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V2500-A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Revision 4 of Service Bulletin V2500-ENG-75-0081.

Document History

Service Bulletin Revision Status

Initial Issue	May. 4/01.
Revision 1	Apr. 1/03.
Revision 2	Jun.11/04.
Revision 3	Oct. 5/05.

Service Bulletin Revision 4

Remove	Incorporate	Reason for change
All pages of the Service Bulletin.	Pages 1 to 84 of the Service Bulletin.	To add Rework Instructions. Minor editorial changes.
All pages of the Supplement.	Pages 1 to 3 of the Supplement.	To update the prices.

V2500-ENG-75-0081

Transmittal - Page 1 of 1

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise IAE International Aero Engines AG

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AIR – STAGE 10 TO HPT AIR VALVE – DELETION OF THE HPC STAGE 10 MAKE-UP AIR VALVE AND
ASSOCIATED HARDWARE

1. Planning Information

A. Effectivity

- (1) Airbus A319
V2522-A5, V2524-A5, V2527M-A5 Engines.
- (2) Airbus A320
V2527-A5, V2527E-A5 Engines.
- (3) Airbus A321
V2530-A5, V2533-A5 Engines.

B. Concurrent Requirements

- R (1) The IAE V2500 Service Bulletin that follows must be fitted prior to or
R concurrently with this Service Bulletin: 73-0170 (00VZ010) (Refer to
paragraph 1.N. References).

C. Reason

- R (1) Condition

A design review of the V2500-A5 engine has indicated that the air system
which supplies HPC stage 10 cooling air to the HPT may be simplified.
- (2) Background
- R See (1) Condition.
- (3) Objective

Incorporation of the changes introduced by this Service Bulletin
(Modification) is designed to simplify the HPC stage 10 to HPT cooling air
system.
- (4) Substantiation

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

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

R Affected (Refer to paragraph 1.0. Other Publications Affected).

(c) Overhaul

R Affected (Refer to paragraph 1.0. Other Publications Affected).

(d) Repair Schemes

Not affected.

(e) Interchangeability

R Affected (Refer to paragraph 1.B. Concurrent Requirements).

(f) Fits and Clearances

Not affected.

D. Description

- (1) The HPC stage 10 make-up air system is used to provide additional cooling air to the HPT stage 2 blades during high power manoeuvres with the air flow being shut off at cruise.

This Service Bulletin simplifies the system so that the air flows continuously throughout the entire flight cycle.

The changes introduced are:

- (a) The stage 10 make-up air valve is replaced by a continuous flow adaptor.
- (b) Revised bolts similar to the existing items, except for a reduction in length, to attach the adaptor.
- (c) The pipe fitting and seal, used to connect the make-up air valve to the existing air tube assembly PS3 tapping to No.4 bearing scavenge valve, are deleted.
- (d) The stage 10 air solenoid valve which controls the make-up air valve is deleted.

- (e) The three bolts, washers and two clip nuts used to attach the stage 10 air solenoid valve are deleted.
- (f) The two pipe fittings and seals used to connect the stage 10 air solenoid valve to the two air tube assemblies are deleted.
- (g) A revised solenoid mounting bracket, similar to the existing item except for:
 - (i) The material is changed from CP titanium to corrosion resistant steel 18-8(Nb).
 - (ii) The bracket is now manufactured from one piece and formed into a U shape.
 - (iii) The existing clipping point attachment hole has been moved slightly to allow for simplified geometry.
 - (iv) A second clipping point attachment hole is introduced.
- (h) Revised solenoid mounting bracket front attaching bolts, similar to the existing items except for a reduction in length and an increase in quantity from 1 to 2. Two washers are also introduced.
- (i) The three nuts which are used to attach the remaining bleed valve solenoid valve are changed from clip nuts to standard nuts.
- (j) A revised EEC Link core harness assembly, similar to the existing item except for:
 - (i) The electrical connector at position 4025KS-A is deleted along with all its associated parts.
 - (ii) Two twisted pairs of cables are removed between connector positions 4006VC and 4025KS-A.
 - (iii) The quantity of sealing plugs at connector position 4006VC is increased from 2 to 6.
 - (iv) A cable support bush at connector position 4006VC.
 - (v) Scotchboy 69 tape is applied at connector position 4006VC to suit the support bush inside diameter.
- (k) A revised EEC core harness assembly similar to the existing item except for:
 - (i) One pair of twisted cables is removed between connector positions 4006VC-A and 4009VC.

- (ii) One pair of twisted cables is removed between connector positions 4006VC-A and 4008VC.
 - (iii) The quantity of sealing plugs at connector position 4006VC-A is increased from 2 to 6.
 - (iv) The quantity of sealing plugs at connector position 4009VC is increased from 12 to 14.
 - (v) The quantity of sealing plugs at connector position 4008VC is increased from 16 to 18.
 - (vi) Scotchboy 69 tape is applied at connector positions 4006VC-A and 4008VC to suit the support bush inside diameter.
- (L) A revised EEC fan harness assembly similar to the existing item except for the following:
- (i) The electrical connector and associated parts at position 4028KS-A is deleted.
 - (ii) One pair of twisted cables is removed between connector positions 4028KS-A and 4000KS-J5.
 - (iii) One pair of twisted cables is removed between connector positions 4028KS-A and 4000KS-J11.
 - (iv) Two cables are removed between connector positions 4008VC-A and 4000KS-J2.
 - (v) Two cables are removed between connector positions 4009VC-A and 4000KS-J8.
 - (vi) The quantity of sealing plugs at connector position 4000KS-J5 is increased from 19 to 21.
 - (vii) The quantity of sealing plugs at connector position 4000KS-J11 is increased from 17 to 19.
 - (viii) The quantity of sealing plugs at connector position 4000KS-J2 is increased from 7 to 9.
 - (ix) The quantity of sealing plugs at connector position 4000KS-J8 is increased from 12 to 14.
 - (x) The quantity of sealing plugs at connector position 4008VC-A is increased from 16 to 18.
 - (xi) The quantity of sealing plugs at connector position 4009VC-A is increased from 12 to 14.

- (xii) Scotchboy 69 tape is applied at connector positions 4000KS-J5, 4000KS-J11, 4000KS-J2, 4000KS-J8, 4008VC-A and 4009VC-A to suit the support bush inside diameter.
- (m) The following tube assemblies are deleted:
 - (i) Air bleed valve solenoid (solenoid to tee piece).
 - (ii) Air On/Off valve (solenoid to disconnect).
 - (iii) Air BU air solenoid (disconnect to disconnect).
 - (iv) Air On/Off valve (bifurcation to disconnect).
 - (v) Air bleed valve control solenoid valve.
 - (vi) Air bleed valve control solenoid valve to on/off valve Bifurcation to disconnect.
- (n) The following tube assemblies are revised:
 - (i) Air servo to bleed valve solenoids.
 - (ii) Air PS3 (Pb) to EEC, disconnect to bifurcation panel (core).
 - (iii) Air stage 10 solenoid valve to stage 10 bleed valve (solenoid to disconnect).
 - (iv) Fuel Servo return (air mod valve) disconnect to tee piece.
- (o) A revised clipping support bracket similar to the existing item except for a change in profile and the introduction of a hole for wire locking of the No.4 bearing scavenge tube assembly.
- (p) A blanking plate along with its attaching nuts and bolts to seal the bifurcation panel when the tube at ((m)(iv)) above is deleted.
- (q) The clip points that follow are deleted:
CP0602, CP0758, CP1021, CP1024, CP5433, CP5763, CP5764, CP5765, CP5913, CP6099, CP6101.

(r) The clip points that follow are revised:

CP0254, CP0256, CP0257, CP0258, CP0517, CP0534, CP0540, CP0541,
CP0554, CP0558, CP0564, CP0576, CP0577, CP0581, CP0583, CP0585,
CP0590, CP0764, CP0765, CP0766, CP0767, CP0768, CP0769, CP0772,
CP0773, CP0774, CP0775, CP0777, CP0778, CP0779, CP0781, CP0783,
CP0787, CP0788, CP0789, CP0796, CP0797, CP0798, CP0799, CP0887,
CP1000, CP1005, CP1006, CP1009, CP1010, CP1011, CP1012, CP1014,
CP1017, CP1022, CP1023, CP1025, CP1029, CP1030, CP1040, CP1077,
CP1079, CP1084, CP1085, CP1086, CP1089, CP1090, CP1092, CP1112,
CP1113, CP1141, CP1172, CP1173, CP1174, CP1189, CP5431, CP5554,
CP5560, CP5647, CP5648, CP5652, CP5678, CP5679, CP5691, CP5692,
CP5694, CP5713, CP5714, CP5739, CP5747, CP5750, CP5751, CP5772,
CP5773, CP5788, CP5789, CP6058, CP6064, CP6065, CP6091, CP6100,
CP6103, CP6108.

(s) The content of the clip points that follow is unaffected, however tubes which are supported by these clip points have been revised, therefore no material information changes have been recorded:

CP0580, CP0792, CP1048, CP5766, CP6080, CP6095.

(t) The clip points that follow are additional:

CP1403, CP1404, CP5990, CP6107, CP6108.

E. Compliance

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

F. Approval

The part number changes and/or part modification described 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 models listed.

R The technical content of this Service Bulletin has been approved under the
R authority of the EASA Design Organization Approval N° EASA.21J.031.

G. Manpower

Estimated Man-hours to incorporate the full intent of this Service Bulletin:

(1) In Service

Not applicable.

- (2) At Overhaul/Shop Visit

Applicable (Hours not affected).

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

H. Material Price and Availability

- (1) Modification kit is not required

- (2) See supplement of this Service Bulletin for prices and availability of future spares

I. Tooling Price and Availability

Special tools are not required

J. Industry Support Information

Not applicable

K. Weight and Balance

- (1) Weight Change

Minus 8.2 lb (3,73 kg).

- (2) Moment Arm

R 1.8 in (45.7 mm) forward of datum.

- (3) Datum

R Engine Front Mount Centerline (Power Plant Station (PPS) 100).

L. Electrical Load Data

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

M. Software Accomplishment Summary

Not applicable.

N. References

- (1) IAE V2500 Reference Service Bulletins:

73-0170 Engine – Fuel and control – To provide a new A5 SCN16/U Electronic Engine Control (EEC).

- (2) Engine Manual, 72-00-32, Removal and Installation.
- (3) Engine Manual, 72-00-40, Removal and Installation.
- (4) Aircraft Maintenance Manual, 71-52-41, 71-52-42, 75-23-51, Removal/Installation.
- (5) Internal references EC99VR004 and EC99VR004D.
- (6) This Service Bulletin is subject to Aircraft Modification No. 31218.

Under no circumstances shall the modified equipment, resulting from the application of this SB, be installed on the aircraft type unless the corresponding modification, and if applicable, its aircraft SB are approved.

- (7) ATA Locator - 75-23-51.

0. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC) S-V2500-2IA, 2IB, 5IA, 5IB, 6IA, 6IB, 7IA and 7IB will be revised.
- (2) Engine Manual, 72-00-32, Removal and Installation.
- (3) Engine Manual, 72-00-40, Removal and Installation.
- (4) Component Maintenance Manuals:
 - (a) Miscellaneous Mechanical, 72-38-25, 75-23-48, 75-32-53, Cleaning and Inspection/Check.
 - (b) Tubes, Hoses and Ducts, 73-11-49, 73-22-49, 75-32-49, Cleaning and Inspection/Check.
 - (c) Electrical Harnesses and Cables, 71-51-41, 71-52-43, 71-52-44, Cleaning, Inspection/Check, Disassembly and Assembly.
- (5) Aircraft Maintenance Manual, 71-52-41, 71-52-42, 75-23-51, Removal/Installation.

P. Interchangeability of Parts

R Affected (Refer to paragraph 2.D. Instruction disposition codes).

2. Material Information

A. The kit required consists of the following parts:

None.

R B. Parts to be reworked:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
R 71-51-41					
R 01005	6A7557	1	Harness assy EEC fan	6A7450	(84D)
R 71-52-43					
R 01005	6A7570	1	Harness assy EEC core	6A5699	(84D)

C. Parts affected by this Service Bulletin:

All Engines

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
01005	6A7557	1	Harness assy EEC fan	6A7450	(A)(B)(S1)
01129	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1040)	TA025074-16	(C)(S1)(1D)
01129	-	1	Clamp loop style cushion (CP1040)	AS61914	(1D)
01169	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1174)	TA025074-16	(C)(S1)(1D)
01169	-	1	Clamp loop style cushion (CP1174)	AS61914	(1D)
01177	AS62509	1	Clamp loop style cushion 14,27 mm (0.562in.) (CP0254)	TA025074-10	(C)(S1)(1D)
01177	-	1	Clamp loop style cushion (CP0254)	AS61908	(1D)
01179	UP10478	1	Spacer 5 mm (CP0254)	5W1029	(C)(S2)(1D)
01185	AS62515	1	Clamp loop style cushion 23,83 mm (0.928in.) (CP0256)	TA025074-16	(C)(S1)(1D)
01185	-	1	Clamp loop style cushion (CP0256)	AS61914	(1D)
01190	4W0104	1	Bolt machine double hex 0.190in. x 0.562in. (CP0257)	4W0105	(C)(S1)(1D)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
01193	AS62513	1	Clamp loop style cushion 20,62 mm (0.812in.) (CP0257)	TA025074- 14	(C)(S1)(1D)
01193	-	1	Clamp loop style cushion (CP0257)	AS61912	(1D)
01201	AS62513	1	Clamp loop style cushion 20,62 mm (0.812in.) (CP0258)	TA025074- 14	(C)(S1)(1D)
01201	-	1	Clamp loop style cushion (CP0258)	AS61912	(1D)
01222	4W0102	1	Bolt, machine double hex 0.190in. x 0.438in. (CP1189)	4W0103	(C)(S1)(1D)
01225	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP1189)	AS62517	(C)(S1)(1D)
01230	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP1404)	-	(E)
01231	K8831	1	Washer 0.190in. dia (CP1404)	-	(E)
01233	AS62505	1	Clamp loop style cushion 7,92 mm (0.312in.) (CP1404)	-	(E)
01237	4W0001	1	Nut self locking double hex 0.190in. dia (CP1404)	-	(E)
01350	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP0517)	4W0104	(C)(S1)(1D)
01353	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP0517)	TA25074- 13	(C)(S1)(1D)
01353	-	1	Clamp loop style cushion (CP0517)	AS61911	(1D)
01478	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0534)	4W0104	(C)(S1)(1D)
01481	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0534)	TA025074- 17	(C)(S1)(1D)
01481	-	1	Clamp loop style cushion (CP0534)	AS61915	(1D)
01529	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0540)	TA025074- 16	(C)(S1)(1D)
01529	-	1	Clamp loop style cushion (CP0540)	AS61914	(1D)
01537	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0541)	TA025074- 16	(C)(S1)(1D)
01537	-	1	Clamp loop style cushion (CP0541)	AS61914	(1D)
01673	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0764)	AS62516	(C)(S1)(1D)
01674	AS62510	1	Clamp loop style cushion 15,88 mm (0.625in.) (CP0764)	AS62511	(C)(S1)(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 10

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
01678	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0765)	4W0104	(C)(S1)(1D)
01681	AS62519	1	Clamp loop style cushion 30,18 mm (1.188in.) (CP0765)	TA025074- 20	(C)(S1)(1D)
01681	-	1	Clamp loop style cushion (CP0765)	AS61918	(1D)
01686	4W0106	1	Bolt machine double hex 0.190in. dia x 0.688in. (CP0766)	4W0107	(C)(S1)(1D)
01689	AS62518	1	Clamp loop style cushion 28,58 mm (1.125in.) (CP0766)	TA025074- 19	(C)(S1)(1D)
01689	-	1	Clamp loop style cushion (CP0766)	AS61917	(1D)
01694	4W0106	1	Bolt machine double hex 0.190in. dia x 0.688in. (CP0767)	4W0107	(C)(S1)(1D)
01697	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP0767)	TA025074- 18	(C)(S1)(1D)
01697	-	1	Clamp loop style cushion (CP0767)	AS61916	(1D)
01702	4W0105	1	Bolt machine double hex 0.190in. dia x 0.625in. (CP0768)	4W0106	(C)(S1)(1D)
01705	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP0768)	TA025074 - 18	(C)(S1)(1D)
01705	-	1	Clamp loop style cushion (CP0768)	AS61916	(1D)
01710	4W0105	1	Bolt machine double hex 0.190in. dia x 0.625in. (CP0769)	4W0106	(C)(S1)(1D)
01713	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP0769)	TA025074- 18	(C)(S1)(1D)
01713	-	1	Clamp loop style cushion (CP0769)	AS61916	(1D)
01734	4W0104	1	Bolt machine double hex 0.190in. dia x 0.562in. (CP0772)	4W0106	(C)(S1)(1D)
01737	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0772)	TA025074- 16	(C)(S1)(1D)
01737	-	1	Clamp loop style cushion (CP0772)	AS61914	(1D)
01745	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP0773)	TA025074- 18	(C)(S1)(1D)
01745	-	1	Clamp loop style cushion (CP0773)	AS61916	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 11

IAE PROPRIETARY INFORMATION

Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 734.3(b)(3).

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
01750	4W0103	1	Bolt, machine double hex 0.190in. dia x 0.500in. (CP0774)	4W0104	(C)(S1)(1D)
01753	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0774)	TA025074- 17	(C)(S1)(1D)
01753	-	1	Clamp loop style cushion (CP0774)	AS61915	(1D)
01758	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP0775)	4W0103	(C)(S1)(1D)
01761	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0775)	TA025074- 17	(C)(S1)(1D)
01761	-	1	Clamp loop style cushion (CP0775)	AS61915	(1D)
01777	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0777)	TA025074- 17	(C)(S1)(1D)
01777	-	1	Clamp loop style cushion (CP0777)	AS61915	(1D)
01784	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0778)	TA025074- 17	(C)(S1)(1D)
01784	-	1	Clamp loop style cushion (CP0778)	AS61915	(1D)
01793	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0779)	TA025074- 17	(C)(S1)(1D)
01793	-	1	Clamp loop style cushion (CP0779)	AS61915	(1D)
01809	AS62521	1	Clamp loop style cushion 33,32 mm (1.312in.) (CP0781)	TA025074- 22	(C)(S1)(1D)
01809	-	1	Clamp loop style cushion (CP0781)	AS61920	(1D)
01825	AS62520	1	Clamp loop style cushion 31,75 mm (1.250in.) (CP0783)	AS62521	(C)(S1)(1D)
01857	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0787)	TA025074- 16	(C)(S1)(1D)
01857	-	1	Clamp loop style cushion (CP0787)	AS61914	(1D)
01865	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0788)	TA025074- 16	(C)(S1)(1D)
01865	-	1	Clamp loop style cushion (CP0788)	AS61914	(1D)
01870	4W0118	1	Bolt machine double hex 0.190in. dia x 1.438in. (CP0789)	AS20924	(C)(S1)(1D)
01873	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP0789)	TA025074- 16	(C)(S1)(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 12

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
01873	-	1	Clamp loop style cushion (CP0789)	AS61914	(1D)
01921	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP0796)	AS62513	(C)(S1)(1D)
01926	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0797)	4W0105	(C)(S1)(1D)
01928	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP0797)	TA025074- 13	(C)(S1)(1D)
01928	-	1	Clamp loop style cushion (CP0797)	AS61911	(1D)
01934	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0798)	4W0105	(C)(S1)(1D)
01936	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP0798)	TA025074- 13	(C)(S1)(1D)
01936	-	1	Clamp loop style cushion (CP0798)	AS61911	(1D)
01942	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0799)	4W0105	(C)(S1)(1D)
01944	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP0799)	TA025074- 13	(C)(S1)(1D)
01944	-	1	Clamp loop style cushion (CP0799)	AS61911	(1D)
01950	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1000)	4W0105	(C)(S1)(1D)
01953	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP1000)	TA025074- 13	(C)(S1)(1D)
01953	-	1	Clamp loop style cushion (CP1000)	AS61911	(1D)
01990	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1005)	4W0105	(C)(S1)(1D)
01993	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP1005)	TA025074- 13	(C)(S1)(1D)
01993	-	1	Clamp loop style cushion (CP1005)	AS61911	(1D)
02007	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP1006)	4W0103	(C)(S1)(1D)
02010	AS62511	1	Clamp loop style cushion 17,48 mm (0.688in.) (CP1006)	TA025074- 12	(C)(S1)(1D)
02010	-	1	Clamp loop style cushion (CP1006)	AS61910	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 13

IAE PROPRIETARY INFORMATION

Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 754.3(b)(3).

