



SERVICE BULLETIN

OIL - REWORK THE ACOC INLET DUCT ASSEMBLY BY INCORPORATING DRAIN HOLES TO PREVENT FLUID ENTRAPMENT - CATEGORY CODE 5 - MOD.ENG-79-0010

1. Planning Information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines, Serial No. V0014 through V0069

B. Reason

(1) Condition

The Duct, A/O Inlet ACOC was modified by Service Bulletin V2500-ENG-79-0009 to prevent possible fluid traps. The duct requires a permanent solution.

(2) Background

A review of the powerplants, installed on A320 A/C No.1, had revealed several possible fluid traps. Therefore, the filters had been incorporated for the Duct, A/O Inlet ACOC.

(3) Objective

To maintain the reliability of the engine.

(4) Substantiation

The configuration change shown in this Service Bulletin has been substantiated by analysis.

(5) Effects of Bulletin on the following shop functions:

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

(6) Supplemental Information

See 2. Accomplishment Instructions.

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C. Description

The filters are removed and the drain holes are incorporated to prevent possible fluid traps on the top of the Duct, A/O Inlet ACOC. (See Figure 1).

D. Approval

The Part number changes and/or part modification 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 Model listed.

E. Compliance

Category code 5

Accomplish when the engine is disassembled sufficiently to afford access to the affected subassembly and to all affected spare subassemblies.

F. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
(1) In Service	Not applicable
(2) In shop	
(a) To embody	
(b) To return part to overhaul condition	
Total	Hours, 41 Minutes
(3) At Overhaul	Not applicable

G. Material Price and Availability

(1) Modification Kit not required

H. Tooling - Price and Availability

Special tools are required to accomplish this Service Bulletin. See 2. Accomplishment Instructions.

I. Weight and Balance

(1) Weight change	None
(2) Moment arm	No effect

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(3) Datum

Engine Front Mount
Centerline

[Powerplant Station (PPS) 100]

J. Electrical Load Data

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

K. Reference

(1) Internal Reference No.

EC88VJ712A

(2) Other References

IAE V2500 Service Bulletin

V2500-ENG-79-0009 Oil – Rework the ACOC Inlet Duct Assembly by
Adding Filler Material to Prevent Fluid Entrapment

V2500 Engine Illustrated Parts Catalog Chapter 79-21-42

Delete

V2500 Facilitate Equipment Manual

V2500 Standard Practices/Processes Manual Chapter 70-09-00 and 70-38-02

V2500 Overhaul Processes and Consumables Index

L. Other Publications Affected

(1) V2500 Engine Illustrated Parts Catalog Chapter 79-21-42, Figure 01, to
add the new parts.

(2) V2500 Component Maintenance Manual Chapter 79-21-42 Cleaning will be
revised to include the new parts.



2. Accomplishment Instructions

A. Rework instructions

WARNING: The filters removed in this Service Bulletin may be sensitive for allergic responses by respiring. A respirator shall be worn by the operators.

CAUTION: A consideration shall be taken to protect other parts (Harness, Tubes, Other components) from any contamination by the swarf during the rework.

Appropriate vacuum cleaner shall be used.

- (1) Rework 5T0061, Duct, A/O Inlet ACOC and reidentify as follows. See Figures 1, 2, 3, 4, 5 and 6.

Procedure	Supplementary Information
(a) Attach the masking tape to prevent surface damage around the filters.	Use CoMat 02-002 Masking Tape. See Figure 1, Sheet 1 of 2.
(b) Remove the filters carefully not to damage the surface of duct.	Use suitable chisel and cutter, RB012 Files, rotary or equivalent.
(c) Clean the surface that the fillers were removed.	Use suitable vacuum cleaner.
(d) Add the masking tape to prevent the surface damage at the reworked area.	See Figures 2 and 3. Use CoMat 02-002 Masking Tape.
(e) Set-up the reworked positions and make small holes initially less than specified dimensions as the guide. Then make specified holes (3 positions).	See Figures 2 and 3. Special Tool is necessary. See Figures 4 and 5.
(f) Remove the burrs around the holes.	See Figures 2 and 3. Tool: RB010 Grinder, hand held pneumatic or equivalent
Finish the surface of the holes.	
(g) Coat inner surfaces of newly drilled holes with Alodine (Alocrom).	Use CoMat 01-275 Chromate conversion coating (Alocrom). Refer to SPM TASK 70-38-02-300-503.



