

SERVICE BULLETIN

OIL - PROVIDE AN OIL TANK SIGHT GLASS OIL LEVEL INDICATOR - CATEGORY CODE 8 -
MOD.ENG-79-0025

1. Planning information

A. Effectivity

- (1) Aircraft: Airbus A320
- (2) Engine: V2500-A1 Engines V0072, V0074, AND V0075 THROUGH V0179.
- (3) Engine: V2500-A1 Engines prior to Serial No. V0075 except V0072 and V0074 which incorporate Service Bulletin V2500-ENG-79-0014.

B. Reason

(1) Condition

- (a) It is difficult to ensure the correct oil content of the existing oil tank with the existing prisma light configuration.
- (b) During oil replenishment visual monitoring of the oil level in the tank is not possible.

(2) Background

This condition was observed in service.

(3) Objective

To make the oil tank replenishment procedure easier and reliable by visually checking the level in the oil tank.

(4) Substantiation

Not necessary.

(5) Effects of Bulletin on Workshop Procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Affected (See Supplemental Information)
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

(6) Supplemental Information

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The Component Maintenance Manual will include the sight glass Assembly/Disassembly procedure.

C. Description

- (1) The changes introduced by this Service Bulletin are as follows: See Figure 3.
 - (a) The existing oil tank level indicator has been deleted.
 - (b) A sight glass has been added
 - (c) The oil spill tube has been modified in its course in order to use the spill flow for keeping the sight glass clean.
 - (d) The new spill tube is secured to the oil tank by an added bracket.
- (2) This Service Bulletin must be incorporated concurrently with or subsequent to Service Bulletin V2500-ENG-71-0110

D. Approval

The part number transactions shown under the MATERIAL INFORMATION paragraph of this have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

E. Compliance

Category Code 8

Accomplish based upon experience with the prior configuration.

F. Manpower

Estimated manhours to incorporate the full intent of this bulletin:

Venue	Estimated Manhours
(1) In service	Not applicable.
(2) At overhaul	15 minutes

G. Material – Price and Availability

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

**SERVICE BULLETIN****H. Tooling Price and Availability**

Tool No.	Qty	Description	Function	Avail
IAE3F10441	1	Mask, Drill	Rework the oil tank	(1)

(1) Indicate that the tool Design aperture card is not available at this time from IAE. Foreseen availability date: June 93

I. Weight and Balance

(1)	Weight change	Not significant
(2)	Moment arm	No effect
(3)	Datum	Engine front mount centerline (Powerplant Station (P.P.S.) 100)

J. Electrical Load Data

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

K. Reference

(1) Internal Reference No.

EC88VF045

EC88VF045-01

(2) Other references

Service Bulletin ENG-79-0030

Service Bulletin ENG-71-0110

The Engine Manual, Chapter/Section 72-60-00

The Component Maintenance Manual, Chapter/Section 79-11-41

L. Other Publications Affected

- (1) The V2500 Illustrated Parts Catalogue, Chapter/Section 79-11-41 and 79-21-41 to add the new parts.
- (2) The v2500 Power Plant Illustrated Parts Catalogue, Chapter/Section 79-11-41 and 79-21-49 to add the new parts.
- (3) The A320 Aircraft Maintenance Manual, Chapter/Section 79-11-41 Removal/Installation to add the new parts.

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International Aero Engines

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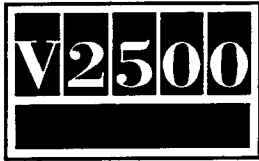
- (4) The V2500 Component Maintenance Manual Chapter/Section 79-11-41
Assembly/disassembly to add new parts

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2. Accomplishment Instructions

A. Prerequisite Instructions

- (1) Remove the oil tank from the engine. Use the approved procedure in Reference (3).
- (2) Disassemble the oil tank. Use the approved procedure in Reference (4)
- (3) Remove the 4P7232 cover.
 - (a) Remove and discard the wire.
 - (b) Remove and discard the eight screws 4W2326.
 - (c) Remove and discard the cover.
- (4) Remove the AS15825 nut

B. Rework Instructions

- (1) Rework 4B7195 Oil Tank and reidentify as follows. See Figure 2.

