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V2500-A1/A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Initial Issue of Service Bulletin V2500-ENG-75-0119.

Service Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 26 of the Service Bulletin.	Initial Issue.
	Page 1 of the Supplement.	Initial Issue.

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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 – ACTIVE CLEARANCE CONTROL – INTRODUCTION OF MOUNTING BUSHES WITH COUNTERBORE**1. Planning Information****A. Effectivity****(1) Airbus A319**

- (a) V2522-A5, V2524-A5, V2527M-A5 Engines from Serial No. V10001 to Serial No. V13190.
- (b) V2522-A5, V2524-A5, V2527M-A5 Engines from Serial No. V15001 to Serial No. V15683 and Engines with Serial No. V15685, V15687, V15689, V15691, V15693, V15695, V15697, V15699, V15701, V15703, V15705, V15707, V15709, V15711, V15713, V15715, V15717, V15719, V15721, V15723, V15737, V15739, V15741, V15743 and V15745.

(2) Airbus A320

- (a) V2500-A1 Engines from Serial No. V0001 to Serial No. V0361.
- (b) V2527-A5, V2527E-A5 Engines from Serial No. V10001 to Serial No. V13190.
- (c) V2527-A5, V2527E-A5 Engines from Serial No. V15001 to Serial No. V15683 and Engines with Serial No. V15685, V15687, V15689, V15691, V15693, V15695, V15697, V15699, V15701, V15703, V15705, V15707, V15709, V15711, V15713, V15715, V15717, V15719, V15721, V15723, V15737, V15739, V15741, V15743 and V15745.

(3) Airbus A321

- (a) V2530-A5, V2533-A5 Engines from Serial No. V10001 to Serial No. V13190.
- (b) V2530-A5, V2533-A5 Engines from Serial No. V15001 to Serial No. V15683 and Engines with Serial No. V15685, V15687, V15689, V15691, V15693, V15695, V15697, V15699, V15701, V15703, V15705, V15707, V15709, V15711, V15713, V15715, V15717, V15719, V15721, V15723, V15737, V15739, V15741, V15743 and V15745.

(4) Boeing MD 90

- (a) V2525-D5, V2528-D5 Engines from Serial No. V20001 to Serial No. V20285.

B. Concurrent Requirements

None.

C. Reason**(1) Condition**

The specification for the manufacture of the bolts used to install the Active Clearance Control mounting system, permits a raised area at the fillet radius, between the bolt head and the shank. Under certain tolerance conditions the distortion prevents the close tolerance bush from seating correctly on the bolt shank and to the underside of the bolt head.

(2) Background

The distortion on the bolt can prevent the bolt from sliding down over the bolt shank and making correct contact between the underside of the bolt head and the bush.

(3) Objective

Introduction of this Service Bulletin is designed to help engine build and prevent incorrect assembly.

(4) Substantiation

A bush with a counterbore feature will eliminate assembly conditions which could produce a gap between the underside of the bolt head and the bush.

(5) Effect of Bulletin on:**(a) Operation**

Not affected.

(b) Maintenance

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

(c) Overhaul

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

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

(6) Supplemental Information

(a) None.

D. Description

This Service Bulletin introduces a redesigned bush with a counterbore within the range of the cold working distortion area of the bolt.

The redesigned bush can be installed on all bolts as expressed in the design intent.

E. Compliance

Category Code 6

Accomplish when the subassembly (i.e. modules, accessories and components build groups) is disassembled sufficiently to afford access to the affected parts.

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

(1) In Service

15 min per bush.

(2) At Overhaul/Shop Visit

Applicable (hours not affected).

H. Material Price and Availability

A modification kit is not required; parts are supplied as single line items.

For prices and availability of spares, refer to the supplement to this Service Bulletin.

I. Tooling Availability

None.

J. Industry Support Information

Not applicable.

K. Weight and Balance**(1) Weight Change**

None.

(2) Moment Arm

No effect.

(3) Datum

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 Engine Manual (E-V2500-1IA), Chapter 72-00-40.

(2) IAE V2500 Engine Manual (E-V2500-3IA), Chapter 72-00-40.

(3) Aircraft Maintenance Manual Chapter 75-24-51.

(4) Internal Reference No.

Engineering Change No. 10VR011, 10VR011-01 and 10VR011A.

(5) ATA Locators - 75-24-47 and 75-24-51.

O. Other Publications Affected

(1) IAE V2500 Engine Illustrated Parts Catalogues (S-V2500-1IA, S-V2500-2IA, S-V2500-2IB, S-V2500-2SA, S-V2500-2SB, S-V2500-3IA, S-V2500-3IB, S-V2500-3IC, S-V2500-5IA, S-V2500-5IB, S-V2500-5SA, S-V2500-5SB, S-V2500-6IA, S-V2500-6IB, S-V2500-6SA, S-V2500-6SB, S-V2500-7IA, S-V2500-7IB, S-V2500-7SA and S-V2500-7SB), Chapter 75-24-47 and 75-24-51 will be amended to incorporate the new part numbers (Refer to paragraph 2. Material Information).

(2) V2500 A1/A5/D5 Engine Manual/Chapter/Section 75-24-47 and 75-24-51, Cleaning, to add the new part number.

(3) V2500 A1/A5/D5 Engine Manual/Chapter/Section 75-24-47 and 75-24-51, Inspection/Check, to add the new part number.

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- (4) V2500 A1/A5/D5 Engine Manual/Chapter/Section 75-24-47 and 75-24-51, Repair, to add the new part number.
- (5) V2500 A1/A5/D5 Aircraft Maintenance Manual/Chapter/Section 75-24-47 and 75-24-51.

P. Interchangeability of Parts

Affected (Refer to paragraph 2.E. Instruction disposition codes).

2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts to be reworked:

None.

