



628 Hebron Avenue, Suite 400  
 Glastonbury, CT 06033, USA.  
 Tel: +1 (860) 368-3823  
 Fax: +1 (860) 755-6876

DATE: Apr. 2/12

## V2500-A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits the Initial Issue of Service Bulletin V2500-ENG-75-0120.

### Service Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 10 of the Service Bulletin.	Initial Issue.
	Page 1 of the Supplement.	Initial Issue.

# V2500-ENG-75-0120

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

IAE PROPRIETARY INFORMATION

© IAE International Aero Engines AG (date as above). All rights reserved.  
 Not subject to the E.O. per 15 C.F.R. Chapter 1, Part 754.3(b)(3).

AIR – TURBINE COOLING CONTROLLED AIR TUBES – STAGE 10 MAKE UP AIR ADAPTOR WITH  
REVISED MACHINING PROFILE

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. V16299.

(2) Airbus A320

(a) V2527-A5, V2527E-A5 Engines from Serial No. V10001 to Serial No. V13190.

(b) V2527-A5, V2527E-A5 Engines from Serial No. V15001 to Serial No. V16299.

(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. V16299.

B. Concurrent Requirements

None.

C. Reason

(1) Condition

The current clearance between the High Pressure (HP) compressor stage 10 make up air valve adaptor and the clip bracket which is mounted on top of the adaptor flange hinders the build process.

(2) Background

Clearance issues have been reported at engine build, between the flange on the HP compressor stage 10 make up air valve adaptor and the clip bracket.



### (3) Objective

Incorporation of this Service Bulletin introduces a redesigned adaptor with an increased machined recess on the flange which connects the adaptor to the HP compressor case. The increased recess provides additional clearance for the clip bracket mounted on top of the adaptor flange.

The material of the adaptor and the minimum wall thickness remain unchanged.

### (4) Substantiation

The changes introduced by this Service Bulletin were the subject of satisfactory engineering analysis. This Service Bulletin complies with the applicable engine certification basis.

### (5) Effect of Bulletin on:

#### (a) Operation

Not affected.

#### (b) Maintenance

Not 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.

**D. Description**

This Service Bulletin introduces a redesigned HP compressor stage 10 make up air valve adaptor:

The change is as follows:

An increased machined recess on the flange which connects the adaptor to the HP compressor case. The increased recess provides additional clearance for the clip bracket which is mounted on top of the adaptor flange.

**NOTE:** The Accomplishment Instruction for this Service Bulletin is divided into two INSTRUCTIONS as follows:

INSTRUCTION I - Applicable for engines "In Service".

INSTRUCTION II - Applicable for engines "At Overhaul/Shop visit

**E. Compliance**

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

**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**

Estimated Man-hours:

(1) In Service

2 hours.

(2) At Overhaul/Shop Visit

Applicable (Hours not affected).

**H. Material Price and Availability**

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

**I. Tooling Price and Availability**

Special tools are not required.

**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) Aircraft Maintenance Manual, Chapter 75-23-51

(3) Internal Reference No.

Engineering Change No. 11VR002 and 11VR002-01.

(4) ATA Locator - 75-23-48.

**O. Other Publications Affected**

(1) IAE V2500 Engine Illustrated Parts Catalogues (S-V2500-2IA, S-V2500-2IB, S-V2500-2SA, S-V2500-2SB, S-V2500-2NA, S-V2500-2NB, S-V2500-5IA, S-V2500-5IB, S-V2500-5SA, S-V2500-5SB, S-V2500-5NA, S-V2500-5NB, S-V2500-6IA, S-V2500-6IB, S-V2500-6SA, S-V2500-6SB, S-V2500-6NA, S-V2500-6NB, S-V2500-7IA, S-V2500-7IB, S-V2500-7SA, S-V2500-7SB, S-V2500-7NA and S-V2500-7NB), Chapter 75-23-48 will be amended to incorporate the new part number (Refer to section 2. Material Information).

(2) Component Maintenance Manual Miscellaneous Mechanical - MECH-V2500-1IA, Chapter 75-23-48.

Apr. 2/12

Apr. 2/12 Initial Issue

# V2500-ENG-75-0120

Page 4

IAE PROPRIETARY INFORMATION

© IAE International Aero Engines AG. All rights reserved.  
Not subject to the EASA per ECAR, Chapter 1, Part 754.3(b)(3).

P. Interchangeability of Parts

Not affected.

## 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
75-23-48						
04-400	6B1429	1	.High Pressure (HP) compressor stage 10 make up air adaptor	-	6A7555	(S1)(A)

### D. Redundant parts:

None.

### E. Instruction disposition codes:

(S1) Old and new parts are fully interchangeable.

(A) Part is available for sale.

### 3. Accomplishment Instructions

#### A. Rework Instructions

- (1) None.