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
02031	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1009)	4W0105	(C)(S1)(1D)
02034	AS62507	1	Clamp loop style cushion 11,13 mm (0.438in.) (CP1009)	TA025074- 08	(C)(S1)(1D)
02034	-	1	Clamp loop style cushion (CP1009)	AS61906	(1D)
02042	AS62507	1	Clamp loop style cushion 11,13 mm (0.438in.) (CP1010)	TA025074- 08	(C)(S1)(1D)
02042	-	1	Clamp loop style cushion (CP1010)	AS61906	(1D)
02050	AS62507	1	Clamp loop style cushion 11,13 mm (0.438in.) (CP1011)	TA025074- 08	(C)(S1)(1D)
02050	-	1	Clamp loop style cushion (CP1011)	AS61906	(1D)
02058	AS62512	1	Clamp loop style cushion 19,05 mm (0.750in.) (CP1012)	TA025074- 12	(C)(S1)(1D)
02058	-	1	Clamp loop style cushion (CP1012)	AS61910	(1D)
02074	AS62511	1	Clamp loop style cushion 17,48 mm (0.688in.) (CP1014)	TA025074- 12	(C)(S1)(1D)
02074	-	1	Clamp loop style cushion (CP1014)	AS61910	(1D)
02090	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP1017)	TA025074- 18	(C)(S1)(1D)
02090	-	1	Clamp loop style cushion (CP1017)	AS61916	(1D)
02119	-	1	Bolt machine double hex (CP1021)	4W0103	(1D)
02120	-	1	Washer (CP1021)	5W1086	(1D)
02122	-	1	Clamp loop style cushion (CP1021)	AS61903	(1D)
02122	-	1	Clamp loop style cushion (CP1021)	TA025074- 05	(1D)
02126	-	1	Nut self locking double hex (CP1021)	4W0001	(1D)
02127	4W0107	1	Bolt machine double hex 0.190in. dia x 0.750in. (CP1022)	4W0108	(C)(S1)(1D)
02130	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1022)	TA025074- 16	(C)(S1)(1D)
02130	-	1	Clamp loop style cushion (CP1022)	AS61914	(1D)
02138	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1023)	TA025074- 16	(C)(S1)(1D)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
02138	-	1	Clamp loop style cushion (CP1023)	AS61914	(1D)
02293	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1077)	4W0104	(C)(S1)(1D)
02296	AS62521	1	Clamp loop style cushion 33,32 mm (1.312in.) (CP1077)	TA025074- 22	(C)(S1)(1D)
02296	-	1	Clamp loop style cushion (CP1077)	AS61920	(1D)
02309	4W0119	1	Bolt machine double hex 0.190in. dia x 1.500in. (CP1084)	AS21425	(C)(S1)(1D)
02312	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP1084)	TA025074- 18	(C)(S1)(1D)
02312	-	1	Clamp loop style cushion (CP1084)	AS61916	(1D)
02317	4W0119	1	Bolt machine double hex 0.190in. dia x 1.500in. (CP1085)	AS21425	(C)(S1)(1D)
02320	AS62517	1	Clamp loop style cushion 26,97 mm (1.062in.) (CP1085)	TA025074- 18	(C)(S1)(1D)
02320	-	1	Clamp loop style cushion (CP1085)	AS61916	(1D)
02336	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1086)	TA025074- 16	(C)(S1)(1D)
02336	-	1	Clamp loop style cushion (CP1086)	AS61914	(1D)
02344	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP1172)	TA025074- 17	(C)(S1)(1D)
02344	-	1	Clamp loop style cushion (CP1172)	AS61915	(1D)
02381	4W0104	1	Bolt machine double hex 0.190in. dia x 0.562in. (CP0887)	4W0107	(C)(S1)(1D)
02384	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP0887)	TA025074- 17	(C)(S1)(1D)
02384	-	1	Clamp loop style cushion (CP0887)	AS61915	(1D)
02389	4W0103	1	Bolt machine double hex 0.190 dia x 0.500 (CP1092)	4W0104	(C)(S1)(1D)
02392	AS62511	1	Clamp loop style cushion 17,48 mm (0.688in.) (CP1092)	TA025074- 12	(C)(S1)(1D)
02392	-	1	Clamp loop style cushion (CP1092)	AS61910	(1D)
02448	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP1112)	TA025074- 17	(C)(S1)(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 15

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
71-51-41					
02448	-	1	Clamp loop style cushion (CP1112)	AS61915	(1D)
02453	4W0116	1	Bolt machine double hex 0.190in. dia x 1.312in. (CP1113)	4W0117	(C)(S1)(1D)
02456	AS62514	1	Clamp loop style cushion 22,23 mm (0.875in.) (CP1113)	TA025074- 15	(C)(S1)(1D)
02456	-	1	Clamp loop style cushion (CP1113)	AS61913	(1D)
02540	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1141)	TA025074- 16	(C)(S1)(1D)
02540	-	1	Clamp loop style cushion (CP1141)	AS61914	(1D)
02542	4W0107	1	Bolt machine double hex 0.190in. dia x 0.750in. (CP1141)	4W0108	(C)(S1)(1D)
03230	-	1	Clamp backshell	ESC65E14	(1D)
03817	-	1	Bush	ESC53-28	(K)(2D)
03817	-	1	Bush	SF15	(K)(2D)
04029	MS27488-20	2	Plug sealing (V96906)	-	(3D)
04089	MS27488-20	2	Plug sealing (V96906)	-	(4D)
04109	MS27488-20	2	Plug sealing (V96906)	-	(5D)
04169	MS27488-20	2	Plug sealing (V96906)	-	(6D)
04189	MS3187- 16-2	2	Plug sealing (V96906)	-	(7D)
04209	MS3187- 16-2	2	Plug sealing (V96906)	-	(5D)
04230	-	1	Connector	ESC10 SE61407S80	(1D)
04237	-	7	Contact socket	ESC30S16BC	(1D)
04249	-	3	Plug sealing (V96906)	MS3187- 16-2	(1D)
07028	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1173)	TA025074- 16	(C)(S1)(1D)
07028	-	1	Clamp loop style cushion (CP1173)	AS61914	(1D)

71-51-44

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01150	4W0106	1	Bolt machine double hex 0.190in. dia x 0.688in. (CP5713)	4W0107	(C)(S1)(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 16

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
R 01153	AS62508	1	Clamp loop style cushion 12,70 mm (0.500in.) (CP5713)	AS62509	(C)(S1)(1D)
01161	AS62508	1	Clamp loop style cushion 12,70 mm (0.500in.) (CP5714)	AS62509	(C)(S1)(1D)
01249	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1089)	TA025074- 16	(C)(S1)(1D)
01249	-	1	Clamp loop style cushion (CP1089)	AS61914	(1D)
01257	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP1090)	TA025074- 16	(C)(S1)(1D)
01257	-	1	Clamp loop style cushion (CP1090)	AS61914	(1D)
01273	AS62514	1	Clamp loop style cushion 22,23 mm (0.875in.) (CP6091)	AS62515	(C)(S1)(1D)
01310	-	1	Bolt machine double hex (CP6099)	4W0103	(1D)
01313	-	1	Clamp loop style cushion (CP6099)	AS62506	(1D)
01317	-	1	Nut self locking double hex (CP6099)	4W0001	(1D)
01321	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP6103)	AS62516	(C)(S1)(1D)

71-52-43

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01005	6A7570	1	Harness assy - Core EEC	6A5699	(A)(B)(S1)
01057	AS62506	1	Clamp loop style cushion 9,53 mm (0.375in.) (CP5560)	TA025074- 07	(C)(S1)(1D)
01057	-	1	Clamp loop style cushion (CP5560)	AS61905	(1D)
01065	AS62508	1	.Clamp loop style cushion (12,70mm (0.500))(CP5747)	-	(E)
01081	AS62506	1	.Clamp loop style cushion (9,53mm) (0.375))(CP6058)	-	(E)
01086	4W0102	1	.Bolt machine double hex (.190 dia x .438)(CP6107)	-	(E)
01087	5W1086	1	.Washer (CP6107)	-	(E)
01089	AS62506	1	.Clamp loop style cushion (9,53mm) (0.375))(CP6107)	-	(E)
01093	4W0001	1	.Nut self locking dbl hex (.190 - dia)(CP6107)	-	(E)
01113	AS62515	1	Clamp loop style cushion 23,83 mm (0.938in.) (CP5678)	AS62516	(C)(S1)(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 17

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01118	4W0110	1	Bolt machine double hex 0.190in. dia x 0.938in. (CP5679)	4W0111	(C)(S1)(1D)
01121	AS62516	1	Clamp loop style cushion 25,40 mm (1.000in.) (CP5679)	AS62517	(C)(S1)(1D)
01214	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP5691)	4W0104	(C)(S1)(1D)
01217	AS62511	1	Clamp loop style cushion 17,48 mm (0.688in.) (CP5691)	TA025074- 12	(C)(S1)(1D)
01217	-	1	Clamp loop style cushion (CP5691)	AS61910	(1D)
01222	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP5692)	4W0104	(C)(S1)(1D)
01225	AS62511	1	Clamp loop style cushion 17,48 mm (0.688in.) (CP5692)	TA025074- 12	(C)(S1)(1D)
01225	-	1	Clamp loop style cushion (CP5692)	AS61910	(1D)
01238	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP5694)	4W0104	(C)(S1)(1D)
01241	AS62508	1	Clamp loop style cushion 12,70 mm (0.500in.) (CP5694)	TA025074- 09	(C)(S1)(1D)
01241	-	1	Clamp loop style cushion (CP5694)	AS61907	(1D)
01377	AS62504	1	Clamp loop style cushion 6,35 mm (0.250in.) (CP5751)	TA025074- 05	(C)(S1)(1D)
01377	-	1	Clamp loop style cushion (CP5751)	AS61903	(1D)
R 01385	AS62503	1	Clamp loop style cushion 4,77 mm (0.188in.) (CP5750)	TA025074- 04	(C)(S1)(1D)
01385	-	1	Clamp loop style cushion (CP5750)	AS61902	(1D)
01422	-	1	Bolt machine double hex (CP5764)	4W0102	(1D)
01425	-	1	Clamp loop style cushion (CP5764)	AS62506	(1D)
01429	-	1	Nut A/O self locking (CP5764)	4W0043	(1D)
01430	-	1	Bolt machine double hex (CP5763)	4W0102	(1D)
01433	-	1	Clamp loop style cushion (CP5763)	AS62506	(1D)
01437	-	1	Nut A/O self locking (CP5763)	4W0043	(1D)
01438	-	1	Bolt machine double hex (CP5765)	4W0102	(1D)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01441	-	1	Clamp loop style cushion (CP5765)	AS62508	(1D)
01445	-	1	Nut A/O self locking (CP5765)	4W0043	(1D)
01446	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP5772)	4W0107	(C)(S1)(1D)
01449	AS62506	1	Clamp loop style cushion 9,53 mm. (0.375in.) (CP5772)	TA025074- 07	(C)(S1)(1D)
01449	-	1	Clamp loop style cushion (CP5772)	AS61905	(1D)
01454	4W0109	1	Bolt machine double hex 0.190in. dia x 0.875in. (CP5773)	4W0112	(C)(S1)(1D)
01457	AS62506	1	Clamp loop style cushion 9,53 mm (0.375in.) (CP5773)	TA025074- 07	(C)(S1)(1D)
01457	-	1	Clamp loop style cushion (CP5773)	AS61905	(1D)
04029	MS27488-16	2	Plug sealing (V96906)	-	(7D)
04049	MS27488-16	2	Plug sealing (V96906)	-	(5D)
04209	MS27488-16	4	Plug sealing (V96906)	-	(8D)

71-52-44

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01005	6A7569	1	Harness assy - Core EEC link	6A5877	(A)(B)(S1)
01070	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP5554)	4W0103	(C)(S1)(1D)
01073	ST1455-04	1	Clip (V77445) (CP5554)	ST1455-07	(C)(F)(S1) (1D)
01073	TA0210046 FT04	1	Clip (V84971) (CP5554)	TA0210046 FT07	(C)(F)(S1) (1D)
01102	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP5739)	4W0103	(C)(S1)(1D)
01105	ST1455-04	1	Clip (V77445) (CP5739)	ST1455-07	(C)(G)(S1) (1D)
01105	TA0210046 FT04	1	Clip (V84971) (CP5739)	TA0210046 FT07	(C)(G)(S1) (1D)
01110	4W0106	1	Bolt machine double hex 0.190in. dia x 0.688in. (CP5788)	4W0107	(C)(S1)(1D)
01113	-	1	Clip (CP5788)	ST1455-05	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 19

IAE PROPRIETARY INFORMATION

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01113	-	1	Clip (CP5788)	TA0210046 FT05	(1D)
01118	4W0109	1	Bolt machine double hex 0.190in. dia x 0.875in. (CP5789)	4W0110	(C)(S1)(1D)
01119	-	1	Washer (CP5789)	5W1086	(9D)
01121	-	1	Clip (CP5789)	ST1455-04	(1D)
01121	-	1	Clip (CP5789)	TA0210046 FT04	(1D)
03030	-	1	Clamp	1021444	(1D)
03784	-	1	I/Blank	2A1422	(10D)
03815	ESC53-32	1	Bush	-	(E)(H)
03815	SF56	1	Bush (VK7823)	-	(E)(H)
03970	U440036	1	Tape (Bulk Stock U322742) 33 me, 108 ft reel	-	(E)(J)
04029	MS27488-16	4	Plug sealing (V96906)	-	(8D)
04030	-	1	Plug	T3K1211- 98SN	(1D)
04030	-	1	Plug assy	MT938T11 K98S	(1D)
04035	-	6	Contact socket	5100-101- 0120	(1D)
04035	-	6	Contact socket	T3-4120- 36LD	(1D)
04049	-	2	Plug sealing	MS27488-20	(1D)

72-38-25

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01290	LK62478	1	Cover	-	(E)
01292	4W0163	2	Bolt machine double hex 0.250in. dia x 0.562in.	-	(E)
01294	4W0002	2	Nut self locking double hex 0.250in. dia	-	(E)

73-11-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
12165	4W0120	1	Bolt machine double hex 0.190in. dia x 1.562in. (CP5747)	4W0109	(C)(S1)(1D)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
12171	UP10480	1	Spacer 15 mm (CP5747)	–	(E)
12173	4W0128	1	Bolt machine double hex 0.190in. dia x 2.125in. (CP6058)	4W0115	(C)(S1)(1D)
12179	UP10481	1	Spacer 20 mm (CP6058)	–	(E)
16162	EU53042	1	Spacer (CP5648)	LK42781	(C)(S1)(1D)
16163	–	1	Spacer (CP5648)	LK64582	(1D)
19565	4W0108	1	Bolt machine double hex 0.190in. dia x 0.812in. (CP6100)	4W0119	(C)(S1)(1D)
19570	–	1	Spacer (CP6100)	LK42781	(1D)
20149	–	1	Bolt machine double hex (CP0758)	4W0103	(1D)
20150	–	2	Washer (CP0758)	5W1086	(1D)
20152	–	1	Clip (CP0758)	400WSS8	(1D)
20156	–	1	Nut self locking double hex (CP0758)	4W0001	(1D)
24500	6A6193	1	Tube assy – Fuel – Servo return disconn to tee piece	6A5359	(A)(B)(S1)
24525	4W0123	1	Bolt machine double hex 0.190in. dia x 1.750in. (CP0576)	4W0124	(C)(S1)(1D)
24533	4W0102	1	Bolt machine double hex 0.190in. dia x 0.438in. (CP0564)	4W0103	(C)(S1)(1D)
24541	–	1	Bolt machine double hex (CP0602)	4W0102	(1D)
24542	–	1	Washer (CP0602)	5W1086	(1D)
24544	–	1	Clip (CP0602)	AS62404	(1D)
24548	–	1	Nut self locking double hex (CP0602)	4W0001	(1D)
24552	AS62404	1	Clip 6,35 mm (0.250in.) (CP1079)	–	(E)

73-22-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
03125	4W0107	1	Bolt machine double hex 0.190in. dia x 0.750in. (CP0577)	4W0108	(C)(S1)(1D)
05125	–	1	Bolt bihex hd (CP5433)	AS20909	(1D)
05126	–	1	Washer (CP5433)	K8831	(1D)
05128	–	1	Clamp loop style cushion (CP5433)	TA025022- 04	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 21

IAE PROPRIETARY INFORMATION

Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 15.106 (b)(3).



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
05132	-	1	Nut self locking double hex (CP5433)	4W0001	(1D)
05157	4W0107	1	Bolt machine double hex 0.190in. dia x 0.750in. (CP6108)	-	(E)
05160	TA025022- 04	1	Clamp loop style cushion 6,35 mm (0.250in.) (CP6108)	-	(E)
05162	LK65219	1	Spacer (CP6108)	-	(E)
05164	4W0001	1	Nut self locking double hex 0.190in. dia (CP6108)	-	(E)
05333	4W0121	1	Bolt machine double hex 0.190in. dia x 1.625in. (CP6064)	AS20930	(C)(S1)(1D)
05341	4W0119	1	Bolt machine double hex 0.190in. dia x 1.500in. (CP5652)	-	(C)(S3)(16D)
05342	K8831	1	Washer 0.190in. dia (CP5652)	-	(12D)
05346	UP10481	1	Spacer 20 mm (CP5652)	-	(13D)
05347	UP10478	1	Spacer 5 mm (CP5652)	-	(14D)
05348	4W0001	1	Nut self locking double hex 0.190in. dia (CP5652)	-	(15D)
05500	6A6192	1	Tube assy - Air - PS3 to EEC disconnect to Bif Panel	6A6011	(A)(B)(S1)
05557	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP5647)	4W0116	(C)(S1)(1D)
05562	-	1	Spacer (CP5647)	LK51288	(1D)
05614	UP11152	1	Bracket inter tube support	-	(11D)

75-22-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
05149	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP6065)	-	(17D)
05150	K8831	1	Washer 0.190in. dia (CP6065)	-	(18D)
05156	4W0001	1	Nut self locking double hex 0.190in. dia (CP6065)	-	(19D)
05525	-	1	Bolt machine double hex (CP6101)	4W0102	(1D)
05526	-	1	Washer (CP6101)	5W1086	(1D)
05528	-	1	Clip (CP6101)	AS62405	(1D)
05532	-	1	Nut self locking double hex (CP6101)	4W0001	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 22



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
05576	-	1	Clip (CP6099)	AS62405	(1D)

75-23-48

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01100	-	1	Tube A/O air B/Val solenoid	5A9141	(B)(L)
01200	-	2	Wire thrust	AS15778	(1D)
01201	-	2	Nut tube coupling	AS15702	(1D)
01202	-	1	Ferrule welding tube	AS15724	(1D)
01240	-	1	Wire thrust	AS15778	(1D)
01241	-	1	Nut tube coupling	AS15702	(1D)
01242	-	1	Ferrule elbow	5W8144	(1D)
01470	-	1	.Bracket	5W8446	(78D)
01471	-	1	.Nut (see appendix 5)	4W0002	(79D)
01474	-	1	.Bolt (see appendix 5)	4W0164	(80D)
01500	-	1	Tube A/O air on/off valve	5A9143	(B)(L)
01552	-	1	Clip (CP0590)	400WSS4	(1D)
01557	-	1	Bolt, machine double hex 0.190in. dia x 0.500in. (CP1029)	4W0103	(39D)
01558	-	1	Washer (CP1029)	5W1086	(40D)
01560	-	1	Clip (CP1029)	400WSS4	(1D)
01564	-	1	Nut, A/O self locking 0.190in. dia (CP1029)	4W0043	(41D)
01565	-	1	Bolt, machine double hex 0.190in. dia x 0.500in. (CP1030)	4W0103	(42D)
01566	-	1	Washer (CP1030)	5W1086	(43D)
01568	-	1	Clip (CP1030)	400WSS4	(1D)
01572	-	1	Nut, A/O self locking 0.190in. dia (CP1030)	4W0043	(44D)
01600	-	1	Wire thrust	AS15777	(1D)
01601	-	1	Nut tube coupling	AS15701	(1D)
01602	-	1	Ferrule assy elbow	5W8143	(1D)
01614	-	1	Lug brazed	5W1059	(1D)
01618	-	1	Adapter	AS15802	(1D)
02100	-	1	Tube assy air B.U. air solenoid	5A8759	(B)(L)
02128	-	1	Clip (CP0585)	400WSS4	(1D)
02136	-	1	Clip (CP0583)	400WSS4	(1D)
02144	-	1	Clip (CP0581)	400WSS4	(1D)
02152	-	1	Clip (CP0577)	400WSS4	(1D)
02160	-	1	Clip (CP0576)	AS62404	(1D)
02200	-	1	Wire thrust	AS15777	(1D)
02201	-	1	Nut tube coupling	AS15701	(1D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 23

IAE PROPRIETARY INFORMATION

Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 754.3(b)(3).

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
02202	-	1	Ferrule assy	AS15768	(1D)
02242	-	1	Adapter	AS15802	(1D)
02500	-	1	Tube A/O air on/off valve	5A9076	(B)(L)
02510	-	2	Nut self locking double hex	4W0002	(1D)
02514	-	2	Bolt machine double hex	4W0163	(1D)
02528	-	1	Clip (CP0564)	AS62404	(1D)
02536	-	1	Clip (CP0758)	400WSS4	(1D)
02600	-	1	Wire thrust	AS15777	(1D)
02601	-	1	Nut tube coupling	AS15701	(1D)
02602	-	1	Ferrule assy	AS15768	(1D)
02614	-	1	Lug brazed	5W1059	(1D)
02618	-	1	Adapter union flanged	5W8019	(1D)
03100	-	1	Tube A/O - Air - Bleed valve control solenoid to on/off valve	6A6006	(B)(L)
03160	-	1	Clip (CP6100)	AS62404	(1D)
03168	-	1	Clip (CP5648)	AS62404	(1D)
03176	-	1	Clip (CP5647)	AS62404	(1D)
03200	-	1	Wire thrust	AS15777	(1D)
03201	-	1	Nut tube coupling	AS15701	(1D)
03202	-	1	Ferrule assy	AS15768	(1D)
03214	-	5	Bracket inter tube support	UP11152	(1D)
03240	-	1	Wire thrust	AS15777	(1D)
03241	-	1	Nut tube coupling	AS15701	(1D)
03242	-	1	Ferrule assy	AS15768	(1D)
03500	-	1	Tube A/O - Air - BV control solenoid valve	6A5310	(B)(L)
03557	-	1	Bolt bihex hd (CP5652)	AS20927	(20D)
03558	-	1	Washer 0.190in. dia (CP5652)	K8831	(45D)
03560	-	1	Clip (CP5652)	400WSS4	(1D)
03561	-	1	Spacer 5 mm (CP5652)	UP10478	(46D)
03562	-	1	Spacer 20 mm (CP5652)	UP10481	(47D)
03564	-	1	Nut self locking dbl hex 0.190in. dia (CP5652)	4W0001	(48D)
03568	-	1	Clip (CP6064)	400WSS4	(1D)
03573	-	1	Bolt bihex hd (CP6065)	AS20910	(21D)
03574	-	1	Washer 0.190in. dia (CP6065)	K8831	(49D)
03576	-	1	Clip (CP6065)	400WSS4	(1D)
03580	-	1	Nut, self locking double hex 0.190in. dia (CP6065)	4W0001	(50D)
03581	-	1	Bolt machine double hex (CP5431)	4W0103	(76D)
03582	-	1	Washer (CP5431)	5W1086	(1D)
03584	-	1	Clip (CP5431)	400WSS4	(1D)
03588	-	1	Nut A/O self locking (CP5431)	4W0043	(77D)
03600	-	1	Wire thrust	AS15777	(B)(L)
03601	-	1	Nut tube coupling	AS15701	(B)(L)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
03602	-	1	Ferrule assy	AS15768	(B)(L)
03614	-	1	Bracket inter tube support	UP11152	(B)(L)
03642	-	1	Adapter	AS15802	(B)(L)
04390	6A7620	1	Bracket	-	(A)(E)
04400	6A7555	1	Adapter HPC stage 10 make-up air	-	(A)(E)
04410	4W0226	4	Bolt machine double hex 0.3125in. dia x 0.812in.	-	(C)(E)
04420	5U0001	1	Seal C	-	(S3)(25D)

75-23-51

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01010	-	1	Bracket	5W8467	(B)(L)
01100	-	1	Valve air stage 10 to HPT	5860010- 108	(B)(L)
01110	-	4	Bolt machine double hex	4W0227	(1D)
01120	-	1	Seal, C	5U0001	(51D)
01150	-	1	Fitting	5863291- 101	(B)(L)
01155	-	1	Seal boss	5863292- 101	(B)(L)

75-23-52

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01100	-	1	Valve solenoid stage 10	AC69674	(B)(L)
01110	-	3	Bolt machine double hex	4W0108	(1D)
01113	-	3	Washer	4W2621	(1D)
01115	-	2	Nut A/O self locking	4W0043	(1D)
01130	-	1	Union double-ended	5A0838	(1D)
01133	-	1	Ring sealing toroidal	5A0840	(1D)
01140	-	1	Union double-ended	5A0839	(1D)
01143	-	1	Ring sealing toroidal	5A0841	(1D)
01500	-	1	Bracket assy	5A0336	(29D)
01510	-	1	Bolt machine double hex	4W0104	(30D)
01518	-	1	Nut self locking double hex 0.250in. dia	4W0002	(52D)
01520	-	1	Bolt, machine double hex 0.250in. dia x 0.625in.	4W0164	(53D)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01570	-	1	Bracket	745-5135-501	(22D)
01573	-	1	Bolt	NAS6303U5	(23D)
01574	-	1	Bolt	NAS6303U4	(24D)
01598	-	1	Packing	745-5143-501	(26D)
01600	-	1	Bracket raft	745-5133-505	(27D)
01610	-	2	Nut, self locking double hex (0.250in. dia)	4W0002	(28D)
01612	-	2	Bolt, machine double hex 0.250in. dia x 0.750in.	4W0166	(56D)
01650	-	1	Bracket	740-5134-503	(57D)
01651	-	2	Nut	NAS1291 C4M	(58D)
01652	-	2	Washer, flat	SP155E	(59D)
01653	-	1	Packing, piece	740-5139-501	(60D)
01654	-	2	Bolt, 100 degree head	NAS7204U6	(61D)

75-32-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
02500	6A6191	1	Tube assy - Air - Servo to bleed valve solenoid	5A9139	(A)(B)(S1)
02528	AS62408	1	Clip 12,70 mm (0.500in.) (CP0558)	400WSS8	(C)(S1)(1D)
02541	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0554)	4W0105	(C)(S1)(1D)
02544	AS62408	1	Clip 12,70 mm (0.500in.) (CP0554)	400WSS8	(C)(S1)(1D)
02557	4W0106	1	Bolt machine double hex 0.190in. dia x 0.688in. (CP1025)	4W0107	(C)(S1)(1D)
02560	AS62408	1	Clip 12,70 mm (0.500in.) (CP1025)	400WSS8	(C)(S1)(1D)
02618	-	1	Connector tee	5A8129	(10D)
03470	5W8446	1	.Bracket	-	(81D)
03472	4W0164	1	.Bolt option (.250 dia x .625)	-	(82D)
03474	4W0002	1	.Nut, self locking dbl hex (.250 dia)	-	(83D)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
03500	6A6194	1	Tube A/O - Air - Stage 10 solenoid valve to stage 10 bleed valve	5A9146	(A)(B)(S1)
03549	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0590)	4W0104	(C)(S1)(1D)
03557	-	1	Bolt machine double hex (CP1024)	4W0103	(1D)
03558	-	1	Washer (CP1024)	5W1086	(1D)
03560	-	1	Clip (CP1024)	400WSS4	(1D)
03564	-	1	Nut self locking double hex (CP1024)	4W0001	(1D)
03565	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1029)	-	(31D)
03566	5W1086	1	Washer (CP1029)	-	(32D)
03571	4W0043	1	Nut A/O self locking 0.190in. dia (CP1029)	-	(33D)
03573	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1030)	-	(34D)
03575	5W1086	1	Washer (CP1030)	-	(35D)
03580	4W0043	1	Nut A/O self locking 0.190in. dia (CP1030)	-	(36D)
03581	4W0115	1	Bolt machine double hex 0.190in. dia x 1.250in. (CP1403)	-	(E)
03584	AS62404	1	Clip 6,35 mm (0.250in.) (CP1403)	-	(E)
03586	UP10481	1	Spacer 20 mm (CP1403)	-	(E)
03588	4W0001	1	Nut self locking double hex 0.190in. dia (CP1403)	-	(E)
03614	UP11152	1	Bracket inter tube support	-	(E)
07557	4W0105	1	Bolt machine double hex 0.190in. dia x 0.625in. (CP1014)	4W0106	(C)(S1)(1D)

75-32-53

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01406	4W0001	3	Nut self locking double hex 0.190in. dia	4W0043	(C)(S1)(1D)
01500	6A7556	1	Bracket - Stage 10 air solenoid valve	-	(S3)(37D)

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 27

IAE PROPRIETARY INFORMATION

Not subject to the E.A.R. per 15 C.F.R. Chapter I, Part 754.3(b)(3).

