



DATE: Jul.10/99

Subject: Transmittal of Revision 4 to Service Bulletin No.V2500-ENG-79-0051

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic issue	Jul.10/95
Revision 1	Sep.25/95
Revision 2	Oct.30/95
Revision 3	Mar.18/96
Revision 4	Jul.10/99

Reason for Issuance of Revision

To incorporate editorial changes and revise dimensions in inches.

List of Effective pages:

<u>Bulletin</u> <u>Page No.</u>	<u>Rev.</u> <u>No.</u>	<u>Effective</u> <u>Date</u>
1 to 2	4	Jul.10/99
3 to 5	basic	Jul.10/95
6 to 7	1	Sep.25/95
8	4	Jul.10/99
9	1	Sep.25/95
10 to 15	4	Jul.10/99
16 to 23	1	Sep.25/95

V2500-ENG-79-0051

Transmittal

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International Aero Engines
SERVICE BULLETIN

ENGINE - OIL - TO INTRODUCE A NEW MAIN SCAVENGE OIL PUMP FEATURING
IMPROVED SPACERS AND COVERS

MODEL APPLICATION

V2500-A1
V2527-A5
V2530-A5
V2525-D5
V2528-D5

BULLETIN INDEX LOCATOR

79-00-00

Compliance Category Code

8

Internal Reference No.

93VF027
93VF027-01
93VF027-03
93VF027-04
93VF008A
93VF008A-01
93VF008A-02

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Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

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International Aero Engines SERVICE BULLETIN

ENGINE - OIL - TO INTRODUCE A NEW MAIN SCAVENGE OIL PUMP FEATURING
IMPROVED SPACERS AND COVERS

1. Planning Information

A. Effectivity

(1) Aircraft:

- (a) Airbus A320
- (b) Airbus A321
- (c) Mc Donnell Douglas MD-90

(2) Engine:

- (a) V2500-A1 Engines prior to V0362
- (b) V2527-A5 Engines prior to V10123
- (c) V2530-A5 Engines prior to V10123
- (d) V2525-D5 Engines prior to V20014 and V20021 and V20022
- (c) V2528-D5 Engines prior to V20014 and V20021 and V20022

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B. Reason

(1) Condition

A number of the early pumps modified to the standard of Service Bulletin V2500-ENG-72-0118 did not achieve the expected result

(2) Background

An examination of these pumps determined that buildup of adverse dimensional tolerances during pump assembly resulted in damage to the pump bushings, input shaft, and some gears.

(3) Objective

To improve pump durability by the introduction of improved spacers and bushings.

(4) Substantiation

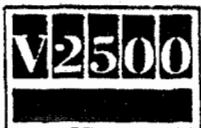
A 150 hours endurance test has successfully been carried out.
100 thermal distress cycles have been successfully carried out.

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(5) Effects of Bulletin on Workshop Procedures:

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

C. Description

(1) The changes introduced by this service bulletin are as follows:

- (a) The bushes are manufactured using an improved material with better mechanical properties.
- (b) Hard coating application on spacer inner diameter has been deleted.
- (c) The Clearance between the bushes and the gears has been increased.
- (d) The bushes thickness has been increased.

D. Approval

The part number changes and part modifications described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulation and are FAA-APPROVED for the Engine Model listed.

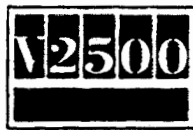
E. Compliance

Category 8

Accomplish based upon experience with the prior configuration.

F. Manpower

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



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Venue

Estimated Man-hours

(1) In service

Not applicable

(2) At overhaul

Not applicable
(Parts are accessible at
overhaul)

G. Material - Price and Availability

(1) Modification Kit is not provided

(2) See "Material information" section for prices and availability
of future spares.

H. Tooling - Price and Availability

N/A

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.

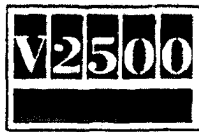
K. References

(1) V2500 Engine Illustrated Parts Catalog

(2) V2500 Standard Practices Manual

L. Other Publications Affected

(1) The V2500 Illustrated Parts Catalog (S-V2500-1IA), Chapter/Sec-
tion 79-22-41 will be revised to show the new parts being
introduced by this Service Bulletin.



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- (2) The V2500 Illustrated Parts Catalog (S-V2500-2IA), Chapter/Section 79-22-41 will be revised to show the new parts being introduced by this Service Bulletin.
- (3) The V2500 Illustrated Parts Catalog (S-V2500-3IA), Chapter/Section 79-22-41 will be revised to show the new parts being introduced by this Service Bulletin.
- (4) The V2500 Illustrated Power Plant Parts Catalog (PIP-V2500-1IA), Chapter/Section 79-22-41 will be revised to show the new parts being introduced by this Service Bulletin.
- (5) The V2500 Illustrated Power Plant Parts Catalog (PIP-V2500-2IA), Chapter/Section 79-22-41 will be revised to show the new parts being introduced by this Service Bulletin.
- (6) The V2500 Illustrated Power Plant Parts Catalog (PIP-V2500-3IA), Chapter/Section 79-22-41 will be revised to show the new parts being introduced by this Service Bulletin.
- (7) The V2500 Component Maintenance Manual (CMM-MECH-V2500-1IA), Chapter/Section 79-22-41 Cleaning, Inspection, Repair and Testing will be revised to show the new parts being introduced by this Service Bulletin.
- (8) The V2500 Component Maintenance Manual (CMM-MECH-V2500-3IA), Chapter/Section 79-22-41 Cleaning, Inspection, Repair and Testing will be revised to show the new parts being introduced by this Service Bulletin.