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- (h) Renumber 5T0056 adjacent to existing Part Number. Delete 5T0061 with a single line.

Refer to Figure 6.
Use marking pencil, vibrating.
Refer to SPM TASK 70-09-00-400-501.

Existing	Renumber
5T0061	5T0056

- (i) Remove the burrs at new and deleted marking positions.
- (j) Coat the new and deleted Part Numbers with Alodine (Alocrom).
- (k) Coat other scratched places with Alodine (Alocrom), if any.

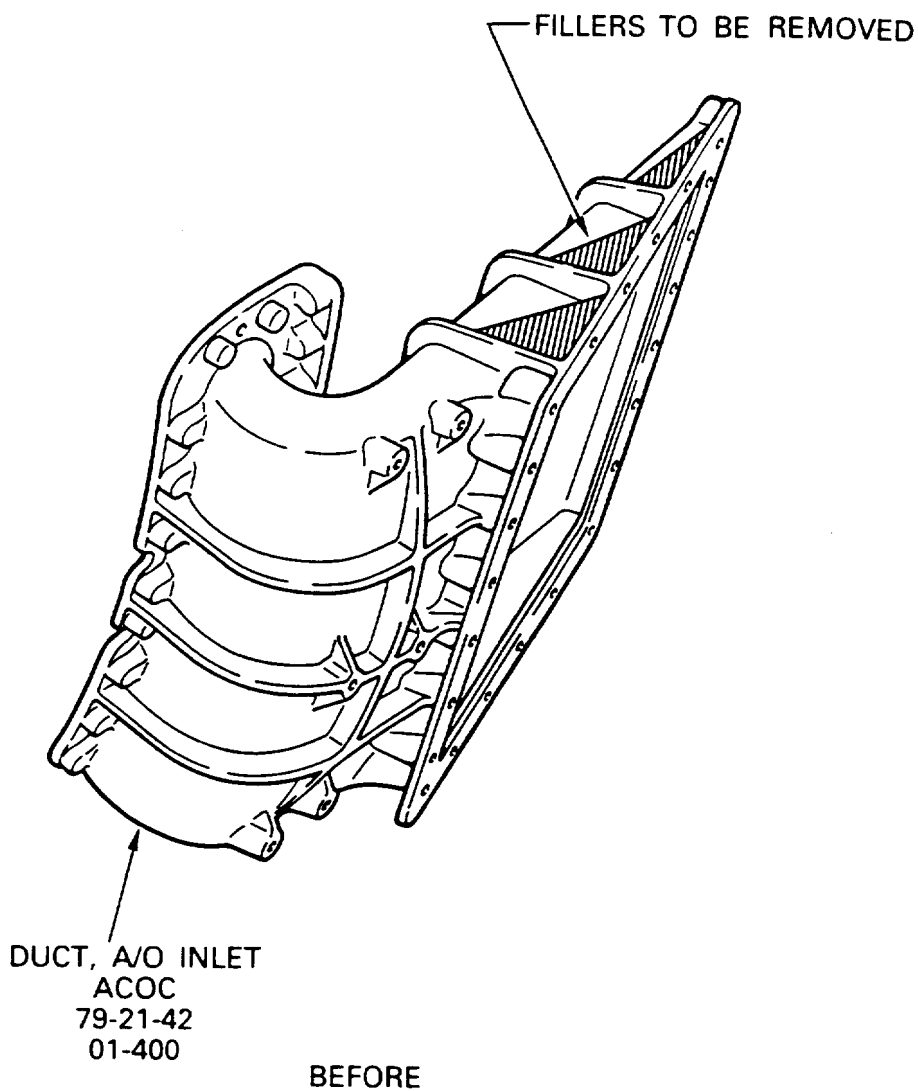
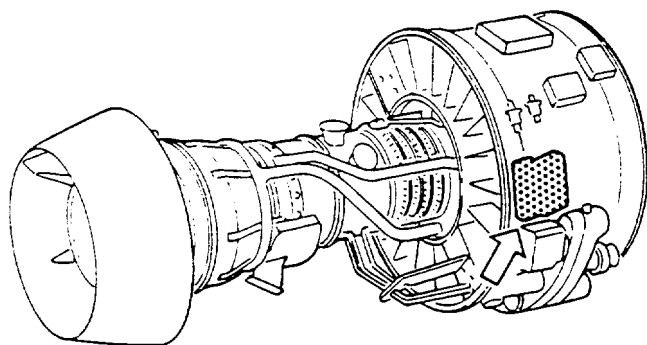
Use CoMat 05-016 or 05-017 Garnet Paper.