#### B. Assembly Instructions

##### INSTRUCTION I – APPLICABLE FOR ENGINES "IN SERVICE"

- (1) General

**CAUTION:** IN ORDER TO REDUCE THE POTENTIAL FOR MULTIPLE ENGINE IN-FLIGHT SHUT DOWN, POWER LOSS, OR OTHER ANOMALIES DUE TO MAINTENANCE ERROR, IAE RECOMMENDS THAT OPERATORS AVOID PERFORMING MAINTENANCE ON MULTIPLE ENGINES INSTALLED ON THE SAME AIRCRAFT AT THE SAME TIME. IF IT IS NOT POSSIBLE TO AVOID MAINTENANCE ON MORE THAN ONE ENGINE AT THE SAME TIME, IAE RECOMMENDS THAT ADDITIONAL CONTROLS BE APPLIED IN ORDER TO ENSURE THAT MAINTENANCE TASKS HAVE BEEN COMPLETED AS DEFINED. MAINTENANCE GUIDELINES SHOULD BE REVISED WHERE POSSIBLE TO PROMOTE THIS RECOMMENDATION.

**WARNING:** DO NOT TOUCH THE ENGINE COMPONENTS FOR A SHORT TIME AFTER THE ENGINE IS SHUT DOWN. THE COMPONENTS STAY HOT AND CAN CAUSE INJURY.

- (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 High Pressure (HP) compressor stage 10 make up air adaptor that is installed in the top central area of the engine
  - (a) Open the fan cowl doors (Refer to the Aircraft Maintenance Manual, TASK 71-13-00-010-010).
  - (b) Deactivate the Thrust Reverser Hydraulic Control Unit (HCU) (Refer to the Aircraft Maintenance Manual, TASK 78-30-00-040-012).
  - (c) Open the left thrust reverser door (Refer to the Aircraft Maintenance Manual, TASK 78-32-00-010-010).
- (3) Remove the old HP compressor stage 10 make up air adaptor (75-23-48, 04-400), P/N 6A7555 (Refer to the Aircraft Maintenance Manual, Chapter 75-23-51).





- (4) Install the new HP compressor stage 10 make up air adaptor (75-23-48, 04-400), P/N 6B1429 (Refer to the Aircraft Maintenance Manual, Chapter 75-23-51).
- (5) Make sure that the work area is clean and clear of tools, equipment and other unwanted materials.
- (6) Close the access to the High Pressure (HP) compressor stage 10 make up air adaptor
  - (a) Close the Left thrust reverser door (Refer to the Aircraft Maintenance Manual, TASK 78-32-00-010-010).
  - (b) Activate the Thrust Reverser Hydraulic Control Unit (HCU) (Refer to the Aircraft Maintenance Manual, TASK 78-30-00-440-012).
  - (c) Close the fan cowl doors (Refer to the Aircraft Maintenance Manual, TASK 71-13-00-410-010).

## 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) For the correct Removal/Installation procedure of the old HP compressor stage 10 make up air adaptor refer to the Engine Manual, Chapter 72-00-40, Removal/Installation.