C. New production parts:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
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For V2500-A1, V2500-A5 and V2500-D5 engines:

75-24-47

01-540	6B1465	2	.Bush	-	5W2059	(S1)
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01-590	6B1465	2	.Bush	-	5W2059	(S1)
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75-24-51

01-190	6B1465	2	.Bush	-	5W2059	(S1)
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01-210	6B1465	2	.Bush	-	5W2059	(S1)
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01-470	6B1465	2	.Bush	-	5W2059	(S1)
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For V2500-D5 Engines only:

01-860	6B1465	2	.Bush	-	5W2059	(S1)
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01-880	6B1465	2	.Bush	-	5W2059	(S1)
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01-905	6B1465	2	.Bush	-	5W2059	(S1)
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01-935	6B1465	2	.Bush	-	5W2059	(S1)
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For V2500-A1 and V2500-A5 engines only:

02-130	6B1465	2	.Bush	-	5W2059	(S1)
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02-160	6B1465	2	.Bush	-	5W2059	(S1)
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02-310	6B1465	2	.Bush	-	5W2059	(S1)
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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02-380	6B1465	2	.Bush	-	5W2059	(S1)

D. Redundant parts:

None.

E. Instruction disposition codes:

(S1) The old and new parts are interchangeable, but once the new part has been installed it is recommended not to re-install the old part.

3. Accomplishment Instructions

A. Rework Instructions

- (1) None.

B. Assembly Instructions

INSTRUCTION I – APPLICABLE FOR ENGINES IN SERVICE

(1) General

- (a) Obey all the WARNINGS and CAUTIONS in the procedures that are referred to.

(b) Consumable Materials

- (i) Refer to the related Manual tasks given in this instruction.

(c) Tools and Equipment

- (i) Refer to the related Manual tasks given in this instruction.

- (2) Get access to the Active Clearance Control (ACC) Valve that is installed on the High Pressure (HP) turbine.

- (3) Disassemble the Linkages of the ACC valve (Refer to the Aircraft Maintenance Manual, Chapter 75-24-51 and Figure 1 or Figure 2)

- (a) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

- (i) Remove and discard the cotter pin (75-24-51, 02-260).

Remove the nut (75-24-51, 02-265) and the bolt (75-24-51, 02-270).

If scheduled, remove the two old bushes (75-24-51, 02-310), P/N 5W2059.

- (ii) Remove and discard the cotter pin (75-24-51, 02-290).

Remove the nut (75-24-51, 02-295) and the bolt (75-24-51, 02-300).

If scheduled, remove the two old bushes (75-24-51, 02-380), P/N 5W2059).

- (iii) Remove and discard the cotter pin (75-24-51, 02-110).

Remove the nut (75-24-51, 02-115) and the bolt (75-24-51, 02-120).

If scheduled, remove the two old bushes (75-24-51, 02-130), P/N 5W2059.

- (iv) Remove and discard the cotter pin (75-24-51, 02-140).

Remove the nut (75-24-51, 02-145) and the bolt (75-24-51, 02-150).

If scheduled, remove the two old bushes (75-24-51, 02-160), P/N 5W2059.

- (b) For V2500-A1, V2500-A5 and V2500-D5 engines:

- (i) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

Remove and discard the cotter pin (75-24-51, 01-136).

Remove the nut (75-24-51, 01-140) and the bolt (75-24-51, 01-155).

If scheduled, remove the two old bushes (75-24-51, 01-210), P/N 5W2059.

- (ii) For V2500-D5 engines only (Refer to Figure 2):

Remove the nut (75-24-51, 01-140), the two washers (75-24-51, 01-142) and the bolt (75-24-51, 01-155).

If scheduled, remove the two old bushes (75-24-51, 01-210), P/N 5W2059.

- (iii) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

Remove and discard the cotter pin (75-24-51, 01-110).

Remove the nut (75-24-51, 01-115) and the bolt (75-24-51, 01-120).

If scheduled, remove the two old bushes (75-24-51, 01-190), P/N 5W2059.

- (iv) Remove and discard the cotter pin (75-24-51, 01-410).

Remove the nut (75-24-51, 01-415), and the bolt (75-24-51, 01-420).

If scheduled, remove the two old bushes (75-24-51, 01-470), P/N 5W2059.

(v) Remove and discard the cotter pin (75-24-47, 01-510).

Remove the nut (75-24-47, 01-515) and the bolt (75-24-47, 01-520).

If scheduled, remove the two old bushes (75-24-47, 01-540), P/N 5W2059.

(vi) Remove and discard the cotter pin (75-24-47, 01-560).

Remove the nut (75-24-47, 01-565) and the bolt (75-24-47, 01-570).

If scheduled, remove the two old bushes (75-24-47, 01-590), P/N 5W2059.

(c) For V2500-D5 engines only (Refer to Figure 2):

(i) Remove and discard the cotter pin (75-24-51, 01-850).

Remove the nut (75-24-51, 01-855) and the bolt (75-24-51, 01-865).

If scheduled, remove the two old bushes (75-24-51, 01-860), P/N 5W2059.

(ii) Remove and discard the cotter pin (75-24-51, 01-895).

Remove the nut (75-24-51, 01-900) and the bolt (75-24-51, 01-910).

If scheduled, remove the two old bushes (75-24-51, 01-905), P/N 5W2059.

(iii) Remove and discard the cotter pin (75-24-51, 01-870).

Remove the nut (75-24-51, 01-875) and the bolt (75-24-51, 01-885).

If scheduled, remove the two old bushes (75-24-51, 01-880), P/N 5W2059.

(iv) Remove and discard the cotter pin (75-24-51, 01-925).

Remove the nut (75-24-51, 01-930) and the bolt (75-24-51, 01-940).

If scheduled, remove the two old bushes (75-24-51, 01-935), P/N 5W2059.

