

International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: March 5, 1998

Subject: Transmittal of Revision 1 to Service Bulletin Number V2500-NAC-71-0135

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Aug. 07/95
Revision 1	Mar. 05/98

Reasons for Issuance of Revision

- (1) This service bulletin has been entirely re-written. The primary changes are as follows:
 - (a) Revision of the Effectivity statement in Paragraph 1.A.
 - (b) Revision of the Compliance Category statements in Paragraph 1.F.
 - (c) Clarification of the re-identification instructions.

Effect on Past Compliance

- (1) Operators must review the Effectivity statement on page 2, the Compliance Category requirements on page 6, and the re-identification instructions on page 15 to determine necessary action.

List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1 thru 23	1	Mar. 05/98

V2500-NAC-71-0135

Transmittal

Page 1 of 1



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

**NACELLE - POWER PLANT - FORWARD MOUNT INCREASED CLEARANCE MONOBALL STOP
AND INCREASED STRENGTH BOLT UPGRADE**

MODEL APPLICATION

V2500-A1, V2522-A5
V2524-A5, V2527-A5, V2527E-A5
V2530-A5, V2533-A5

BULLETIN INDEX LOCATOR

71-00-00

Compliance Category Code

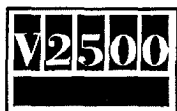
3 - V2500-A5
6 - V2500-A1

Internal Reference No.

JG/LL 91VN022, 93VN018, 97VN104

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 1 of 23



International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

1. Planning Information

A. Effectivity

(1) Airplane: Airbus A320-231

(a) Engine: V2500-A1

(b) Forward Engine Mount Assembly:

1 Forward engine mount assemblies with part number 740-2010-513 N or 740-2010-513 with a revision letter of "N" or later only require re-identification as instructed in Part 3 of the Accomplishment Instructions in this bulletin.

2 Forward engine mount assemblies with part numbers other than in 1 require Part 1 or Part 2 of this modification as determined from the results of the part number inspection.

NOTE: This service bulletin must be done for forward engine mounts which will or may be used on A5 engine applications and which are described in 2 above. This service bulletin is recommended for V2500-A1 forward engine mounts, at Category 6, but is not mandatory for V2500-A1.

(2) Airplane: Airbus A319-131,-132
Airbus A320-232,-233
Airbus A321-131
Airbus A321-231

(a) Engine: V2522-A5
V2524-A5
V2527-A5
V2527E-A5
V2530-A5
V2533-A5

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 2



International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

(b) Forward Engine Mount Assembly:

- 1 Forward engine mount assemblies with serial numbers 6611001 and above, which were delivered as components of EBU serial numbers 0311001 and above, do not require this service bulletin.

NOTE: The intent of this change has been incorporated prior to delivery on forward engine mount assemblies with serial numbers; 6571001, 6573001, 6575001, 6577001, 6579001, 6581001, 6583001, 6585001, 6593001, 6595001, 6597001, 6599001, 6603001, 6605001, 6607001, and 6609001. These forward engine mount assemblies were delivered as components of EBU serial numbers; 0295001, 0296001, 0297001, 0298001, 0299001, 300001, 301001, 302001, 303001, 304001, 305001, 306001, 307001, 308001, 309001, and 310001.

- 2 Forward engine mount assemblies with part number 745-2010-501 do not require this service bulletin.
- 3 Forward engine mount assemblies with part number 740-2010-513 N or 740-2010-513 with a revision letter of "N" or later only require re-identification as instructed in Part 3 of the Accomplishment Instructions in this bulletin.
- 4 Forward engine mount assemblies with part numbers other than in 3 require either Part 1 or Part 2 of this modification as determined from the results of the part number inspection.

NOTE: This service bulletin must be done for all forward engine mounts which are described in 4 above.



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

B. Concurrency Recommendations

If available, it is recommended you do Service Bulletin V2500-NAC-71-0210 at the same time as this service bulletin.

C. Reason

(1) Condition

Part 1 - The V2500-A1 forward engine mount assembly secondary load path does not meet the thrust load specification requirements of the V2500-A5 engine models.

Part 2 - The torque specification on some forward engine mount assembly monoball stop bolts, 121203-6H12, was not to the latest standard. The torque of the monoball stop bolts must be correct to ensure the secondary load path meets the thrust load specifications of the V2500-A5 engine models.

(2) Background

Part 1 - Certification tests and analysis have proven the V2500-A1 forward engine mount secondary load path does not meet the load specification requirements of the V2500-A5 engine models.