Use CoMat 01-275 Chromate conversion coating (Alocrom). Refer to SPM TASK 70-38-02-300-503.

Use CoMat 01-275 Chromate conversion coating (Alocrom). Refer to SPM TASK 70-38-02-300-503.

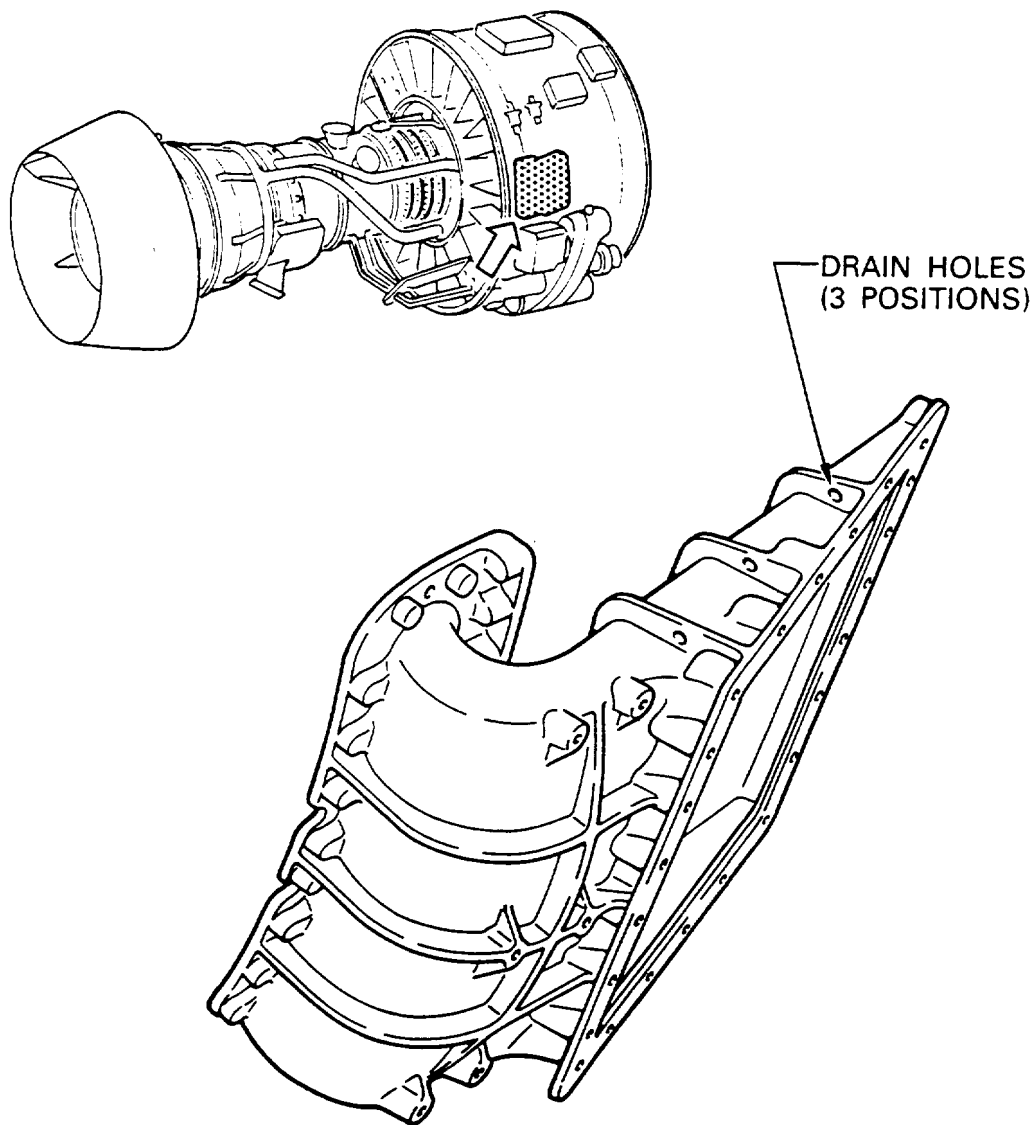
B. Recording Instructions

