

International Aero Engines

SERVICE BULLETIN

Jan. 12/00

Subject: Transmittal of Revision 1 to Service Bulletin V2500-ENG-75-0069

Service Bulletin Revision History:

Event	Date
Basic Issue	Oct.31/97
Revision 1	Jan. 12/00

Reason for Revision:

- (1) To revise 1. B. Concurrent Requirements and 1. L. References. To the effect that SB75-0069 must be fitted concurrently with either SB75-0070 or SB75-0079.

Effect on Past Compliance:

See above

List of Effective Pages:

Page No.	Revision No.	Effective Date
1 to 7	Revision 1	Jan. 12/00

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Transmittal
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AIR-HPC STAGE 10 BLEED VALVES - INTRODUCTION OF REVISED BLEED VALVE SILENCER
WITH INTEGRAL SEAL LAND

MODEL APPLICATION

V2525-D5
V2528-D5

BULLETIN INDEX LOCATION

75-00-00

Compliance Category Code

7

Internal Reference No

EC96VR016C

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AIR-HPC STAGE 10 BLEED VALVES - INTRODUCTION OF REVISED BLEED VALVE SILENCER WITH INTEGRAL SEAL LAND

1. Planning Information

A. Effectivity

(1) Aircraft:

- (a) Boeing - Douglas Product Division MD-90

(2) Engines:-

- (a) V2525-D5 Engines prior to Serial No.V20190
- (b) V2528-D5 Engines prior to Serial No.V20190

B. Concurrent Requirements

- R (1) This Service Bulletin must be fitted concurrently with either of the following IAE V2500
- R Service Bulletins :- Service Bulletin 75-0070 or Service Bulletin 75-0079. (See 1.L)

C. Reason

(1) Condition

A design review has shown that the manufacture of the HP compressor stage 10 bleed valve silencer of the HP Compressor can be easier.

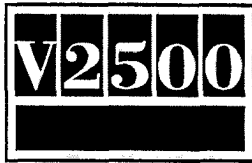
In addition, changes must be made to the silencer so that the bleed valve supplied by Parker Hannifin can be installed.

(2) Background

(See Condition)

(3) Objective

The purpose of this Service Bulletin is to make the process of manufacture easier.



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(4) Substantiation

A satisfactory engineering analysis and successful trail run on V2500 development engines have been done on the changes introduced by this Service Bulletin.

(5) Effect of Bulletin on :

Removal/Installation	Affected
Disassembly/Assembly	Not affected
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Affected
Testing	Not affected

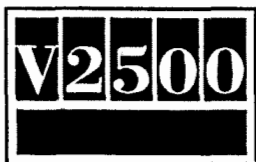
(6) Supplemental Information

None.

D. Description

(1) The changes introduced are as follows:

- (a) The seal of the stage 10 bleed-valve silencer has been made an integral part of the silencer. (Refer to step (b).)
- (b) A revised bleed valve silencer is introduced with changes that follow:
 - (i) The silencer caps have a different shape. They have been changed for the additional space envelope of the Parker Hannifin bleed valve.
 - (ii) The seal land has been made an integral part of the assembly.
 - (iii) To make the manufacture of the seal easier, several pressed radii and draw angles have been changed.
 - (iv) The exhaust hole has been changed to increase the flow area .
- (c) The length of the bolts that attach the silencer assembly to the bleed valve has been decreased.
- (d) The self locking plate nuts and associated rivets located on the air seal, have been replaced by standard self locking bi-hexagonal nuts.



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E. Approval

The part number changes and/or part modification described in Section 2 and 3 of this Modification Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model Listed.

F. Compliance

Category Code 7

Do this Service Bulletin when there are no initial parts remaining.

G. Manpower

Estimated man-hours to incorporate the full intent of this bulletin:-

<u>Venue</u>	<u>Estimated Man-hours</u>
(1) In Service	Not applicable
(2) At Over haul	No more time is necessary to do this Service Bulletin

NOTE: It is possible to get access to the parts affected by this Service Bulletin at overhaul.

H. Material - Price and Availability

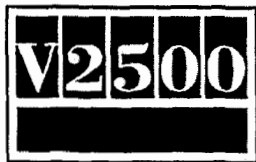
- (1) Modification Kit is not required.
- (2) See "Material Information" section for prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not necessary.

J. Weight and Balance

- | | |
|-------------------|--|
| (1) Weight change | Plus 0.27lb (0,123kg) |
| (2) Moment arm | 22.0in (558,8mm) Rearward. |
| (3) Datum | Engine front mount centreline
(Power Plant Station - PPS 100) |



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K. Electrical Load Data

This modification has no effect on the aircraft electrical load.

L. References

R (1) IAE V2500 reference Service Bulletins:-

R 75-0070 AIR - HP COMPRESSOR BLEED VALVES -INTRODUCTION
OF A PARKER HANNIFIN CORP. STAGE 10 HP
COMPRESSOR BLEED VALVE. 97VI004C/97VI012

R 75-0079 AIR - HP COMPRESSOR STAGE 10 BLEED VALVE –
INTRODUCTION OF A REVISED PARKER HANNIFIN
BLEED VALVE WITH INCREASED LENGTH IN THE PISTON
BORE. 98VI007

M. Other Publications Affected

- (1) Illustrated parts catalogue (IPC), Chapter/Section, 75-32-54.
- (2) Engine Manual (EM), Chapter/Section, 72-00-40, Removal-04 and Installation-07.
- (3) Repair schemes are affected.
- (4) MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section, 75-33-54
Removal/Installation

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2. Accomplishment Instructions

A. Rework Instructions

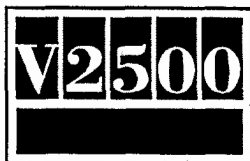
None

B. Assembly Instructions

- (1) Remove the silencer (6A4404) and seal (6A4415) from the stage-10 bleed-valve.
- (2) Install the silencer (6A6538) to the stage-10 bleed-valve.
- (3) For the correct removal/installation procedures refer to:
 - (a) MD-90 Aircraft Maintenance Manual (AMM), Chapter/Section, 75-33-54 Removal/Installation
or
 - (b) D5 Engine Manual (EM), Chapter/Section, 72-00-40, Removal-04 and Installation-07.

C. Recording Instructions

A record of accomplishment is necessary.



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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 (\$)	PART TITLE	OLD PART No. (IPC No.)	INSTR DISP
6A6538 (75-32-54)	1	3951.00	.Silencer assy,air, HP10-RH upper	6A4404 (01-350)	(A)(B)(S1)
- (75-32-54)	1		.Seal	6A4415 (01-365)	(B)(E)
4W0002 (75-32-54)	12	9.32	.Nut, self locking double hex (0.250 dia)	- (01-366)	(A)(C)(S1)
4W1244 (75-32-54)	12	8.50	.Bolt,hexagonal head (0.250 dia x 0.625)	AS49912 (01-368)	(A)(B)(1D) (S1)
- (75-32-54)	12		Nut,self locking plate	AS46726 (01-392)	(E)(1D)
- (75-32-54)	24		Rivet, solid countersunk head	AS16446 (01-394)	(E)(1D)

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

C. Instruction/Disposition Code

- (A) New part will be available from October 1997.
- (B) Old part will be discontinued.
- (C) Additional.
- (E) Redundant part.
- (S1) New parts coded (S1) are freely and fully interchangeable as a complete engine set with old parts coded (S1).
- (1D) Old part may be used up on other applications.

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