Part 2 - The manufacturer increased the torque requirement for the monoball stop bolts due to the increased thrust load design for the V2500-A5 forward engine mount assembly.

(3) Objective

Part 1 - To ensure the secondary load paths of all V2500 forward engine mounts which will be used on V2500-A5 engine models meet the thrust load specification of the V2500-A5 engine models in the event the primary load path is lost or compromised.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 4



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Part 2 - To re-torque the monoball stop bolts to the correct torque specification to ensure the secondary load path meets the thrust load specifications of the V2500-A5 engine models in the event the primary load path is lost or compromised.

(4) Substantiation

A fit check on two independent engine mock-ups demonstrated that the solution given in this Bulletin is satisfactory.

(5) Impact of Bulletin on Workshop Procedures:

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

(6) Supplemental Information

None

D. Description

Part 1 - Removes the forward engine mount monoball stop and associated hardware, and installs a new monoball stop with improved clearances, longer monoball stop-to-engine mount attach bolts installed with engine oil to increased torques, and new high strength monoball stop-to-engine attach bolts.

Part 2 - Removes the monoball stop bolts and monoball stop and reinstalls the same bolts lubricated with engine oil and tightened to increased torques.

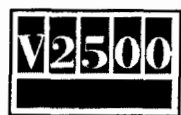
Part 3 - Re-identifies the forward engine mounts modified by this service bulletin and forward engine mounts that have part

August 7, 1995

Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 5



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

number 740-2010-513 N or part number 740-2010-513 with a revision letter of "N" or later.

E. Approval

The technical information, including design data, contained in the Service Bulletin has been approved under the authority of AIB Design Organisation Approval No F.JA.02 granted by the DGAC.

F. Compliance

Category 3 -V2500-A5 Engine Applications:

1. You must inspect all forward engine mount assemblies for correct part number at the next "A" check or first engine removal, whichever occurs first, as instructed in Paragraph 2.B.
2. For forward engine mount assemblies found to have part numbers other than 740-2010-513 N or part number 740-2010- 513 with a revision of "N" or later, which will be used on V2500-A5 engines, you must visually inspect the forward engine mount links for failure and do the modification procedures in this Service Bulletin within 2,250 cycles since the last inspection of the engine mount links or at the next engine removal, whichever occurs first.

Category 6 - V2500-A1 Engine Applications:

For forward engine mounts, other than those with part number 740-2010-513 N or part number 740-2010-513 with a revision of "N" or later, which are or will be used only on V2500-A1 engines, accomplish when the nacelle subassembly (i.e. accessories, components) is disassembled sufficiently to afford access to the affected part and to all affected spare parts. This service bulletin must be done for forward engine mounts which will or may be used on V2500-A5 applications as explained in the Category 3 compliance statement above.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 6



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

G. Manpower

Estimated Manhours to incorporate the full intent of this Bulletin:

VENUE	ESTIMATED MANHOURS
(1) In Service	Not Applicable
(a) To remove engine	17.0 M/Hrs
(b) To rework	1.0 M/Hrs
(c) To install engine	<u>17.0 M/Hrs</u>
Total	35.0 M/Hrs
VENUE	ESTIMATED MANHOURS
(2) In shop	
(a) To rework	<u>1.0 M/Hrs</u>
Total	1.0 M/Hrs

H. Material Cost and Availability

The parts to accomplish Part 1 of this Service Bulletin are available from the supplier as kit V2571135-551 at no cost to the operator.

Operators with units listed in Paragraph 1.A requiring Part 1 of this Service Bulletin should submit a no-charge purchase order for the applicable quantity of kits. The purchase order must specify this service bulletin number and only the parts listed herein. Operators will have one year from the issue date of the Service Bulletin to place an order. After one year, kits will no longer be available and Operators will have to order parts individually at catalog price, if they desire to incorporate the change.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 7



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Direct Purchase order to:

Rohr Inc.

850 Lagoon Drive

Chula Vista, CA 91910-2098

U.S.A.