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2. Accomplishment instructions

A. Return the pump to:
FIAT AVIO S.p.A
Via Nizza 312
10127 TORINO (Italy)
OR
AVIAL INC.
Dallas Engines Service
93 Reeves Street
DALLAS - TEXAS 75235 2095 (USA)

B. Rework instructions

- (1) Do a modification to the 4B7002 cover (See Reference (1) Chapter/Section 79-22-41, Figure No. 01-330) and identify as follows:

Procedure

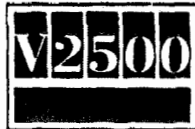
Supplementary Information

- | | |
|---|---|
| (a) Machine the cover to remove old bushes | Refer to Figure 2. Keep parent material removal to minimum value |
| (b) Do an inspection of the cover in locality of bores. | See reference (2), TASK No. 70-23-05-230-501. No cracks are permitted |
| (c) Apply the chromate conversion coating to the machined surfaces. | See reference (2), TASK No. 70-38-02-300-503 |

WARNING: 1. DO NOT TOUCH THE
HOT PARTS WITHOUT
PROTECTIVE GLOVES

2. HOT PARTS CAN
CAUSE REDDENING AND
BLISTERING OF THE
SKIN IF THE HANDS
ARE NOT PROTECTED.

3. IMMERSE THE CONTACTED AREA IN COLD WATER FOR 10 MINUTES IF THE SKIN IS BURNED, IMMEDIATELY GET THE MEDICAL ATTENTION IF PAIN OR BLISTERING PERSIST.



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- (d) Put the cover in to the oven

The oven temperature must be between 212 to 248 deg F (100 to 120 deg C).

Hold the cover for 8 minutes.

- (e) Install the bush to a suitable drift

- (f) Remove the cover from the oven

CAUTION: INSTALL THE BUSHING
IN MACHINED BORE
IMMEDIATELY,
OTHERWISE BUSHING
CANNOT BE CORRECTLY
INSTALLED

- (g) Lubricate the machined bores and install the bushes P/N 4P7323 (2 off) and P/N 4P7324 (1 off)

Use CoMat 10-077 approved engine oil. Refer to Figure 3

- (h) Let the parts get the room temperature

- (i) Machine the bushes inner diameter and grooves

Refer to Figure 1 and 3

- (j) Cancel the old part number and identify with the new part number.

<u>Old p/n</u>	<u>New p/n</u>
4B7002	4B7318

See reference (2), TASK No. 70-09-00-400-501.

Use vibro-engraving equipment.

- (2) Do a modification to the 4B7003 covers (2 off) (See Reference (1) Chapter/Section 79-22-41, Figure No. 01-050) and identify as follows:

Procedure

Supplementary Information

- (a) Machine the covers to remove old bushes.

Refer to Figure 5. Keep parent material removal to minimum value

- (b) Do an inspection of the cover in locality of bores.

See reference (2), TASK No. 70-23-05-230-501. No cracks are permitted



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- (c) Apply the chromate conversion coating to the machined surfaces.

See reference (2), TASK No.
70-38-02-300-503

WARNING: 1. DO NOT TOUCH THE
HOT PARTS WITHOUT
PROTECTIVE GLOVES

2. HOT PARTS CAN
CAUSE REDDENING AND
BLISTERING OF THE
SKIN IF THE HANDS
ARE NOT PROTECTED.

3. IMMERSE THE CON-
TACTED AREA IN COLD
WATER FOR 10 MINUTES
IF THE SKIN IS
BURNED IMMEDIATELY
GET THE MEDICAL
ATTENTION IF PAIN OR
BLISTERING PERSIST.

- (d) Put the cover in to the
oven

The oven temperature must be
between 212 to 248 deg F (100
to 120 deg C).
Hold the cover for 8 minutes.

- (e) Install the bush to a suit-
able drift

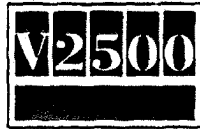
- (f) Remove the cover from the
oven

CAUTION: INSTALL THE BUSHING
IN MACHINED BORE
IMMEDIATELY, OTHER
WISE BUSHING CANNOT
BE CORRECTLY
INSTALLED

- (g) Lubricate the machined
bores and install the
bushes P/N 4P7323 (2 off)

Use CoMat 10-077 approved en-
gine oil. Refer to Figure 6

- (h) Let the parts get the room
temperature



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- | | | | | | | | | | |
|---|---|----------------|----------------|--------|--------|---|--|--------------------------------|--|
| (i) Machine the bushes inner diameter and grooves | Refer to Figure 4 and 6 | | | | | | | | |
| (j) Cancel the old part number and identify with the new part number. | <table border="0"><tr><td><u>Old p/n</u></td><td><u>New p/n</u></td></tr><tr><td>4B7003</td><td>4B7319</td></tr><tr><td colspan="2">See reference (2), TASK No. 70-09-00-400-501.</td></tr><tr><td colspan="2">Use vibro-engraving equipment.</td></tr></table> | <u>Old p/n</u> | <u>New p/n</u> | 4B7003 | 4B7319 | See reference (2), TASK No. 70-09-00-400-501. | | Use vibro-engraving equipment. | |
| <u>Old p/n</u> | <u>New p/n</u> | | | | | | | | |
| 4B7003 | 4B7319 | | | | | | | | |
| See reference (2), TASK No. 70-09-00-400-501. | | | | | | | | | |
| Use vibro-engraving equipment. | | | | | | | | | |

C. Assembly instructions

(1) V2500-A1 Engine Model

- (a) Assemble scavenge oil pump by use of approved procedure, Component Maintenance Manual, 79-22-41 Assembly.
- (b) Reidentify the pump to P/N 4A7117. See references (2) Task 70-09-00-400-501. Use Vibroengraving equipment.