- (4) Assemble the linkages of the ACC valve (Refer to the Aircraft Maintenance Manual, Chapter 75-24-51 and Figure 1 or Figure 2)

(a) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

- (i) If scheduled, install the two new bushes (75-24-51, 02-310), P/N 6B1465.

Install the bolt (75-24-51, 02-270) and the nut (75-24-51, 02-265).

Torque the nut (75-24-51, 02-265) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-260).

- (ii) If scheduled, install the two new bushes (75-24-51, 02-380), P/N 6B1465.

Install the bolt (75-24-51, 02-300) and the nut (75-24-51, 02-295).

Torque the nut (75-24-51, 02-295) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-290).

- (iii) If scheduled, install the two new bushes (75-24-51, 02-130), P/N 6B1465.

Install the bolt (75-24-51, 02-120) and the nut (75-24-51, 02-115).

Torque the nut (75-24-51, 02-115) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-110).

- (iv) If scheduled, install the two new bushes (75-24-51, 02-160), P/N 6B1465.

Install the bolt (75-24-51, 02-150) and the nut (75-24-51, 02-145).

Torque the nut (75-24-51, 02-145) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-140).

(b) For V2500-A1, V2500-A5 and V2500-D5 engines:

(i) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

If scheduled, install the two new bushes (75-24-51, 01-210), P/N 6B1465.

Install the bolt (75-24-51, 01-155) and the nut (75-24-51, 01-140).

Torque the nut (75-24-51, 01-140) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-136).

(ii) For V2500-D5 engines only (Refer to Figure 2):

If scheduled, install the two new bushes (75-24-51, 01-210), P/N 6B1465.

Install the bolt (75-24-51, 01-155), the two washers (75-24-51, 01-142) and the nut (75-24-51, 01-140).

Torque the nut (75-24-51, 01-140) to 88.5 to 106 lbf in. (10 to 12 Nm).

(iii) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

If scheduled, install the two new bushes (75-24-51, 01-190), P/N 6B1465.

Install the bolt (75-24-51, 01-120) and the nut (75-24-51, 01-115).

Torque the nut (75-24-51, 01-115) to 22.5 to 30 lbf in. (2,54 to 3,39 Nm).

Install a new cotter pin (75-24-51, 01-110).

(iv) If scheduled, install the two new bushes (75-24-51, 01-470), P/N 6B1465.

Install the bolt (75-24-51, 01-420) and the nut (75-24-51, 01-415).

Torque the nut (75-24-51, 01-415) to 22.5 to 30 lbf in. (2,54 to 3,39 Nm).

Install a new cotter pin (75-24-51, 01-410).

- (v) If scheduled, install the two new bushes (75-24-47, 01-540), P/N 6B1465.

Install the bolt (75-24-47, 01-520) and the nut (75-24-47, 01-515).

Torque the nut (75-24-47, 01-515) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-47, 01-510).

- (vi) If scheduled, install the two new bushes (75-24-47, 01-590), P/N 6B1465.

Install the bolt (75-24-47, 01-570) and the nut (75-24-47, 01-565).

Torque the nut (75-24-47, 01-565) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-47, 01-560).

- (c) For V2500-D5 engines only (Refer to Figure 2):

- (i) If scheduled, install the two new bushes (75-24-51, 01-860), P/N 6B1465.

Install the bolt (75-24-51, 01-865) and the nut (75-24-51, 01-855).

Torque the nut (75-24-51, 02-855) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-850).

- (ii) If scheduled, install the two new bushes (75-24-51, 01-905), P/N 6B1465.

Install the bolt (75-24-51, 01-910) and the nut (75-24-51, 01-900).

Torque the nut (75-24-51, 01-900) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-895).

- (iii) If scheduled, install the two new bushes (75-24-51, 01-880), P/N 6B1465.

Install the bolt (75-24-51, 01-885) and the nut (75-24-51, 01-875).

Torque the nut (75-24-51, 02-875) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-870).

- (iv) If scheduled, install the two new bushes (75-24-51, 01-935), P/N 6B1465.

Install the bolt (75-24-51, 01-940) and the nut (75-24-51, 01-930).

Torque the nut (75-24-51, 01-930) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-925).

- (5) Make sure that the work area is clean and clear of tools, equipment and other unwanted materials.

INSTRUCTION II – APPLICABLE FOR ENGINES AT OVERHAUL/SHOP VISIT

(1) General

(a) Obey all the WARNINGS and CAUTIONS in the procedures that are referred to.

(b) Consumable Materials

(i) Refer to the related Manual tasks given in this instruction.

(c) Tools and Equipment

(i) Refer to the related Manual tasks given in this instruction.

(2) Disassemble the Linkages of the ACC valve (Refer to the Engine Manual, Chapter 72-00-40, and Figure 1 or Figure 2)

(a) For V2500-A1 and V2500-A5 engines only (Figure 1):

(i) Remove and discard the cotter pin (75-24-51, 02-110).

Remove the nut (75-24-51, 02-115) and the bolt (75-24-51, 02-120).

If scheduled, remove the two old bushes (75-24-51, 02-130), P/N 5W2059.

(ii) Remove and discard the cotter pin (75-24-51, 02-140).

Remove the nut (75-24-51, 02-145) and the bolt (75-24-51, 02-150).

If scheduled, remove the two old bushes (75-24-51, 02-160), P/N 5W2059.

(iii) Remove and discard the cotter pin (75-24-51, 02-260).

Remove the nut (75-24-51, 02-265) and the bolt (75-24-51, 02-270).

If scheduled, remove the two old bushes (75-24-51, 02-310), P/N 5W2059.

(iv) Remove and discard the cotter pin (75-24-51, 02-290).

Remove the nut (75-24-51, 02-295) and the bolt (75-24-51, 02-300).