Procedure	Supplementary Information	
(a) Install the IAE3F10441 drill mask on the oil tank and secure with screws.	See figure 2	
(b) Make two holes as required.	See figure 2 Use a suitable drill	
(c) Remove the mask		
(D) Remove the burrs around the holes.	Use an hand pneumatic grinder.	
(e) Clean the internal surfaces of the oil tank from the debris.	Use suitable vacuum cleaner.	
(f) Renumber 4B7244 adjacent to existing Part Number. Delete 4B7195 with a single line.	Use marking pencil, vibrating. Refer to SPM TASK 70-09-00-400-501.	
	Existing	Renumber
	4B7195	4B7244



- (g) Remove the burrs at new and deleted marking positions

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

C. Assembly Instructions

- (1) Assemble the renumbered oil tank as follow. See Figure 3.

- (a) Install the 4T7921 Sight Glass in place of the cover. See Figure 3.

(i) Place the new 4T7921-02 Gasket and the new 4T7921 Sight Glass in position.

(ii) Place TORX5703-10 screws (8 off) in their seats and make sure you engage properly the helicoil.

(iii) Run down the screws in a cross sequence from No. 1 to 8 until they are seated. See Figure 2

(iv) Torque the screws, always in the correct sequence, to between 30.0 and 35.0 lbfin (3,39 to 3,95 Nm).

- (b) Place a new AS3209-122 packing, the 4P7236 cover, the 5W8391 bracket and the two 4W0165 bolts.

- (c) Torque the 4W0165 bolts to 85 to 95 lbfin (9,604 to 10,734 Nm)

- (d) Install the AS3209-113 packing and the 4P7237 plug.

- (e) Torque the 4P7237 plug to 53 to 70 lbfin (6 to 8 Nm.)

- (f) Continue the assembly of the oil tank. Use the approved procedure in Reference (4)

- (2) Install the oil tank to the engine. Use the approved procedure in Reference (3)

