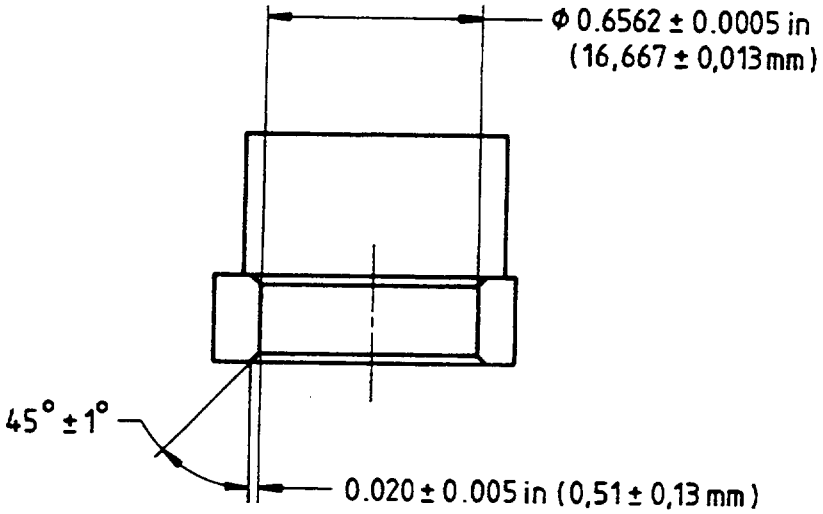
SECTION THOUGH HOLE
PRIOR TO FITTING SPHERICAL BEARING



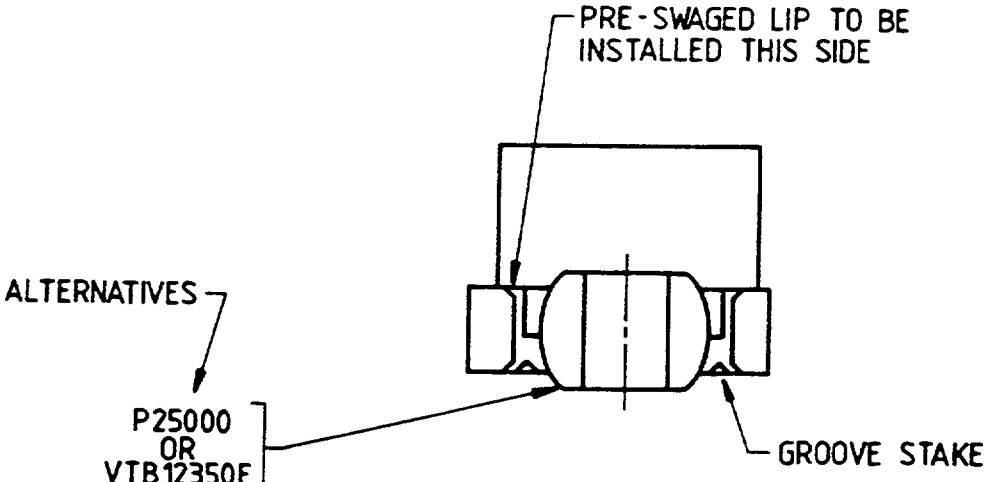
SECTION THOUGH HOLE
SHOWING SPHERICAL BEARING FITTED

ded0001250

Installation of spherical bearings - Assemblies 6A6487, 6A6489, 6A6490 and 6A6491
Figure 2