If scheduled, remove the two old bushes (75-24-51, 02-380), P/N 5W2059.

(b) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

(i) Remove and discard the cotter pin (75-24-47, 01-510).

Remove the nut (75-24-47, 01-515) and the bolt (75-24-47, 01-520).

If scheduled, remove the two old bushes (75-24-47, 01-540), P/N 5W2059.

(ii) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

Remove and discard the cotter pin (75-24-51, 01-136).

Remove the nut (75-24-51, 01-140) and the bolt (75-24-51, 01-155).

If scheduled, remove the two old bushes (75-24-51, 01-210), P/N 5W2059.

(iii) For V2500-D5 engines only (Refer to Figure 2):

Remove the nut (75-24-51, 01-140), the two washers (75-24-51, 01-142) and the bolt (75-24-51, 01-155).

If scheduled, remove the two old bushes (75-24-51, 01-210), P/N 5W2059.

(iv) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

Remove and discard the cotter pin (75-24-51, 01-110).

Remove the nut (75-24-51, 01-115) and the bolt (75-24-51, 01-120).

If scheduled, remove the two old bushes (75-24-51, 01-190), P/N 5W2059.

(v) Remove and discard the cotter pin (75-24-51, 01-410).

Remove the nut (75-24-51, 01-415) and the bolt (75-24-51, 01-420).

If scheduled, remove the two old bushes (75-24-51, 01-470), P/N 5W2059.

(vi) Remove and discard the cotter pin (75-24-47, 01-560).

Remove the nut (75-24-47, 01-565) and the bolt (75-24-47, 01-570).

If scheduled, remove the two old bushes (75-24-47, 01-590), P/N 5W2059.

(c) For V2500-D5 engines only (Refer to Figure 2):

(i) Remove and discard the cotter pin (75-24-51, 01-850).

Remove the nut (75-24-51, 01-855) and the bolt (75-24-51, 01-865).

If scheduled, remove the two old bushes (75-24-51, 01-860), P/N 5W2059.

(ii) Remove and discard the cotter pin (75-24-51, 01-895).

Remove the nut (75-24-51, 01-900) and the bolt (75-24-51, 01-910).

If scheduled, remove the two old bushes (75-24-51, 01-905), P/N 5W2059.

(iii) Remove and discard the cotter pin (75-24-51, 01-01-870).

Remove the nut (75-24-51, 01-875) and the bolt (75-24-51, 01-885).

If scheduled, remove the two old bushes (75-24-51, 01-880), P/N 5W2059.

(iv) Remove and discard the cotter pin (75-24-51, 01-925).

Remove the nut (75-24-51, 01-930) and the bolt (75-24-51, 01-940).

If scheduled, remove the two old bushes (75-24-51, 01-935), P/N 5W2059.

- (3) Assemble the linkages of the ACC valve (Refer to the Engine Manual, Chapter 72-00-40 and Figure 1 or Figure 2)

(a) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

- (i) If scheduled, install the two new bushes (75-24-51, 02-130), P/N 6B1465.

Install the bolt (75-24-51, 02-120) and the nut (75-24-51, 02-115).

Torque the nut (75-24-51, 02-115) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-110).

- (ii) If scheduled, install the two new bushes (75-24-51, 02-160), P/N 6B1465.

Install the bolt (75-24-51, 02-150) and the nut (75-24-51, 02-145).

Torque the nut (75-24-51, 02-145) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-140).

- (iii) If scheduled, install the two new bushes (75-24-51, 02-310), P/N 6B1465.

Install the bolt (75-24-51, 02-270) and the nut (75-24-51, 02-265).

Torque the nut (75-24-51, 02-265) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-260).

- (iv) If scheduled, install the two new bushes (75-24-51, 02-380), P/N 6B1465.

Install the bolt (75-24-51, 02-300) and the nut (75-24-51, 02-295).

Torque the nut (75-24-51, 02-295) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 02-290).

(b) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

- (i) If scheduled, install the two new bushes (75-24-47, 01-540), P/N 6B1465.

Install the bolt (75-24-47, 01-520) and the nut (75-24-47, 01-515)

Torque the nut (75-24-51, 01-515) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-47, 01-510).

(c) For V2500-A1 and V2500-A5 engines only (Refer to Figure 1):

- (i) If scheduled, install the two new bushes (75-24-51, 01-210), P/N 6B1465.

Install the bolt (75-24-51, 01-155) and the nut (75-24-51, 01-140).

Torque the nut (75-24-51, 01-140) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-136).

- (ii) For V2500-D5 engines only (Refer to Figure 2):

If scheduled, install the two new bushes (75-24-51, 01-210), P/N 6B1465.

Install the bolt (75-24-51, 01-155), the two washers (75-24-51, 01-142) and the nut (75-24-51, 01-140).

Torque the nut (75-24-51, 01-140) to 88.5 to 106 lbf in. (10 to 12 Nm).

(d) For V2500-A1, V2500-A5 and V2500-D5 engines (Refer to Figure 1 and Figure 2):

- (i) If scheduled, install the two new bushes (75-24-51, 01-190), P/N 6B1465.

Install the bolt (75-24-51, 01-120) and the nut (75-24-51, 01-115).

Torque the nut (75-24-51, 01-115) to 22.5 to 30 lbf in. (2,54 to 3,39 Nm).

Install a new cotter pin (75-24-51, 01-110).

- (ii) If scheduled, install the two new bushes (75-24-51, 01-470), P/N 6B1465.

Install the bolt (75-24-51, 01-420) and the nut (75-24-51, 01-415).

Torque the nut (75-24-51, 01-415) to 22.5 to 30 lbf in. (2,54 to 3,39 Nm).

Install a new cotter pin (75-24-51, 01-410).

- (iii) If scheduled, install the two new bushes (75-24-47, 01-590), P/N 6B1465.