- (1) A record of accomplishment is required.



Before and After views of configuration changes
Fig.1 (Sheet 1 of 2)

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AFTER

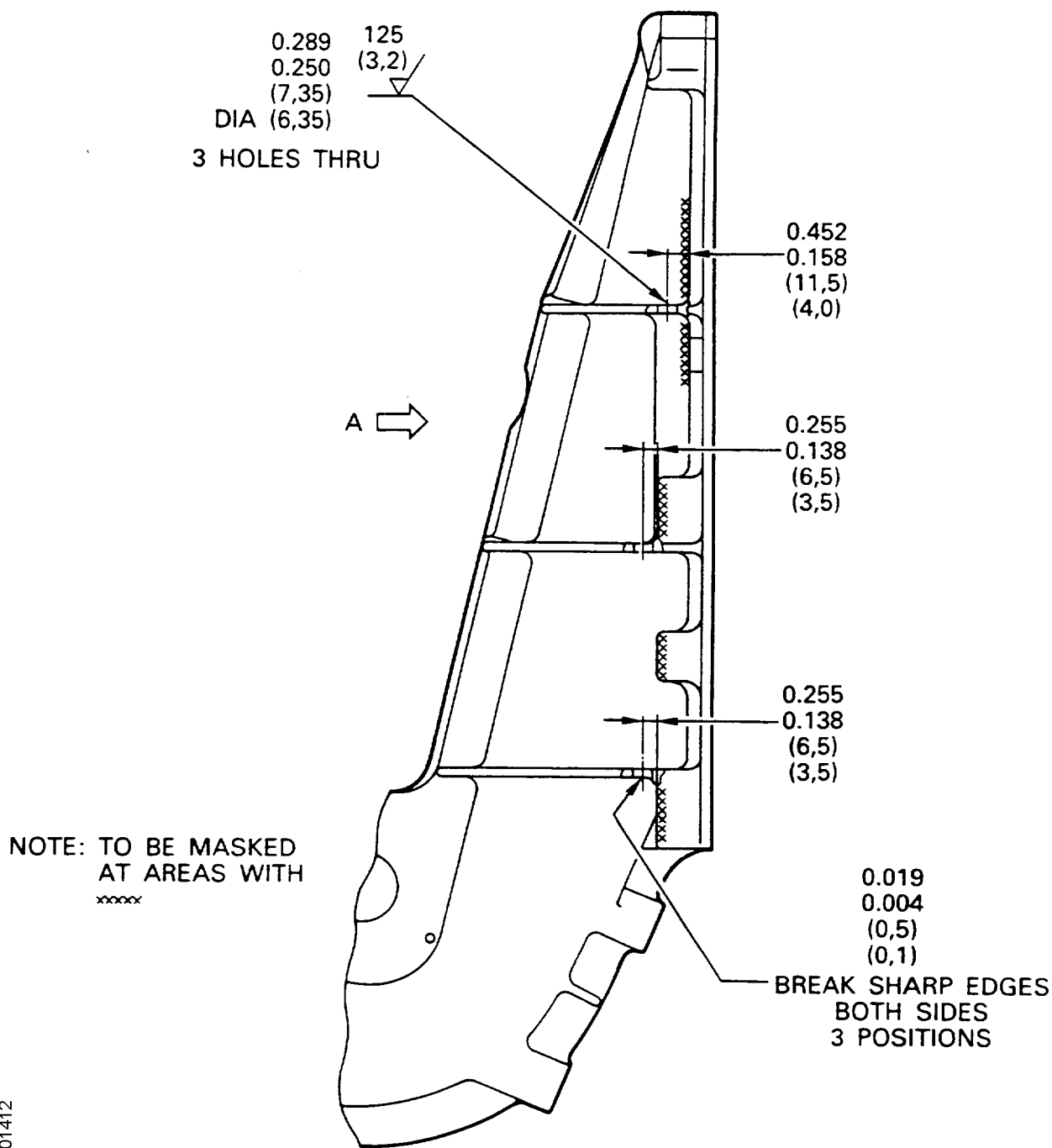
Before and After views of configuration changes
Fig.1 (Sheet 2 of 2)