Attn: Airline Support Manager, MZ -107A
(Ref. Service Bulletin No V2500-NAC-71-0135)

I. Tooling -Cost and Availability

None Required

J. Weight and Balance

- (1) Weight change None
- (2) Moment arm No effect
- (3) Datum Engine Front Mount
Centerline (Powerplant Station PPS 100.00)

K. Electrical Load Data

Not Affected

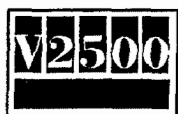
L. References

IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)	70-09-00
A320/A321 Aircraft Maintenance Manual	71-00-20
A320/V2500-A1/A320/A321/V2500-A5 Engine Manual (E-V2500-1IA)	71-00-32
Airbus Industrie Service Bulletin	A320-71-1021
Aircraft Modification No. 27020	
Overhaul Processes and Consumable Index (PCI-V2500-1IA)	

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 8



**International
Aero Engines**

V2500 Propulsion System — Nacelle

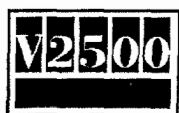
SERVICE BULLETIN

M. Other Publications Affected

A320/V2500A1 Power Plant Illustrated Parts Catalog (PIP-V2500-1IA)	71-21-12
A320/A321/V2500A5 Power Plant Illustrated Parts Catalog (PIP-V2500-2IA)	71-21-12
A320/V2500-A1 Engine Illustrated Parts Catalog (S-V2500-1IA)	71-21-12
A320/V2500-A5 Engine Illustrated Parts Catalog (S-V2500-2IA)	71-21-12
A320/V2500A1 Power Plant Build-Up Manual (PPB-V2500-1IA)	71-00-02
A320/A321/V2500A5 Power Plant Build-Up Manual (PPB-V2500-2IA)	71-00-02

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 9



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

2. Accomplishment Instructions

A. For forward engine mount assemblies which are or will be used only on V2500-A1 engines, determine which parts of this Service Bulletin must be done. Refer to Figures 1 and 2.

- (1) If the forward engine mount assembly part number is 740-2010-513 N, or 740-2010-513 with a revision of "N" or later, it is only necessary to do the re-identification as instructed in Part 3 of this service bulletin.
- (2) If the forward engine mount assembly part number is 740-2010-513 but does not have the letter "N" or a revision of "N" or later, you must do Parts 2 and 3 of this service bulletin.
- (3) If the forward engine mount assembly part number is other than 740-2010-513, you must do Parts 1 and 3 of this service bulletin.
- (4) If you cannot find a part number on the forward engine mount assembly, remove the monoball stop as instructed in Part 1 of this service bulletin and inspect the monoball stop part number as follows:

NOTE: If the engine is installed, it is necessary to remove the engine to do this inspection. Refer to the A320/A321 Aircraft Maintenance Manual TASK 71-00-20-000-010.

- (a) If the monoball stop part number is 740-2055-501, install the monoball stop as instructed in Part 2 of this service bulletin and re-identify the mount as instructed in Part 3.
- (b) If the monoball stop part number is 740-2017-503, install the 740-2055-501 monoball stop as instructed in Part 1 of this service bulletin and re-identify the mount as instructed in Part 3.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 10



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

(c) If you cannot find a monoball stop part number, measure the monoball stop as shown in Figure 3.

- 1 If the monoball stop dimension X measurement is 0.836 inch (21.23 mm), re-install the monoball stop as instructed in Part 2 of this service bulletin and re-identify the mount as instructed in Part 3.
- 2 If the monoball stop dimension X measurement is 0.730 inch (18.54 mm), replace with the 740-2055-501 monoball stop as instructed in Part 1 of this service bulletin and re-identify the mount as instructed in Part 3.

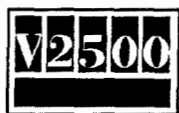
B. For forward engine mount assemblies which are or will be used on V2500-A5 engines, determine which parts of this Service Bulletin must be done. Refer to Figures 1 and 2.

- (1) If the forward engine mount assembly part number is 740-2010-513 N, or 740-2010-513 with a revision of "N" or later, it is only necessary to do the re-identification as instructed in Part 3 of this service bulletin.
- (2) If the forward engine mount assembly part number is other than in 2.B.(1) or you cannot find a part number, you must inspect the forward engine mount links immediately as instructed in paragraph 2.B.(3).
- (3) Visually inspect the forward engine mount links, 740-2018-501 and 740-2018-502 for cracks or failure. Use a mirror to inspect all sides of the links in the areas indicated in Figure 4. Do not remove the links to do this inspection.
 - (a) If any link is bad, and the engine mount part number is 740-2010-513 but without the letter "N" or a revision of "N" or later, you must replace the bad link(s) (Refer to the Engine Manual TASKs 71-21-12-030-001 and 71-21-12-430-001) and do Parts 2 and 3 of this service bulletin.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 11



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

- (b) If any link is bad, and the engine mount part number is other than 740-2010-513, you must replace the bad link(s) (Refer to the Engine Manual TASKs 71-21-12-030-001 and 71-21-12-430-001) and do Parts 1 and 3 of this service bulletin.
- (c) If any link is bad, and you cannot find a part number on the forward engine mount assembly, you must replace the bad link(s) (Refer to the Engine Manual TASKs 71-21-12-030-001 and 71-21-12-430-001) and do the procedures in paragraph 2.B.(4).