Install the bolt (75-24-47, 01-570) and the nut (75-24-47, 01-565).

Torque the nut (75-24-51, 01-565) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-47, 01-560).

- (e) For V2500-D5 engines only (Refer to Figure 2):

- (i) If scheduled, install the two new bushes (75-24-51, 01-860), P/N 6B1465.

Install the bolt (75-24-51, 01-865) and the nut (75-24-51, 01-855).

Torque the nut (75-24-51, 01-855) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-850)

- (ii) If scheduled, install the two new bushes (75-24-51, 01-905), P/N 6B1465.

Install the bolt (75-24-51, 01-910) and the nut (75-24-51, 01-900).

Torque the nut (75-24-51, 01-900) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-895).

- (iii) If scheduled, install the two new bushes (75-24-51, 01-880), P/N 6B1465.

Install the bolt (75-24-51, 01-885) and the nut (75-24-51, 01-875).

Torque the nut (75-24-51, 01-875) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-870).

- (iv) If scheduled, install the two new bushes (75-24-51, 01-935), P/N 6B1465.

Install the bolt (75-24-51, 01-940) and the nut (75-24-51, 01-930).

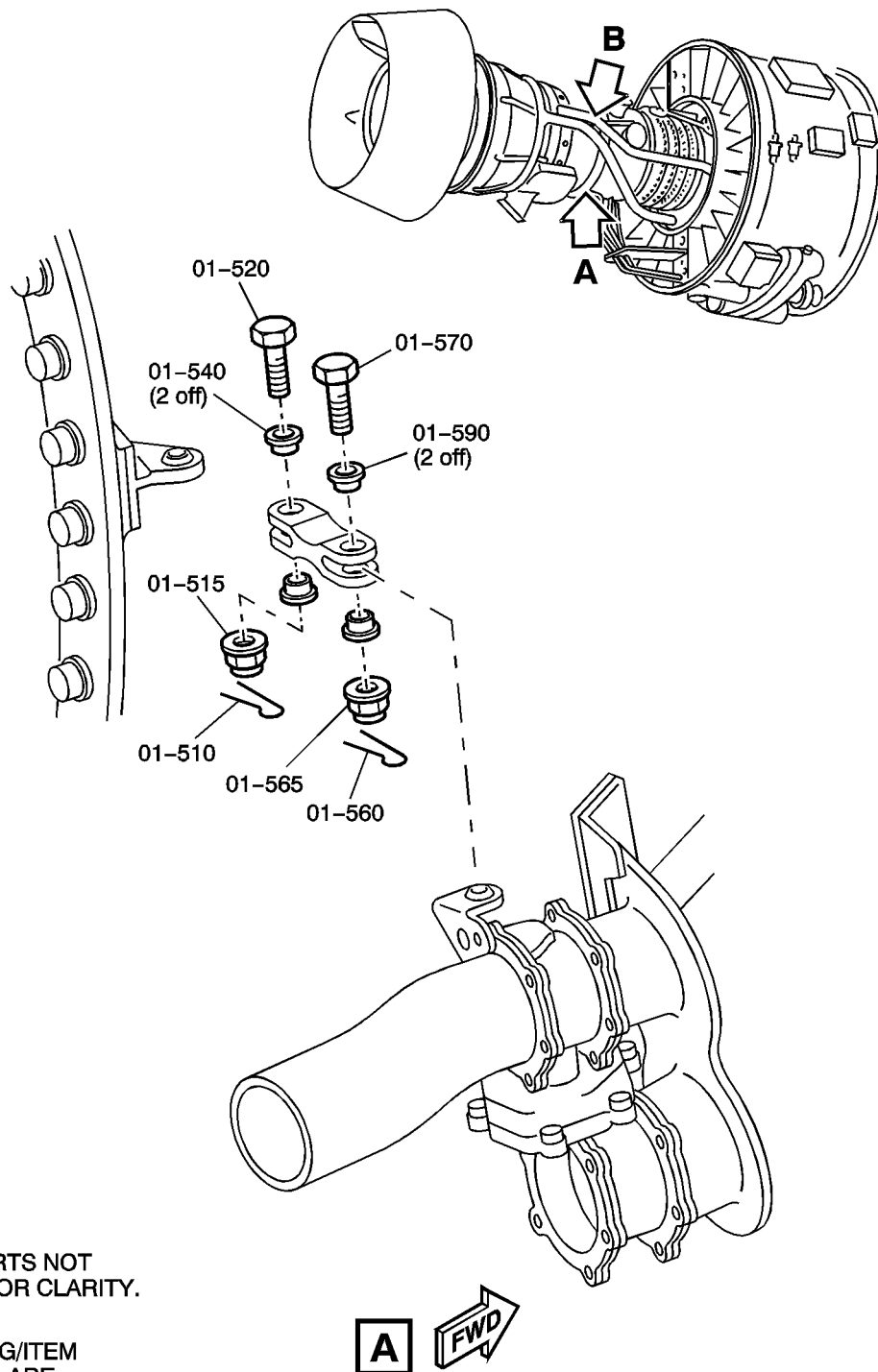
Torque the nut (75-24-51, 0-930) to 32.5 to 42.5 lbf in. (3,67 to 4,8 Nm).

Install a new cotter pin (75-24-51, 01-925).

- (4) Make sure that the work area is clean and clear of tools, equipment and other unwanted materials.