(2) V2527-A5 and V2500-A5 Engine Models

- (a) Assemble scavenge oil pump by use of approved procedure, Component Maintenance Manual, 79-22-41 Assembly.
- (b) Reidentify Pump to P/N 4A7118: See references (2) Task 70-09-00-400-501. Use Vibroengraving equipment.

(3) V2525-D5 and V2528-D5 Engine Models

- (a) Assemble scavenge oil pump by use of approved procedure, Component Maintenance Manual, 79-22-41 Assembly.
- (b) Reidentify Pump to P/N 4A7119. See references (2) Task 70-09-00-400-501. Use Vibroengraving equipment.

D. Recording instructions

- (1) A record of accomplishment is necessary.

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FF

CC

45°

0.8661 (22)

0.0787 (2)

2.0866 (53)

1.4173 (36)

1.4173 (36)

FF

2.0866 (53)

0.0787 (2)

CC

0.8661 (22)

45°

40°

0.0787 (2)

VIEW ON AA

R 0.0197 (0,5)

PARTIAL SECTION FF-FF
3 POSITIONS
(Typical)

0.0079 - 0.0118 (0,2 - 0,3)

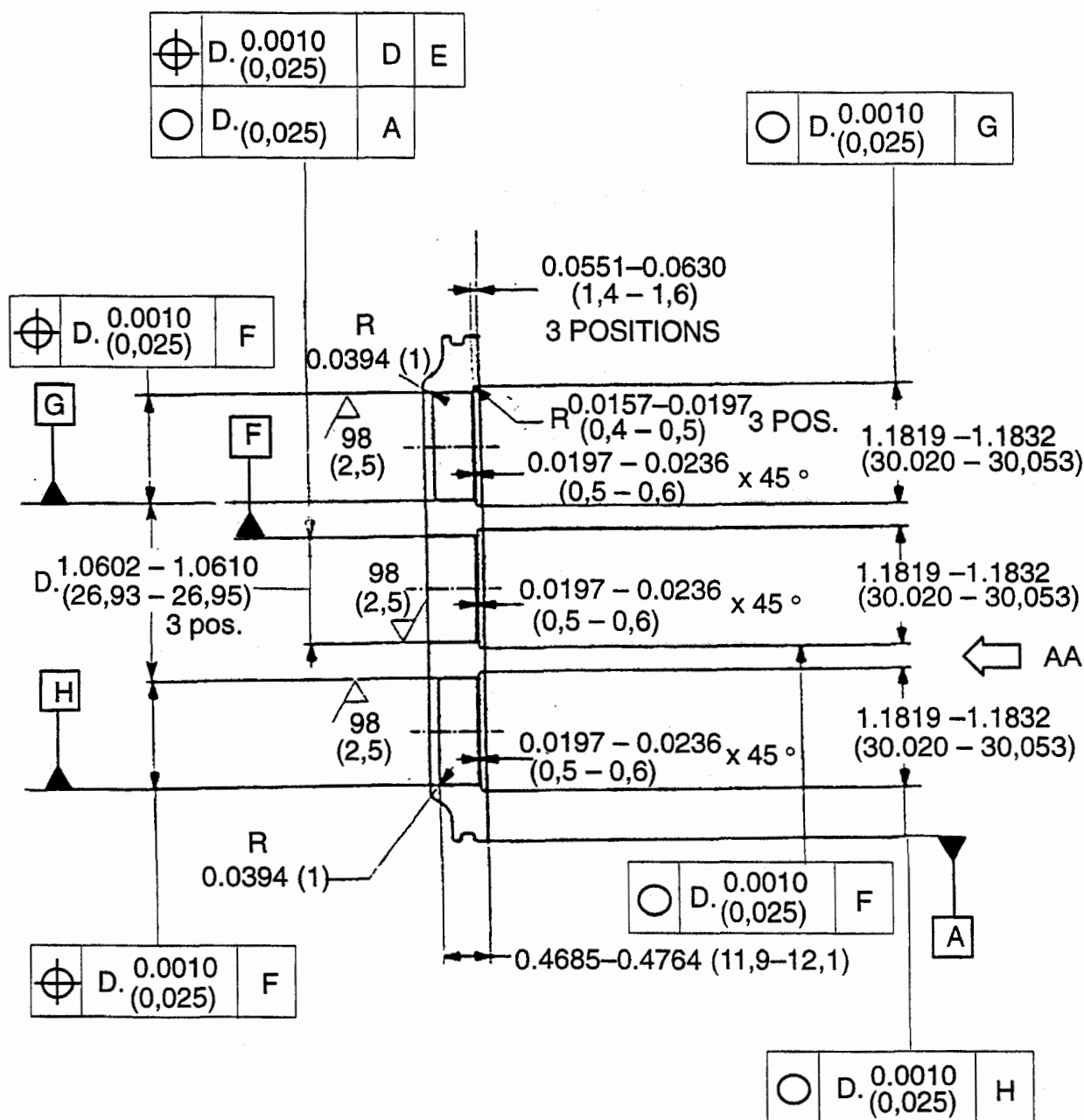
98. (2,5)