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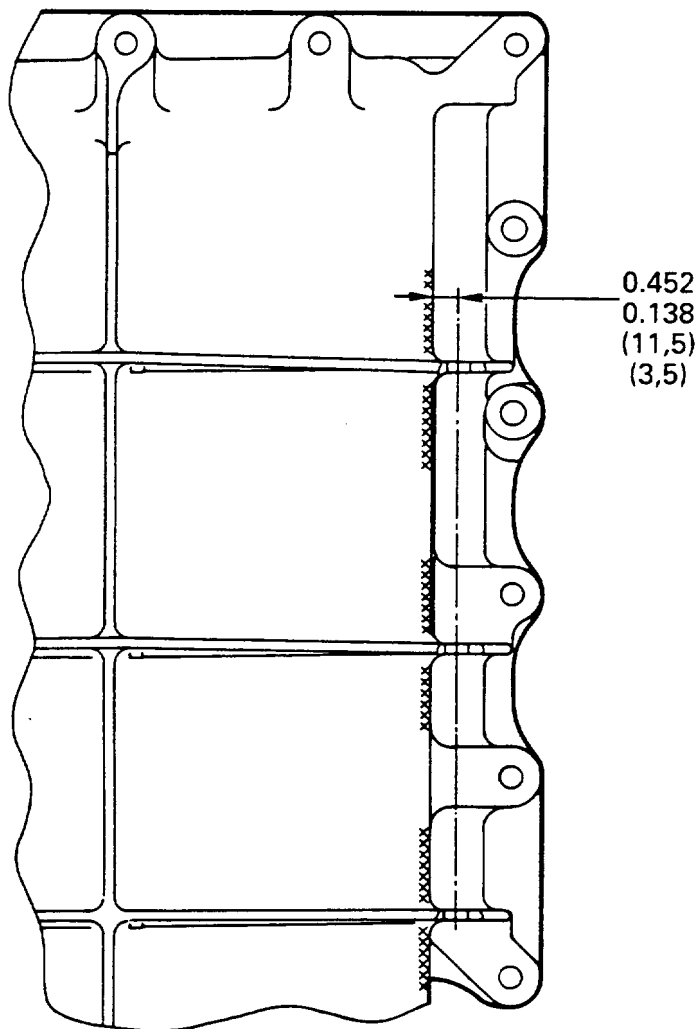


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Rework of the Duct, A/O inlet ACOC
Fig.2