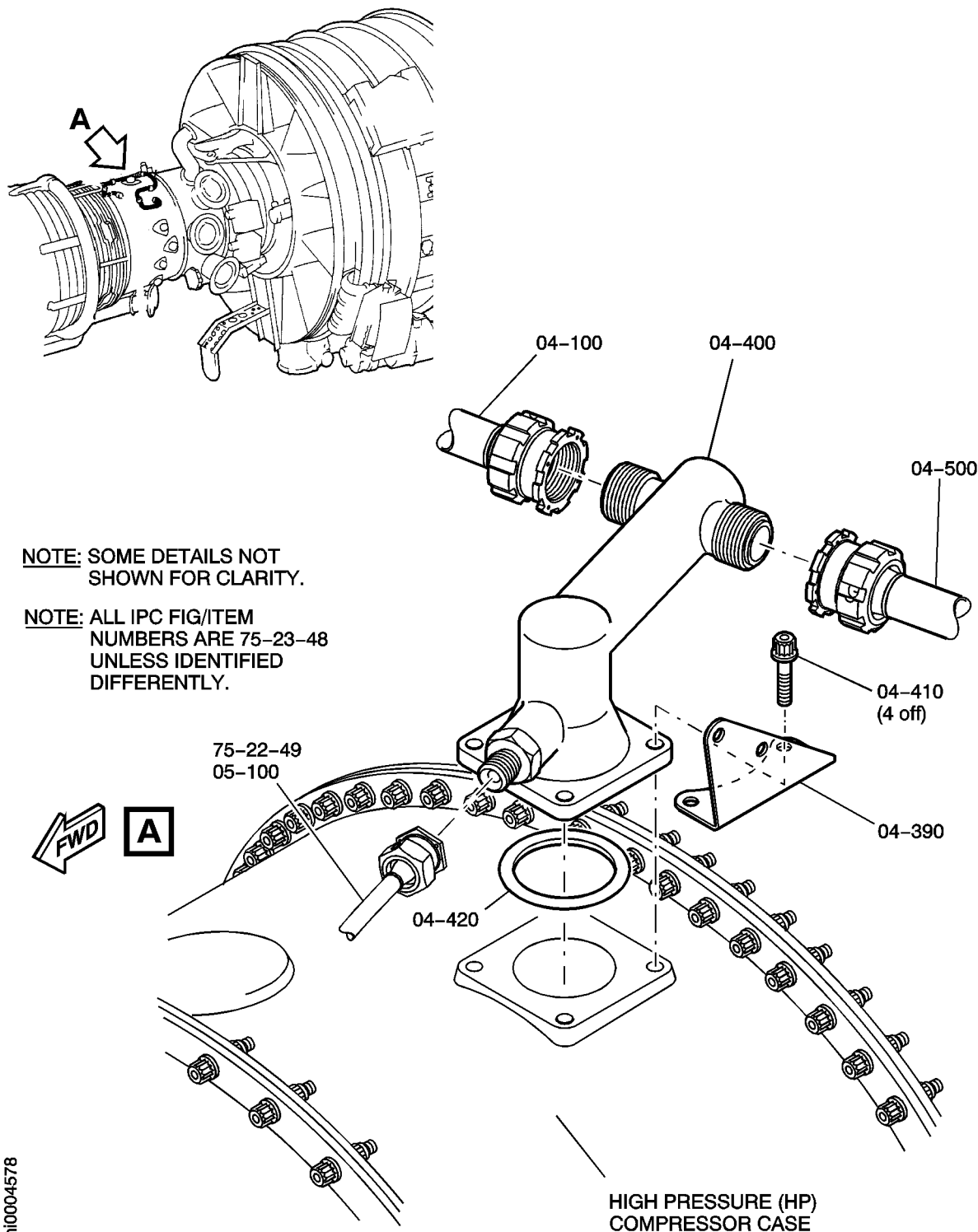
(3) Remove the old HP compressor stage 10 make up air adaptor (75-23-48, 04-400), P/N 6A7555 from the engine.

(4) Install the new HP compressor stage 10 make up air adaptor (75-23-48, 04-400), P/N 6B1429 on the engine.

(5) 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.



Remove and Install the High Pressure (HP) Compressor Stage 10 Air Make Up Adaptor  
Figure 1

AIR – TURBINE COOLING CONTROLLED AIR TUBES – STAGE 10 MAKE UP AIR ADAPTOR WITH  
REVISED MACHINING PROFILE

SUPPLEMENT – PRICES AND AVAILABILITY

The prices (if shown) are for estimating purposes only and as such are given in good faith, without commercial liability for advanced planning purposes only. Refer to IAE Spares and/or current price catalogue for current prices.

1. Modification Kit:

Not applicable.

2. New Production Parts:

Part No.	Description	Unit Price US Dollars
6B1429	.High Pressure (HP) compressor stage 10 make-up air adaptor	6,383.00

Part is currently available for sale.



## 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	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Quality rating of the Accomplishment Instructions	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Quality rating of the Illustration	<input type="checkbox"/> 1	<input type="checkbox"/> 2	<input type="checkbox"/> 3	<input type="checkbox"/> 4	<input type="checkbox"/> 5
- Is this Service Bulletin easy to understand ?	<input type="checkbox"/> Yes		<input type="checkbox"/> 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:
<input type="checkbox"/> 1.A.	<input type="checkbox"/> 1.I.	<input type="checkbox"/> 2.A.	<input type="checkbox"/> General
<input type="checkbox"/> 1.B.	<input type="checkbox"/> 1.J.	<input type="checkbox"/> 2.B.	<input type="checkbox"/> Get Access
<input type="checkbox"/> 1.C.	<input type="checkbox"/> 1.K.	<input type="checkbox"/> 2.C.	<input type="checkbox"/> Removal/Installation
<input type="checkbox"/> 1.D.	<input type="checkbox"/> 1.L.	<input type="checkbox"/> 2.D.	<input type="checkbox"/> Inspection
<input type="checkbox"/> 1.E.	<input type="checkbox"/> 1.M.	<input type="checkbox"/> 2.E.	<input type="checkbox"/> Test
<input type="checkbox"/> 1.F.	<input type="checkbox"/> 1.N.	<input type="checkbox"/> 2.F.	<input type="checkbox"/> Close the Access
<input type="checkbox"/> 1.G.	<input type="checkbox"/> 1.O.		<input type="checkbox"/> Log Book Entry
<input type="checkbox"/> 1.H.	<input type="checkbox"/> 1.P.		

Explanatory notes:

Operator:	Overhaul Site:
Name/Title:	Date:

**Please send the completed Service Bulletin Feedback Form to IAE, Customer Support.  
Email: GPIAECUSTCOM@IAEV2500.COM**