SERVICE BULLETIN REVISION NOTICE

OIL — INTRODUCTION OF OPTIMIZED DESIGN FEATURES TO THE OIL TANK, THE PRESSURE PUMP AND FILTER HOUSING, THE SCAVENGE OIL PUMP, THE SCAVENGE OIL FILTER ASSEMBLY AND THE TRANSPORTATION FITTINGS.

Turbojet Engine Service Bulletin No. V2500 79-0101 Revision No. 1 dated November 17, 2016.

Revision History

Original Issue September 2, 2014

Revision 1 dated November 17, 2016

Reason for the Revision

Updated the Description, Interchangeability, and Material Table footnotes, to correct interchangeability of the old scavenge filter assembly as the assembly is fully interchangeable, however the housing is only one-way interchangeable.

Effect of Revision on Prior Compliance

None.

This is a Complete Revision (Not Applicable to the SGML version)

The format of this Service Bulletin has been changed from previous versions. This revision shows flow bars and the revision date on the bottom of every page. Technical changes incorporated in this revision are marked with revision bars. The contents are in accordance with the list of effective pages.

MODEL APPLICATION

V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525-D5, V2528-D5

BULLETIN ISSUE SEQUENCE

V2500 Series 79-0101

Page	Revision No.	Date
1 thru 21	1	November 17/16

A copy of this Revision Notice and any future revision notices must be filed as a permanent record with your copy of the subject bulletin.

SERVICE BULLETIN

OIL — INTRODUCTION OF OPTIMIZED DESIGN FEATURES TO THE OIL TANK, THE PRESSURE PUMP AND FILTER HOUSING, THE SCAVENGE OIL PUMP, THE SCAVENGE OIL FILTER ASSEMBLY AND THE TRANSPORTATION FITTINGS.

MODEL APPLICATION

V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525-D5, V2528-D5

BULLETIN ISSUE SEQUENCE

V2500 Series 79-0101

ATA NUMBER

79-00-00

Compliance Category

8

Summary

See the reason.

Planning Information

Effectivity Data

Engine Models Applicable

V2500-A1
Engine Serial Nos. V0001 thru V0361

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5
Engine Serial Nos. V10001 thru V13190

V2522-A5, V2524-A5, V2527M-A5, V2527-A5, V2527E-A5, V2530-A5, V2533-A5
Engine Serial Nos. V15001 thru V16311
Engine Serial No. V16315
Engine Serial No. V16320
Engine Serial No. V16362
Engine Serial No. V16411

V2525-D5, V2528-D5
Engine Serial Nos. V20001 thru V20285

Concurrent Requirements

There are no concurrent requirements.

Reason

1. Condition: Some components of the oil system retain features with minor parts as well as transportation fittings that are not used in operation. A design review was done to eliminate superfluous features and parts, simplify shop maintenance activity and improve manufacture.
2. Background:
   A. The oil tank deaerator retains a threaded hole with packing and safety wire for a plug that is not utilized.
   B. The oil pressure pump and filter housing assembly retains two threaded holes for adaptors that are not utilized in service. The material of the relief valve requires nitriding to be produced.
   C. The oil pressure pump and the scavenge oil pump feature identification plates with different part numbers, but the plates can be intermixed.
   D. The scavenge oil filter assembly features one threaded hole with packing and safety wire for an adaptor that is not utilized. There are holes with inserts no longer utilized on the flange of the assembly where the tube connecting with the oil tank is installed.
   E. The design of two spacers of the scavenge oil pump can be standardized for easier manufacturing.
   F. The design of the transportation fittings for the above assemblies is obsolete.
3. Objective:

A. To remove the threaded hole of the oil tank deaerator, together with the plug, the packing and the safety wire.

B. To remove both threaded holes and adaptors from the oil pressure pump. To change the material of the relief valve.

C. To provide each type of oil pump with a different identification plate of its own.

D. To remove one threaded hole and the adaptor from the scavenge oil filter, the packing and the safety wire. To remove holes and inserts from the flange.

E. To standardize the design of the bushings fitted in two spacers of the scavenge pump.

F. To change the material of some transportation fittings. To eliminate transportation fittings that are not used.

4. Substantiation:

A. The plug removed from the oil tank deaerator is not required for engine operation or test.

B. The two adaptors of the oil pressure pump are not used for operation or test. In order to do the rig test of the pump assembly, pressure P4 can be measured by connecting a pressure transducer to the filter cover assembly. The relief valve operation is not affected by change of valve material.

C. To ensure that the new identification plates can only be correctly installed, the specific layout of the screw holes of each type of plate will match with those on the relevant type of pump.