NOTE: If available, it is recommended you incorporate Service Bulletin V2500-NAC-71-0210, which replaces the links, at the same time as this bulletin.

- (d) If the links are good, and the forward engine mount assembly part number is 740-2010-513 but does not have the letter "N" or a revision of "N" or later, you must do Parts 2 and 3 of this service bulletin within 2,250 cycles or at the first engine removal, whichever occurs first.
- (e) If the links are good, and the forward engine mount assembly part number is other than 740-2010-513, you must do Parts 1 and 3 of this service bulletin within 2,250 cycles or at the first engine removal, whichever occurs first.
- (f) If the links are good, and you cannot find a part number on the forward engine mount assembly go to paragraph 2.B.(4).

NOTE: If available, it is recommended you incorporate Service Bulletin V2500-NAC-71-0210, which replaces the links, at the same time as this bulletin.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 12



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

- (4) If you cannot find a part number on the forward engine mount assembly, remove the monoball stop as instructed in Part 1 of this service bulletin and inspect the monoball stop part number as follows:

NOTE: If the engine is installed, it is necessary to remove the engine to do this inspection. Refer to the A320/A321 Aircraft Maintenance Manual TASK 71-00-20-000-010.

- (a) If the monoball stop part number is 740-2055-501, install the monoball stop as instructed in Part 2 of this service bulletin and re-identify the mount as instructed in Part 3.
- (b) If the monoball stop part number is 740-2017-503, install the 740-2055-501 monoball stop as instructed in Part 1 of this service bulletin and re-identify the mount as instructed in Part 3.
- (c) If you cannot find a monoball stop part number, measure the monoball stop as shown in Figure 3.

1 If the monoball stop dimension X measurement is 0.836 inch (21.23 mm), re-install the monoball stop as instructed in Part 2 of this service bulletin and re-identify the mount as instructed in Part 3.

2 If the monoball stop dimension X measurement is 0.730 inch (18.54 mm), replace with the 740-2055-501 monoball stop as instructed in Part 1 of this service bulletin and re-identify the mount as instructed in Part 3.

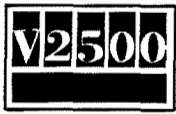
C. Part 1 - Modification Instructions

NOTE: If the engine is installed on the aircraft, remove the engine to do this part of the service bulletin. Refer to the A320/A321 Aircraft Maintenance Manual TASK 71-00-20-000-010.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 13



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

- (1) Remove the forward engine mount from the engine. Refer to the A320/V2500-A1/A320/A321/V2500-A5 Engine Manual, Task 71-00-32-350-001. Discard the six 121203-7H7 bolts. Keep the washers.
- (2) Remove the lockwire, four bolts 121203-6H10, four washers VN936NP6C and the monoball stop. Discard the bolts and monoball stop. Keep the washers. Refer to Figure 1.

CAUTION: YOU MUST EXAMINE THE THREADS OF THE ENGINE MOUNT FOR AND REMOVE, UNWANTED MATERIAL BEFORE YOU INSTALL THE MONOBALL STOP. IF YOU DO NOT DO THIS, THE THREADS OF THE ENGINE MOUNT CAN GET DAMAGED.

- (3) Examine the engine mount threads for, and remove, unwanted material.

CAUTION: USE ONLY APPROVED ENGINE OILS (COMAT 10-077). IF YOU DO NOT DO THIS, THE THREADS OF THE ENGINE MOUNT CAN GET DAMAGED.

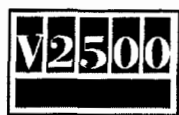
- (4) Install the monoball stop 740-2055-501 with four bolts 121203-6H12 and washers VN936NP6C. Lubricate the bolts with CoMat 10-077 engine oil. Torque the bolts to 520-630 lb-in. (58.7-71.2 N.m).
- (5) Safety the bolts with lockwire (CoMat 02-147).
- (6) Re-identify the forward engine mount assembly as instructed in Part 3 of this service bulletin.
- (7) A record of accomplishment is required. Note in the aircraft log that Service Bulletin V2500-NAC-71-0135, Part 1 has been incorporated.