C. Recording Instructions

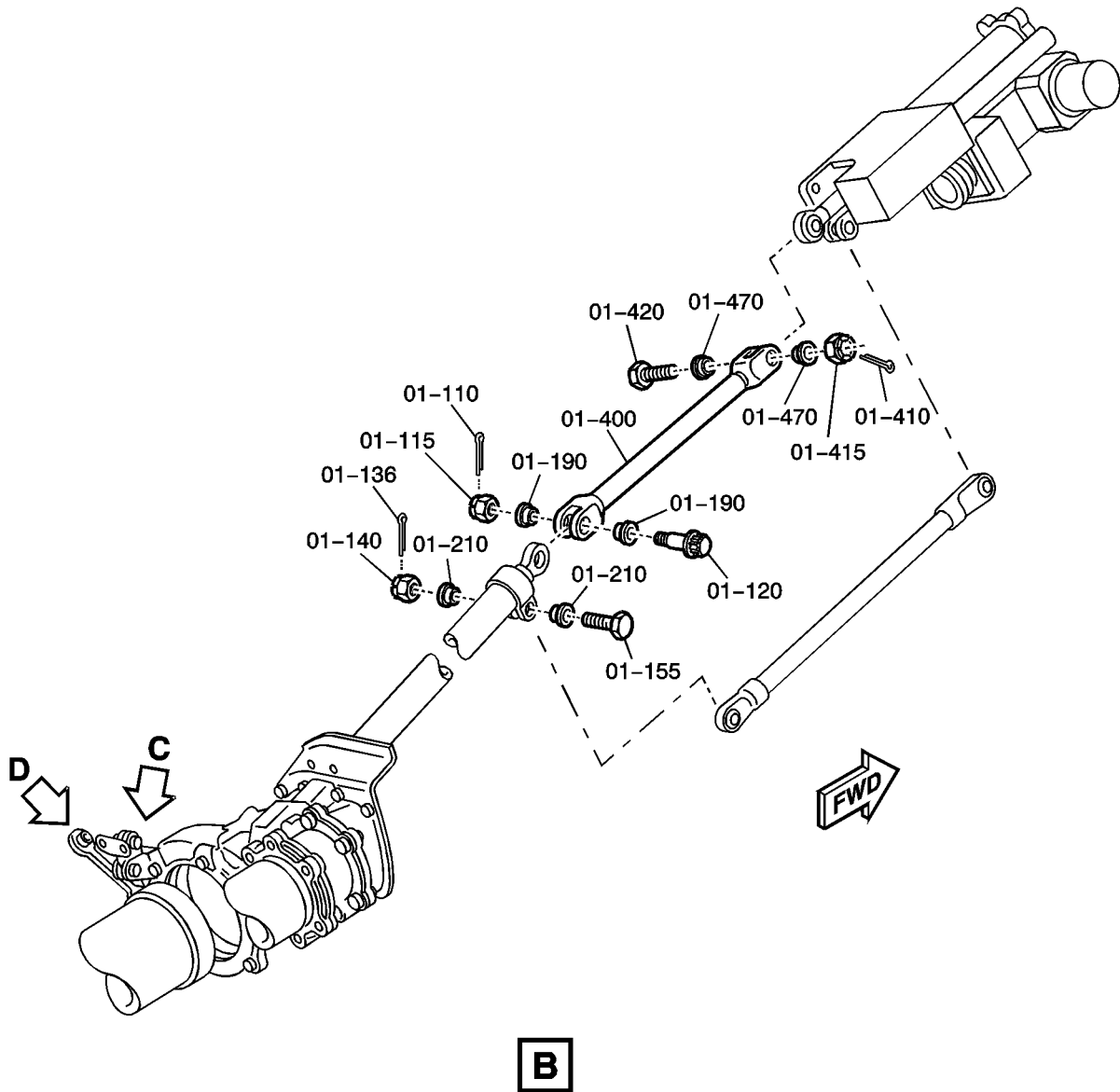
- (1) A record of accomplishment is required.



NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

NOTE: ALL IPC FIG/ITEM NUMBERS ARE 75-24-47 UNLESS IDENTIFIED DIFFERENTLY.

Active Clearance Control Actuator Linkages
V2500-A1 and V2500-A5 Engines
Figure 1 (Sheet 1 of 3)