D. The adaptor on the scavenge oil filter is not used for operation or test. The tube connecting with the flange does not feature attaching bolts any more after introduction of Reference 4, Service Bulletin V2500-ENG-70-0347.

E. The standardized design of the two spacers does not affect internal lubrication conditions.

F. The changes introduced to transportation fittings are based on experience with similar parts utilized in production.

5. Effects of Bulletin on:

A. Operation

(1) Not affected.

B. Maintenance

(1) Not affected.

C. Overhaul

(1) Not affected.

D. Repair Schemes

(1) Affected.

E. Interchangeability

(1) Affected.

F. Fits and Clearances

(1) Not affected.

6. Supplemental Information

None.

Description

1. The new oil tank assembly and the modified deaerator are freely interchangeable with the old ones.
2. The new pressure oil pump and the modified casing assembly are freely interchangeable with the old ones. In order to do the rig test of the pressure pump, test adapter part number IAE2P16602 must be procured to be connected to the filter cover assembly, see Accomplishment Instructions of this Service Bulletin.
3. The new identification plates are not interchangeable with the old ones. It is possible for the new plate to be fitted to pumps produced before the introduction of this Service Bulletin.
4. The modified scavenge oil filter housing can replace the old one but not vice-versa.
5. The new spacers do not affect performance or interchangeability of the scavenge oil pump. See Accomplishment Instructions of this Service Bulletin.
6. The new transportation fittings are freely interchangeable with the old ones.

Compliance

Category 8

Accomplish based upon experience with the prior configuration.

Approval Data

The part number changes and/or part modifications specified in the Accomplishment Instructions and Material Information sections of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

Manpower

1. In Service

..... Not Applicable.

2. At Overhaul

..... Not Applicable.

Weight and Balance

Not Applicable.

Electrical Load Data

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

Software Accomplishment Summary

Not Applicable.

References

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

1. ATA Locator — 72-60-03, 79-11-41, 79-21-41, 79-22-41, 79-22-43.
2. V2500 A1/A5 Series CMM-MMC, P&W Ref. PN 2A4411, Chapters 79-11-41, 79-21-41, 79-22-41 and 79-22-43.
3. V2500 D5 Series CMM-MMC, P&W Ref. PN 2A4420 Chapters 79-11-41, 79-21-41, 79-22-41 and 79-22-43.
4. IAE V2500 Service Bulletin V2500-ENG-70-0347 (Standard Practices — Engine — Main Gearbox Assembly — To Announce The Availability Of New Oil Scavenge Tube Assemblies).

Other Publications Affected

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, a Technical Publications conversion table is provided in the Appendix.

1. For effects on Illustrated Parts Catalog (IPC), refer to Material Information Section.
2. V2500 A1/A5 Series CMM-MMC, P&W Ref. PN 2A4411 Chapters 79-11-41, 79-21-41, 79-22-41 and 79-22-43.
3. V2500 D5 Series CMM-MMC, P&W Ref. PN 2A4420 Chapters 79-11-41, 79-21-41, 79-22-41 and 79-22-43.
4. The following Repair Schemes will be revised to include the new parts introduced by this Service Bulletin: VRS5206, VRS5207, VRS5208, VRS5209, VRS5210, VRS5211, VRS5212, VRS5215, VRS5216, VRS5241, VRS5242, VRS5243, VRS5244, VRS5246, VRS5249, VRS5250, VRS5251, VRS5252, VRS5340, VRS5356, VRS5425, VRS5431, VRS5651, VRS5656.

Interchangeability of Parts

See Material Information for part interchangeability.

Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

Material Information

Material — Price and Availability

1. There is no kit provided to do this Service Bulletin.
2. Part availability information is provided in material data Instructions — Disposition.

Industry Support Program

Not Applicable.

The material data that follows is for each engine.

For V2500-A1 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4A7003R	1	*	TANK, ASSEMBLY OIL	4A7003 (79-11-41-01-001)	(F)(S2)(L)
4A7115A	1	*	PUMP AND FILTER ASSY OIL PRESS	4A7115 (79-21-41-01-001)	(F)(S2)(L)
4A7123A	1	*	PUMP ASSY OIL SCAVENGE	4A7123 (79-22-41-01-001)	(F)(S2)(L)
4W1249	8	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-055)	(B)(S2)(L)
4G0151	1	787.00	.COVER	4P7196 (72-60-03-01-650)	(B)(S2)(S6)(C1)
4G0145	2	72.00	.PLUG	AS15825 (72-60-03-01-850)	(B)(S2)(S6)(C)
4G0150	1	127.00	.PLUG	MS9954-09 (72-60-03-01-950)	(B)(S2)(S6)(C1)
4B7381	1	*	.DEAERATOR, A/O	4B7199 (79-11-41-01-240)	(F)(S2)(L)
4W0165 (79-11-41-01-355)	4	12.70	.BOLT, MACHINE DOUBLE HEX		(A)(S3)
MS9902-08	1	59.30	.PLUG, MACHINE THREAD	4B7097 (79-21-41-01-260)	(A)(S2)(L)
4P7383	1	520.00	..VALVE	4P7186 (79-21-41-01-610)	(B)(S2)(L)
			OR		
4P7383-01	Ref	520.00	..VALVE		(S5)
			OR		