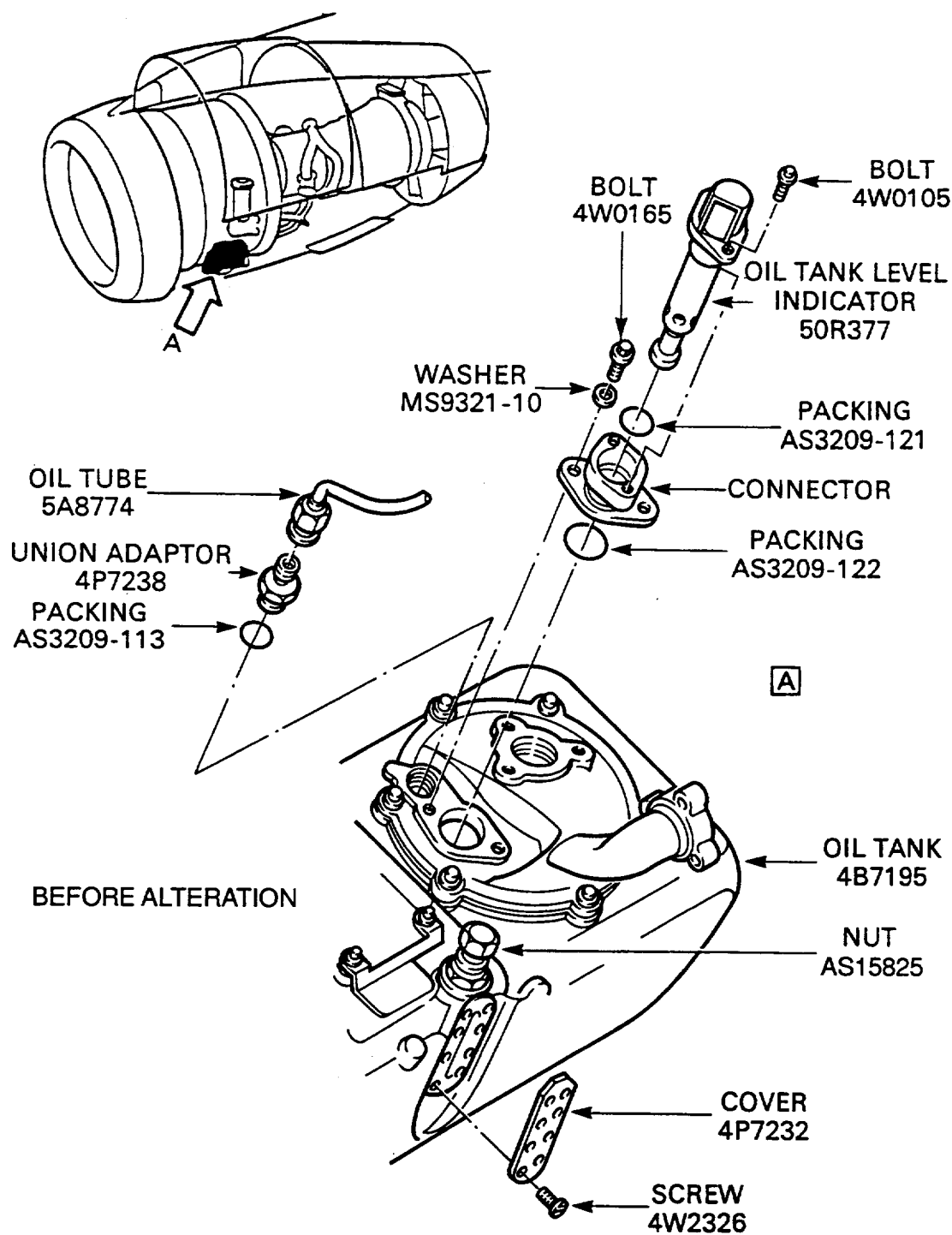
D. Recording Instructions

- (1) A record of accomplishment is required.



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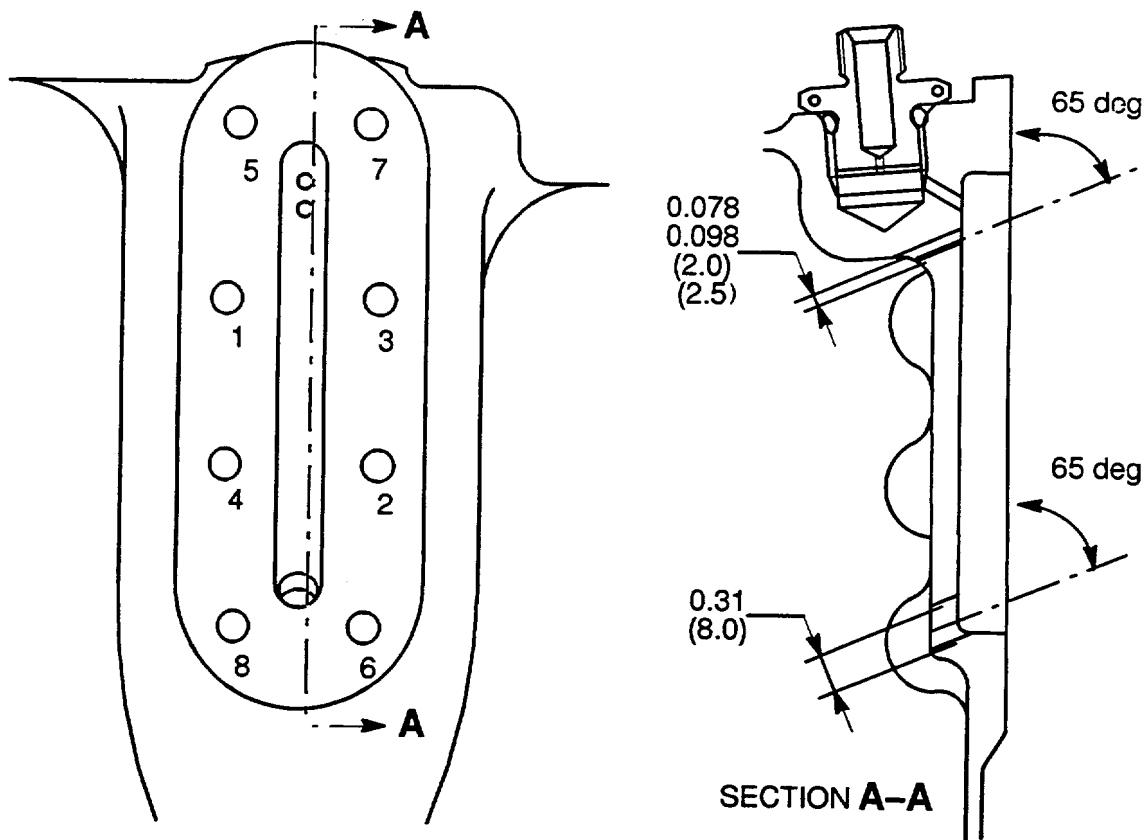
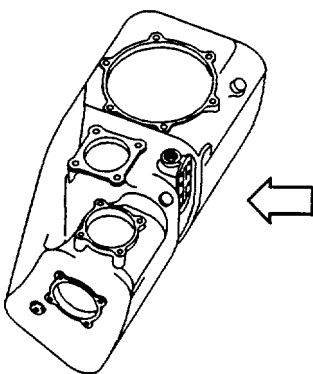
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Oil tank assembly before alteration
Fig.1