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01510	4W0103	2	Bolt machine double hex 0.190in. dia x 0.500in.	—	(S3)(38D)
01512	4W2621	2	Washer	—	(E)
01518	4W0002	1	Nut self locking double hex 0.250in. dia	—	(54D)
01520	4W0164	1	Bolt machine double hex 0.250in. dia x 0.625in.	—	(55D)
01570	745-5135- 501	1	Bracket	—	(62D)
01573	NAS6303U5	1	Bolt	—	(63D)
01574	NAS6303U4	1	Bolt	—	(64D)
01598	745-5143- 501	1	Packing	—	(65D)
01600	745-5133- 505	1	Bracket raft	—	(66D)
01610	4W0002	2	Nut self locking double hex 0.250in. dia	—	(67D)
01612	4W0166	2	Bolt machine double hex 0.250in. dia x 0.750in.	—	(68D)
01650	740-5134- 503	1	Bracket	—	(69D)
01651	NAS1291C4M	2	Nut	—	(70D)
01652	SP155E	2	Washer, flat	—	(71D)
01653	740-5139- 501	1	Packing, piece	—	(72D)
01654	NAS7204U6	2	Bolt, 100 degree head	—	(73D)

79-22-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
02133	4W0113	1	Bolt machine double hex 0.190in. dia x 1.125in. (CP1079)	4W0106	(C)(S1)(1D)
02139	UP10479	1	Spacer 10 mm (CP1079)	—	(E)
04525	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP0558)	4W0104	(C)(S1)(1D)
10533	4W0103	1	Bolt machine double hex 0.190in. dia x 0.500in. (CP1010)	4W0104	(C)(S1)(1D)
10540	4W0001	1	Nut, self locking double hex 0.190in. dia (CP1010)	4W0043	(C)(S1)(1D)

V2500-A5 Nacelles Only

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Page 28

36-21-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01560	-	1	Clamp assy (CP5433)	C10GT3-04	(1D)
01562	C10GT3-04	1	Clamp assy (CP6108)	-	(C)(E)

71-52-41

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01050	-	1	Bolt, bihex hd 0.190in. dia x 0.438in. (CP5913)	AS21407	(1D)
01052	-	1	Washer, flat 0.190in. dia (CP5913)	SP154D	(1D)
01054	-	1	Clamp, loop style, cushion 0.313in. dia (CP5913)	TA02504-05	(1D)
01054	-	1	Clamp, loop style, cushion 7,92 mm (0.312in.) (CP5913)	AS61903	(1D)
01056	-	1	Clamp, loop style, cushion 0.313in. dia (CP5913)	TA025074-05	(1D)
01056	-	1	Clamp, loop style, cushion 7,92 mm (0.312in.) (CP5913)	AS61903	(1D)
01058	-	1	Nut, self locking, bihex 0.190in. dia (CP5913)	AS20624	(1D)
01390	AS21407	1	Bolt, bihex hd 0.190in. dia x 0.438in. (CP5990)	-	(C)(E)
01395	SP154D	1	Washer, flat 0.190in. dia (CP5990)	-	(C)(E)
01400	TA025074-05	1	Clamp, loop style, cushion 0.313in. dia (CP5990)	-	(C)(E)
01400	AS61903	1	Clamp, loop style, cushion 7,92 mm (0.312in.) (CP5990)	-	(C)(E)
01405	TA025074-05	1	Clamp, loop style, cushion 0.313in. dia (CP5990)	-	(C)(E)
01405	AS61903	1	Clamp, loop style, cushion 7,92 mm. (0.312in.) (CP5990)	-	(C)(E)
01410	AS20624	1	Nut, self locking, bihex 0.190in. dia (CP5990)	-	(C)(E)

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
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71-52-42

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01068	4W0103	1	Bolt, machine double hex 0.190in. dia x 0.500in. (CP5431)	-	(74D)
01070	TA025074- 01	1	Clamp, loop style, cushion 0.125in. dia (CP5431)	TA025074- 02	(C)(S4)(1D)
01074	SP154D	1	Washer, flat 0.190in. dia (CP5431)	-	(C)
01078	4W0043	1	Nut, A/O self locking 0.190in. dia (CP5431)	-	(75D)

D. Instructions disposition codes:

- (A) New part is currently available for sale.
- (B) Old part will continue to be made available.
- (C) New part is currently available.
- (E) Additional.
- (F) Parts coded (F) are alternatives.
- (G) Parts coded (G) are alternatives.
- (H) Parts coded (H) are alternatives.
- (J) Alternative to U322742.
- (K) Parts coded (K) are alternatives.
- (L) Part becomes redundant upon embodiment of this modification.
- (S1) Old and new parts are not interchangeable.
- (S2) Old and new parts are freely and fully interchangeable.
- (S3) New part at new location is not interchangeable with old part at old location.
- (S4) New part may be used in place of old part, but not vice versa.
- (1D) Old part maybe used up on other applications.
- (2D) Quantity reduced from 8 to 7.
- (3D) Quantity increased from 7 to 9.

- (4D) Quantity increased from 19 to 21.
- (5D) Quantity increased from 12 to 14.
- (6D) Quantity increased from 17 to 19.
- (7D) Quantity increased from 16 to 18.
- (8D) Quantity increased from 2 to 6.
- (9D) Quantity reduced from 2 to 1.
- (10D) Quantity reduced from 4 to 3.
- (11D) Quantity increased from 5 to 6.
- (12D) Previously located at chapter 75-23-48 fig item 03 558.
- (13D) Previously located at chapter 75-23-48 fig item 03 562.
- (14D) Previously located at chapter 75-23-48 fig item 03 561.
- (15D) Previously located at chapter 75-23-48 fig item 03 564.
- (16D) Previously located at chapter 75-23-48 fig item 03 557.
- (17D) Previously located at chapter 75-23-48 fig item 03 573.
- (18D) Previously located at chapter 75-23-48 fig item 03 574.
- (19D) Previously located at chapter 75-23-48 fig item 03 580.
- (20D) Now located at chapter 73-22-49 fig item 05 341.
- (21D) Now located at chapter 75-22-49 fig item 05 149.
- (22D) Now located at chapter 75-32-53 fig item 01 570.
- (23D) Now located at chapter 75-32-53 fig item 01 573.
- (24D) Now located at chapter 75-32-53 fig item 01 574.
- (25D) Previously located at chapter 75-23-51 fig item 01 120.
- (26D) Now located at chapter 75-32-53 fig item 01 598.
- (27D) Now located at chapter 75-32-53 fig item 01 600.
- (28D) Now located at chapter 75-32-53 fig item 01 610.
- (29D) Now located at chapter 75-32-53 fig item 01 500.

- (30D) Now located at chapter 75-32-53 fig item 01 510.
- (31D) Previously located at chapter 75-23-48 fig item 01 557.
- (32D) Previously located at chapter 75-23-48 fig item 01 558.
- (33D) Previously located at chapter 75-23-48 fig item 01 564.
- (34D) Previously located at chapter 75-23-48 fig item 01 565.
- (35D) Previously located at chapter 75-23-48 fig item 01 566.
- (36D) Previously located at chapter 75-23-48 fig item 01 572.
- (37D) Previously located at chapter 75-23-52 fig item 01 500.
- (38D) Previously located at chapter 75-23-52 fig item 01 510.
- (39D) Now located at chapter 75-32-49 fig item 03 565.
- (40D) Now located at chapter 75-32-49 fig item 03 566.
- (41D) Now located at chapter 75-32-49 fig item 03 571.
- (42D) Now located at chapter 75-32-49 fig item 03 573.
- (43D) Now located at chapter 75-32-49 fig item 03 575.
- (44D) Now located at chapter 75-32-49 fig item 03 580.
- (45D) Now located at chapter 73-22-49 fig item 05 342.
- (46D) Now located at chapter 73-22-49 fig item 05 347.
- (47D) Now located at chapter 73-22-49 fig item 05 346.
- (48D) Now located at chapter 73-22-49 fig item 05 348.
- (49D) Now located at chapter 75-22-49 fig item 05 150.
- (50D) Now located at chapter 75-22-49 fig item 05 156.
- (51D) Now located at chapter 75-23-48 fig item 04 420.
- (52D) Now located at chapter 75-32-53 fig item 01 518.
- (53D) Now located at chapter 75-32-53 fig item 01 520.
- (54D) Previously located at chapter 75-23-52 fig item 01 518.
- (55D) Previously located at chapter 75-23-52 fig item 01 520.

- (56D) Now located at chapter 75-32-53 fig item 01 612.
- (57D) Now located at chapter 75-32-53 fig item 01 650.
- (58D) Now located at chapter 75-32-53 fig item 01 651.
- (59D) Now located at chapter 75-32-53 fig item 01 652.
- (60D) Now located at chapter 75-32-53 fig item 01 653.
- (61D) Now located at chapter 75-32-53 fig item 01 654.
- (62D) Previously located at chapter 75-23-52 fig item 01 570.
- (63D) Previously located at chapter 75-23-52 fig item 01 573.
- (64D) Previously located at chapter 75-23-52 fig item 01 574.
- (65D) Previously located at chapter 75-23-52 fig item 01 598.
- (66D) Previously located at chapter 75-23-52 fig item 01 600.
- (67D) Previously located at chapter 75-23-52 fig item 01 610.
- (68D) Previously located at chapter 75-23-52 fig item 01 612.
- (69D) Previously located at chapter 75-23-52 fig item 01 650.
- (70D) Previously located at chapter 75-23-52 fig item 01 651.
- (71D) Previously located at chapter 75-23-52 fig item 01 652.
- (72D) Previously located at chapter 75-23-52 fig item 01 653.
- (73D) Previously located at chapter 75-23-52 fig item 01 654.
- (74D) Previously located at chapter 75-23-48 fig item 03 581.
- (75D) Previously located at chapter 75-23-48 fig item 03 588.
- (76D) Now located at chapter 71-52-42 fig item 01 068.
- (77D) Now located at chapter 71-52-42 fig item 01 078.
- (78D) Now located at chapter 75-32-49 fig item 03 470.
- (79D) Now located at chapter 75-32-49 fig item 03 474.
- (80D) Now located at chapter 75-32-49 fig item 03 472.
- (81D) Previously located at chapter 75-23-48 fig item 01 470.

(82D) Previously located at chapter 75-23-48 fig item 01 474.

(83D) Previously located at chapter 75-23-48 fig item 01 471.

R (84D) Rework old part number and re-identify to the new part number.

3. Accomplish Instructions

R A. Rework Instructions

R (1) Effectivity

ENGINE MARK	FIG/ITEM	PART No
A5	01-005	6A5699
A5	01-005	6A7450

R (2) Standard Equipment

R Standard workshop equipment
 R Cable lacing ties
 R Strap wrench (BT-BS-611)
 R Strap wrench (TG-70)
 R Wrench and holder (IAE 3J12704)
 R Insertion/Extraction tool (M81969/14-02)
 R Insertion/Extraction tool (M81969/14-03)

R (3) Consumable Materials

CoMat NUMBER	PART IDENT
CoMat 08-026	Thread Locking Material
CoMat 02-148	Adhesive Tape
CoMat 06-153	Marking Pen
CoMat 02-146	Locking Wire (AS44725-1)

R **NOTE:** It is possible that some materials in the Consumable
 R Materials chart cannot be used for some or all of the
 R necessary applications. Before you use the materials, make
 R sure the types, quantities and applications of the materials
 R necessary are legally permitted in your location. All
 R persons must obey all applicable federal, state, local and
 R provincial laws and regulations when it is necessary to work
 R with these materials.
 R To identify the consumable materials refer to the Overhaul
 R Processes and Consumables Index (PCI).
 R Other necessary consumable materials are referred to in the
 R SPP TASKS.

(4) Repair Parts

PART NUMBER	PART IDENT
MS27488-16	Sealing Plug
MS27488-20	Sealing Plug
M39029/56-351	Socket Contact
ESC30S16BC	Socket Contact
ESC30P16BC	Pin Contact

(5) General Data

(a) This rework instruction gives the procedure to rework the Engine Electronic Controller (EEC) Core Harness Assembly and the EEC Fan Harness Assembly by the removal of cables between connector positions.

(b) TASKS identified by SPP TASK are in the Standard Practices Manual.

(c) TASKS identified by EM TASK are in the Engine Manual.

(d) TASKS identified by the CMM TASK are in the Component Maintenance Manual.

(6) Accomplishment Instructions

(a) EEC Core Harness Rework Instructions - 6A5699

WARNING: PUT ON PROTECTIVE GOGGLES WHEN YOU CUT THE LOCKWIRE. PIECES OF THE LOCKWIRE CAN CAUSE DAMAGE TO YOUR EYES.

(i) Cut and remove the lockwire from the screws, coupling nut and shell on the 4009VC connector (refer to Figure 1).

(ii) Remove the screws and the strain relief clamp from the coupling nut.

(iii) Remove the coupling nut from the shell and the shell from the connector/receptacle. Use a BT-BS-611, TG-70, or IAE 3J12704 strap wrench or equivalent. This will give access to the cables and contacts in the connector refer to SPP TASK 70-35-25-300-001-A01.

(iv) Remove the pin contacts, numbers 31 and 16 (cables 6B430B20 and 6B430R20) from the 4009VC connector with the M81969/14-03 insertion/extraction tool (white end) or equivalent tool (refer to Figure 2).

(v) Install new pin contacts (ESC30P16BC), into the vacant connector holes (without cables). Make sure the pins are pushed fully until locked in place. Use the M81969/14-03 insertion/extraction tool or equivalent tool.

- R (vi) Install sealing plugs (MS27488-16) into the corresponding holes
R in the back of the connector.
- R (vii) Do steps (1) thru (3) for the 4008VC connector.
- R (viii) Remove the pin contacts, number 35 and 19 (cables 6B429B20 and
R 6B429R20) from the 4008VC connector with the M81969/14-03
R insertion/extraction tool (white end) or equivalent tool.
- R (ix) Install new pin contacts (ESC30P16BC), into the vacant
R connector holes (without cables). Make sure the pins are pushed
R fully until locked in place. Use the M81969/14-03
R insertion/extraction tool or equivalent tool.
- R (x) Install sealing plugs (MS27488-16) into the corresponding holes
R in the back of the connector.
- R (xi) Do steps (1) thru (3) for the 4006VC-A connector.
- R (xii) Remove socket contacts, numbers 5, 4, 3 and 10 (cables
R 6B430B20, 6B430R20, 6B429B20 and 6B429R20) from the 4006VC-A
R connector with the M81969/14-03 insertion/extraction tool
R (white end) or equivalent tool.
- R (xiii) Install new socket contacts (ESC30S16BC) into the connector
R holes (without cables). Make sure the sockets are pushed fully
R until locked in place. Use the M81969/14-03
R insertion/extraction tool or equivalent tool.
- R (xiv) Install sealing plugs (MS27488-16) into the corresponding holes
R in the back of the connector.
- R (xv) Make sure the removed redundant cables are clear of the
R connector assemblies.
- R NOTE: Make sure the redundant cables (6B430B20, 6B430R20,
R 6B429B20 and 6B429R20) are not re-assembled into the
R connector assembly, as these cables need to be fully
R removed from the harness.
- R (xvi) Install the 4009VC connector shell to the connector and tighten
R the nut by hand. Tighten the backshell nut through 90 degrees
R with the BT-BS-611, TG-70 or IAE 3J12704 strap wrench or
R equivalent. Make sure the ground shields are an equal distance
R apart around the shell (refer to Figure 2).
- R (xvii) Install the grounding ferrule along the harness as shown until
R it touches the ground shields. Put the ground shields through
R the coupling nut.

- (xviii) Put two drops of thread locking material (CoMat 08-026) opposite to each other on the threads of the shell as shown and install the coupling nut (refer to Figure 2). Install and tighten the coupling nut to the shell. Torque the coupling nut and shell to 10 lbf in. (1,13 Nm.) refer to SPP TASK 70-41-00-400-501.
- (xix) Wrap a sufficient number of layers of adhesive tape (CoMat 02-148) over the remaining cables to suit the support bush inside diameter and to the ends of the braided ground shields so that the strain relief clamping bars fit tight on the harness.
- (xx) Install the strain relief clamp to the coupling nut as shown. Apply one drop of thread locking material (CoMat 08-026) to each of the clamp screws, and tighten the screws (refer to Figure 2).
- (xxi) Do steps (15) thru (20) for the 4008VC and 4006VC-A connectors.
- (xxii) Wirelock the 4009VC, 4008VC and 4006VC-A connectors as shown with Lockwire (CoMat 02-146). Refer to SPP TASK 70-42-05-400-501. Make sure the connectors, the shells, the coupling nuts and screws are all locked (refer to Figure 1).
- (xxiii) Once the connectors have been re-assembled, remove the redundant cables from the harness assembly. Cables are to be removed one at a time. It is recommended to remove the cables at local intervals. The ties and the tape for clipping and connector marking should then be replaced once each local section of the cable is removed. Make a note of the position of the different ties and tape: the general ties, the tapes that identify the positions of the datum clamps and the ties at the connection of two wire bundles. Make sure the ties and tape are replaced with new at the exact location they were removed. Refer to SPP TASK 70-35-25-300-001-H01.
- (xxiv) Do continuity and insulation test refer to CMM TASK 71-52-43-700-301.
- (xxv) Remove the existing assembly part number identification sleeve. Apply two turns of 1.0 in. (25 mm) wide adhesive tape (CoMat 02-148) at the same position and mark the new part number using CoMat 06-153 marking pen.

Existing	Re-number
6A5699	6A7570

(b) EEC Fan Harness Rework Instructions - 6A7450

WARNING: PUT ON PROTECTIVE GOGGLES WHEN YOU CUT THE LOCKWIRE. PIECES OF THE LOCKWIRE CAN CAUSE DAMAGE TO YOUR EYES.

- (i) Cut and remove the lockwire from the screws, coupling nut and shell on the 4000KS-J5 connector (refer to Figure 1).
- (ii) Remove the screws and the strain relief clamp from the coupling nut.
- (iii) Remove the coupling nut from the shell and the shell from the connector. Use a BT-BS-611, TG-70, or IAE 3J12704 strap wrench or equivalent. This will give access to the cables and contacts in the connector, refer to SPP TASK 70-35-25-300-001-A01.
- (iv) Remove the socket contacts, numbers G and b (cables 6A241B20 and 6A241R20) from the 4000KS-J5 connector with the M81969/14-02 insertion/extraction tool (white end) or equivalent tool (refer to Figure 2).
- (v) Install new socket contacts (M39029/56-351), into the vacant connector holes (without cables). Make sure the sockets are pushed fully until locked in place. Use the M81969/14-02 insertion/extraction tool or equivalent tool.
- (vi) Install sealing plugs (MS27488-20) into the corresponding holes in the back of the connector.
- (vii) Do steps (1) thru (3) for the 4000KS-J11 connector.
- (viii) Remove the socket contacts, number G and b (cables 6A242B20 and 6A242R20) from the 4000KS-J11 connector with the M81969/14-02 insertion/extraction tool (white end) or equivalent tool.
- (ix) Install new socket contacts (M39029/56-351), into the vacant connector holes (without cables). Make sure the sockets are pushed fully until locked in place. Use the M81969/14-02 insertion/extraction tool or equivalent tool.
- (x) Install sealing plugs (MS27488-20) into the corresponding holes in the back of the connector.
- (xi) Make sure the removed redundant cables are clear of the connector assemblies.

NOTE: Make sure the redundant cables (6A241B20, 6A241R20, 6A242B20 and 6A242R20) are not re-assembled into the connector assembly, as these cables need to be fully removed from the harness.

- (xii) Instal the 4000KS-J5 connector shell to the connector and tighten the nut by hand. Tighten the backshell nut through 90 degrees with the BT-BS-611, TG-70 or IAE 3J12704 strap wrench or equivalent. Make sure the ground shields are an equal distance apart around the shell (refer to Figure 2).
- (xiii) Install the grounding ferrule along the harness as shown until it touches the ground shields. Put the ground shields through the coupling nut.
- (xiv) Put two drops of thread locking material (CoMat 08-026) opposite to each other on the threads of the shell as shown and install the coupling nut (refer to Figure 2). Install and tighten the coupling nut to the shell. Torque the coupling nut and shell to 10 lbf in. (1,13 Nm.) refer to SPP TASK 70-41-00-400-501.
- (xv) Wrap a sufficient number of layers of adhesive tape (CoMat 02-148) over the remaining cables to suit the support bush inside diameter and to the ends of the braided ground shields so that the strain relief clamping bars fit tight on the harness.
- (xvi) Install the strain relief clamp to the coupling nut as shown. Apply one drop of thread locking material (CoMat 08-026) to each of the clamp screws, and tighten the screws (refer to Figure 2).
- (xvii) Do steps (11) thru ((16) for the 4000KS-J11 connector.
- (xviii) Wirelock the 4000KS-J5 and 4000KS-J11 connectors as shown with Lockwire (CoMat 02-146). Refer to SPP TASK 70-42-05-400-501. Make sure the connectors, the shells, the coupling nuts and screws are all locked (refer to Figure 1).
- (xix) Once the connectors have been re-assembled, remove the redundant cables from the harness assembly. Cables are to be removed one at a time. It is recommended to remove the cables at local intervals. The ties and the tape for clipping and connector marking should then be replaced once each local section of the cable is removed. Make a note of the position of the different ties and tape: the general ties, the tapes that identify the positions of the datum clamps and the ties at the connection of two wire bundles. Make sure the ties and tape are replaced with new at the exact location they were removed. Refer to SPP TASK 70-35-25-300-001-H01.

NOTE: The redundant cables are directly connected to the 4028KS-A solenoid. The 4028KS-A solenoid is to be fully removed from the harness assembly along with the cables.