F790051-1

FIGURE 1

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SECTION CC – CC
(Before bushes installation)

F720051-2

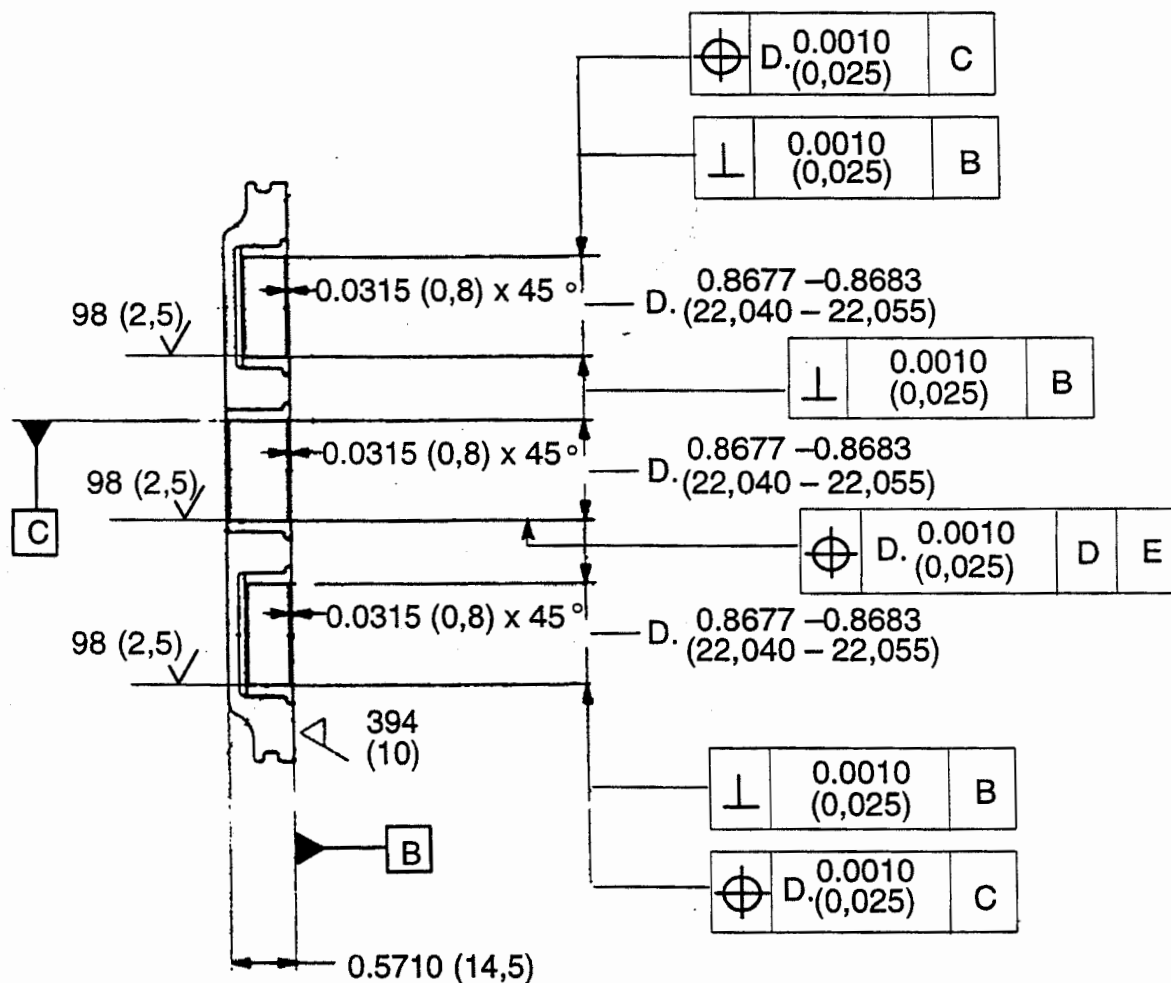
FIGURE 2

V2500-ENG-79-0051



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SECTION CC - CC
(After bushes installation)