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4P7383-02	Ref	520.00	..VALVE		(S5)
4A7304A	1	*	.CASING, ASSY OIL PUMP	4A7304 (79-21-41-01-750)	(B)(S2)(L)
4W1249	4	17.80	.BOLT, HEX HEAD	4P7026 (79-21-41-01-760)	(B)(S2)(L)
4P7374	1	17.80	.PLATE, IDENTIFICATION	4P7239 (79-21-41-01-850)	(B)(C)
4W1249	6	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-335)	(B)(S2)(L)
4B7385 (79-22-41-01-500)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7385CL01 (79-22-41-01-501)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7385CL02 (79-22-41-01-502)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7384 (79-22-41-01-507)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7384CL01 (79-22-41-01-508)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7384CL02 (79-22-41-01-509)	1	2279.00	.SPACER, ASSY CLASS		(B)
4A7033B	1	*	FILTER, ASSY OIL SCAVENGE	4A7033 (79-22-43-01-001)	(B)(S2)(L)
MS9902-08	1	59.30	.PLUG, MACHINE THREAD	MS9954-08 (79-22-43-01-120)	(A)(S2)(L)
AS3208-04	2	7.27	.PACKING	AS3208-04 (79-22-43-01-300)	(C)(S9)
4P7099	2	785.00	.ADAPTER, UNION	4P7099 (79-22-43-01-320)	(C)(S9)
4B7382	1	*	.HOUSING, A/O OIL FILTER	4B7215 (79-22-43-01-550)	(B)(S1)(L)
MS21209F4-15L	12	3.11	..INSERT	MS21209F4-15L (79-22-43-01-570)	(C)(S10)
Redundant Parts:					

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	4		.BOLT, MACHINE DOUBLE HEX	4W0165 (72-60-03-01-660)	(S4)
	1		.PACKING	AS3209-234 (72-60-03-01-670)	(C1)
	2		.NUT ASSY TUBE CLOSURE	AS15825 (72-60-03-01-800)	(C)
	1		.PACKING	AS3208-09 (72-60-03-01-940)	(C1)
	1		.PACKING	AS3209-113 (79-11-41-01-160)	(C)
	1		.PLUG	4P7237 (79-11-41-01-182)	(C)
	1		.NUT, ASSY	AS15826 (79-21-41-01-240)	(L)
	2		.PACKING	AS3208-04 (79-21-41-01-650)	(C)
	2		.ADAPTOR, UNION	4P7099 (79-21-41-01-660)	(C)
	1		.SPACER, A/O	4B7368 (79-22-41-01-197)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7368CL01 (79-22-41-01-198)	(L)
	1		.SPACER, ASSY CLASS	4B7368CL02 (79-22-41-01-199)	(L)
	1		.SPACER, A/O	4B7369 (79-22-41-01-225)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7369CL01 (79-22-41-01-226)	(L)
	1		.SPACER, ASSY CLASS	4B7369CL02 (79-22-41-01-227)	(L)
	1		.NUT, ASSY TUBE CLOSURE	AS15825 (79-22-43-01-322)	(C)

The material data that follows is for each engine.

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4A7004-01F	1	*	TANK, ASSEMBLY OIL	4A7004-01 (79-11-41-01-001)	(F)(S2)(L)
4A7110B	1	*	PUMP AND FILTER	4A7110 (79-21-41-01-001)	(B)(S2)(L)
4A7124A	1	*	PUMP ASSY OIL SCAVENGE	4A7124 (79-22-41-01-001)	(B)(S2)(L)
4W1249	6	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-055)	(B)(S2)(L)
4G0151	1	787.00	.COVER	4P7196 (72-60-03-01-650)	(B)(S2)(S6)(C1)
4G0145	2	72.00	.PLUG	AS15825 (72-60-03-01-850)	(B)(S2)(S6)(C)
4G0150	1	127.00	.PLUG	MS9954-09 (72-60-03-01-950)	(B)(S2)(S6)(C1)
4B7381	1	*	.DEAERATOR, A/O	4B7199 (79-11-41-01-240)	(F)(S2)(L)
4W0165 (79-11-41-01-355)	4	12.70	.BOLT, MACHINE DOUBLE HEX		(A)(S3)
MS9902-08	1	59.30	.PLUG, MACHINE THREAD	4B7097 (79-21-41-01-260)	(A)(S2)(L)
4P7383	1	520.00	..VALVE	4P7186 (79-21-41-01-610)	(B)(S2)(L)
			OR		
4P7383-01	Ref	520.00	..VALVE		(S5)
			OR		
4P7383-02	Ref	520.00	..VALVE		(S5)
4A7304A	1	*	.CASING, ASSY OIL PUMP	4A7304 (79-21-41-01-750)	(B)(S2)(L)
4W1249	4	17.80	.BOLT, HEX HEAD	4P7026 (79-21-41-01-760)	(B)(S2)(L)
4P7374	1	17.80	.PLATE, IDENTIFICATION	4P7239 (79-21-41-01-850)	(B)(C)