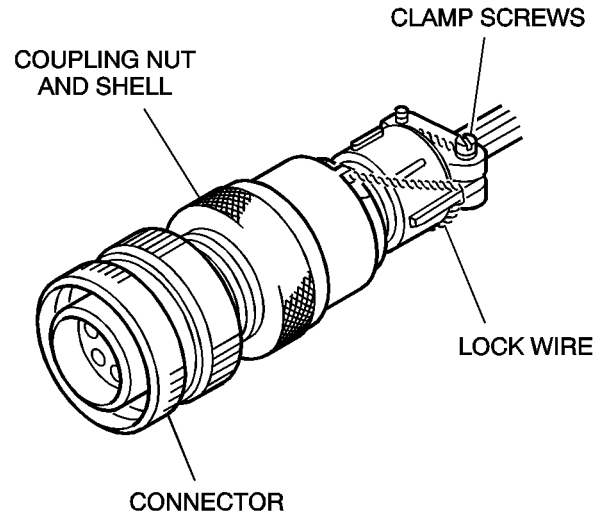
SERVICE BULLETIN

R (xx) Do continuity and insulation test refer to CMM TASK
R 71-51-41-700-301.

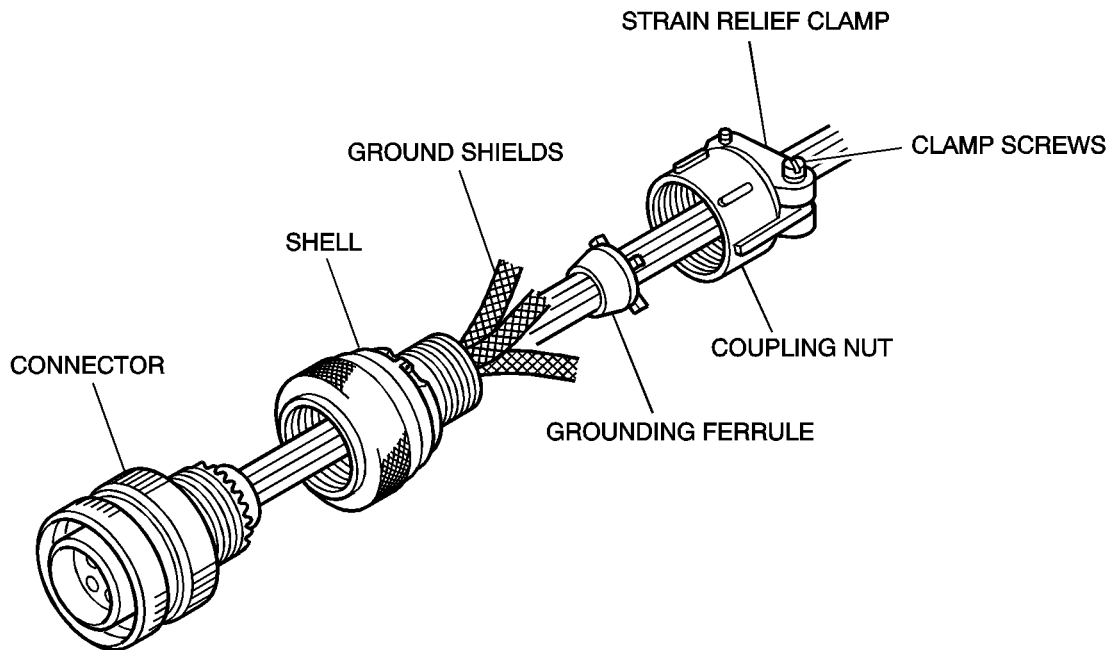
R (xxi) Remove the existing assembly part number identification sleeve.
R Apply two turns of 1.0 in. (25 mm) wide adhesive tape (CoMat
R 02-148) at the same position and mark the new part number using
R CoMat 06-153 marking pen.

R	Existing	Re-number
R	6A7450	6A7557

7



R



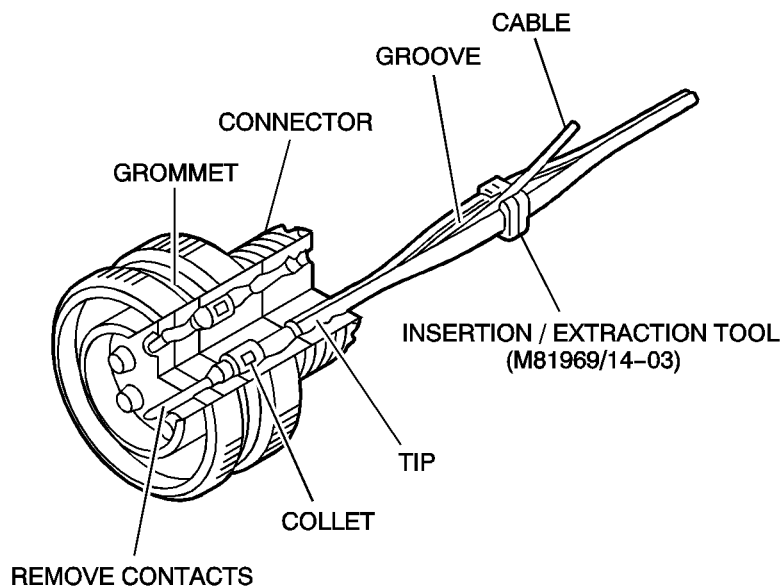
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R
R

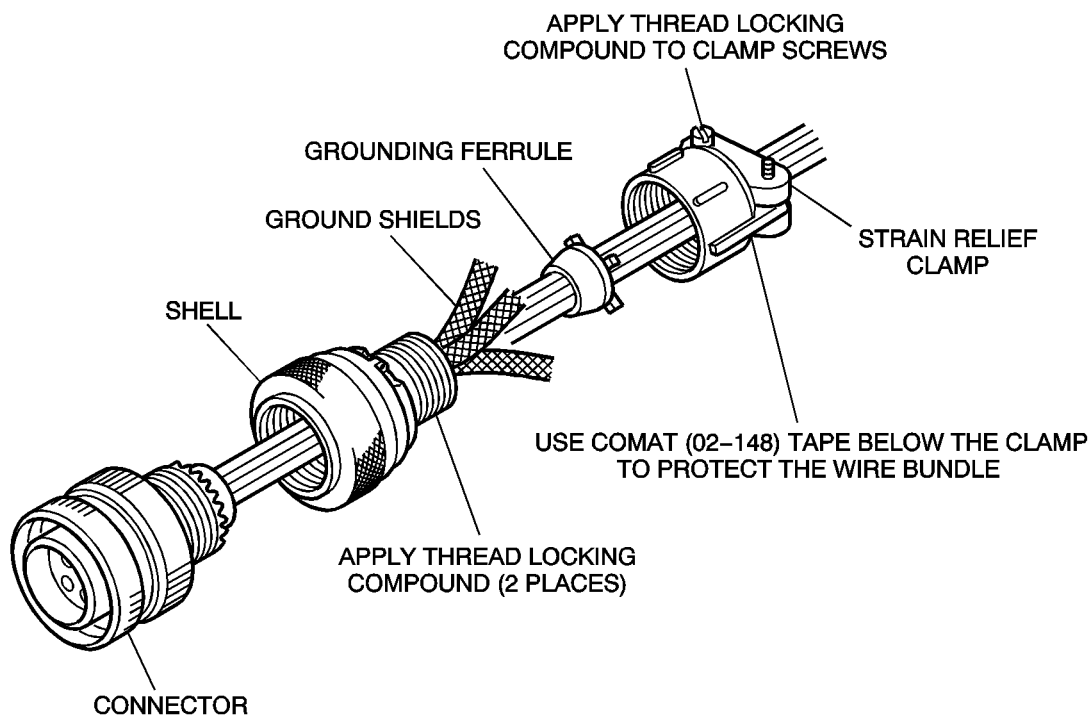
Removal/Installation of Cables and Attaching Hardware
Figure 1

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081
Page 42



R



bmi0004858

R
R

Removal/Installation of Cables and Attaching Hardware
Figure 2

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

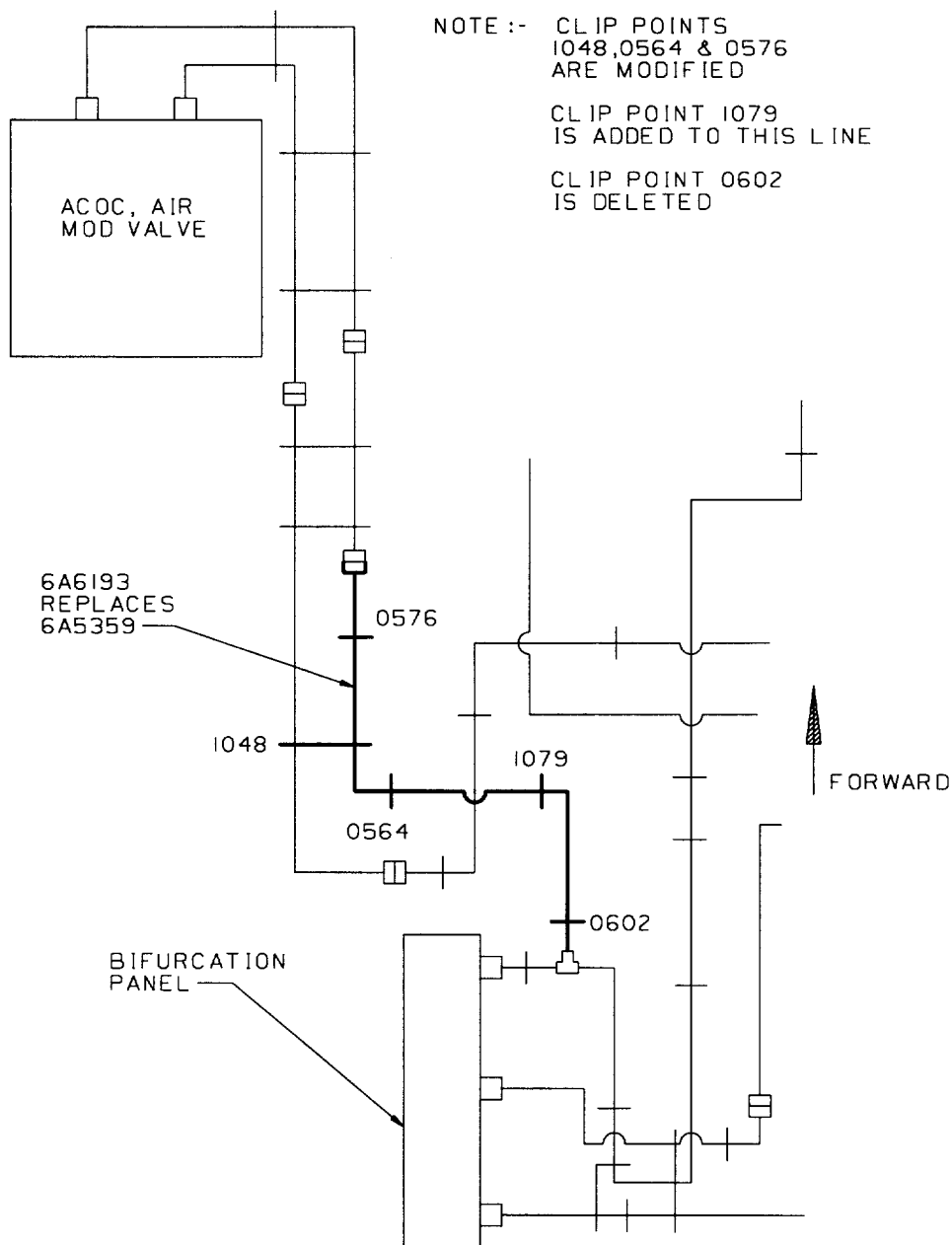
Page 43

B. Assembly Instructions

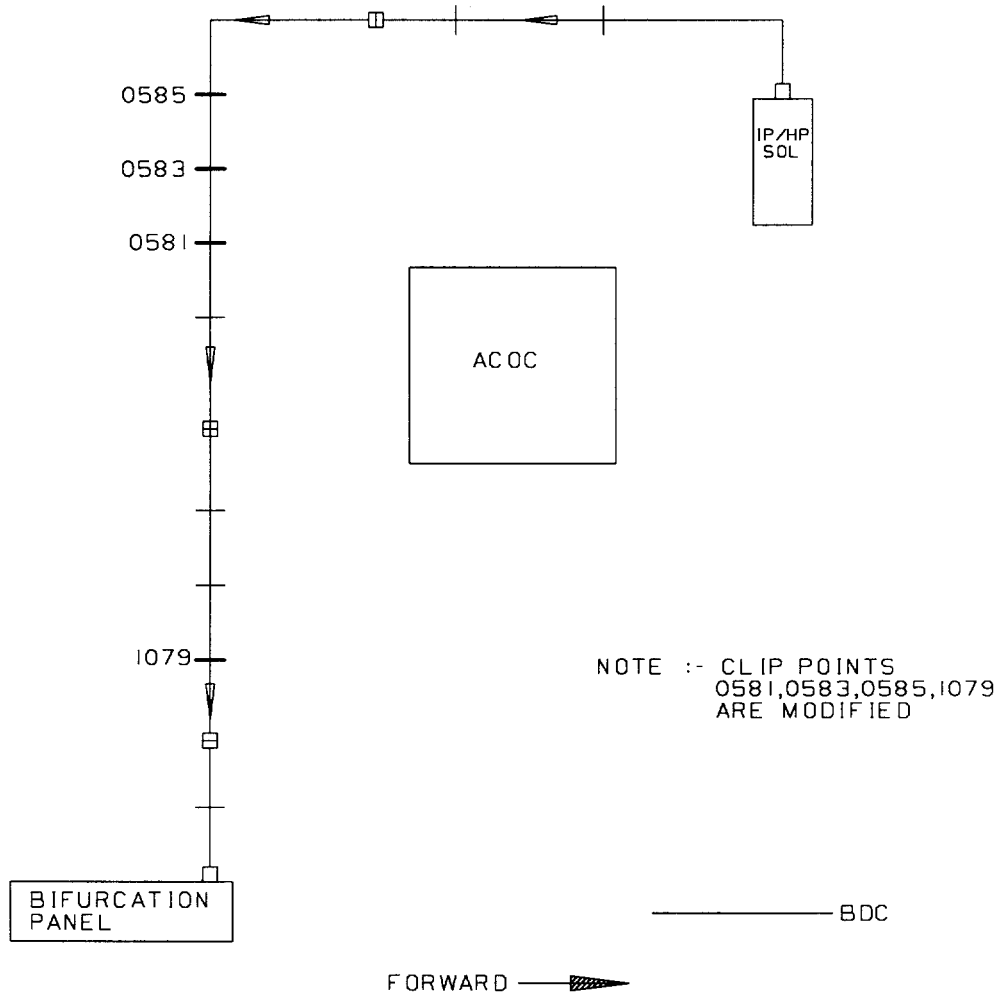
The revised parts introduced by this Service Bulletin are interchangeable as a set. Remove and install in accordance with current overhaul procedures and maintenance practices (Engine Manual, 72-00-32, 72-00-40, Removal and Installation and Aircraft Maintenance Manual, 71-52-41, 71-52-42, 75-23-51, Removal/Installation).