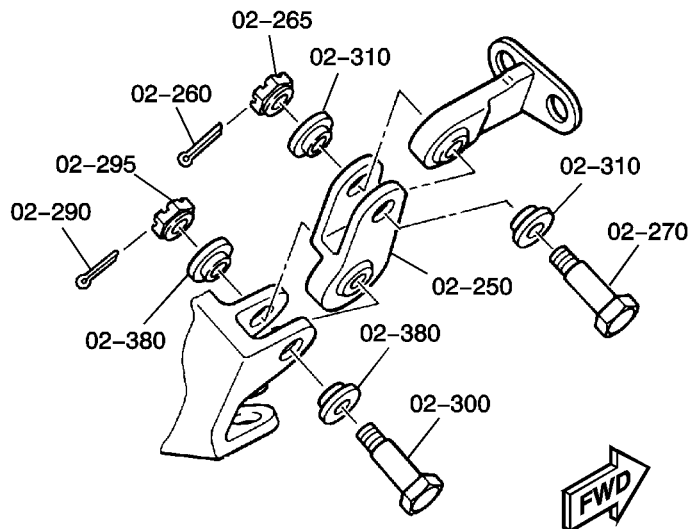


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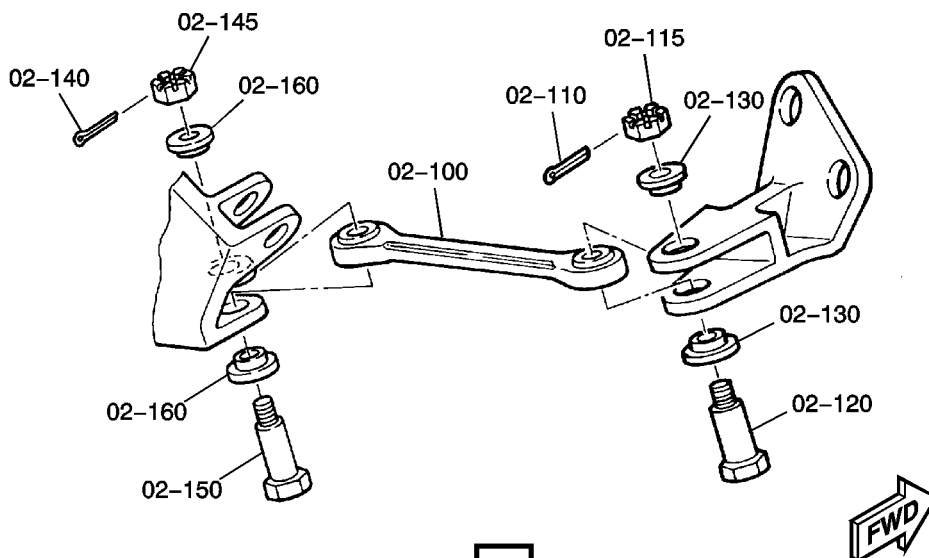
NOTE: ALL IPC FIG/ITEM NUMBERS ARE 75-24-51 UNLESS IDENTIFIED DIFFERENTLY.

NOTE: SOME PARTS NOT SHOWN FOR CLARITY.

Active Clearance Control Actuator Linkages
V2500-A1 and V2500-A5 Engines
Figure 1 (Sheet 2 of 3)