D. Part 2 - Modification Instructions

NOTE: If the engine is installed on the aircraft, remove the engine to do this part of the service bulletin. Refer to the A320/A321 Aircraft Maintenance Manual TASK 71-00-20-000-010.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 14



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

- (1) Remove the forward engine mount from the engine. Refer to the A320/V2500-A1/A320/A321/V2500-A5 Engine Manual, Task 71-00-32-350-001. Keep the bolts and washers.
- (2) Remove the lockwire, four bolts 121203-6H12, four washers VN936NP6C and the monoball stop. Keep the bolts, the washers and the monoball stop. Refer to Figure 2.

CAUTION: YOU MUST EXAMINE THE THREADS OF THE ENGINE MOUNT FOR AND REMOVE, UNWANTED MATERIAL BEFORE YOU INSTALL THE MONOBALL STOP. IF YOU DO NOT DO THIS, THE THREADS OF THE ENGINE MOUNT CAN GET DAMAGED.

- (3) Examine the engine mount threads for, and remove, unwanted material.

CAUTION: USE ONLY APPROVED ENGINE OILS (COMAT 10-077). IF YOU DO NOT DO THIS, THE THREADS OF THE ENGINE MOUNT CAN GET DAMAGED.

- (4) Install the monoball stop 740-2055-501 with the bolts 121203-6H12 and washers VN936NP6C. Lubricate the bolts with CoMat 10-077 engine oil. Torque the bolts to 520-630 lb-in. (58.7-71.2 N.m).
- (5) Safety the bolts with lockwire (CoMat 02-147).
- (6) Re-identify the forward engine mount assembly as instructed in Part 3 of this service bulletin.
- (7) A record of accomplishment is required. Note in the aircraft log that Service Bulletin V2500-NAC-71-0135, Part 2 has been incorporated.

E. Part 3 - Re-Identification Instructions

CAUTION: DO NOT USE METAL STAMP OR VIBROETCH METHOD TO MAKE A MARK ON THE FORWARD ENGINE MOUNT ASSEMBLY.

- (1) Change the identification of the forward engine mount

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 15



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

assembly as follows. Use the electroetch method as instructed in the IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA) chapter 70-09-00. Make the electroetch marks 0.002-0.003 inch (0.051-0.076 mm) deep. Do not use metal stamp or vibroetch methods to make a mark on the engine mount:

- (a) Make "XXXX" marks over the old part number.
- (b) Identify the forward engine mount assembly as 740-2010-517. Put the new part number near the old part number.
- (c) Mark service bulletin number V2500-NAC-71-0135 REV 1 on the mount assembly near the new part number.

F. Post-requisite Instructions

- (1) Install the forward engine mount assembly 740-2010-517 on the engine with the six bolts 275B0307-7H and washers. Lubricate the bolts with engine oil (CoMat 10-077). Torque the bolts to 500-550 lb-in (56.5-62.2 Nm). Safety the bolts with lockwire (CoMat 02-147). Refer to the A320/V2500-A1/A320/A321/V2500-A5 Engine Manual, Task 71-00-32-350-001.
- (2) If you removed the engine to do this service bulletin, install the engine. Refer to the A320/A321 Aircraft Maintenance Manual TASK 71-00-20-400-010.

G. Quick Engine Change (QEC) Kits and Spare Forward Engine Mounts

- (1) For engine mounts which will only be used on V2500-A1 engines, do the forward engine mount part number inspection as instructed in paragraph 2. A. of this service bulletin.
- (2) For engine mounts which will or may be used on V2500-A5 engines, do the forward engine mount part number inspection as instructed in Paragraph 2.B. of this service bulletin.

August 7, 1995

Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 16



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

- (3) Based upon the results of the inspection in paragraph 2.A. or 2.B.:
 - (a) Incorporate the appropriate Part(s) of this Service Bulletin. Use kit V2571135-551 if required. Note in the QEC kit log and/or other applicable records that Service Bulletin V2500-NAC-71-0135, Parts 1 or 2, and 3 have been incorporated in the QEC kit.