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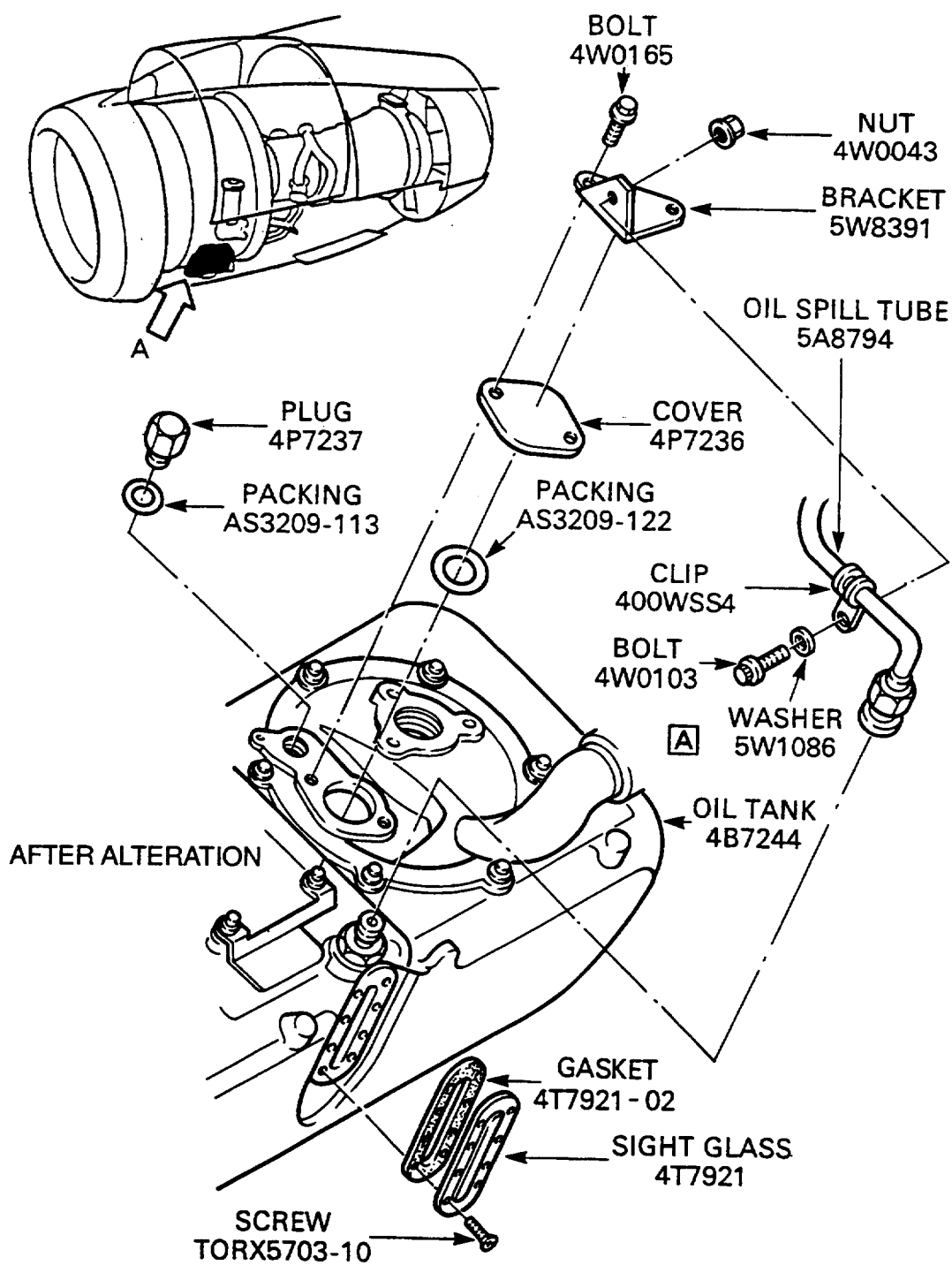
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RUN DOWN AND TORQUE THE SCREWS
IN THE SEQUENCE FROM 1 TO 8