F790051-3

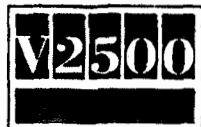
FIGURE 3

V2500-ENG-79-0051

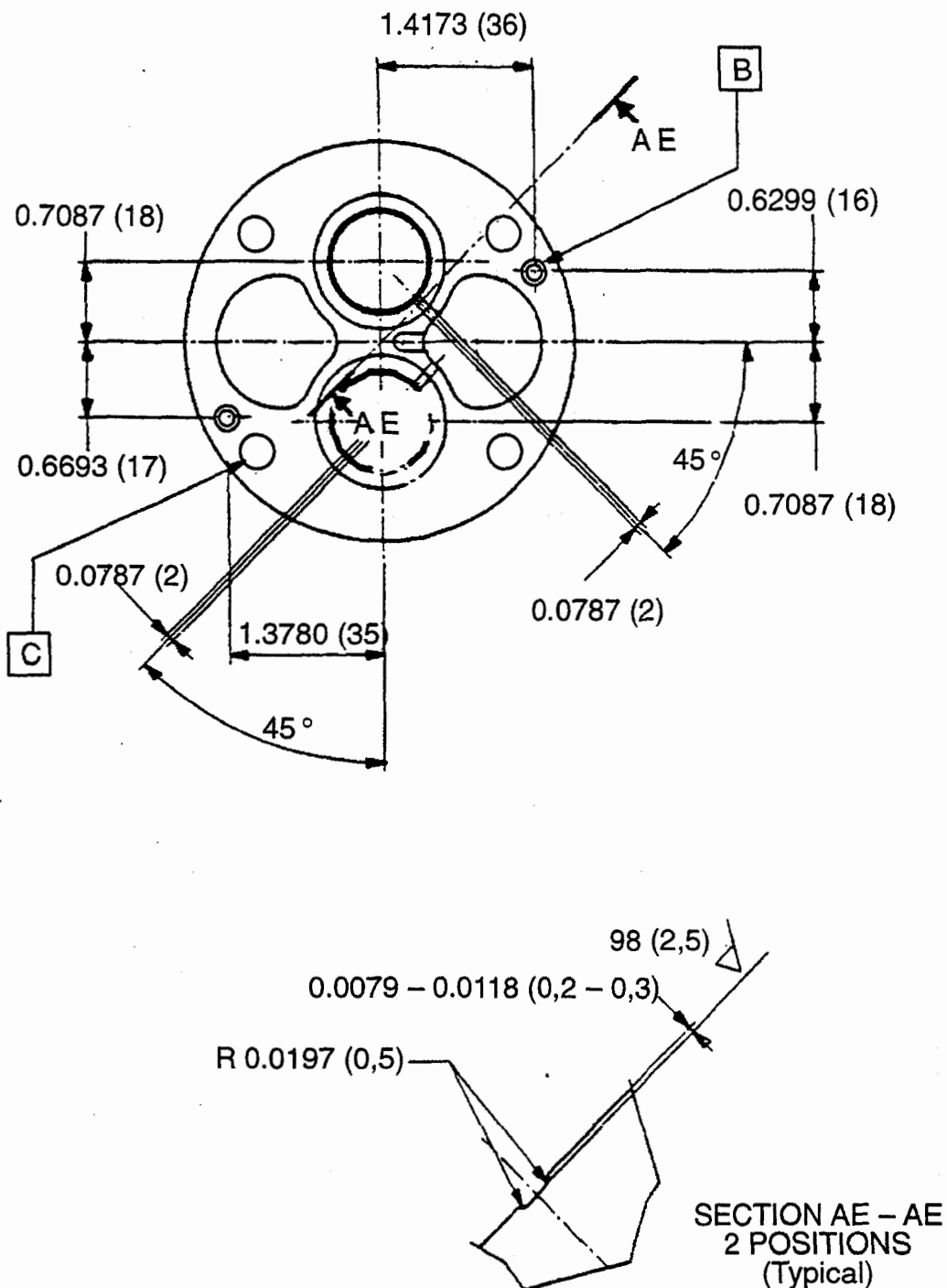
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NOTE: 1. All dimensions are in in. (mm)
2. Roughness rates are given in microinch (micrometer)

F790051-4

FIGURE 4

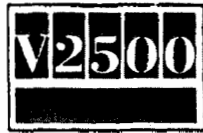
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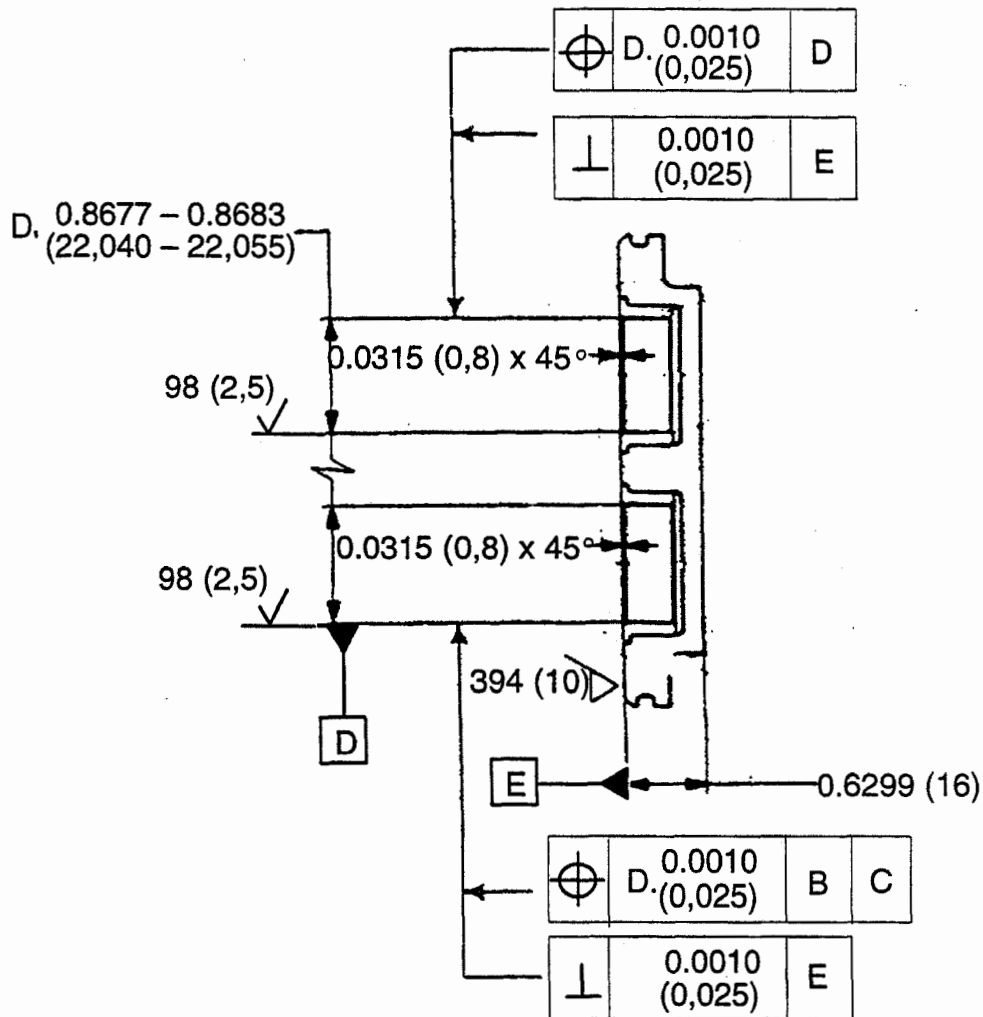
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(After bushes installation)