August 7, 1995
Revision 1 - March 5, 1998

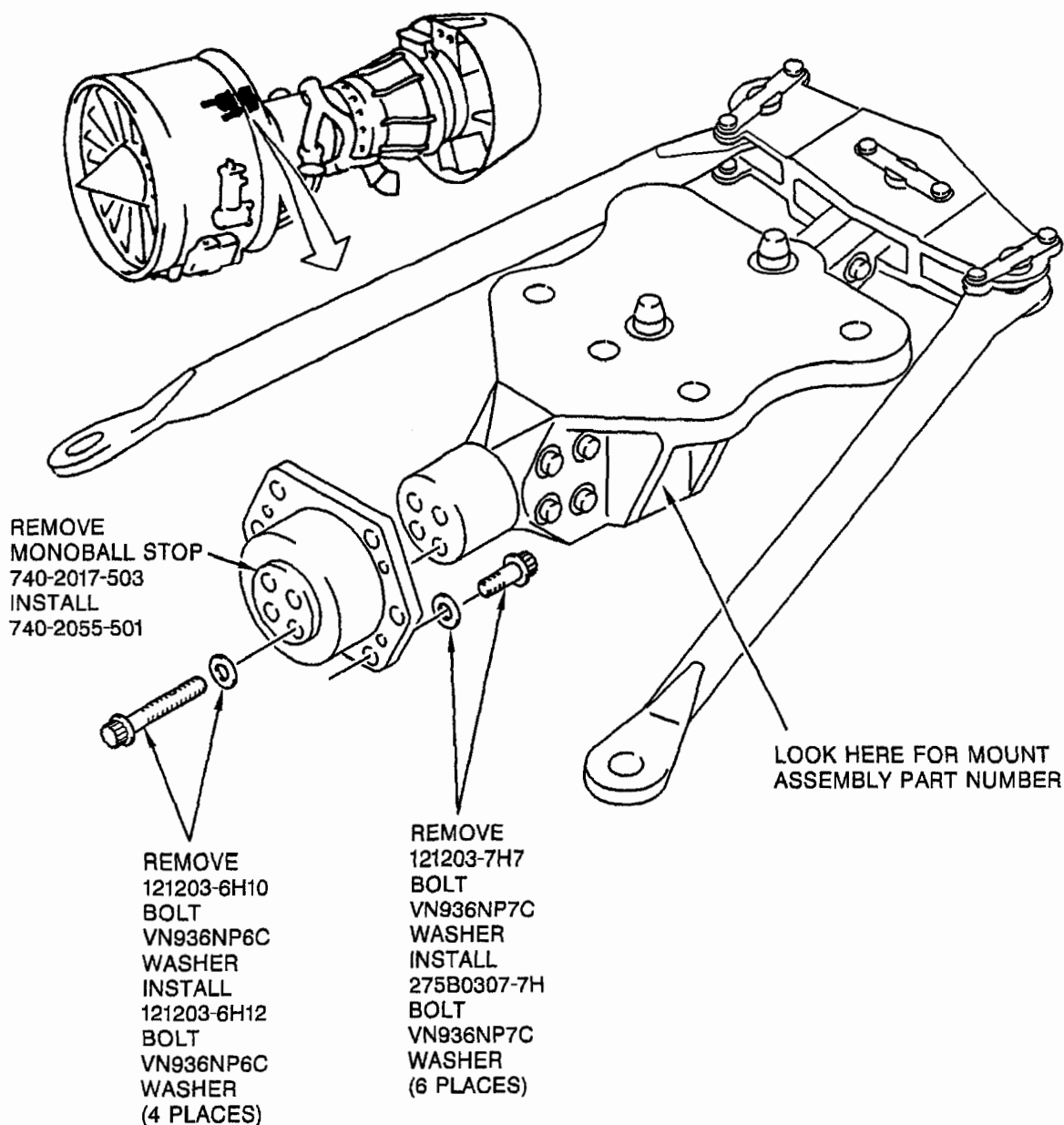
V2500-NAC-71-0135
Page 17



International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN



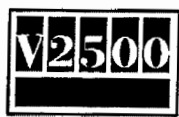
VSB547

Replacement of Engine Mount Bolts and Monoball Stop
Figure 1

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

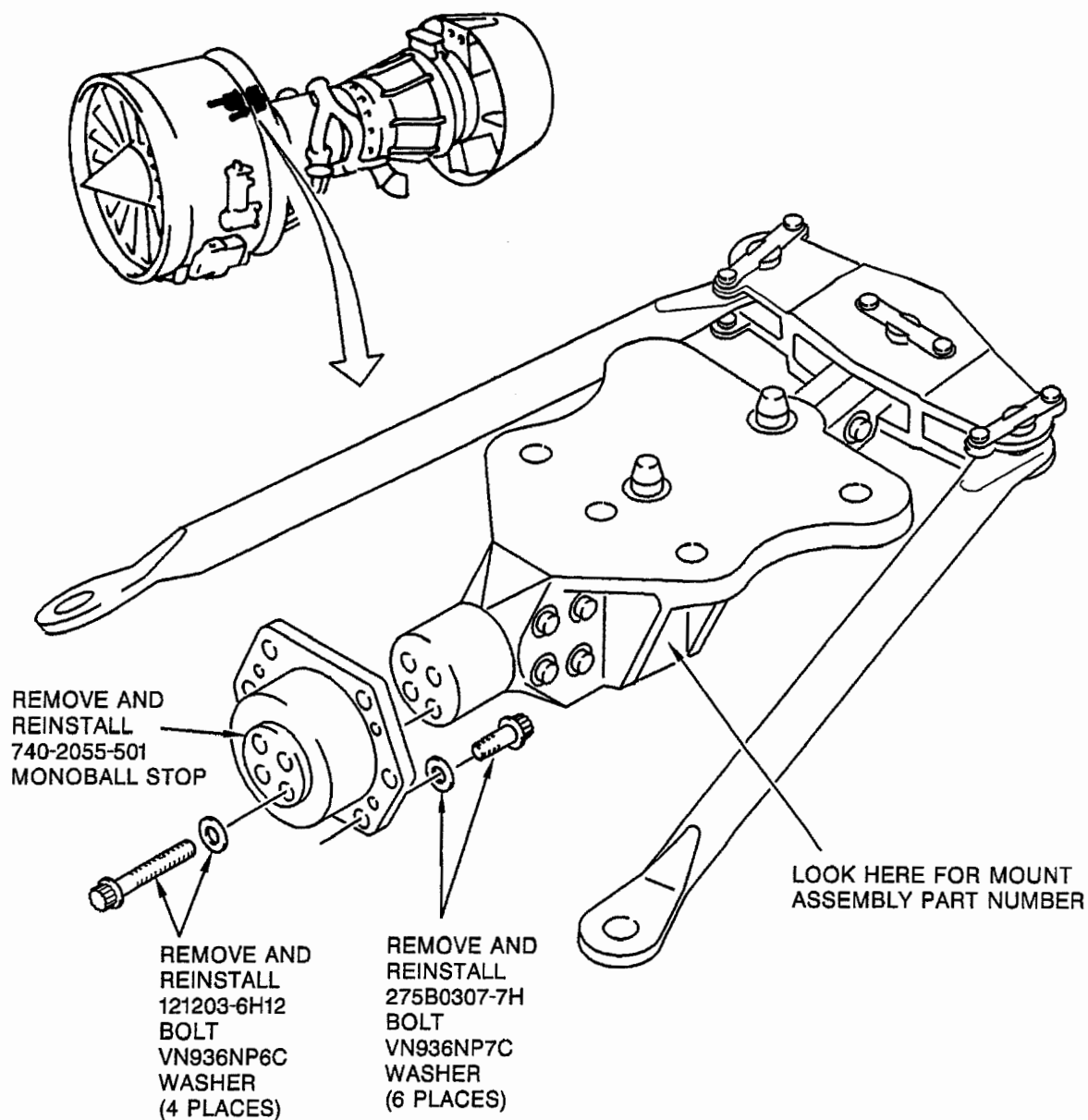
Page 18



International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN



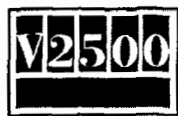
VSB548

Engine Mount Bolts Intallation and Re-Torque
Figure 2

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

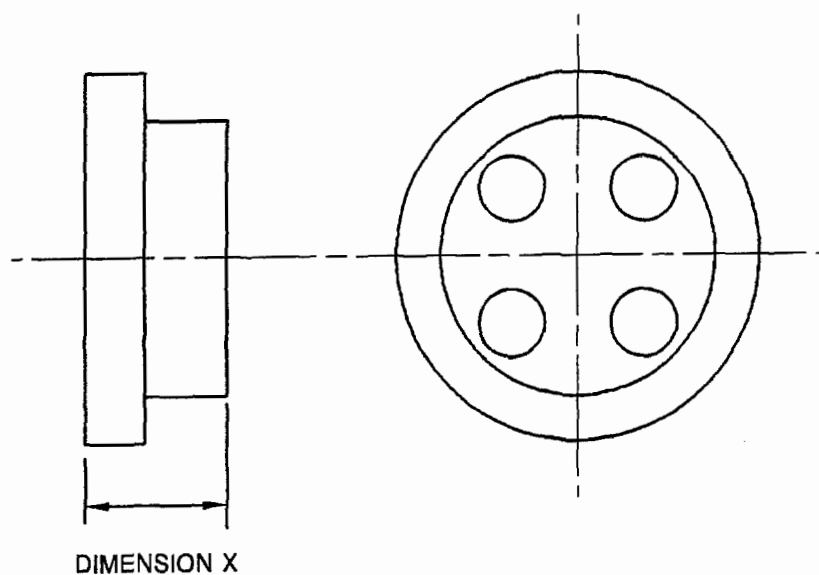
Page 19



International
Aero Engines

V2500 Propulsion System — Nacelle

SERVICE BULLETIN



MONOBALL STOP

VSB549

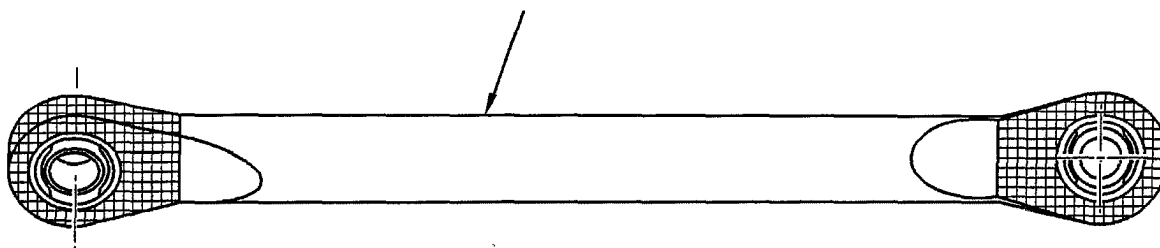
Monoball Stop Dimension Check
Figure 3

August 7, 1995
Revision 1 - March 5, 1998

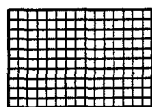
V2500-NAC-71-0135
Page 20

SERVICE BULLETIN