C. Recording Instructions

A record of accomplishment is required

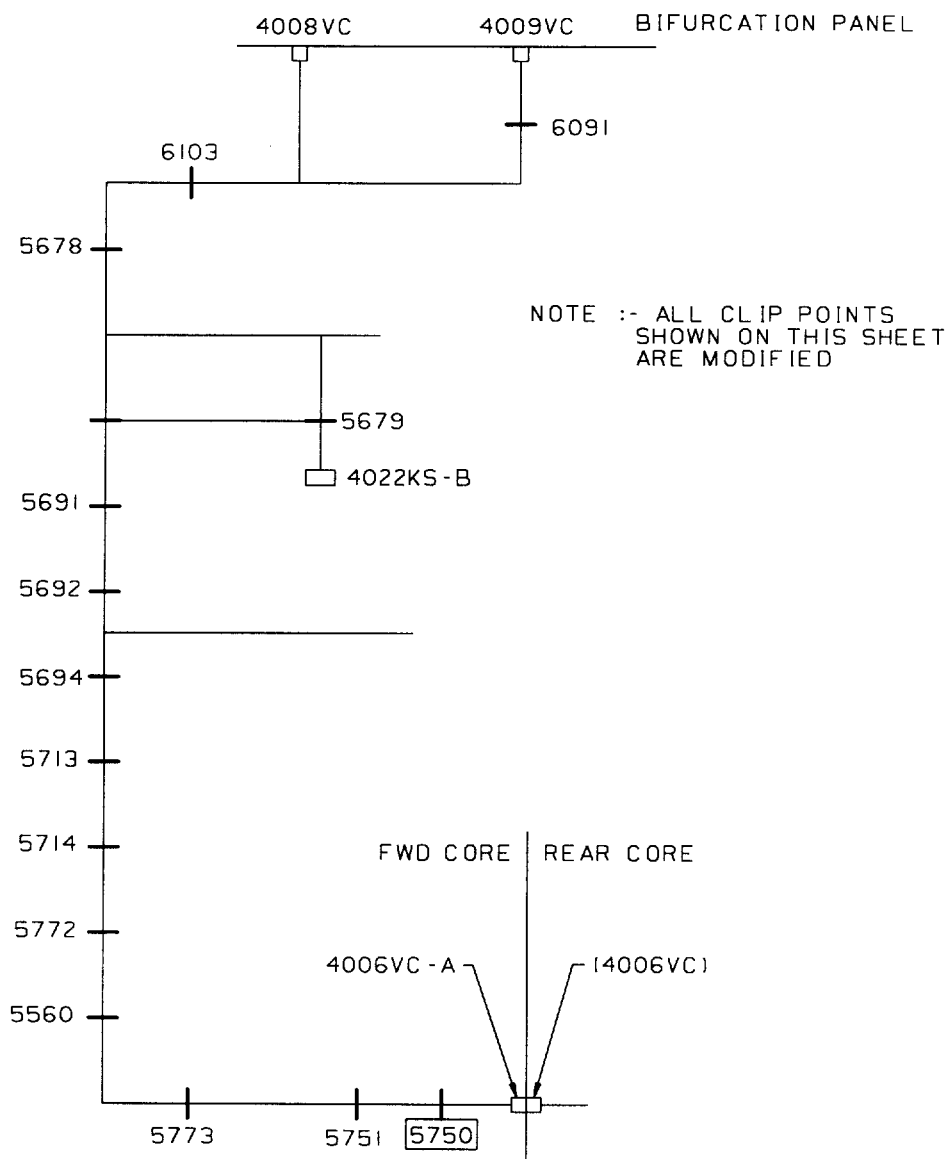


Part schematic view of fuel tubes
Fig 1



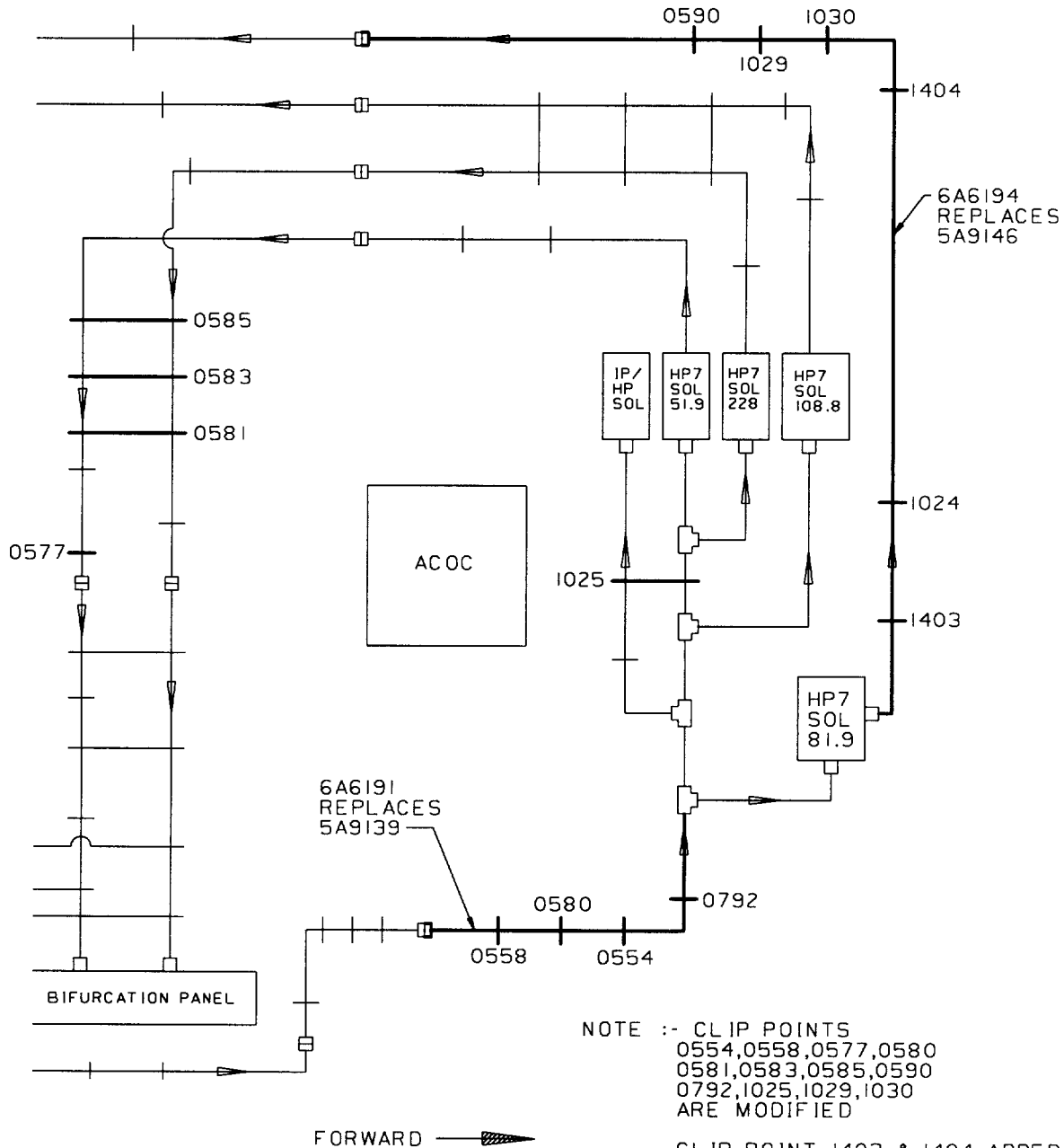
dem0000135

Schematic view of IP/HP cabin air bleed tubes
Fig 2



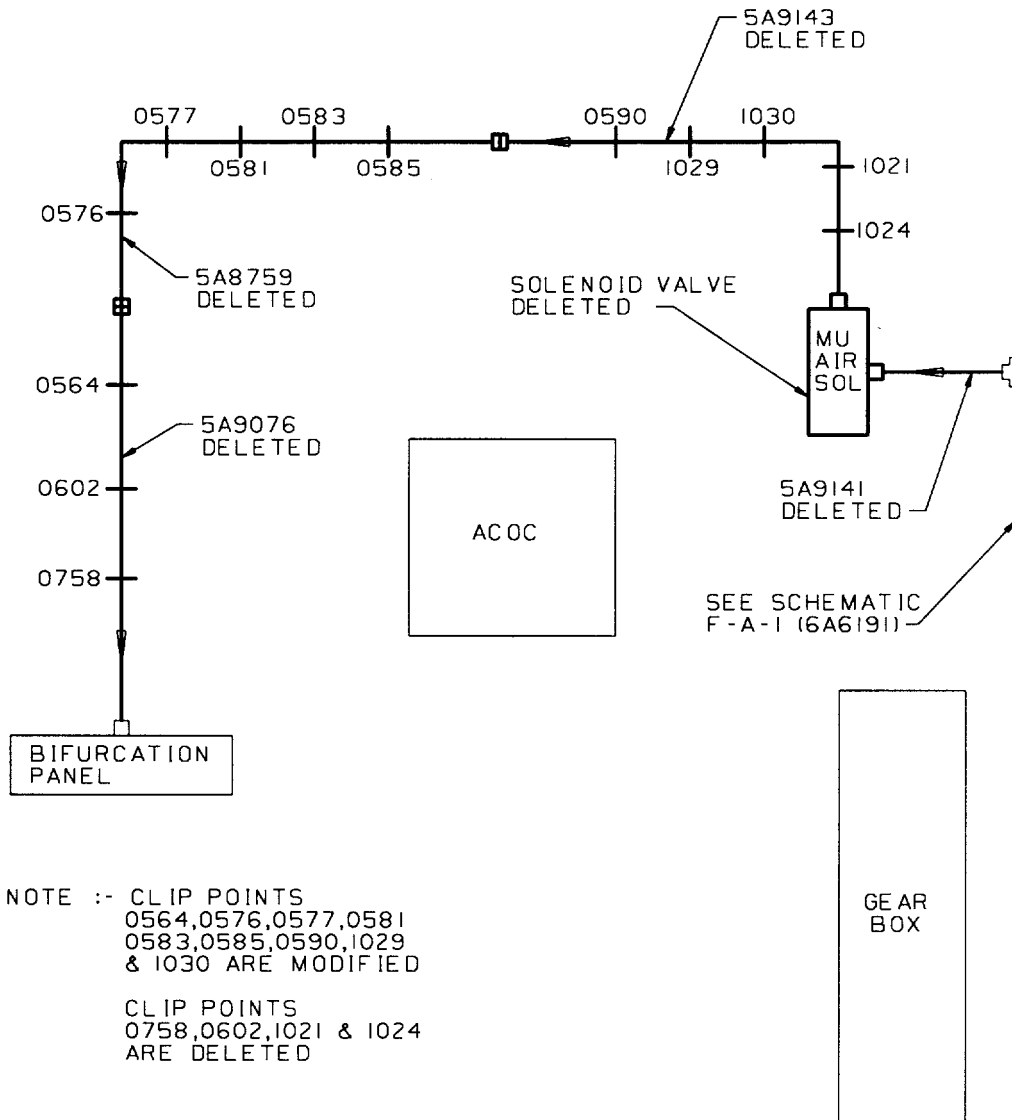
dem0000136

Part schematic of the core EEC harness showing clipping point sequence
Fig 3



Part schematic view of HP compressor bleed valve control tubes
Fig 4

R.H SIDE



L.H. SIDE

FORWARD

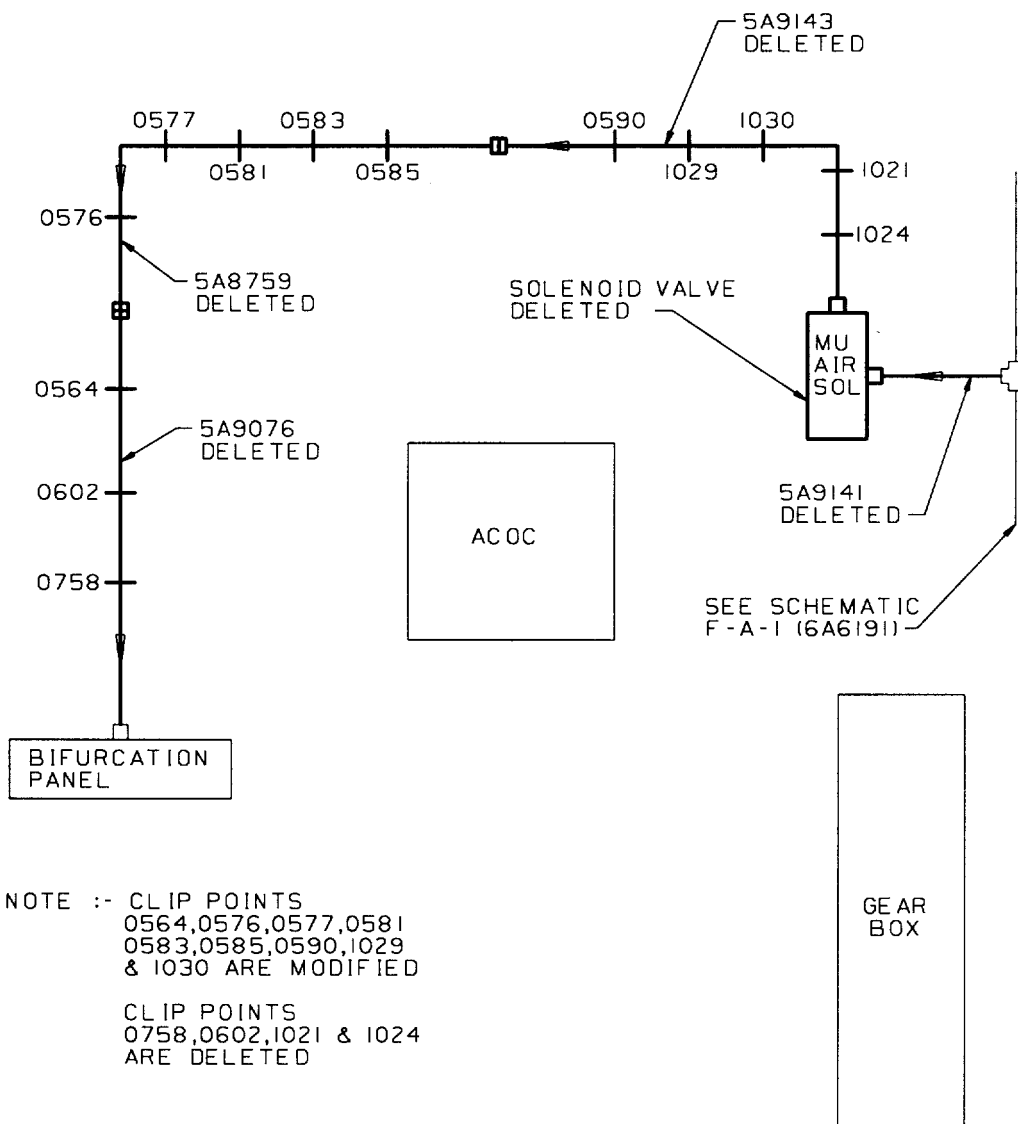
dem0000138

Schematic view of stage 10 make up air servo tubes
Fig 5

May 4/01
Apr.21/11 Revision 4

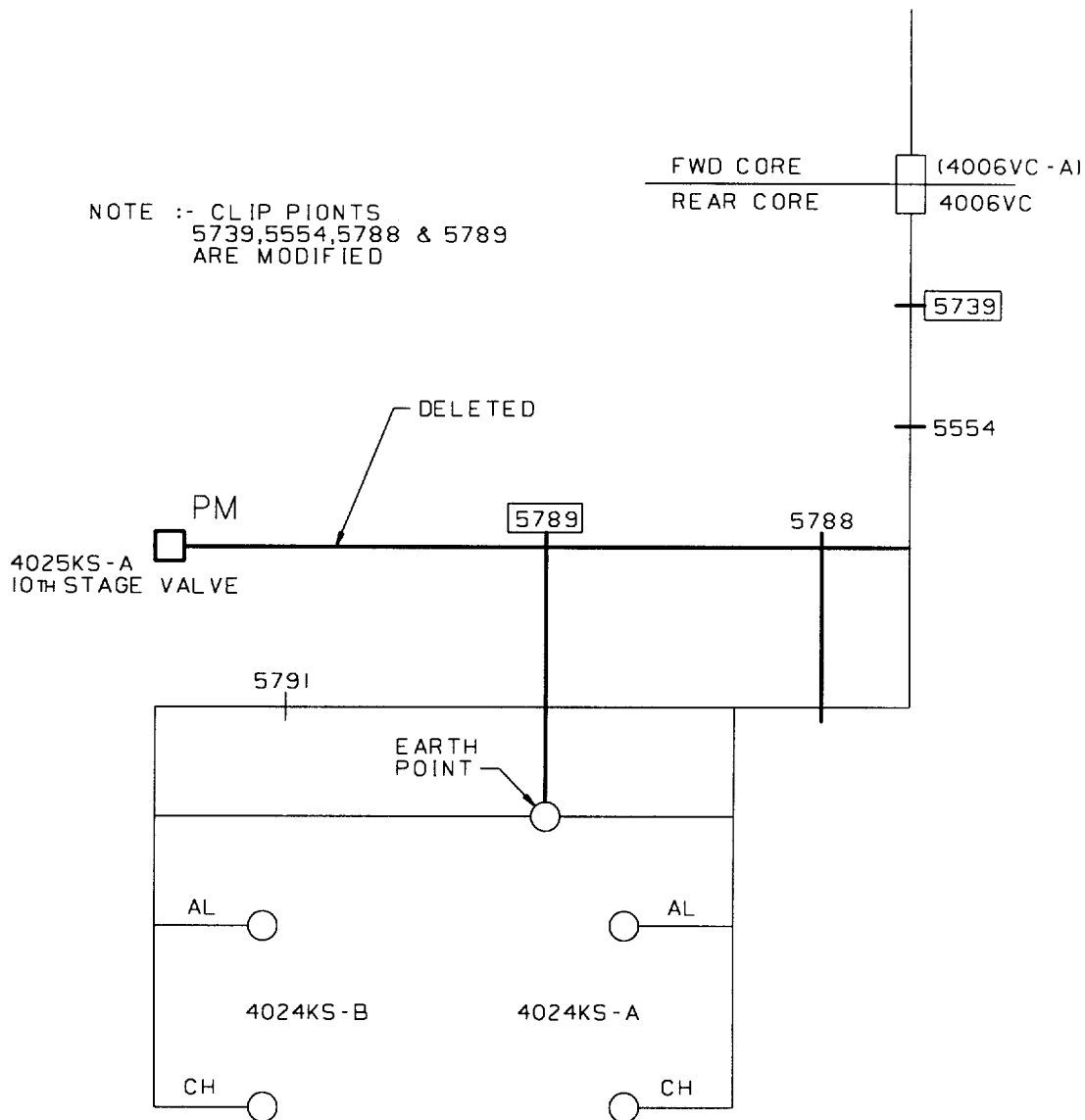
V2500-ENG-75-0081
Page 49

R.H SIDE



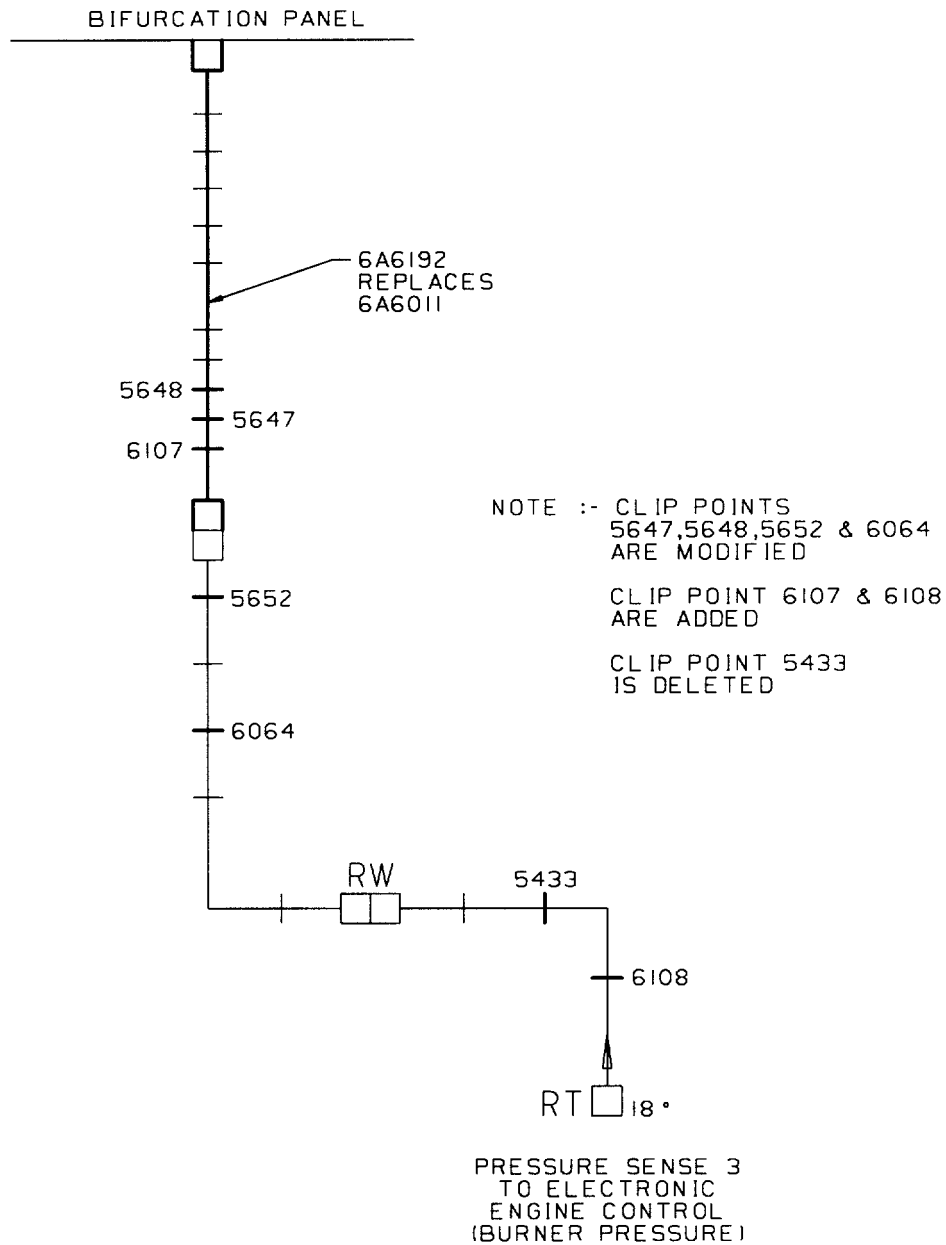
L.H SIDE

Part schematic view showing clipping of EEC harness core
Fig 6

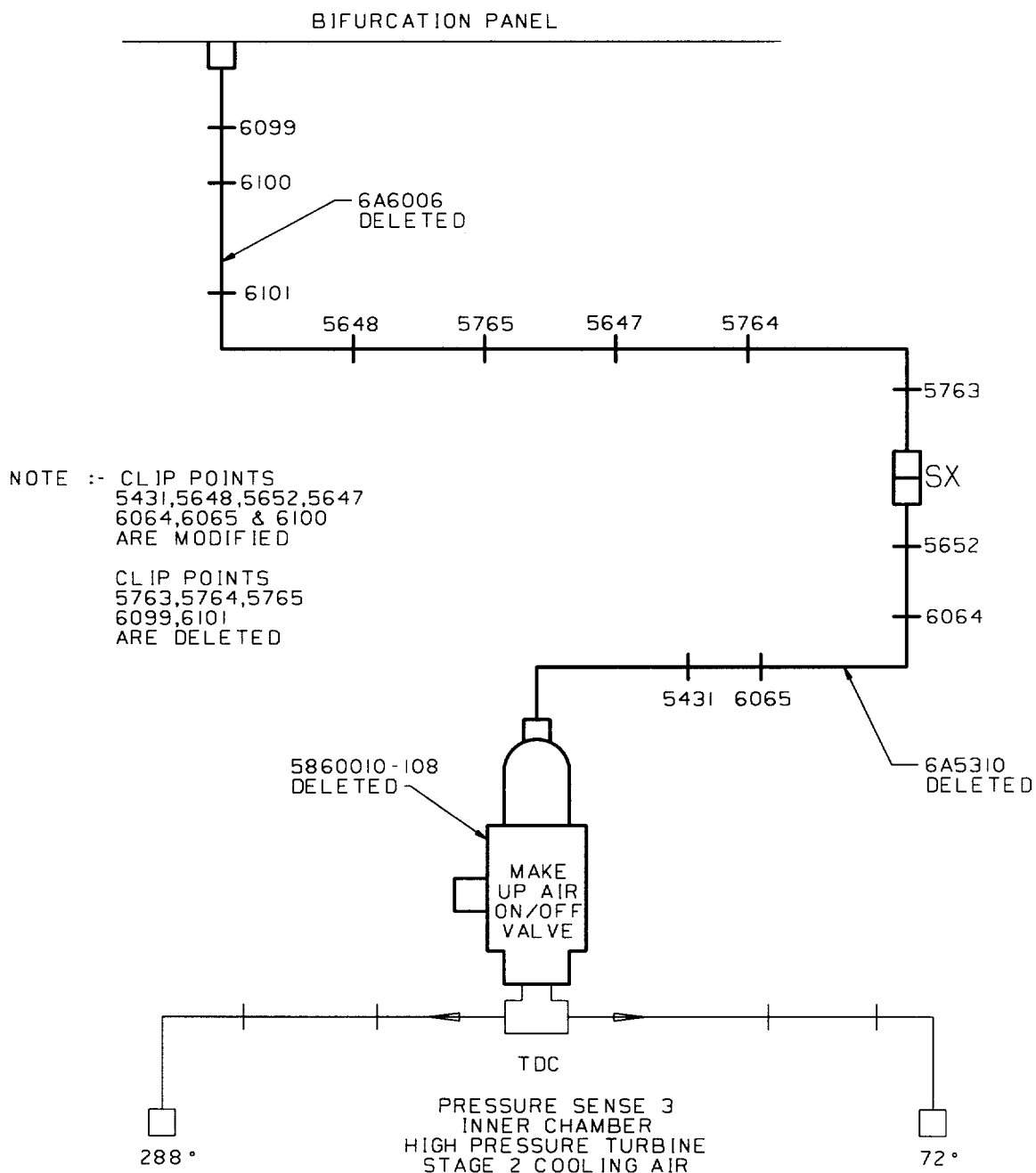


Idem0000140

Schematic of the engine control link harness core showing clipping point sequence
Fig 7