F790051-6

FIGURE 6

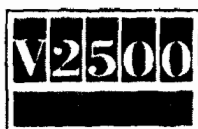
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3. Material Information

A. Kits associated with this Bulletin

None

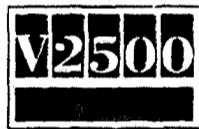
B. Parts affected by this Bulletin

New	Est'd			Old	
Part No.	Unit			Part No.	Instruction
(ATA No.)	Qty	Price(\$)	Keyword	(IPC No.)	Disposition

Applicability: For Each V2500-A1 Engine Not Incorporating Service Bulletin V2500-ENG-72-0118 To Incorporate This Bulletin.

R	4A7117 (79-22-41)	1	42.110.00	Pump, Assy Oil Scavenge	4A7013 (01-001)	(A) (B) (1D) (S1)
R	4B7319 (79-22-41)	2	1307.00	.Cover, Assy	4B7003 (01-050)	(A) (B) (S2) (1D)
R	4P7323 (79-22-41)	2		..Bush	4P7019 (01-001)	(A) (C) (S2)
	- (79-22-41)	4		.Spacer, Assy	4B7096 (01-200)	(B) (S2)
R	4B7320 (79-22-41)	4	893.00	.Spacer, Assy	- (01-200)	(A) (S2)
	4B7320CL01 (79-22-41)	4		.Spacer, Assy	- (01-201)	(A) (S2) (S3)
R	4B7320CL02 (79-22-41)	4		.Spacer, Assy	- (01-202)	(A) (S2) (S3)
	- (79-22-41)	4		.Spacer, Assy	4B7115 (01-270)	(B) (S2) (S3)
	4B7321 (79-22-41)	4	662.00	.Spacer, Assy	- (01-200)	(A) (S2)
	4B7321CL01 (79-22-41)	4		.Spacer, Assy	- (01-271)	(A) (S2) (S3)
	4B7321CL02 (79-22-41)	4		.Spacer, Assy	- (01-272)	(A) (S2) (S3)

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International Aero Engines SERVICE BULLETIN

New Part No. (ATA No.)	Est'd Unit Qty Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2500-A1 Engine Not Incorporating Service Bulletin
V2500-ENG-72-0118 To Incorporate This Bulletin. (Continued)

R 4B7318 (79-22-41)	1	1701.00	.Cover, A/O	4B7002 (01-330)	(A)(B)(S1) (1D)
R 4P7324 (79-22-41)	1		..Bush	4P7022 (01-370)	(A)(C)(S2)
4P7323 (79-22-41)	2		..Bush	4B7019 (01-375)	(A)(C)(S2)
R - (79-22-41)	4		.Spacer, Assy	4B7115 (01-530)	(B)(S2)
R 4P7321 (79-22-41)	2	662.00	.Spacer Assy	- (01-530)	(A)(S2)
R 4B7321CL01 (79-22-41)	2		.Spacer, Assy	- (01-531)	(A)(S3)(S2)
R 4B7321CL02 (79-22-41)	2		.Spacer, Assy	- (01-532)	(A)(S3)(S2)
R - (79-22-41)	1		.Spacer, Assy	4B7114 (01-590)	(B)(S2)
R 4B7322 (79-22-41)	1	782.00	.Spacer, Assy	- (01-590)	(A)(S2)
R 4B7322CL01 (79-22-41)	1		.Spacer, Assy	- (01-591)	(A)(S3)(S2)
R 4B7322CL02 (79-22-41)	1		.Spacer, Assy	- (01-592)	(A)(S3)(S2)

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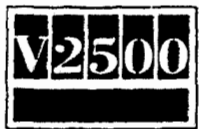
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New Part No. (ATA No.)	Qty	Est'd Unit Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2500-A1 Engine Incorporating Service Bulletin
V2500-ENG-72-0118 To Incorporate This Bulletin.