740-2018-501 (740-2018-502 OPPOSITE)
FORWARD ENGINE MOUNT LINK



INSPECT FOR CRACKS OR FAILURE
IN THESE AREAS OF THE LINKS
(LINK SHOWN REMOVED FOR CLARITY)



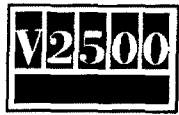
VSB578

Visual Inspection of the Forward Engine Mount Link
Figure 4

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 21



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

3. Material Information

NEW PART NO. (ATA NO)	EST'D UNIT QTY PRICE (\$)	KEYWORD	OLD PART NO. (IPC NO.)	INSTR/ DISPOS
--------------------------	------------------------------	---------	---------------------------	------------------

Applicability: For each V2500 Nacelle to incorporate this Service Bulletin.

A. Kits associated with this Bulletin:

V2571135-551	1	Kit		(A)
Consisting of:				
740-2055-501	1	Stop	740-2017-503	
275B0307-7H	6	Bolt	121203-7H7	
121203-6H12	4	Bolt	121203-6H10	

B. Parts affected by this Bulletin:

740-2010-517	1	Mount Assy	740-2010-507	(S1)(S2)
			740-2010-509	(2D)
			740-2010-511	
			740-2010-513	
(71-21-12)			(01-010)	
275B0307-7H	6	Bolt	121203-7H7	(B)(S1)
(71-21-12)			(01-080)	(S2)(1D)
740-2055-501	1	Stop	740-2017-503	(B)(S1)
(71-21-12)			(01-100)	(S2)(1D)
121203-6H12	4	Bolt	121203-6H10	(B)(S1)
(71-21-12)			(01-110)	(S2)(1D)

C. Instruction/Disposition Code Statements:

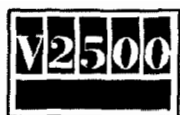
(A) Kit is available.

(B) New part supplied as detail of the Kit.

(1D) Discard old part.

August 7, 1995
Revision 1 - March 5, 1998

V2500-NAC-71-0135
Page 22



**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

(2D) Rework old part to the new configuration.

(S1) New parts coded S1 must replace old parts coded S1 as a complete set.

(S2) New part may be used in place of old part, but not vice versa.

D. Materials Required to Incorporate This Service Bulletin:

CoMat 02-147

Lockwire

CoMat 10-077

Approved Engine Oil

NOTE: To identify the consumable materials, refer to the Overhaul Processes and Consumable Index PCI-V2500-1IA.

August 7, 1995

Revision 1 - March 5, 1998

V2500-NAC-71-0135

Page 23