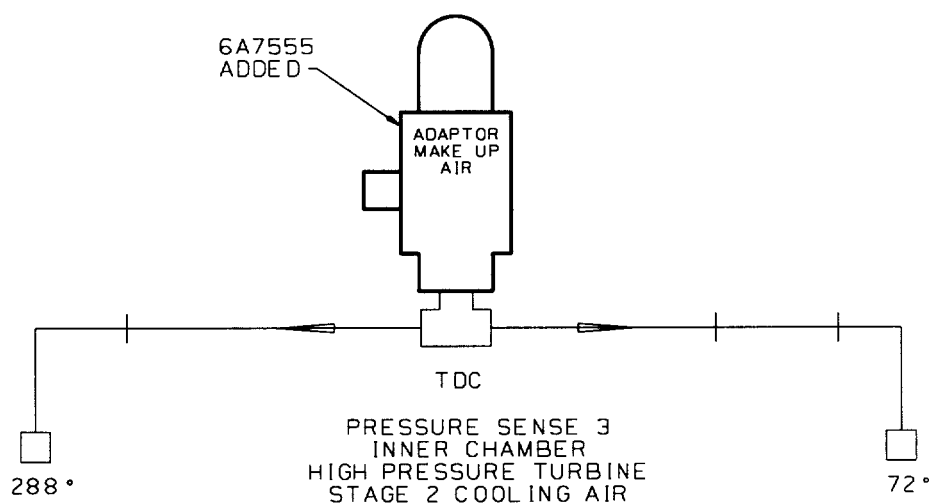


Part schematic view of air sense lines core
Fig 8

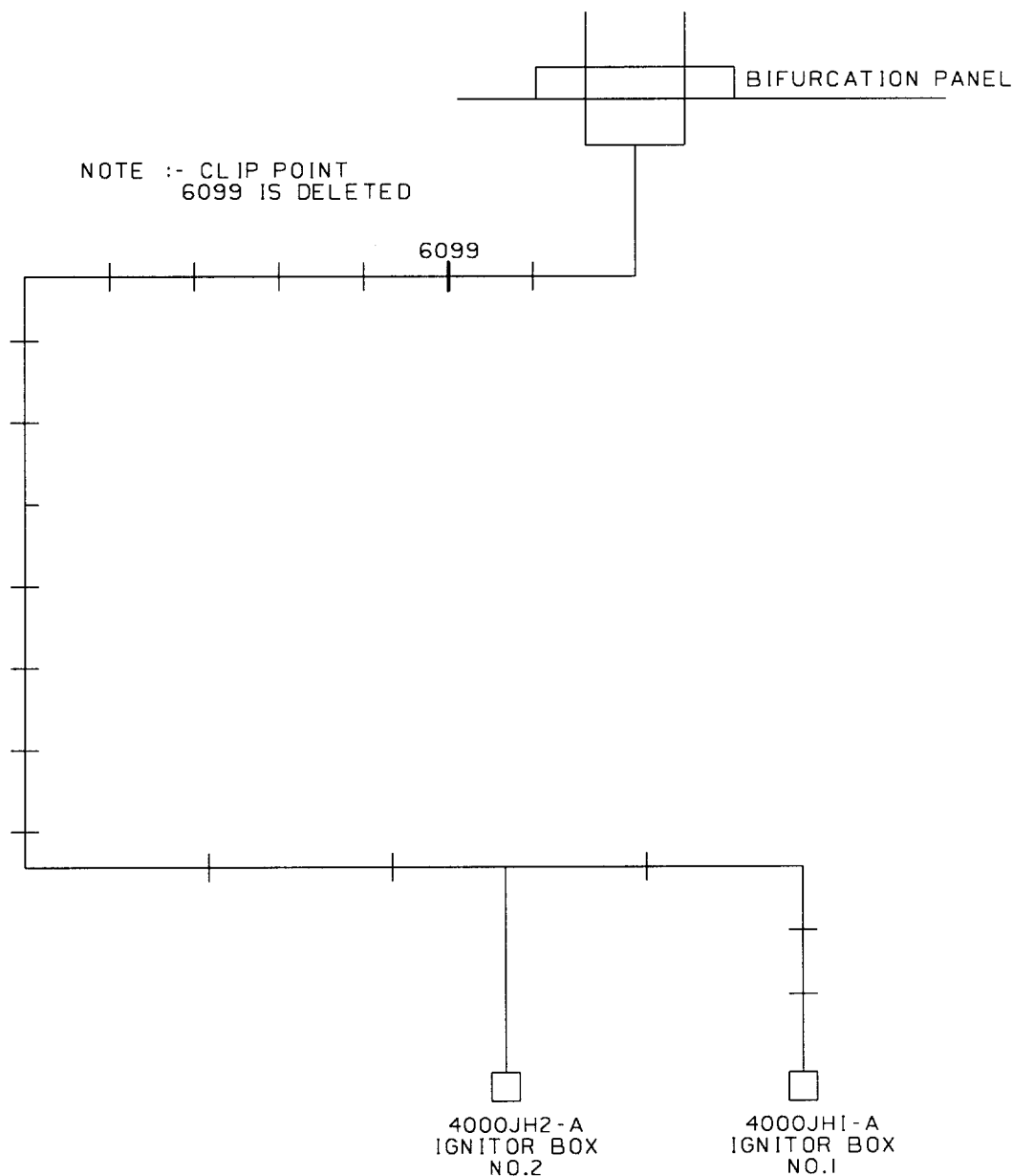


dem0000142

Schematic view of TCA tubes before alteration
Fig 9

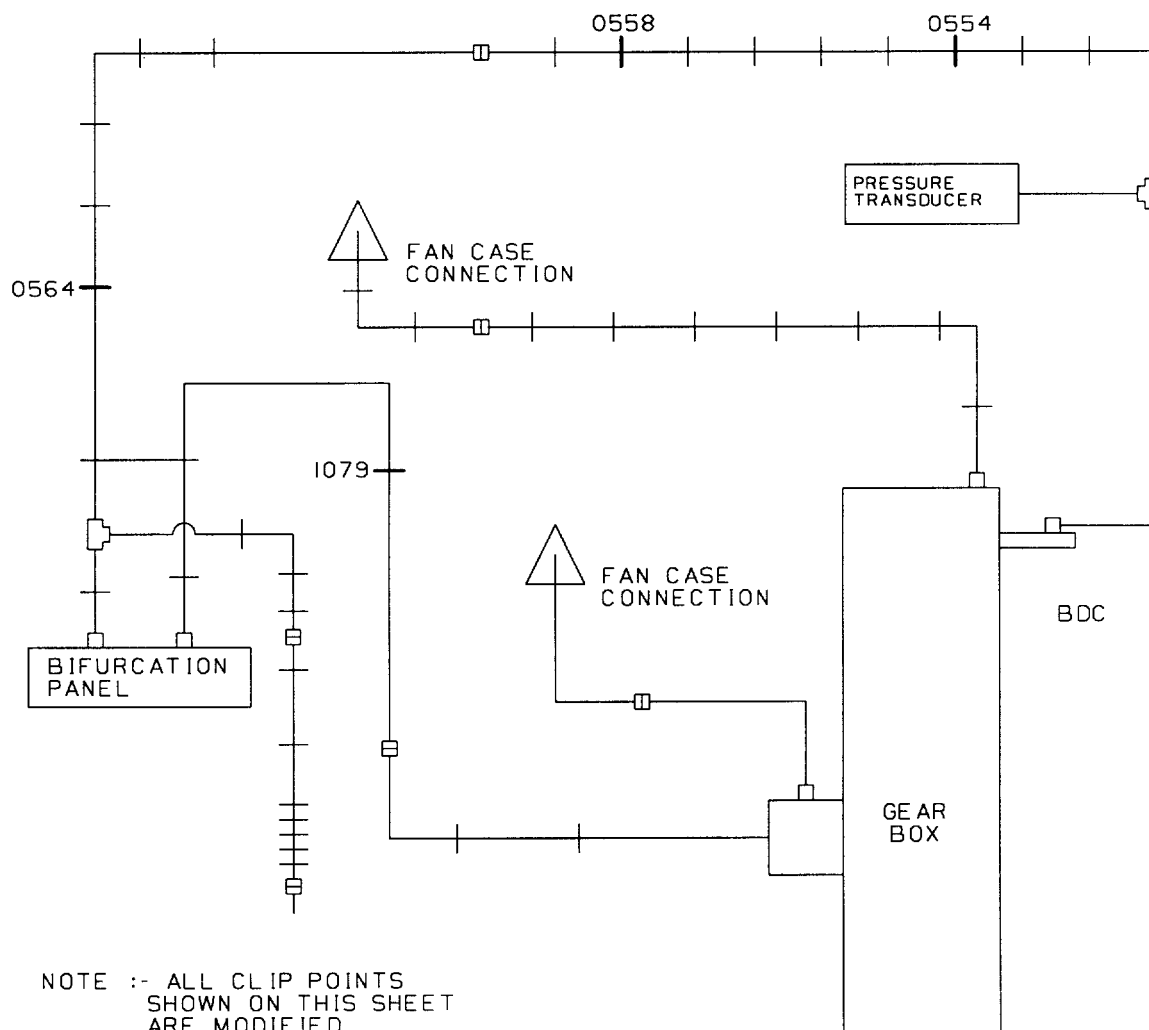


Schematic view of TCA tubes after alteration
Fig 10

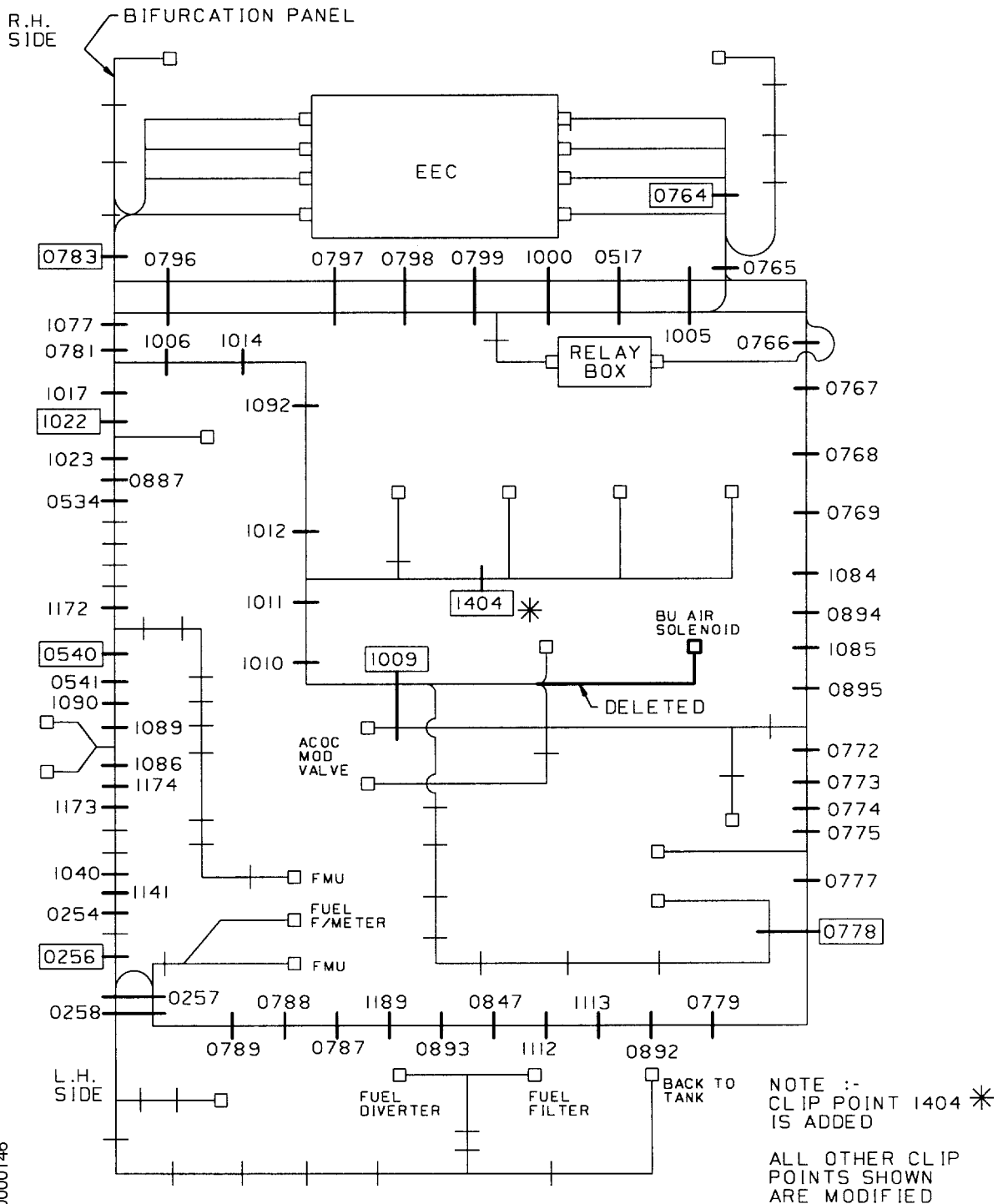


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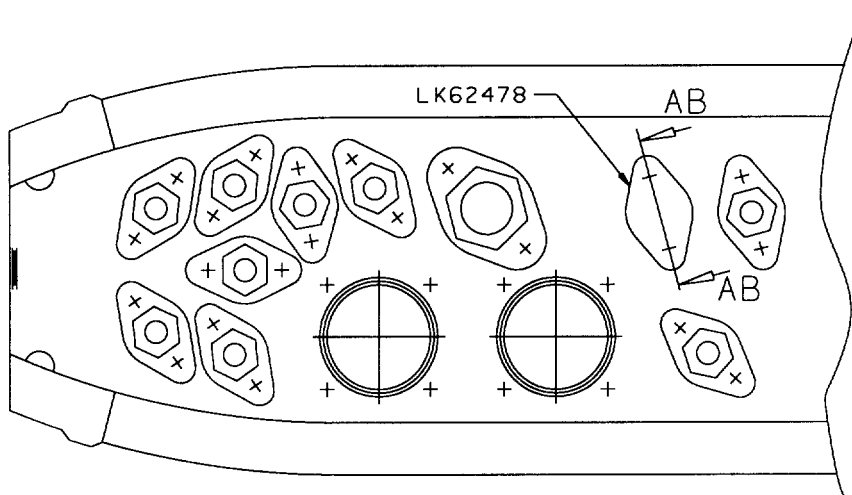
Diagrammatic view of ignition supply harness showing clipping point sequence
Fig 11



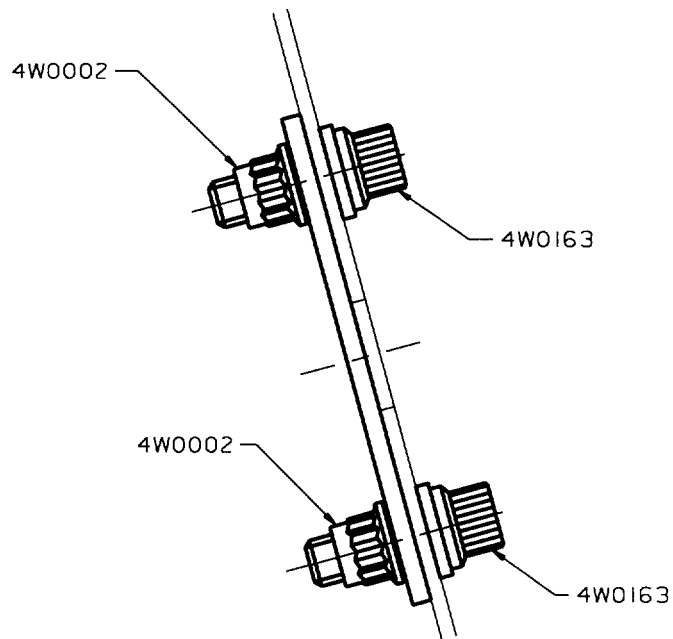
Part schematic view of oil scavenge tubes
Fig 12



Schematic view of EEC harness - fancase
Fig 13



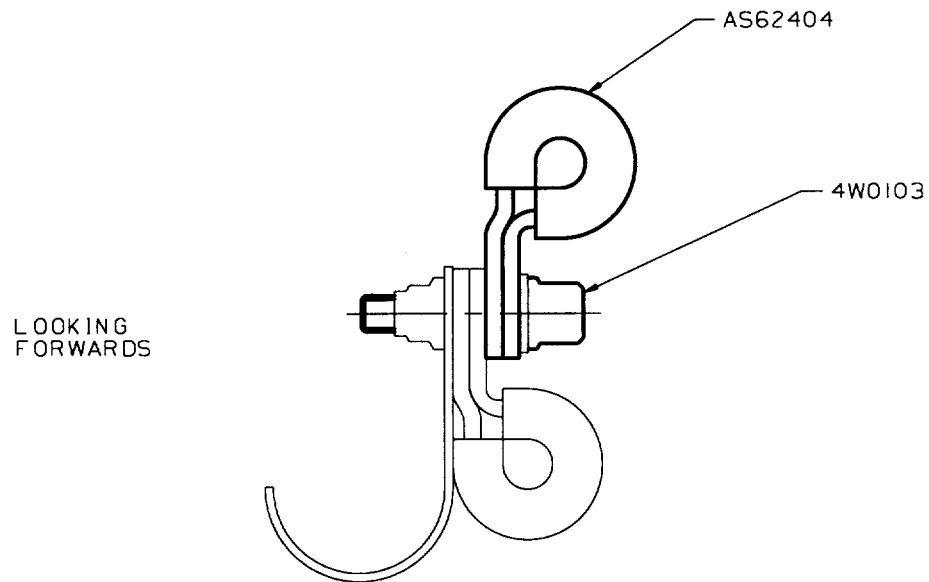
VIEW ON FRONT (LOWER) FACE
OF BIFURCATION PANEL



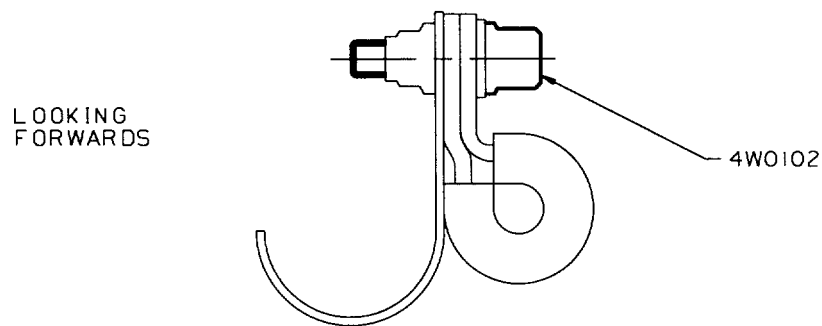
SECTION AB

Views of bifurcation panel
Fig 14

dem0000147



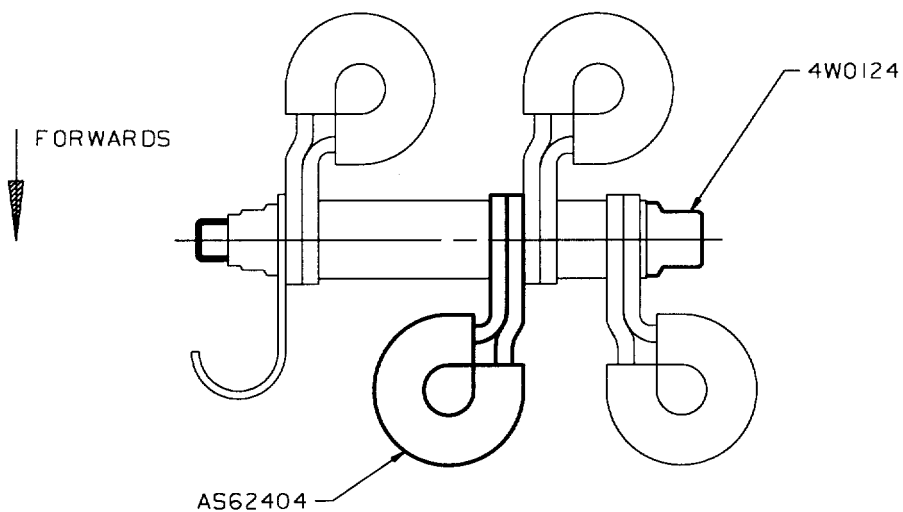
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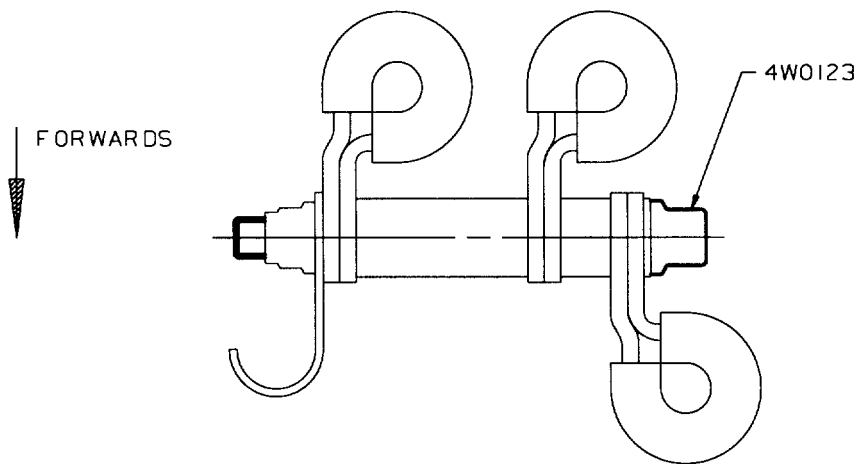
CLIP POINT 0564 AFTER ALTERATION

Clip point 0564 before and after alteration
Fig 15

dem0000148

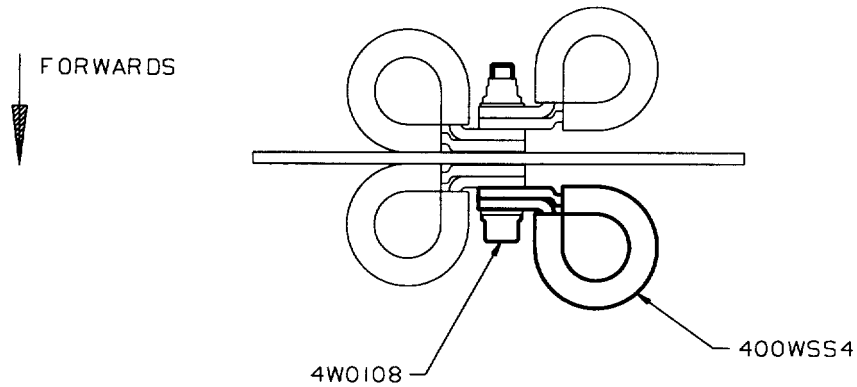


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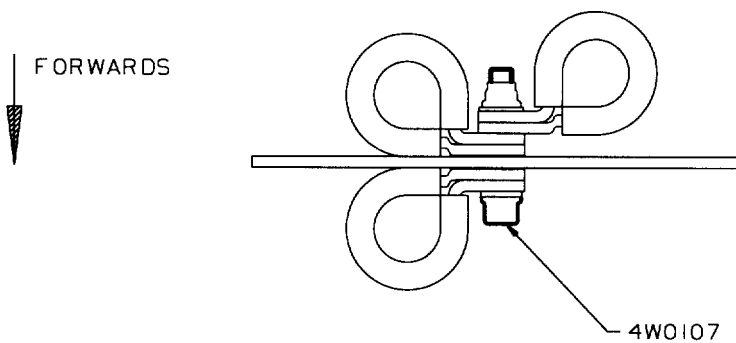


Clip point 0576 before and after alteration
Fig 16

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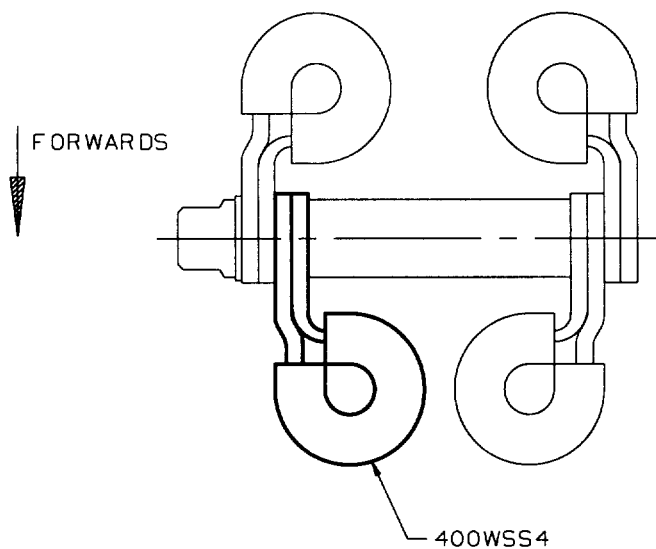
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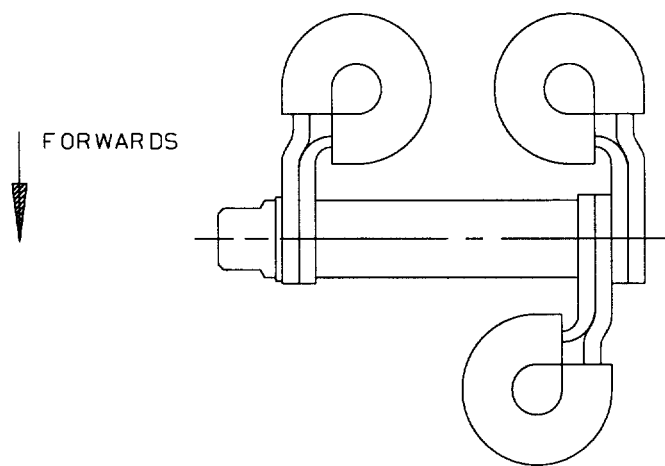
CLIP POINT 0577 AFTER ALTERATION

Clip point 0577 before and after alteration
Fig 17

dem0000150



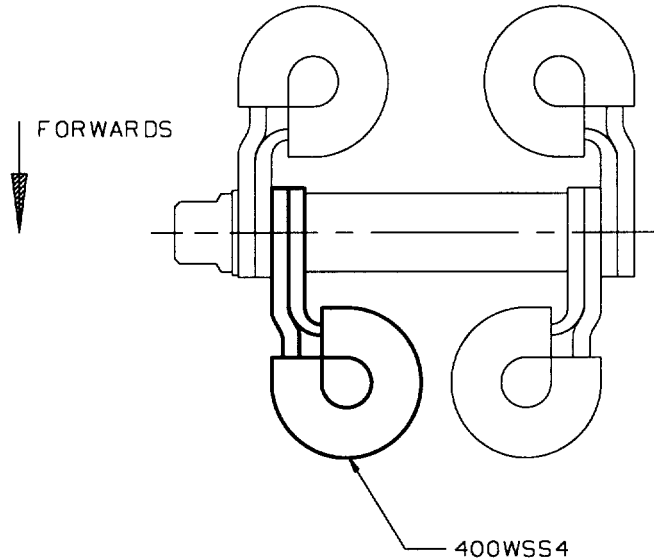
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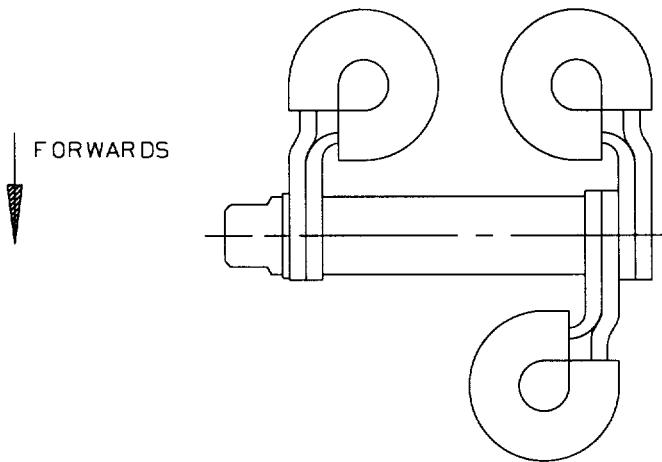
CLIP POINT 0581 AFTER ALTERATION

Clip point 0581 before and after alteration
Fig 18

dem0000151



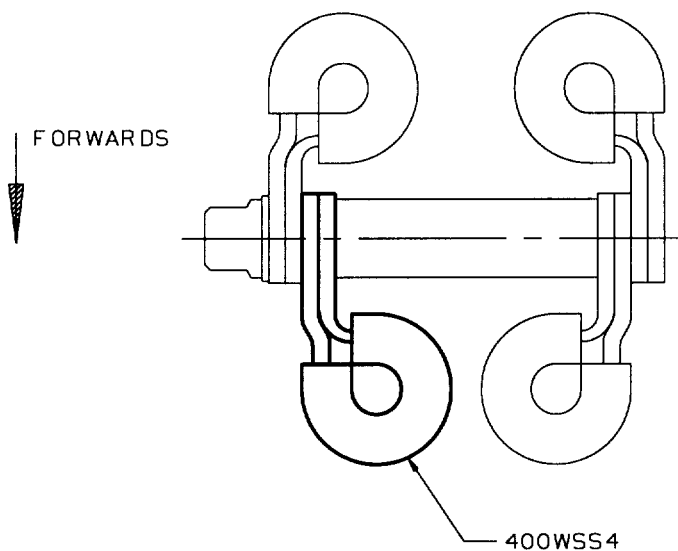
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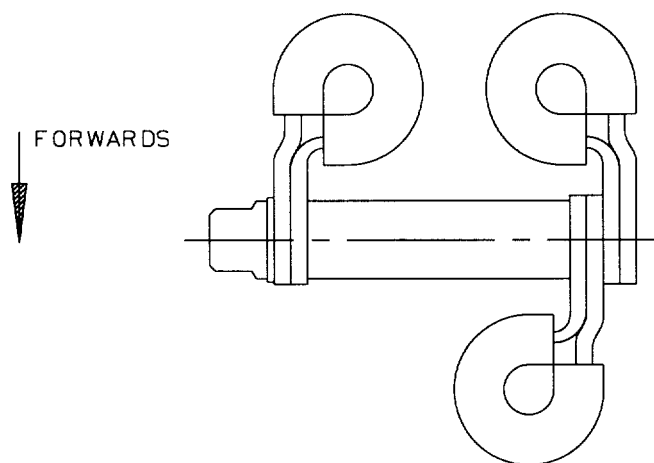
CLIP POINT 0583 AFTER ALTERATION