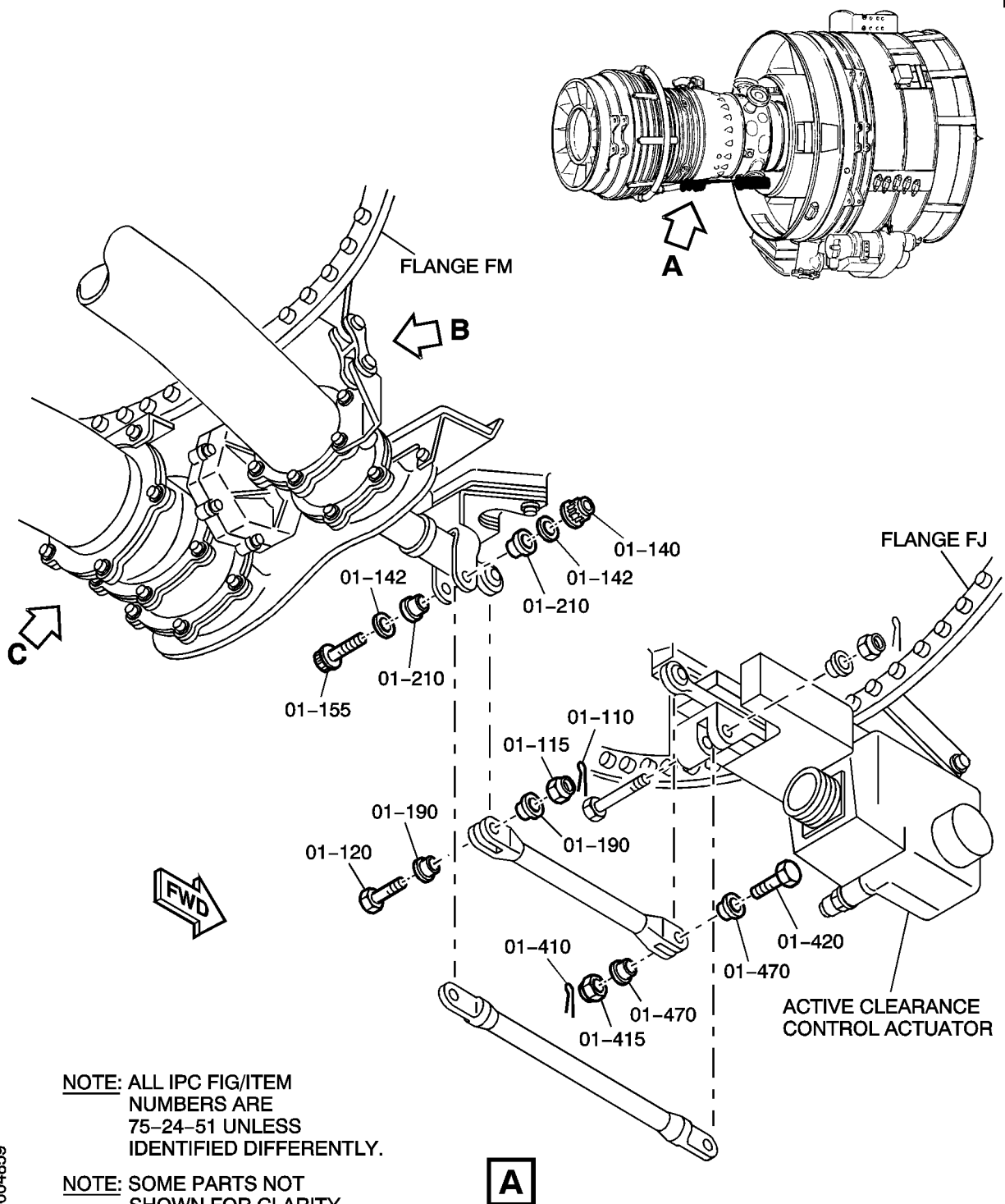
C



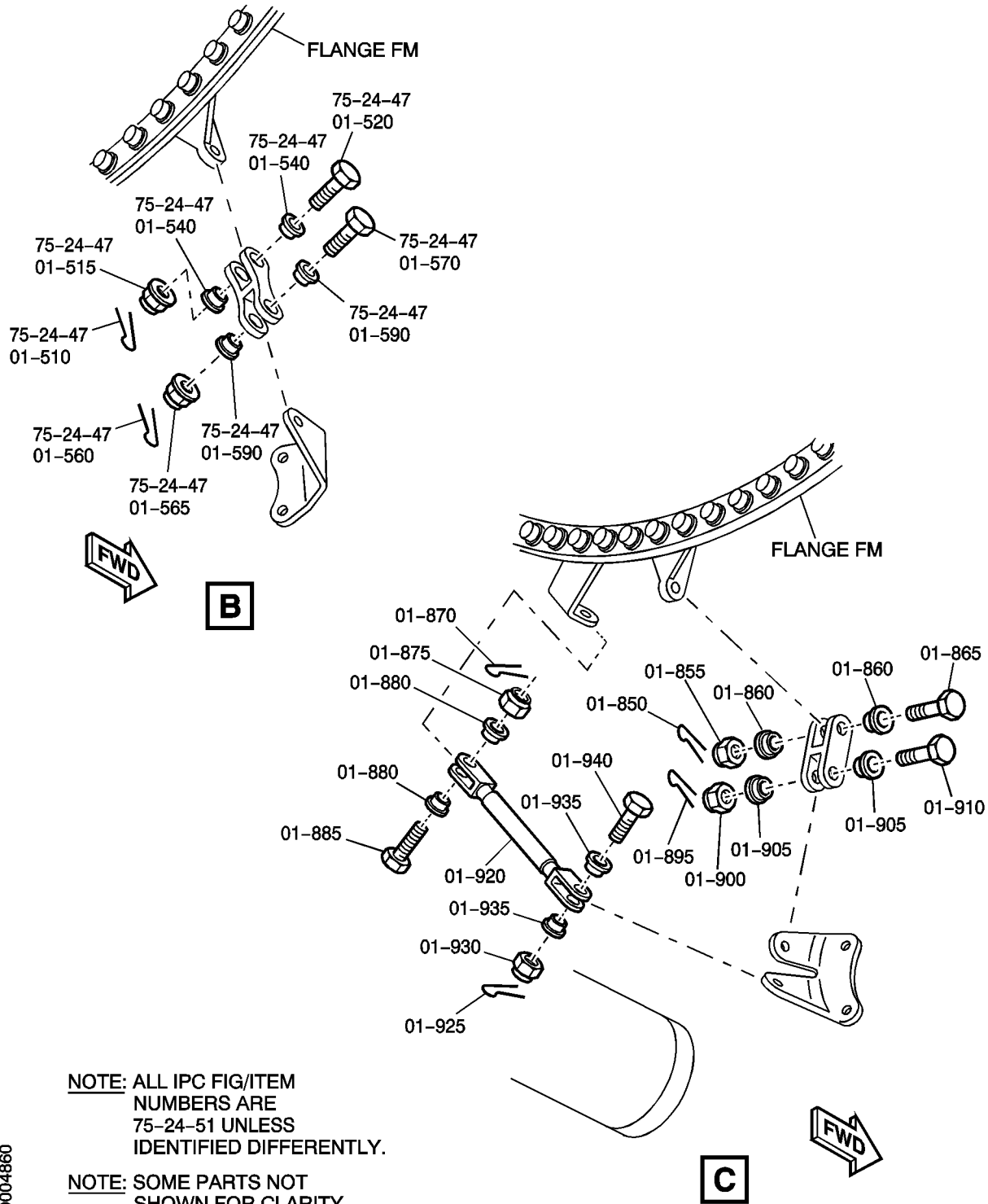
D

NOTE: ALL IPC FIG/ITEM
NUMBERS ARE
75-24-51 UNLESS
IDENTIFIED DIFFERENTLY.

Active Clearance Control Actuator Linkages
V2500-A1 and V2500-A5 Engines
Figure 1 (Sheet 3 of 3)



Active Clearance Control Actuator Linkages
V2500-D5 Engines
Figure 2 (Sheet 1 of 2)



Active Clearance Control Actuator Linkages
V2500-D5 Engines
Figure 2 (Sheet 2 of 2)

AIR – ACTIVE CLEARANCE CONTROL – INTRODUCTION OF MOUNTING BUSHES WITH COUNTERBORESUPPLEMENT – 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.	Description	Unit Price
		US Dollars
6B1465	Bush	34.30

Part is currently available for sale.

3. Tools

None.



SERVICE BULLETIN FEEDBACK FORM

Please use this form to give feedback on the quality of this Service Bulletin. The input you provide will be used to analyse areas of improvement and to take action to further improve on the quality of our Service Bulletins.

We thank you for the time you spent in completing this form.

Please rate on a scale of 1 to 5, with 5 being the highest score:

- General quality rating of this Service Bulletin	☐ 1	☐ 2	☐ 3	☐ 4	☐ 5
- Quality rating of the Accomplishment Instructions	☐ 1	☐ 2	☐ 3	☐ 4	☐ 5
- Quality rating of the Illustration	☐ 1	☐ 2	☐ 3	☐ 4	☐ 5
- Is this Service Bulletin easy to understand ?	☐ Yes		☐ No		

If you have had difficulties to perform this Service Bulletin please quote below the area(s) and give a short description of the issue:

Planning Information Section:		Material Information Section:	Accomplishment Instruction Section:
☐ 1.A.	☐ 1.I.	☐ 2.A.	☐ General
☐ 1.B.	☐ 1.J.	☐ 2.B.	☐ Get Access
☐ 1.C.	☐ 1.K.	☐ 2.C.	☐ Removal/Installation
☐ 1.D.	☐ 1.L.	☐ 2.D.	☐ Inspection
☐ 1.E.	☐ 1.M.	☐ 2.E.	☐ Test
☐ 1.F.	☐ 1.N.	☐ 2.F.	☐ Close the Access
☐ 1.G.	☐ 1.O.		☐ Log Book Entry
☐ 1.H.	☐ 1.P.		

Explanatory notes:

Operator:	Overhaul Site:
Name/Title:	Date:

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Email: GPIAECUSTCOM@IAEV2500.COM**