Rework the Oil Tank
Fig.2

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Oil tank assembly after alteration
Fig.3

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3. Material Information

Applicability: For each V2500 Engine to incorporate this Bulletin.

A. Kits associated with this Bulletin:

none

B. Parts affected by this Bulletin:

New Part No. (ATA No.)	Qty	Est'd Unit Price (\$)	Keyword	Old Part No. (IPC No.)	Instructions/ Disposition
4A7003 (79-11-41)	1	-	.Tank, Assy oil	4A7002 (01-001)	(A) (B) (1D) (S1)
- (79-11-41)	1	-	.Cover	4P7232 (01-080)	(B) (S2)
4T7921 (79-11-41)	1	1236.00	.Sight Glass	- (01-081)	(C) (S2)
4T7921-02 (79-11-41)	1	50.00	..Gasket, sight glass	- (01-083)	(C) (S2)
TORX5703-10 (79-11-41)	8	-	.Screw	4W2326 (01-084)	(C) (B) (S2)
- (79-11-41)	1	-	.Nut, Assy Tube closure	AS15825 (01-090)	(B) (S2)
- (79-11-41)	1	-	.Indicator, Oil Tank Level	50R377 (01-100)	(B) (S2)
5W8391 (79-11-41)	1	-	.Bracket	- (01-101)	(A) (S2)
4P7236 (79-11-41)	1	-	.Cover	- (01-102)	(A) (S2)
- (79-11-41)	2	-	.Bolt, Machine Double Hex.190 Dia x 0,625	4W0105 (01-120)	(E) (S2)
- (79-11-41)	1	-	.Packing	AS3209-121 (01-140)	(B) (S2)
- (79-11-41)	1	-	.Connector, A/O	4B7181 (01-144)	(B) (S2)
- (79-11-41)	2	-	.Washer, Flat	MS9321-10 (01-147)	(E) (S2)
- (79-11-41)	2	-	..Insert	MS21209F1- 20L (01-151)	(E) (S2)
- (79-11-41)	1	-	.Adaptor, Union	4P7238 (01-180)	(E) (S2)
4P7237 (79-11-41)	1	-	.Plug	- (01-182)	(A) (S2)
4B7244 (79-11-41)	1	-	.Tank, A/O Oil	4B7195 (01-860)	(A) (B) (1D) (S2)

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5A8794 (79-21-49)	1	1204.00	.Tube, Assy Oil Spill to Oil Tank	5A8774 (05-100)	(A) (B) (S2)
4W0103 (79-21-49)	1	11.40	.Bolt, Machine Double Hex .190 Dia x .500	- (05-157)	(A) (S2)
5W1086 (79-21-49)	1	.32	.Washer	- (05-158)	(A) (S2)
400WSS4 (79-21-49)	1	4.90	.Clip, Loop Type	- (05-160)	(A) (S2)
4W0043 (79-21-49)	1	1.99	.Nut, A/O Self Locking .190 Dia	- (05-164)	(A) (S2)

C. Instructions/Disposition Code Statements:

- (1D) Old part may be reworked and reidentified to new part number.
- (A) New part is currently available for sale.
- (B) Old part will no longer be available for sale.
- (C) New part is no longer available for sale . Ref. to SBE 79-0030
- (E) Old part will continue to be for sale for other applications.
- (S1) Old and new parts coded (S1) are fully interchangeable, both physically and functionally.
- (S2) Old parts coded (S2) must be used with old parts coded (S1).
New parts coded (S2) must be used with new parts coded (S2).

NOTE: The estimated 1993 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