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4W1249	6	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-335)	(B)(S2)(L)
4B7385 (79-22-41-01-500)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7385CL01 (79-22-41-01-501)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7385CL02 (79-22-41-01-502)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7384 (79-22-41-01-507)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7384CL01 (79-22-41-01-508)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7384CL02 (79-22-41-01-509)	1	2279.00	.SPACER, ASSY CLASS		(B)
4A7033B	1	*	FILTER, ASSY OIL SCAVENGE	4A7033 (79-22-43-01-001)	(B)(S2)(L)
MS9902-08	1	59.30	.PLUG, MACHINE THREAD	MS9954-08 (79-22-43-01-120)	(A)(S2)(L)
AS3208-04	2	7.27	.PACKING	AS3208-04 (79-22-43-01-300)	(C)(S9)
4P7099	2	785.00	.ADAPTOR, UNION	4P7099 (79-22-43-01-320)	(C)(S9)
4B7382	1	*	.HOUSING, A/O OIL FILTER	4B7215 (79-22-43-01-550)	(B)(S1)(L)
MS21209F4-15L	12	3.11	..INSERT	MS21209F4-15L (79-22-43-01-570)	(C)(S10)
Redundant Parts:					
	4		.BOLT, MACHINE DOUBLE HEX	4W0165 (72-60-03-01-660)	(S4)
	1		.PACKING	AS3209-234 (72-60-03-01-670)	(C1)
	2		.NUT ASSY TUBE CLOSURE	AS15825 (72-60-03-01-800)	(C)
	1		.PACKING	AS3208-09 (72-60-03-01-940)	(C1)

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	1		.PACKING	AS3209-113 (79-11-41-01-160)	(C)
	1		.PLUG	4P7237 (79-11-41-01-182)	(C)
	1		.NUT, ASSY	AS15826 (79-21-41-01-240)	(L)
	2		.PACKING	AS3208-04 (79-21-41-01-650)	(C)
	2		.ADAPTOR, UNION	4P7099 (79-21-41-01-660)	(C)
	1		.SPACER, A/O	4B7368 (79-22-41-01-197)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7368CL01 (79-22-41-01-198)	(L)
	1		.SPACER, ASSY CLASS	4B7368CL02 (79-22-41-01-199)	(L)
	1		.SPACER, A/O	4B7369 (79-22-41-01-225)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7369CL01 (79-22-41-01-226)	(L)
	1		.SPACER, ASSY CLASS	4B7369CL02 (79-22-41-01-227)	(L)
	1		.NUT, ASSY TUBE CLOSURE	AS15825 (79-22-43-01-322)	(C)

The material data that follows is for each engine.

For V2525-D5, V2528-D5 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4G0151	1	787.00	.COVER	4P7196 (72-60-03-01-650)	(B)(S2)(S6)(C1)
4G0145	2	72.00	.PLUG	AS15825 (72-60-03-01-850)	(B)(S2)(S6)(C)
4G0150	1	127.00	.PLUG	MS9954-09 (72-60-03-01-950)	(B)(S2)(S6)(C1)