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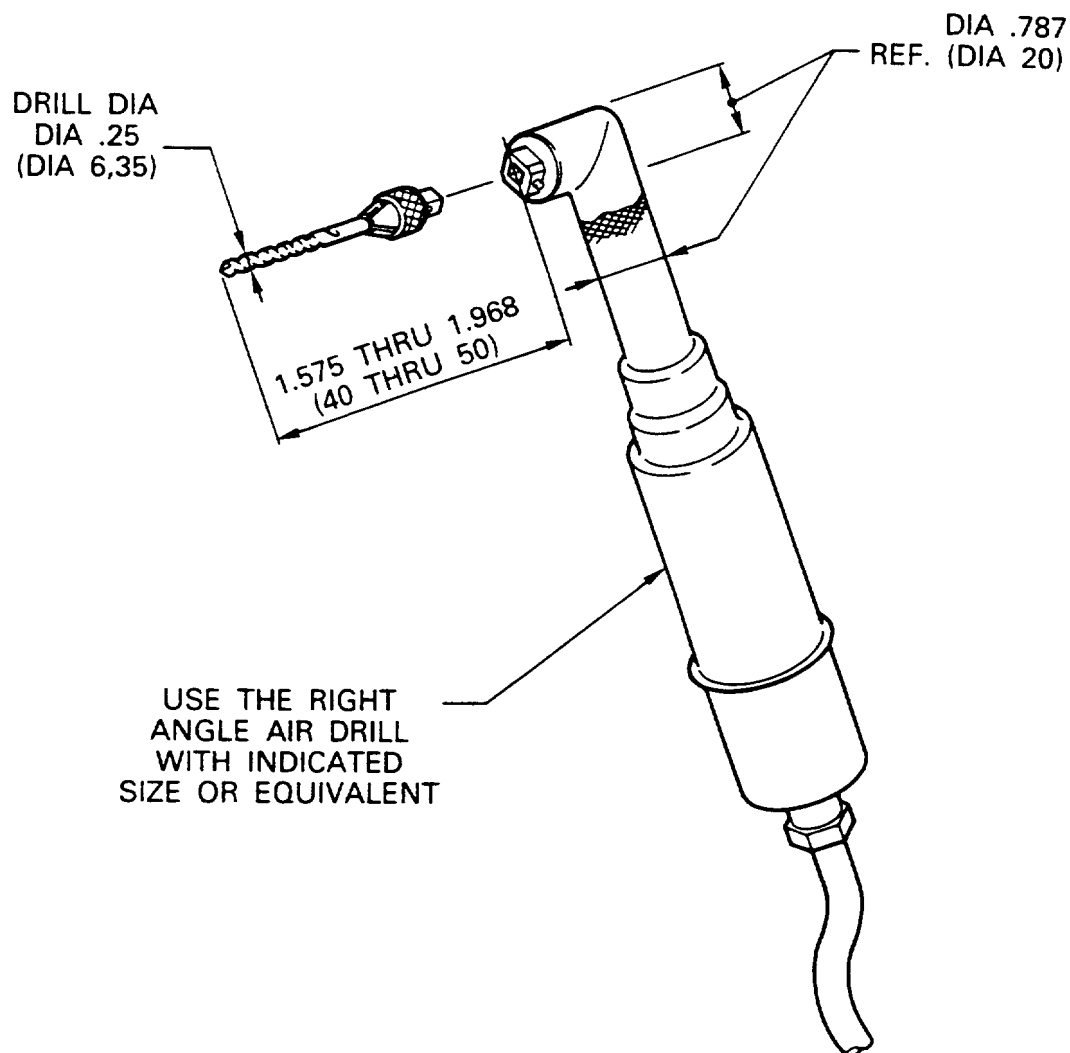
NOTE: TO BE MASKED
AT AREAS WITH xxxxxx