R	4A7117 (79-22-41)	1	42,110.00	Pump, Assy Oil Scavenge	4A7112 (01-001)	(A) (B) (1D) (S1)
R	4B7319 (79-22-41)	2	1307.00	. Cover, Assy	4B7003 (01-050)	(A) (B) (1D) (S2)
	4P7323 (79-22-41)	2		. . Bush	4P7019 (01-001)	(A) (C) (S2)
R	4B7320 (79-22-41)	4	893.00	. Spacer, Assy	4B7315 (01-200)	(A) (B) (S2)
	4B7320CL01 (79-22-41)	4		. Spacer, Assy	4B7315CL01 (01-201)	(A) (B) (S2) (S3)
	4B7320CL02 (79-22-41)	4		. Spacer, Assy	4B7315CL02 (01-202)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7315CL03 (01-203)	(B) (S2) (S3)
R	4B7321 (79-22-41)	4	662.00	. Spacer, Assy	4B7301 (01-270)	(A) (B) (S2)
	4B7321CL01 (79-22-41)	4		. Spacer, Assy	4B7301CL01 (01-271)	(A) (B) (S2) (S3)
	4B7321CL02 (79-22-41)	4		. Spacer, Assy	4B7301CL02 (01-272)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7301CL03 (01-273)	(B) (S2) (S3)
	4B7318 (79-22-41)	1		. Cover, A/O	4B7002 (01-330)	(A) (B) (1D) (S2)
R	4P7324 (79-22-41)	1		. . Bush	4P7022 (01-370)	(A) (C) (S2)

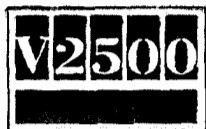
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New	Est'd			Old	
Part No.	Unit			Part No.	Instruction
(ATA No.)	Qty	Price(\$)	Keyword	(IPC No.)	Disposition

Applicability: For Each V2500-A1 Engine Incorporating Service Bulletin
V2500-ENG-72-0118 To Incorporate This Bulletin. (Continued)

R	4P7323 (79-22-41)	2		..Bush	4P7019- (01-375)	(A)(C)(S2)
R	4P7321 (79-22-41)	2	662.00	.Spacer Assy	4B7301 (01-530)	(A)(B)(S2)
R	4B7321CL01 (79-22-41)	2		.Spacer, Assy	4B7301CL01 (01-531)	(A)(B)(S2) (S3)
R	4B7321CL02 (79-22-41)	2		.Spacer, Assy	4B7301CL02 (01-532)	(A)(B)(S2) (S3)
R	- (79-22-41)	2		.Spacer, Assy	4B7301CL03 (01-533)	(B)(S2)(S3)
R	4B7322 (79-22-41)	1	782.00	.Spacer, Assy	4B7302 (01-590)	(A)(B)(S2)
R	4B7322CL01 (79-22-41)	1		.Spacer, Assy	4B7302CL01 (01-591)	(A)(B)(S2)
R	4B7322CL02 (79-22-41)	1		.Spacer, Assy	4B7302CL02 (01-592)	(A)(B)(S2) (S3)
R	- (79-22-41)	1		.Spacer, Assy	4B7302CL03 (01-593)	(B)(S2)(S3)

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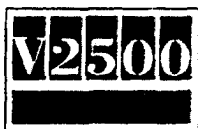
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New Part No. (ATA No.)	Est'd Unit Qty Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2527-A5 or V2530-A5 Engine To Incorporate This Bulletin.

R	4A7118 (79-22-41)	1	48,850.00	Pump, Assy Oil Scavenge	4A7114 (01-001)	(A) (B) (1D) (S1)
R	4B7319 (79-22-41)	2	1307.00	. Cover, Assy	4B7003 (01-050)	(A) (B) (1D) (S2)
R	4P7323 (79-22-41)	2		. . Bush	4P7019 (01-001)	(A) (C) (S2)
R	4B7320 (79-22-41)	4	893.00	. Spacer, Assy	4B7315 (01-200)	(A) (B) (S2) (S3)
	4B7320CL01 (79-22-41)	4		. Spacer, Assy	4B7315CL01 (01-201)	(A) (B) (S2) (S3)
	4B7320CL02 (79-22-41)	4		. Spacer, Assy	4B7315CL02 (01-202)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7315CL03 (01-203)	(B) (S2) (S3)
R	4B7321 (79-22-41)	4	662.00	. Spacer, Assy	4B7301 (01-270)	(A) (B) (S2)
	4B7321CL01 (79-22-41)	4		. Spacer, Assy	4B7301CL01 (01-271)	(A) (B) (S2) (S3)
	4B7321CL02 (79-22-41)	4		. Spacer, Assy	4B7301CL02 (01-272)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7301CL03 (01-273)	(B) (S2) (S3)
R	4B7318 (79-22-41)	1	1701.00	. Cover, A/O	4B7002 (01-330)	(A) (B) (1D) (S2)
R	4P7324 (79-22-41)	1		. . Bush	4P7022 (01-370)	(A) (C) (S2)