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4A7004-02F	1	*	TANK, ASSEMBLY OIL	4A7004-02 (79-11-41-01-001)	(F)(S2)(L)
4B7381	1	*	.DEAERATOR, A/O	4B7199 (79-11-41-01-240)	(F)(S2)(L)
4W0165 (79-11-41-01-355)	4	12.70	.BOLT MACHINE DOUBLE HEX		(S3)(A)
4A7111B	1	*	PUMP AND FILTER ASSY OIL PRESS	4A7111 (79-21-41-01-001)	(F)(S2)(L)
MS9902-08	1	59.30	.PLUG, MACHINE THREAD	4B7097 (79-21-41-01-260)	(A)(S2)(L)
4P7383	1	520.00	..VALVE	4P7186 (79-21-41-01-610)	(B)(S2)(L)
			OR		
4P7383-01	Ref	520.00	..VALVE		(S5)
			OR		
4P7383-02	Ref	520.00	..VALVE		(S5)
4A7304A	1	*	.CASING, ASSY OIL PUMP	4A7304 (79-21-41-01-750)	(B)(S2)(L)
4W1249	4	17.80	.BOLT, HEX HEAD	4P7026 (79-21-41-01-760)	(B)(S2)(L)
4P7374	1	17.80	.PLATE, IDENTIFICATION	4P7239 (79-21-41-01-850)	(B)(C)
4A7125A	1	*	PUMP ASSY OIL SCAVENGE	4A7125 (79-22-41-01-001)	(F)(S2)(L)
4W1249	8	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-055)	(B)(S2)(L)
4W1249	6	17.80	.BOLT, HEX HEAD	4P7026 (79-22-41-01-335)	(B)(S2)(L)
4B7385 (79-22-41-01-500)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7385CL01 (79-22-41-01-501)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7385CL02 (79-22-41-01-502)	1	2279.00	.SPACER, ASSY CLASS		(B)

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
4B7384 (79-22-41-01-507)	1	2279.00	.SPACER, A/O		(D)(S7)
4B7384CL01 (79-22-41-01-508)	1	2279.00	.SPACER, ASSY CLASS		(B)
4B7384CL02 (79-22-41-01-509)	1	2279.00	.SPACER, ASSY CLASS		(B)
4A7034A	1	*	FILTER, ASSY OIL SCAVENGE	4A7034 (79-22-43-01-001)	(F)(S2)(L)
MS9902-08	1	59.30	.PLUG MACHINE THREAD	MS9954-08 (79-22-43-01-120)	(A)(S2)(L)
AS3208-04	2	7.27	.PACKING	AS3208-04 (79-22-43-01-300)	(C)(S9)
4B7382	1	*	.HOUSING A/O OIL FILTER	4B7215 (79-22-43-01-550)	(B)(S1)(L)
MS21209F4-15L	12	3.11	..INSERT	MS21209F4-15L (79-22-43-01-570)	(C)(S10)
Redundant Parts:					
	4		.BOLT, MACHINE DOUBLE HEX	4W0165 (72-60-03-01-660)	(S4)
	1		.PACKING	AS3209-234 (72-60-03-01-670)	(C1)
	2		.NUT ASSY TUBE CLOSURE	AS15825 (72-60-03-01-800)	(C)
	1		.PACKING	AS3208-09 (72-60-03-01-940)	(C1)
	1		.PACKING	AS3209-113 (79-11-41-01-160)	(C)
	1		.PLUG	4P7237 (79-11-41-01-182)	(C)
	1		.NUT, ASSY	AS15826 (79-21-41-01-240)	(L)
	2		.PACKING	AS3208-04 (79-21-41-01-650)	(C)
	2		.ADAPTOR, UNION	4P7099 (79-21-41-01-660)	(C)

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	1		.SPACER, A/O	4B7368 (79-22-41-01-197)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7368CL01 (79-22-41-01-198)	(L)
	1		.SPACER, ASSY CLASS	4B7368CL02 (79-22-41-01-199)	(L)
	1		.SPACER, A/O	4B7369 (79-22-41-01-225)	(D)(L)
	1		.SPACER, ASSY CLASS	4B7369CL01 (79-22-41-01-226)	(L)
	1		.SPACER, ASSY CLASS	4B7369CL02 (79-22-41-01-227)	(L)
	1		.PACKING	AS3208-04 (79-22-43-01-310)	(C)
	1		.PLUG	MS9954-04 (79-22-43-01-322)	(F1)

Instructions/Disposition Code Statements:

Parts Modification Conditions

Estimated part prices are provided when they are available at time of publication. The Estimate of Unit Price is only for planning purposes and does not constitute a firm quotation. An asterisk (*) is shown where part pricing information was unavailable. In either case, contact IAE Spares for firm quotations.

Spare Parts Availability

(A) The new parts coded (A) are available for sale.

(B) The new part will be available approximately October 1st, 2014.

(C) The old part will continue to be supplied.

(C1) The old part will continue to be supplied for testing.

(D) The part coded (D) is a control drawing.

(F) The new part will be available on a full manufacturing lead time quote basis only.

(S1) The new parts coded (S1) can replace the old parts coded (S1) but not vice versa.

(S2) Old and new parts are fully interchangeable.

(S3) This part is transferred from Chapter 72-60-03.