VIEW ON A

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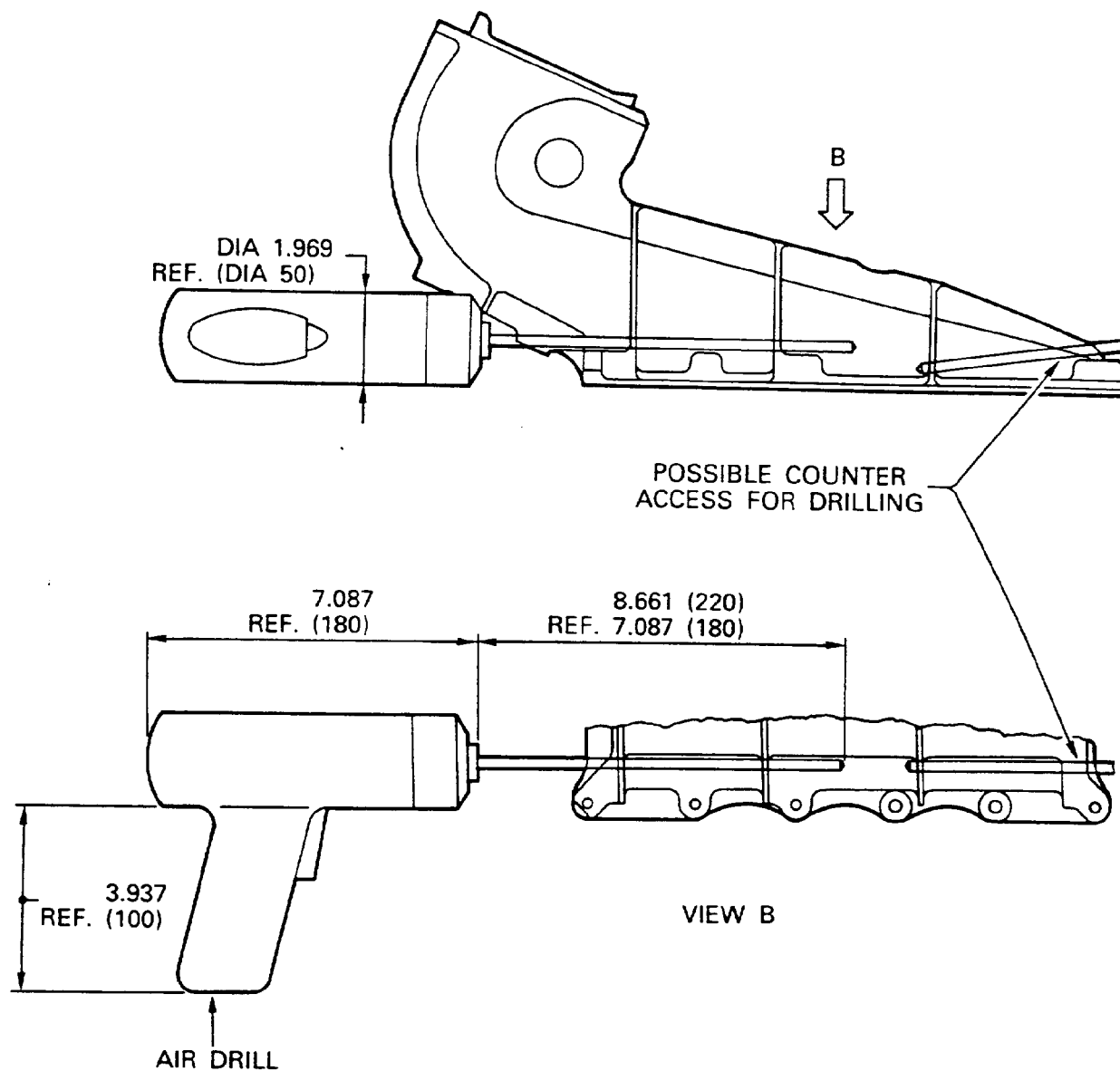
Rework of the Duct, A/O inlet ACOC
Fig.3

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Rework of the Duct, A/O inlet ACOC
Fig.4