Clip point 0583 before and after alteration
Fig 19

dem0000152



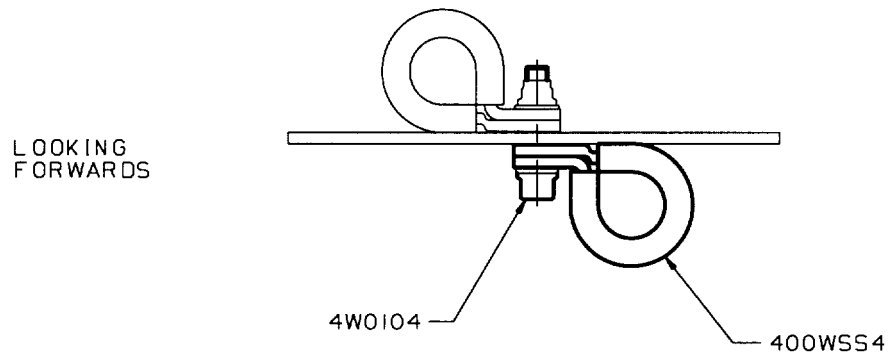
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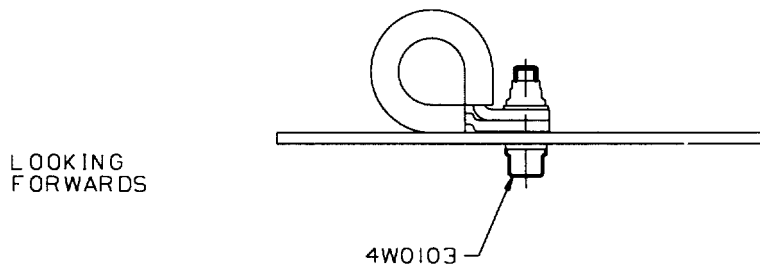
CLIP POINT 0585 AFTER ALTERATION

Clip point 0585 before and after alteration
Fig 20

dem0000153

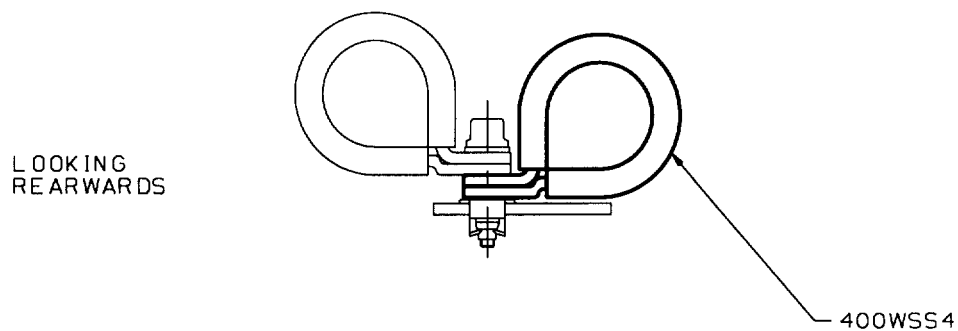


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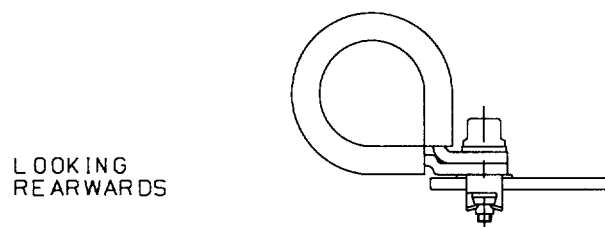


CLIP POINT 0590 AFTER ALTERATION

Clip point 0590 before and after alteration
Fig 21



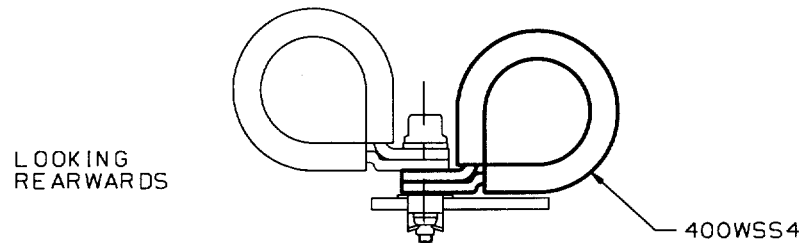
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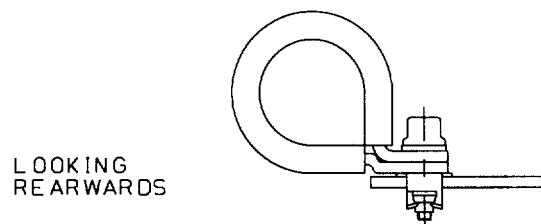
CLIP POINT 1029 AFTER ALTERATION

dem0000155

Clip point 1029 before and after alteration
Fig 22



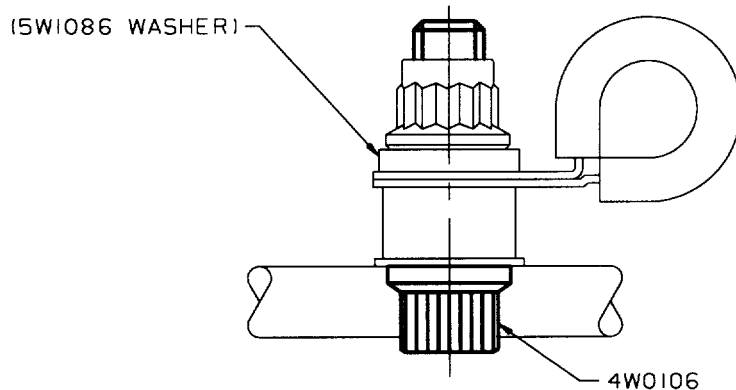
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CLIP POINT 1030 AFTER ALTERATION

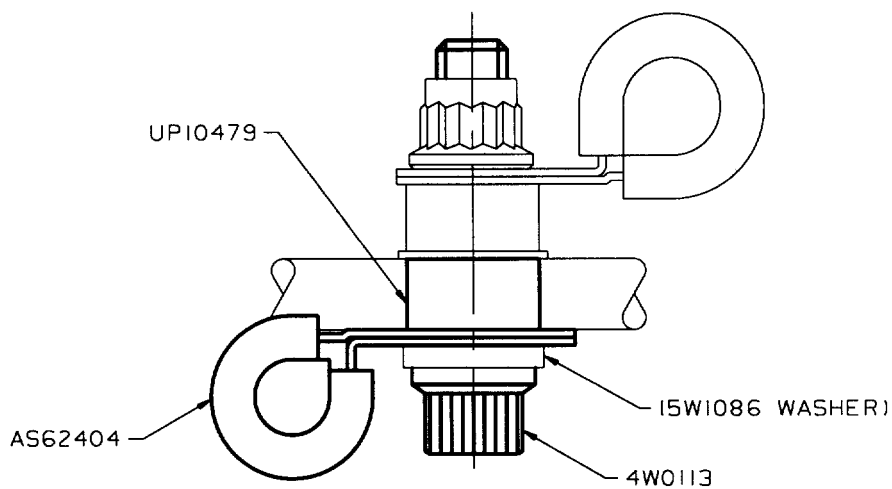
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Clip point 1030 before and after alteration
Fig 23



CLIP POINT 1079 BEFORE ALTERATION
LOOKING FORWARDS

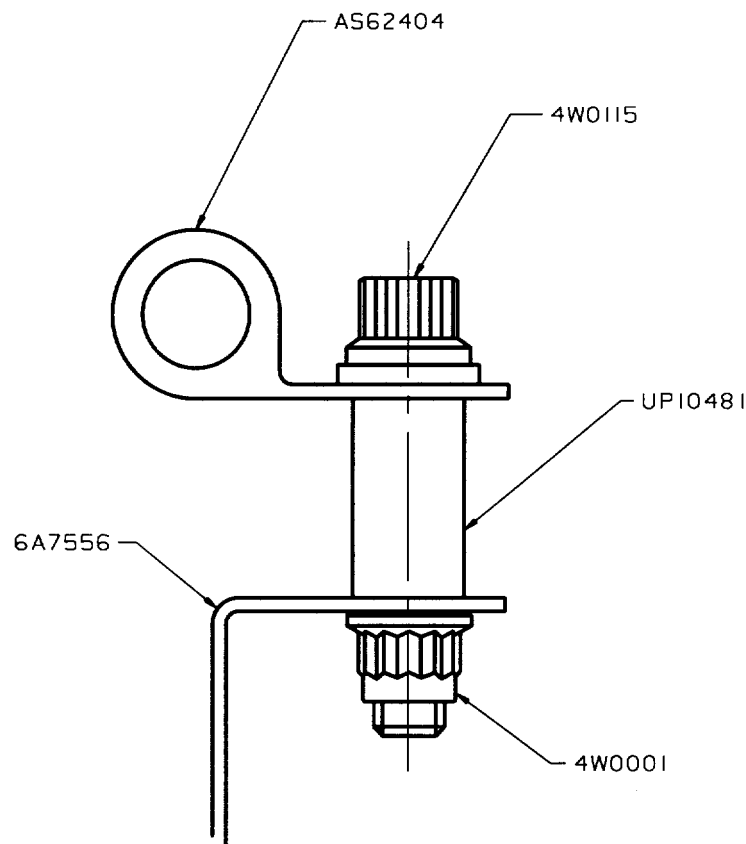
NOTE :-
POSITION OF WASHER IS
CHANGED IN CLIP STACK



CLIP POINT 1079 AFTER ALTERATION
LOOKING FORWARDS

Clip point 1079 before and after alteration
Fig 24

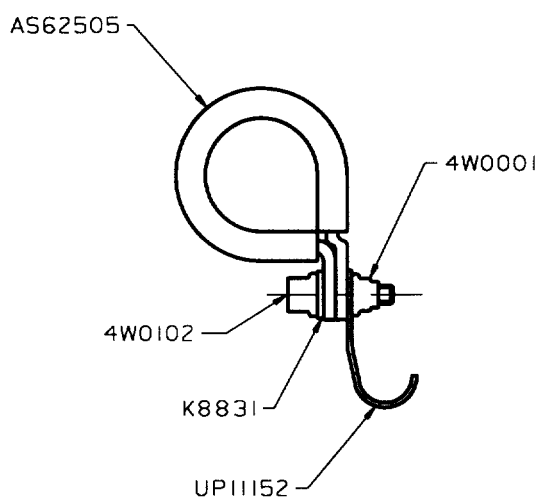
dem0000157



CLIP POINT 1403 ADDED
LOOKING REARWARD

dem0000158

Clip point 1403 before and after alteration
Fig 25



CLIP POINT 1404 ADDED
LOOKING REARWARDS

dem0000159

Clip point 1404 additional
Fig 26

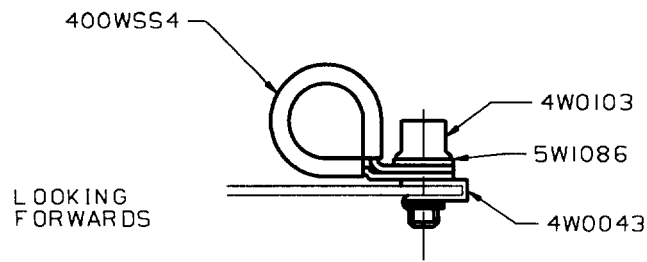
May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

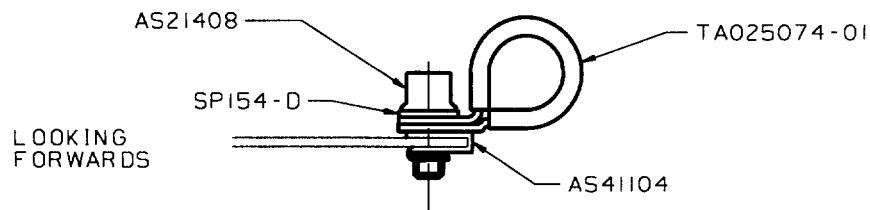
Page 70

IAE PROPRIETARY INFORMATION

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Not subject to the EAR per EC-CAR Chapter 1, Part 754.3(b)(3).



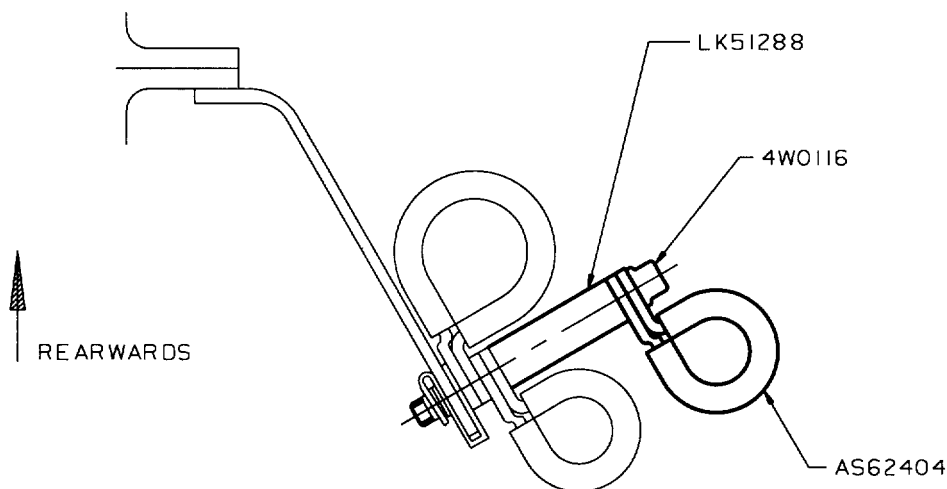
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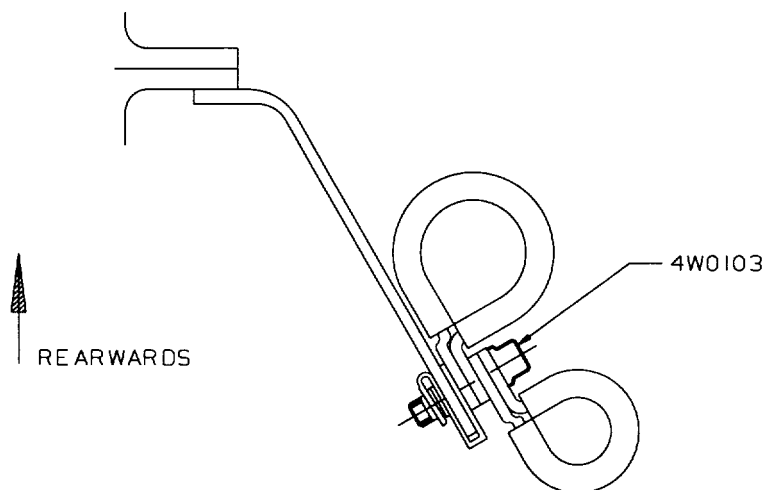
CLIP POINT 5431 AFTER ALTERATION