(S4) This part is transferred to Chapter 79-11-41.

(S5) Alternative Part.

(S6) The new parts coded (S6) must not be used in any way for test.

(S7) The new parts coded (S7) must be fitted as a set.

(S9) The new quantity of this part is 2.

(S10) The new quantity of this part is 12.

(L) The old part will be supplied until supply is fully used.

(F1) The old part will continue to be supplied on a full manufacturing lead time quote basis only.

Vendor Services or Special Components/Materials

Not Applicable.

Tooling — Price and Availability

Support Equipment available before

Tool No.	Name	Manufacturer
IAE2P16602	TEST ADAPTER	IAE

Reidentified Parts

Not Applicable.

Other Material Information Data

Not Applicable.

Accomplishment Instructions

1. Rework Instructions

   A. None.

2. Instructions to incorporate Service Bulletin

   A. Partial embodiment of this Service Bulletin is allowed according to the Disposition code S1 in Material Information Section.

3. Preliminary Instructions to test the Oil Pressure Pump that incorporates this Service Bulletin.

   A. These instructions are applicable to Pump and Filter Assy Oil Pressure, PN 4A7115A (V2500-A1), PN 4A7110B (V2500-A5) and PN 4A7111B (V2500-D5).

   B. In order to perform Reference 2 or 3, CMM, Task 79-21-41-700-401 the following instructions must be followed to connect the pump assembly to the test rig and measure pressure P4.

      (1) Remove the plug (79-21-41-01-260A), discard the packing (79-21-41-01-250) if it is damaged or worn.

      (2) Install a packing in the groove of the adaptor part number IAE2P16602.

      (3) Install the adaptor part number IAE2P16602 in the plug seat. Torque between 54 and 60 lbf-in. (6.0 to 6.8 N-m).

      (4) Connect the pressure probe of the test rig to the adaptor on the pump. The thread of the adaptor is .4970-20 UNS-3A. Do not torque in excess of 60 lbf-in. (6.8 N-m).

      (5) After the test, disconnect the pressure probe. Remove the adaptor and discard the packing.

      (6) Install the plug (79-21-41-01-260A) with a new packing (79-21-41-01-250) on the pump. Torque between 54 and 70 lbf-in (6.0 to 8.0 N-m). Make sure that the maximum torque is not exceeded.

      (7) Lock the plug (79-21-41-01-260A) with the oil filter cover (79-21-41-01-300). Use CoMat 02-119 locking wire.

4. Instructions to incorporate the new spacers of this Service Bulletin to the Oil Scavenge Pump

   A. These instructions are applicable to Pump Assy Oil Scavenge, PN 4A7123 (V2500-A1), PN 4A7124 (V2500-A5) and PN 4A7125 (V2500-D5).

   B. Before disassembly, measure the static torque of the pump. Refer to SUBTASK 79-22-41-470-059.

      (1) If the torque is in excess of 450 lbf-in. (51.0 N-m) the pump must be fully disassembled. Refer to Reference 2 or 3, CMM, TASK 79-22-41-060-401, and subsequently to operations Step 4.D to Step 4.I of this section.

      (2) If the torque is less than 450 lbf-in. (51.0 N-m) the pump can be partially disassembled. Refer to operation (3) of this section.

   C. Refer to Reference 2 or 3, CMM, SUBTASK 79-22-41-060-051, and follow instructions (A) to (K) limited to the cover, gears and spacers located near the magnetic chip detector position of the pump. Refer to Figure 1.

D. To do the change of configuration required to introduce this Service Bulletin, the parts that must be replaced are those identified in Figure 1.

E. Discard the parts to be replaced with the new parts. Refer to Material Information section.

F. To assemble the pump, refer to Reference 2 or 3, CMM, TASK 79-22-41-460-401 and the relevant criteria for the selection of components. The current criteria are applicable to the spacers introduced by this Service Bulletin. Refer to Figure 2 to ensure the correctness of the reciprocal position of the new spacers, and the installation of the set of new spacers into the pump.