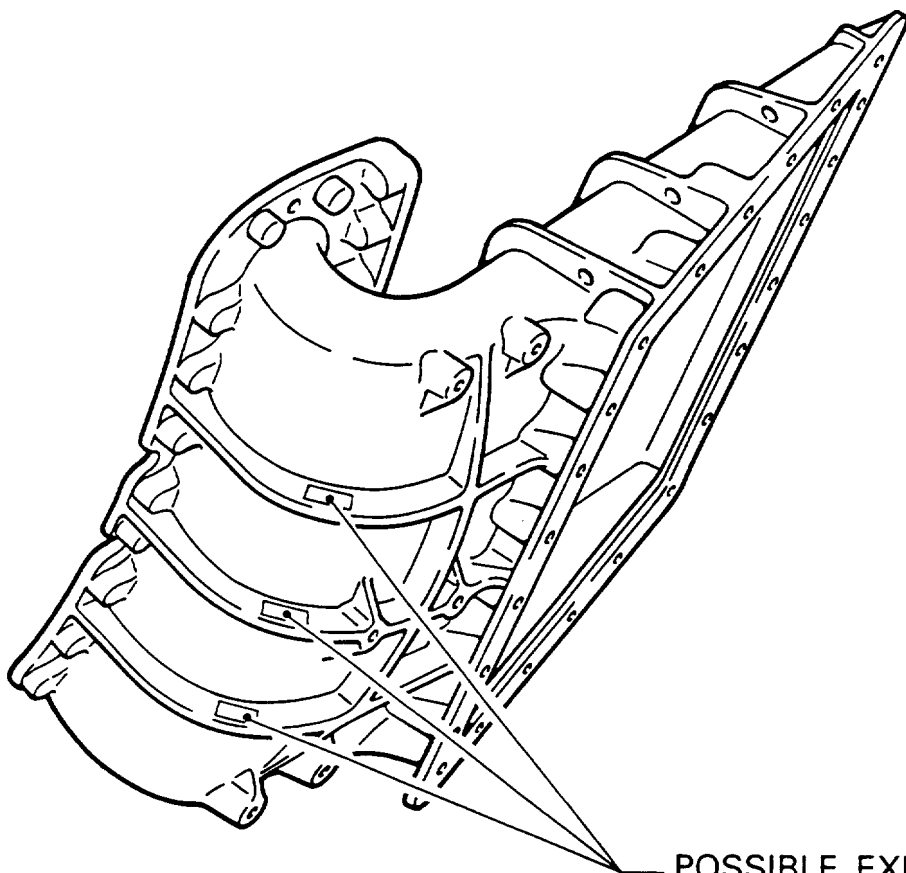
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Rework of the Duct, A/O inlet ACOC – Alternative method of Figure 4
Fig.5

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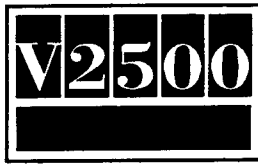


POSSIBLE EXISTING
MARKING LOCATION.
MARK NEW PART NUMBER
ADJACENT TO EXISTING
PART NUMBER.
DELETE EXISTING PART
NUMBER WITH A SINGLE
LINE.

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Rework of the Duct, A/O inlet ACOC
Fig.6

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3. Material Information

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
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Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

5T0056	1	9,726.00	Duct	5T0061	(1D)(A)(B)
(79-21-42)				(01-400)	(S1)

NOTE: The estimated 1990 Unit Price shown is provided for planning purposes only and does not constitute a firm quotation. Consult IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

Reference:

(1) Material of the Duct, A/O Inlet ACOC:

AMS 4218 (Aluminium A356)

(2) Material of the filler removed:

Epoxy EA934NA

C. Instruction/Disposition Code Statements:

(1D) New Part may be reworked form Old Part.
(A) New Part is currently available for sale.
(B) Old Part will no longer be available for sale.
(S1) New Part may be used in place of Old Part, but not vice versa.

D. Consumable Materials:

The following consumable materials are required.

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CoMat 01-076 Methylethylketone
CoMat 01-275 Chromate conversion coating (Alocrom)
CoMat 02-002 Masking tape
CoMat 02-099 Lint free cloth
CoMat 05-016 Garnet paper
CoMat 05-017 Garnet paper
CoMat 05-126 Scotch brite

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