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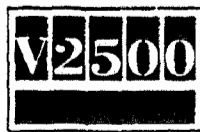
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New Part No. (ATA No.)	Est'd Unit Qty Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2527-A5 or V2530-A5 Engine To Incorporate This
Bulletin. (Continued)

R	4P7323 (79-22-41)	2		..Bush	4P7019 (01-375)	(A)(C)(S2)
R	4B7321 (79-22-41)	2	662.00	.Spacer Assy	4B7301 (01-530)	(A)(B)(S2)
R	4B7321CL01 (79-22-41)	2		.Spacer, Assy	4B7301CL01 (01-531)	(A)(B)(S2) (S3)
R	4B7321CL02 (79-22-41)	2		.Spacer, Assy	4B7301CL02 (01-532)	(A)(B)(S2) (S3)
R	- (79-22-41)	2		.Spacer, Assy	4B7301CL03 (01-533)	(B)(S2)(S3)
R	4B7322 (79-22-41)	1	782.00	.Spacer, Assy	4B7302 (01-590)	(A)(B)(S2)
R	4B7322CL01 (79-22-41)	1		.Spacer, Assy	4B7302CL01 (01-591)	(A)(B)(S2) (S3)
R	4B7322CL02 (79-22-41)	1		.Spacer, Assy	4B7302CL02 (01-592)	(A)(B)(S2) (S3)
R	- (79-22-41)	1		.Spacer, Assy	4B7302CL03 (01-593)	(B)(S2)(S3)

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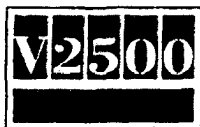
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International Aero Engines SERVICE BULLETIN

New Part No. (ATA No.)	Est'd Unit Qty Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2525-D5 or V2528-D5 Engine To Incorporate This Bulletin.

R	4A7119 (79-22-41)	1	48,850.00	Pump, Assy Oil Scavenge	4A7113 (01-001)	(A) (B) (1D) (S1)
R	4B7319 (79-22-41)	2	1307.00	. Cover, Assy	4B7003 (01-050)	(A) (B) (1D) (S2)
R	4P7323 (79-22-41)	2		. . Bush	4P7019 (01-001)	(A) (C) (S2)
R	4B7320 (79-22-41)	4	983.00	. Spacer, Assy	4B7315 (01-200)	(A) (B) (S2)
	4B7320CL01 (79-22-41)	4		. Spacer, Assy	4B7315CL01 (01-201)	(A) (B) (S2) (S3)
	4B7320CL02 (79-22-41)	4		. Spacer, Assy	4B7315CL02 (01-202)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7315CL03 (01-203)	(B) (S2) (S3)
R	4B7321 (79-22-41)	4	662.00	. Spacer, Assy	4B7301 (01-270)	(A) (B) (S2)
	4B7321CL01 (79-22-41)	4		. Spacer, Assy	4B7301CL01 (01-271)	(A) (B) (S2) (S3)
	4B7321CL02 (79-22-41)	4		. Spacer, Assy	4B7301CL02 (01-272)	(A) (B) (S2) (S3)
	- (79-22-41)	4		. Spacer, Assy	4B7301CL03 (01-273)	(B) (S2) (S3)
	4B7318 (79-22-41)	1		. Cover, A/O	4B7002 (01-330)	(A) (B) (1D) (S2)
R	4P7324 (79-22-41)	1		. . Bush	4P7022 (01-370)	(A) (C) (S2)
R	4P7323 (79-22-41)	2		. . Bush	4P7019 (01-375)	(A) (C) (S2)
R	4B7321 (79-22-41)	2	662.00	. Spacer Assy	4B7301 (01-530)	(A) (B) (S2)
R	4B7321CL01 (79-22-41)	2		. Spacer, Assy	4B7301CL01 (01-531)	(A) (B) (S2) (S3)
R	4B7321CL02 (79-22-41)	2		. Spacer, Assy	4B7301CL02 (01-532)	(A) (B) (S2) (S3)

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International Aero Engines SERVICE BULLETIN

New Part No. (ATA No.)	Est'd Unit Qty Price(\$)	Keyword	Old Part No. (IPC No.)	Instruction Disposition
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Applicability: For Each V2525-D5 or V2528-D5 Engine To Incorporate This
Bulletin. (Continued)

R	- (79-22-41)	2	. Spacer, Assy	4B7301CL03 (B)(S2)(S3) (01-533)
R	4B7322 (79-22-41)	1	. Spacer, Assy	4B7302 (A)(B)(S2) (01-590) (S3)
R	4B7322CL01 (79-22-41)	1	. Spacer, Assy	4B7302CL01 (A)(B)(S2) (01-591)
R	4B7322CL02 (79-22-41)	1	. Spacer, Assy	4B7302CL02 (A)(B)(S2) (01-592) (S3)
R	- (79-22-41)	1	. Spacer, Assy	4B7302CL03 (B)(S2)(S3) (01-593)

C. Instruction/Disposition Code Statements.

- (A) New part is available for sale
- (B) Old part is no longer available
- (C) Old part is not spareable. Part is shown for progression puposes
- (S1) Old and new parts coded (S1) are directly interchangeable.
- (S2) New parts coded (S2) replace old parts coded (S2) as a complete set per engine
- (S3) At the time of the assembly of the pump, the proper spacer classification will be selected.
- (1D) New pump part number may be obtained by rework and reidentification of the old part number

NOTE: The estimated 1995 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.

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