Clip point 5431 before and after alteration
Fig 27

dem00000160



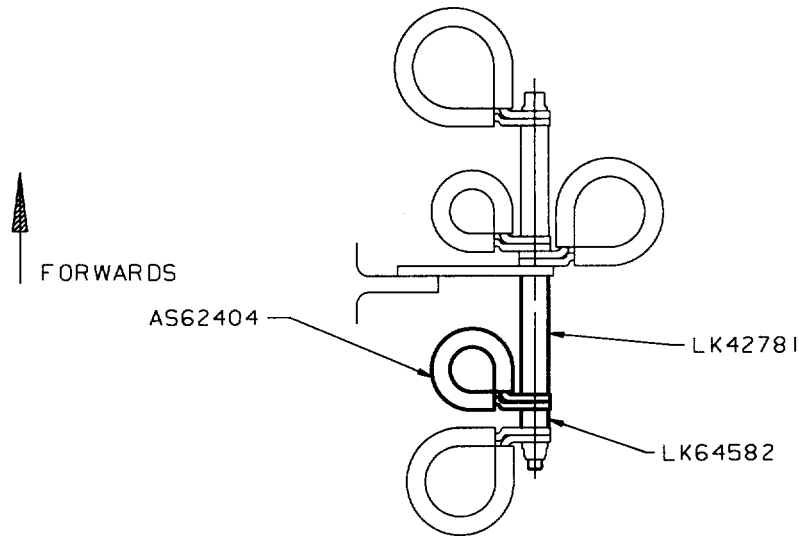
CLIP POINT 5647 BEFORE ALTERATION



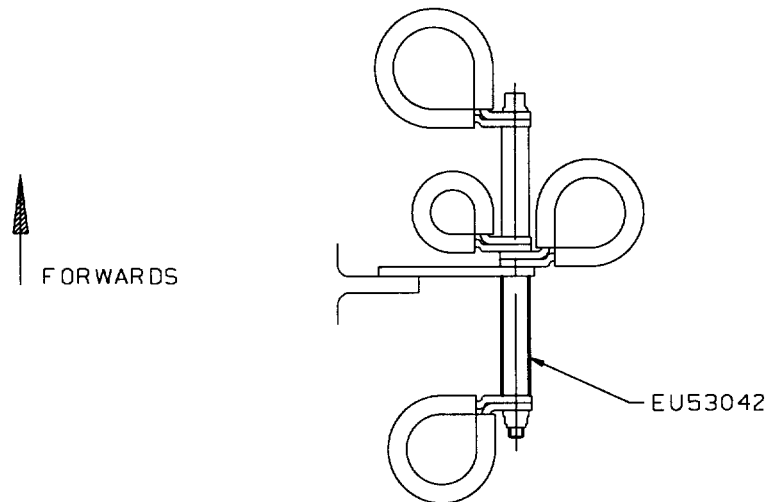
CLIP POINT 5647 AFTER ALTERATION

Clip point 5647 before and after alteration
Fig 28

Idem0000161



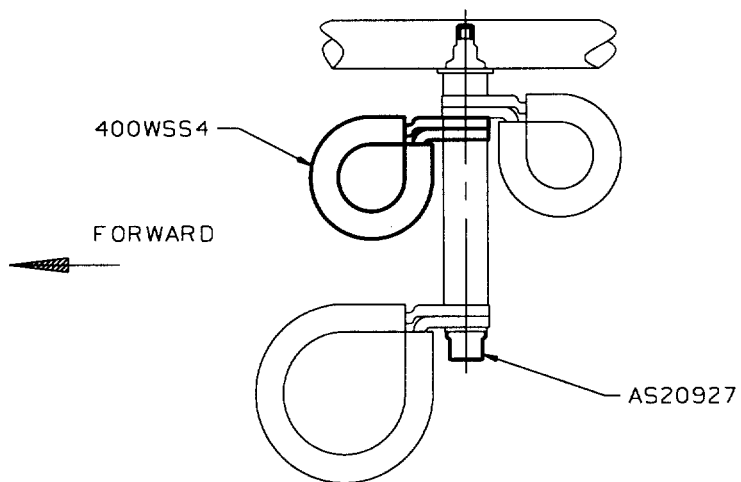
CLIP POINT 5648 BEFORE ALTERATION



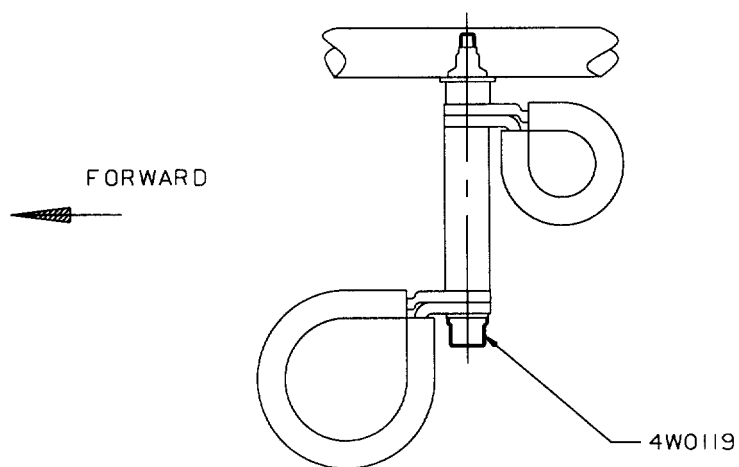
CLIP POINT 5648 AFTER ALTERATION

Clip point 5648 before and after alteration
Fig 29

dem0000162



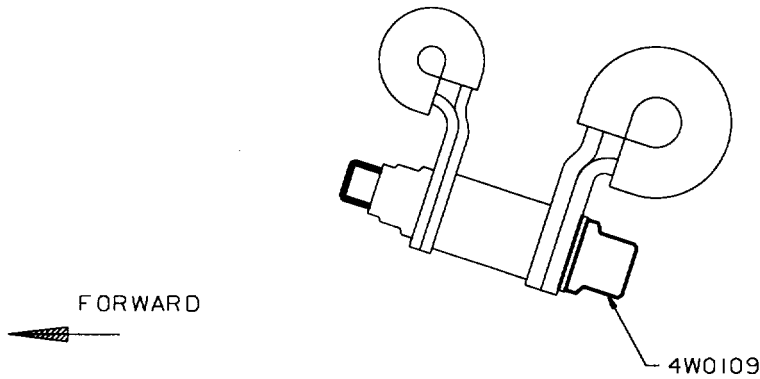
CLIP POINT 5652 BEFORE ALTERATION



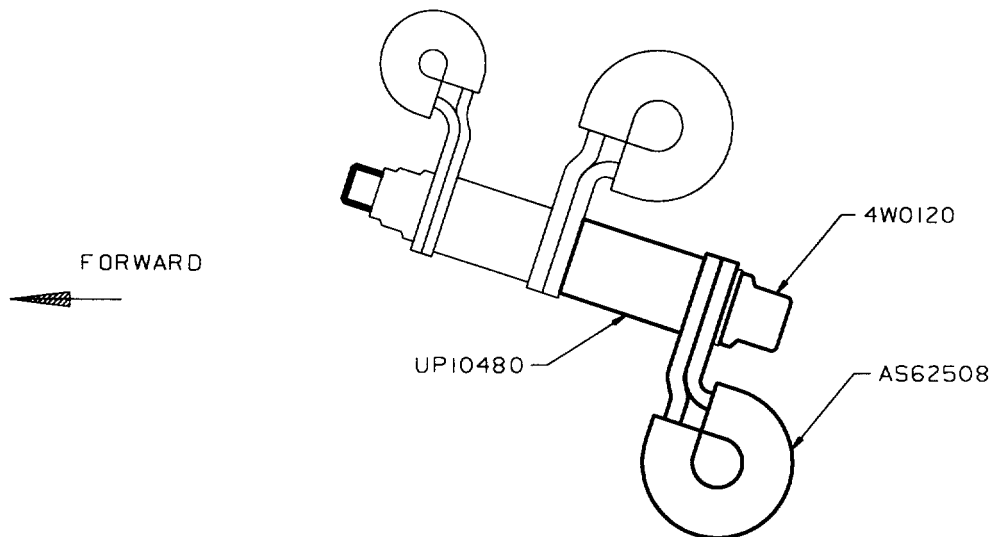
CLIP POINT 5652 AFTER ALTERATION

Clip point 5652 before and after alteration
Fig 30

dem00000163



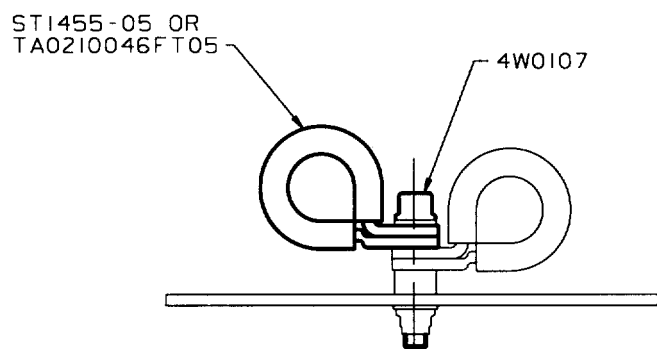
CLIP POINT 5747 BEFORE ALTERATION



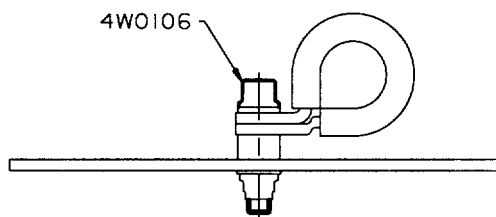
CLIP POINT 5747 AFTER ALTERATION

Clip point 5747 before and after alteration
Fig 31

dem0000164



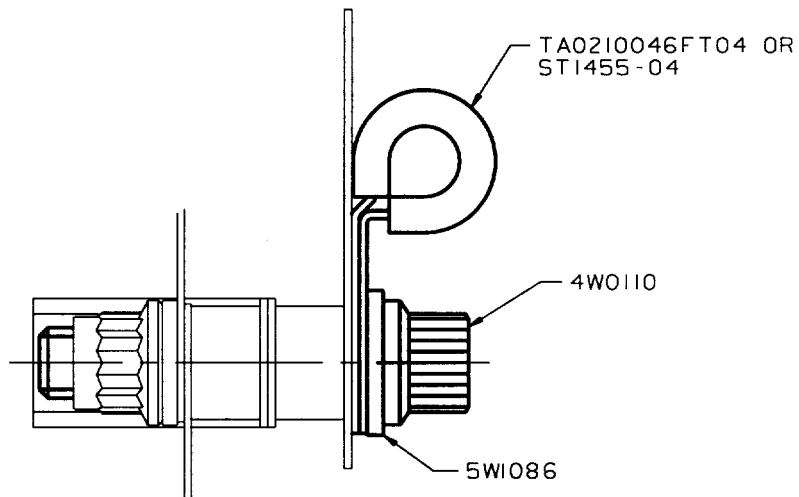
CLIP POINT 5788 BEFORE ALTERATION
LOOKING FORWARD



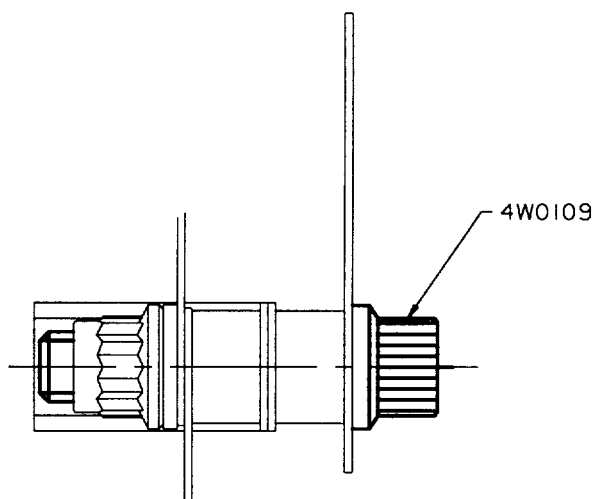
CLIP POINT 5788 AFTER ALTERATION
LOOKING FORWARD

Clip point 5788 before and after alteration
Fig 32

dem0000165



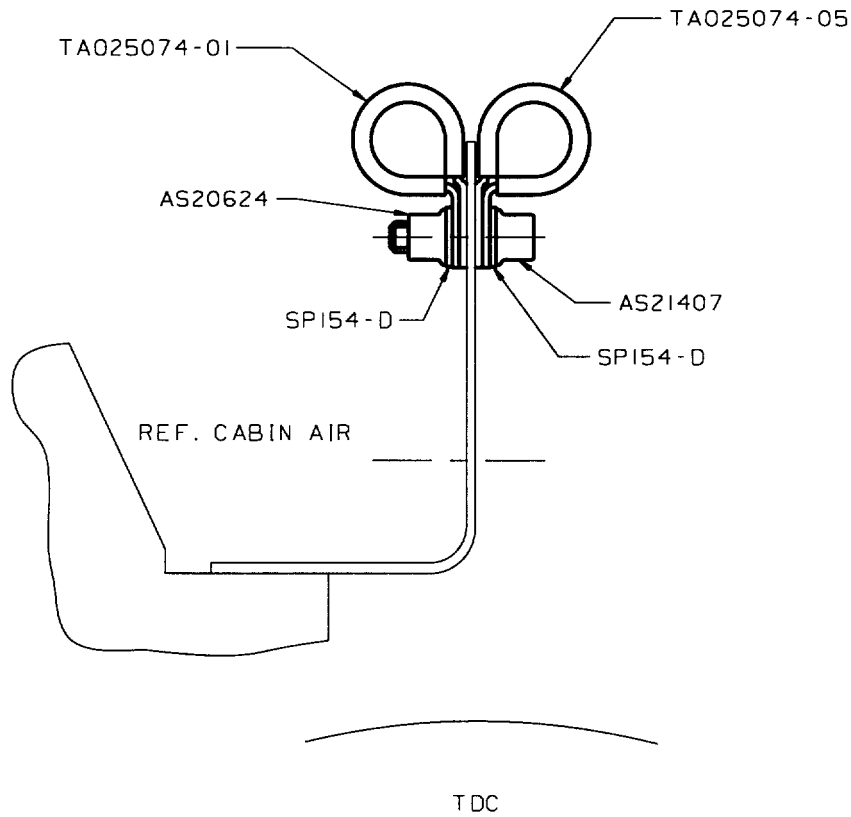
CLIP POINT 5789 BEFORE ALTERATION
LOOKING INTO ENGINE



CLIP POINT 5789 AFTER ALTERATION
LOOKING INTO ENGINE

Clip point 5789 before and after alteration
Fig 33

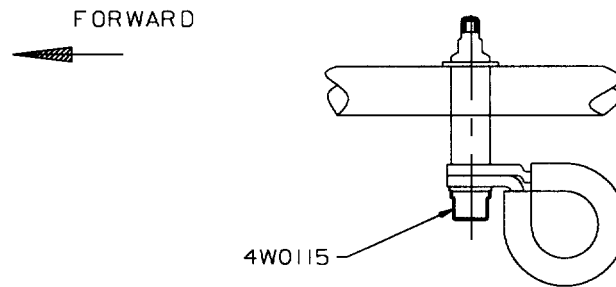
dem0000166



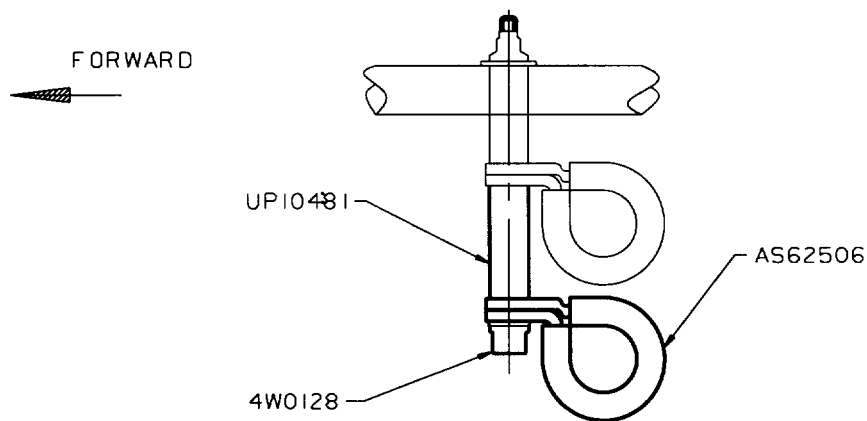
CLIP POINT 5990 ADDED
LOOKING REARWARD

Clip point 5990 additional
Fig 34

Idem0000167



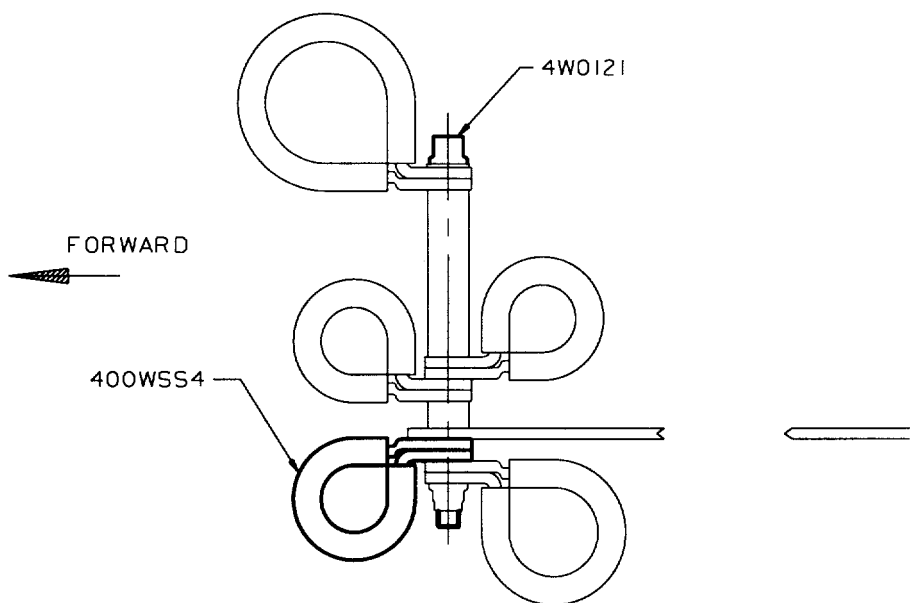
CLIP POINT 6058 BEFORE ALTERATION



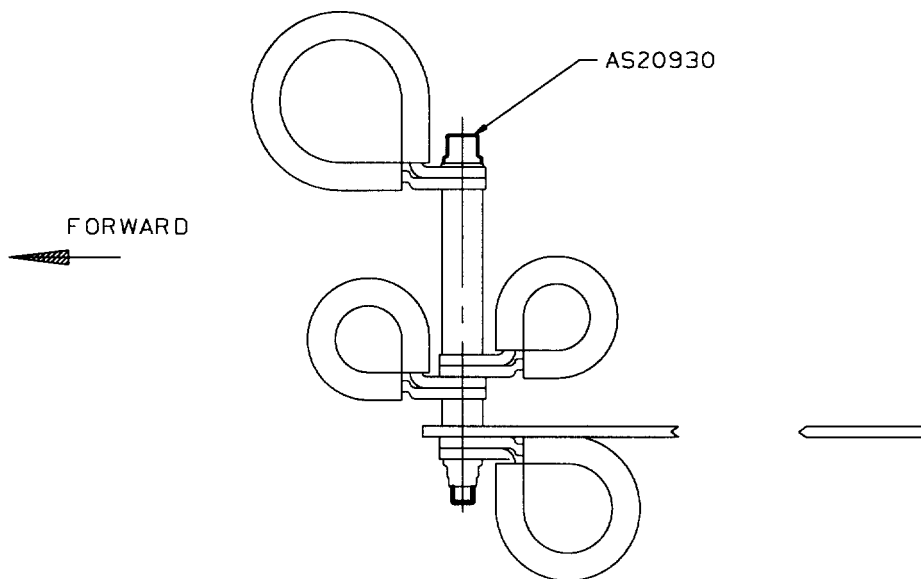
CLIP POINT 6058 AFTER ALTERATION

Clip point 6058 before and after alteration
Fig 35

Idem0000168



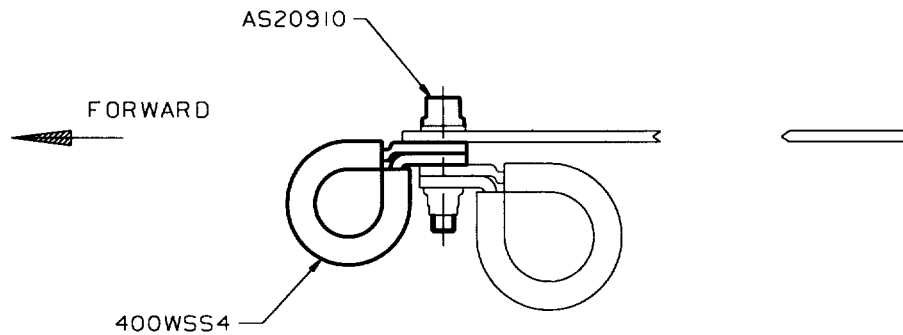
CLIP POINT 6064 BEFORE ALTERATION



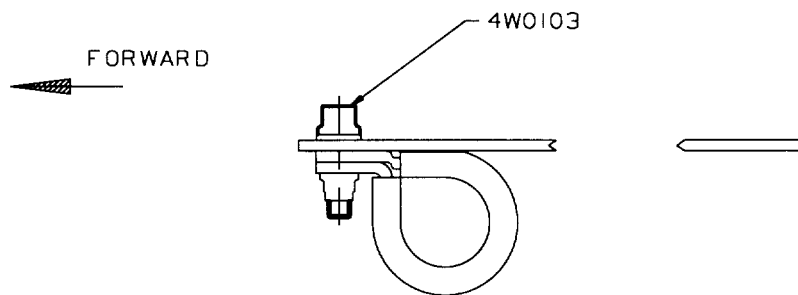
CLIP POINT 6064 AFTER ALTERATION

Clip point 6064 before and after alteration
Fig 36

dem0000169



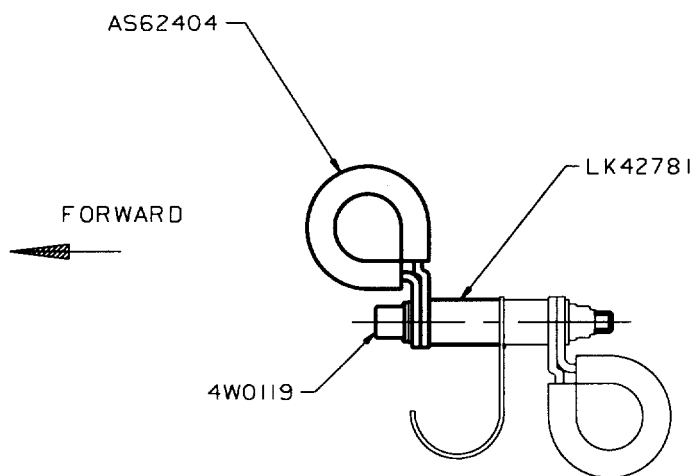
CLIP POINT 6065 BEFORE ALTERATION



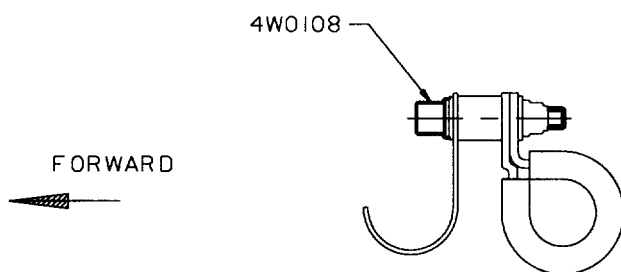
CLIP POINT 6065 AFTER ALTERATION

Clip point 6065 before and after alteration
Fig 37

dem0000170



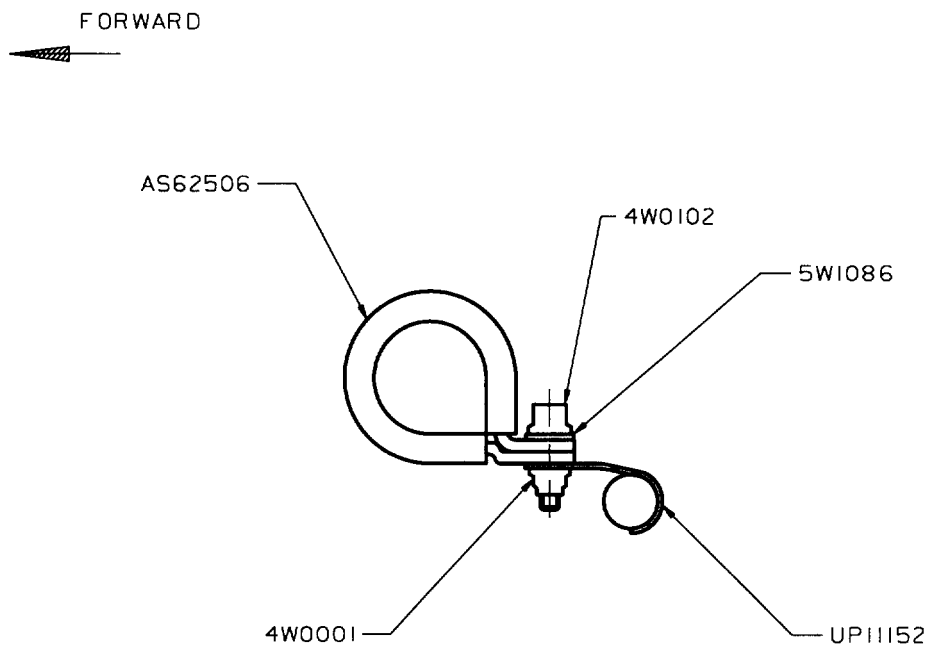
CLIP POINT 6100 BEFORE ALTERATION



CLIP POINT 6100 AFTER ALTERATION

Clip point 6100 before and after alteration
Fig 38

dem0000171



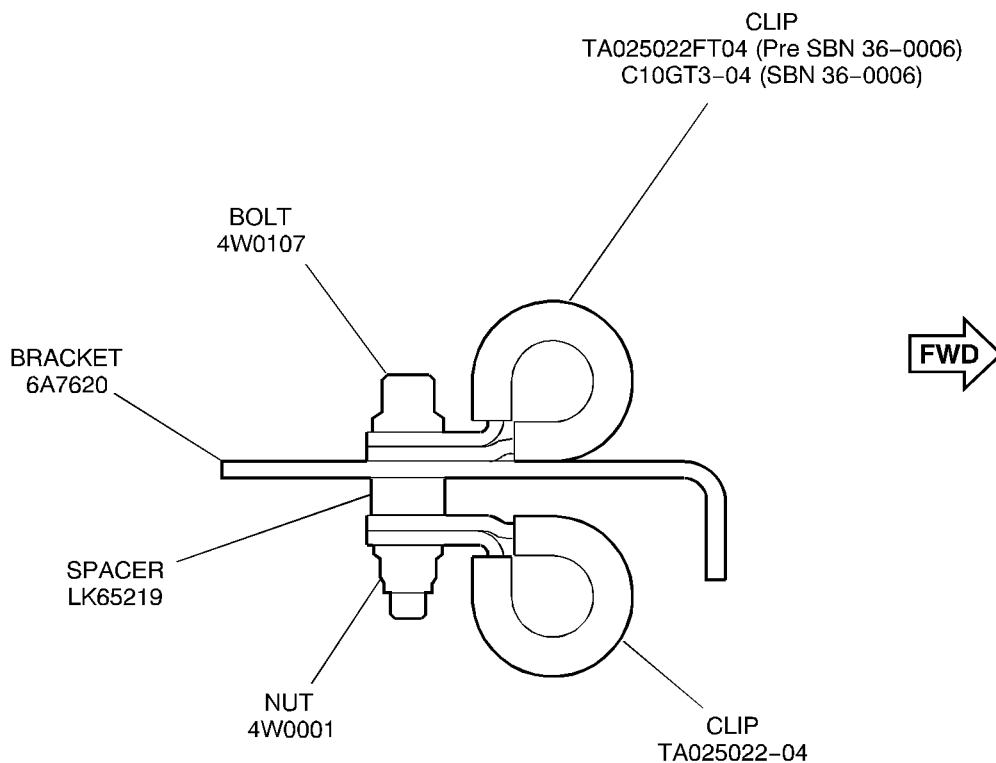
CLIP POINT 6107 ADDED

dem0000172

Clip point 6107 additional
Fig 39

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081
Page 83



CLIP POSITION 6108

ded0005259

Clip point 6108 additional
Fig 40

AIR – STAGE 10 TO HPT AIR VALVE – DELETION OF THE HPC STAGE 10 MAKE-UP AIR VALVE AND ASSOCIATED HARDWARE

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. Parts required:

Part No.	Description	Unit Price US Dollars
4W0001	Nut	5.43
4W0002	Nut	4.59
4W0043	Nut	5.01
4W0102	Bolt	9.47
4W0103	Bolt	9.47
4W0104	Bolt	9.47
4W0105	Bolt	9.47
4W0106	Bolt	9.47
4W0107	Bolt	10.20
4W0108	Bolt	17.10
4W0109	Bolt	8.99
4W0110	Bolt	9.85
4W0113	Bolt	17.60
4W0115	Bolt	6.77
4W0116	Bolt	25.20
4W0118	Bolt	6.25
4W0119	Bolt	9.66
4W0120	Bolt	9.66
4W0121	Bolt	31.70
4W0123	Bolt	32.20
4W0128	Bolt	18.40
4W0163	Bolt	10.70
4W0164	Bolt	10.70
4W0226	Bolt	41.60
4W2621	Washer	1.54
5U0001	Seal	213.00
5W1086	Washer	0.78
5W8446	Bracket	77.30
6A6191	Tube Assy	5,180.00
6A6192	Tube Assy	1,397.00
6A6193	Tube Assy	4,188.00
6A6194	Tube Assy	1,260.00
6A7555	Adaptor HPC	6,033.00

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081

Supplement Page 1 of 3

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Part No.	Description	Unit Price US Dollars
6A7556	Bracket	313.00
6A7557	Harness Assy	106,390.00
6A7569	Harness Assy	5,925.00
6A7570	Harness Assy	39,450.00
6A7620	Bracket	93.30
AS20624	Nut	5.43
AS21407	Bolt	9.47
AS62404	Clip	43.70
AS62408	Clip	46.70
AS62503	Clamp	17.60
AS62504	Clamp	17.80
AS62505	Clamp	18.40
AS62506	Clamp	19.00
AS62507	Clamp	19.60
AS62508	Clamp	20.40
AS62509	Clamp	20.90
AS62510	Clamp	21.20
AS62511	Clamp	21.90
AS62512	Clamp	22.40
AS62513	Clamp	23.70
AS62514	Clamp	23.80
AS62515	Clamp	24.30
AS62516	Clamp	24.30
AS62517	Clamp	24.30
AS62518	Clamp	27.20
AS62519	Clamp	27.60
AS62520	Clamp	28.00
AS62521	Clamp	28.60
ESC53-32	Bush	5.12
EU53042	Spacer	52.50
K8831	Washer	0.36
LK62478	Cover	12.70
LK65219	Spacer	54.40
MS27488-16	Plug	1.70
MS27488-20	Plug	1.12
MS3187-16-2	Plug	1.70
SF56	Bush	5.12
ST1455-04	Clip	20.98
TA0210046FT04	Clip	7.38
TA025022-04	Clamp	26.90
TA025074-01	Clamp	13.30
TA025074-05	Clamp	14.40
U440036	Tape	77.20
UP10478	Spacer	21.10
UP10479	Spacer	22.40
UP10480	Spacer	22.60
UP10481	Spacer	27.30

May 4/01
Apr.21/11 Revision 4

V2500-ENG-75-0081
Supplement Page 2

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Part No.	Description	Unit Price
		US Dollars
UP11152	Bracket	11.10

Parts are currently available.