SECTION THROUGH HOLE
PRIOR TO FITTING SPHERICAL BEARING



SECTION THROUGH HOLE
SHOWING SPHERICAL BEARING FITTED

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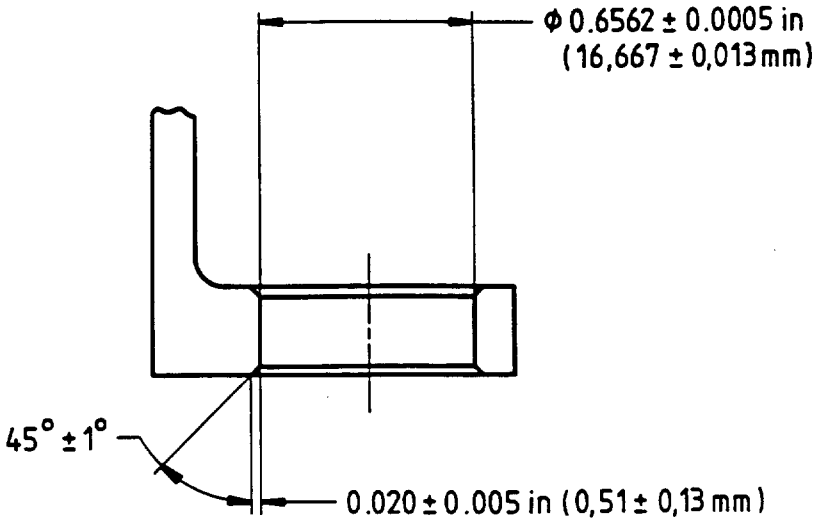
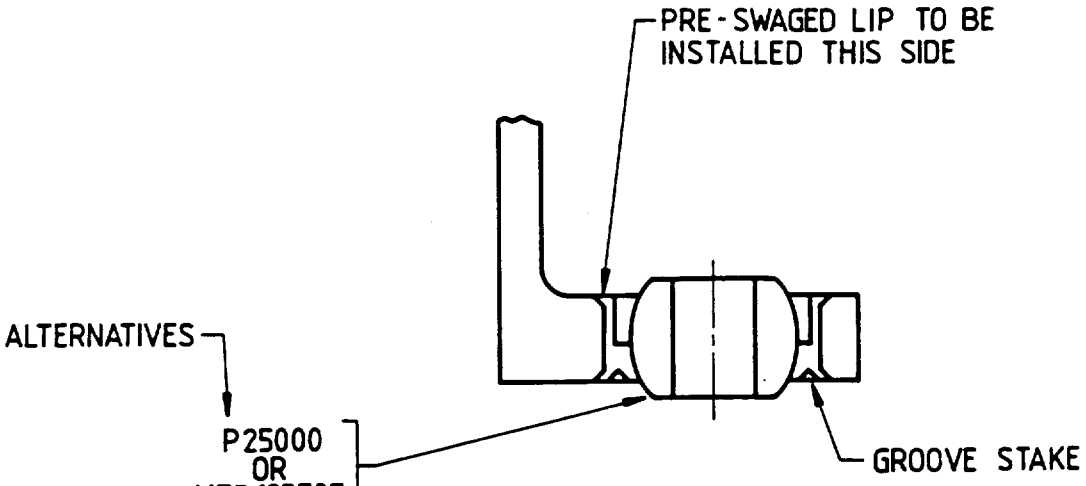
Installation of spherical bearings - Assembly 6A6488
Figure 3



SECTION THROUGH HOLE
PRIOR TO FITTING SPHERICAL BEARING



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SECTION THROUGH HOLE
SHOWING SPHERICAL BEARING FITTED

Installation of spherical bearings - Assembly 6A6486
Figure 4

AIR-ACTIVE CLEARANCE CONTROL SYSTEM - INTRODUCTION OF REVISED (ACC) MOUNTING BRACKET AND LINK ASSEMBLIES WITH SLOTTED ENTRY BEARINGS

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

Not applicable.

2. New Production Parts

Part No.	Desc.	Unit Price US Dollars
6A6487	Bracket	Price on request
VTB12350E	Bearing assy	162.00
VTB12351	Bearing	97.20
6A6489	Bracket	Price on request
6A6486	Bracket	Price on request
6A6491	Rod, stator	1104.00
6A6490	Link	Price on request
6A6488	Link	Price on request