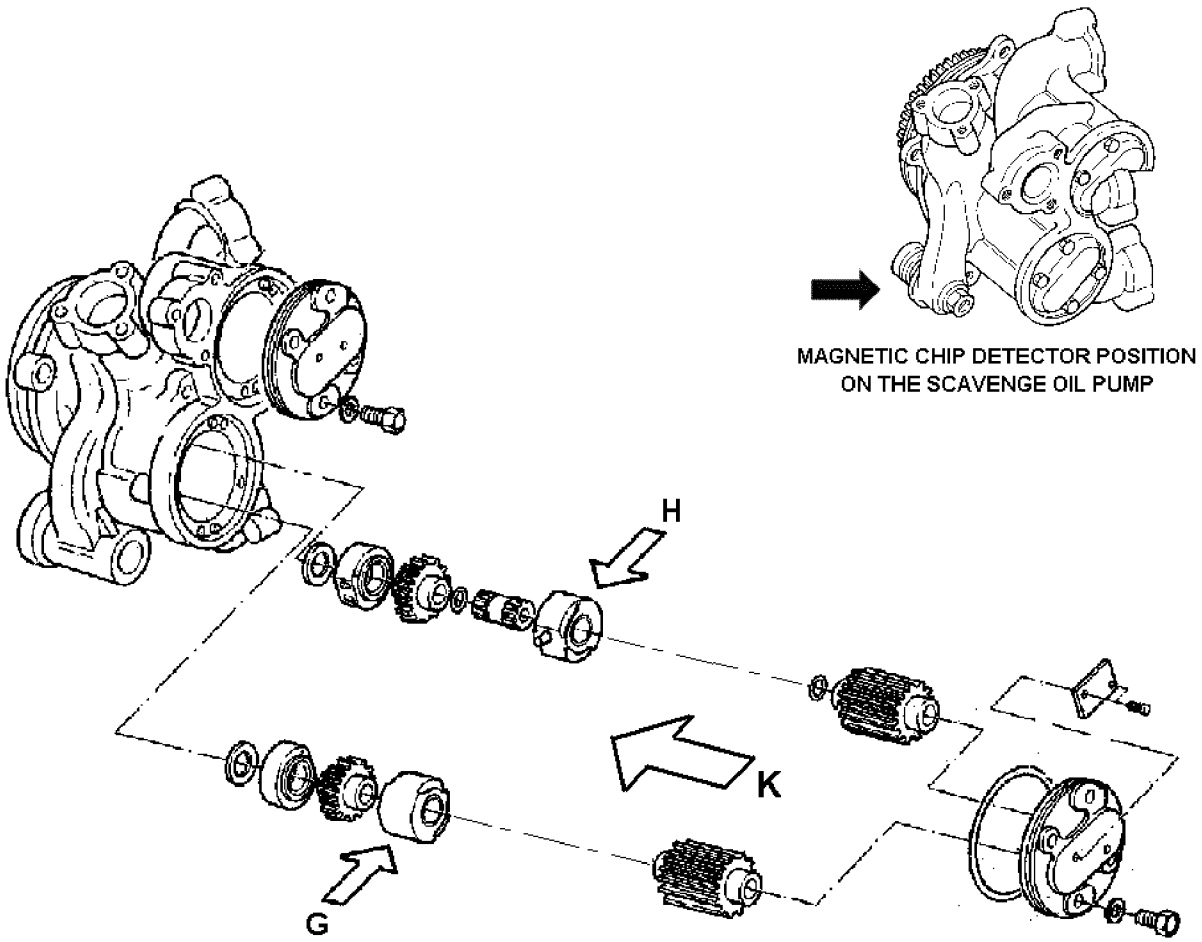
G. If the pump is fully disassembled, refer to TASK 79-22-41-460-401 to reassemble the pump. The static torque of the pump required by Reference 2 or 3, CMM, SUBTASK 79-22-41-470-059 must be less than or equal to 450 lbf-in. (51.0 N-m). Refer to TASK 79-22-41-700-401 to do the test of the pump.

H. If the pump is partially disassembled, refer Reference 2 or 3, CMM, only to the required SUBTASKS of TASK 79-22-41-460-401 to reassemble the pump. The static torque of the pump required by SUBTASK 79-22-41-470-059 must be less than or equal to 450 lbf-in. (51.0 N-m). Refer to TASK 79-22-41-700-401 to do the test of the pump.

I. Engrave the new part number of the pump and the serial number on a new plate. Attach the new plate to the pump.

5. Recording Instructions

A. A record of accomplishment of this Service Bulletin is required.



DETAIL G - OLD CONFIGURATION	
01-197	4B7368
01-198	4B7368CL01
01-199	4B7368CL02
DETAIL G - NEW CONFIGURATION	
01-507	4B7384
01-508	4B7384CL01
01-509	4B7384CL02

DETAIL H - OLD CONFIGURATION	
01-225	4B7369
01-226	4B7369CL01
01-227	4B7369CL02
DETAIL H - NEW CONFIGURATION	
01-500	4B7385
01-501	4B7385CL01
01-502	4B7385CL02

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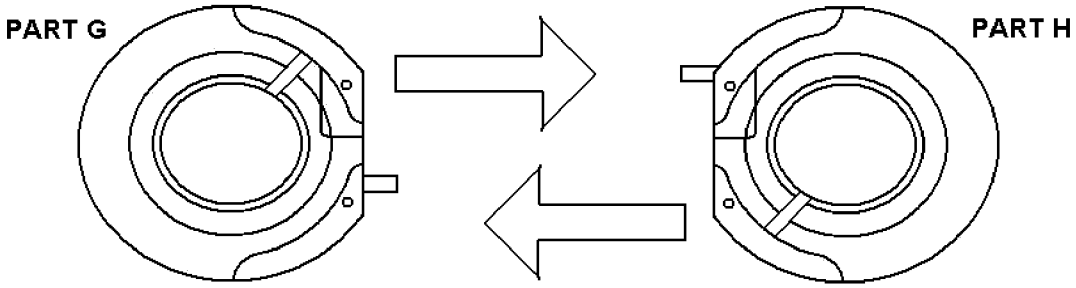
DETAILS OF NEW FIGURE-ITEMS OF THE SPACERS INTRODUCED BY THIS SERVICE BULLETIN TO THE OIL SCAVENGE PUMP
FIGURE 1



VIEW ON K

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DETAIL OF INSTALLATION OF THE SPACERS INTRODUCED BY THIS SERVICE BULLETIN TO THE OIL SCAVENGE PUMP
FIGURE 2

Appendix

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC10VF005 EC10VF005-01 EC10VF005-02 EC10VF005A	AC/IEL
1	EC10VF005-03	AC/RCM

Number values shown in parentheses adjacent to U.S. values are International System of units (SI) equivalents.

NOTE: In 2014 IAE converted the V2500 Technical Publications to a new system. As a result of the conversion, some manuals were consolidated. All manuals received new P&W part numbers. To facilitate the use of this Service Bulletin, the following Technical Publications cross reference table is provided.

Technical Publications Cross Reference Table

Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
ENGINE MANUAL — A1, A5	All	E-V2500-1IA	2A4407
CMM-EHC — A1, A5	All	EHC-V2500-1IA	2A4409
CMM-FN — A1, A5	All	FN-V2500-1IA	2A4410
CMM-MMC — A1, A5	All	MECH-V2500-1IA	2A4411
CMM-THD — A1, A5	All	THD-V2500-1IA	2A4412
TLM — A1, A5	All	T-V2500-1IA	2A4408
ENGINE MANUAL — D5	All	E-V2500-3IA	2A4416
CMM-EHC — D5	All	EHC-V2500-31A	2A4418
CMM-FN — D5	All	FN-V2500-3IA	2A4419
CMM-MMC — D5	All	MECH-V2500-3IA	2A4420
CMM-THD — D5	All	THD-V2500-3IA	2A4423
TLM	All	T-V2500-3IA	2A4417
SPPM (SPM) — D5	All	SPP-V2500-1IA	2A4414
EIPC — A1	V2500-A1102Q00	S-V2500-1IA	2A4427

Publication	Engine Model(s)	IAE IETM Pub Ref	P&W Part Number
EIPC — A5	V2522/V2524/V2527M-AQ02	S-V2500-6IA	2A4428
	V2522/V2524/V2527M-AQ03	S-V2500-6IB	
	V2522/V2524/V2527M-SQ02	S-V2500-6SA	
	V2522/V2524/V2527M-SQ03	S-V2500-6SB	
	V2522/V2524/V2527M-SQ04	S-V2500-6NA	
	V2522/V2524/V2527M-SQ05	S-V2500-6NB	
	V2527/V2527E-AQ02	S-V2500-7IA	
	V2527/V2527E-AQ03	S-V2500-7IB	
	V2527/V2527E-SQ02	S-V2500-7SA	
	V2527/V2527E-SQ03	S-V2500-7SB	
	V2527/V2527E-SQ04	S-V2500-7NA	
	V2527/V2527E-SQ05	S-V2500-7NB	
	V2530-AQ02	S-V2500-2IA	
	V2530-AQ03	S-V2500-2IB	
	V2530-SQ02	S-V2500-2SA	
	V2530-SQ03	S-V2500-2SB	
	V2530-SQ04	S-V2500-2NA	
	V2530-SQ05	S-V2500-2NB	
	V2533-AQ02	S-V2500-5IA	
	V2533-AQ03	S-V2500-5IB	
	V2533-SQ02	S-V2500-5SA	
	V2533-SQ03	S-V2500-5SB	
	V2533-SQ04	S-V2500-5NA	
	V2533-SQ05	S-V2500-5NB	
EIPC — D5	V2525/V2528-AQ02	S-V2500-3IA	2A4426
	V2525/V2528-AQ03	S-V2500-3IB	
	V2525/V2528-AQ04	S-V2500-3IC	