

**International
Aero Engines**

V2500 Propulsion System — Nacelle

SERVICE BULLETIN

Date: August 6, 1997

Subject: Transmittal of Revision 2 to Service Bulletin Number V2500-NAC-75-0058

Service Bulletin Revision History:

<u>Event</u>	<u>Date</u>
Basic Issue	Dec. 02/96
Revision 1	May 21/97
Revision 2	Aug. 06/97

Reasons for Issuance of Revision

(1) To revise the new back-up ring part number from 740-0364-1 to 740-0364-7.

Effect on Past Compliance

(1) None.

List of Effective Pages:

<u>Page No.</u>	<u>Rev. No.</u>	<u>Date</u>
1	2	Aug. 06/97
2 thru 6	Basic	Dec. 02/96
7	2	Aug. 06/97
8 and 9	Basic	Dec. 02/96
10 thru 12	2	Aug. 06/97
13	1	May 21/97

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Transmittal

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NACELLE - EXHAUST - SEAL, ACAC DUCT -
REPLACEMENT OF

MODEL APPLICATION

V2500-A1/A5

BULLETIN INDEX LOCATOR

75-00-00

Compliance Category Code

6

Internal Reference No.

JG/LL 93VN016

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1. Planning Information

A. Effectivity

(1) Aircraft:

(a) Airbus A320

(b) Airbus A321

(2) Nacelle: (a) V2500-A1 engine buildup units serial numbers and cum units prior to 0319001.

(b) V2500-A5 engine buildup units serial numbers prior to 0206001.

B. Concurrency Requirements

Service Bulletin V2500-NAC-75-0062 must be incorporated prior to or concurrent with this Service Bulletin.

C. Reason

(1) Condition

The air cooled air cooler (ACAC) exhaust duct support ring may not provide adequate support for the exhaust duct.

(2) Background

Operators have experienced support ring failure.

(3) Objective

Modify the way the ACAC exhaust duct is supported to prevent failure of the support ring.

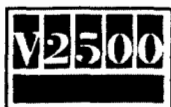
(4) Substantiation

Testing of the modified support ring and support ring housing has been successful.

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(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

- (1) The change introduced by this Service Bulletin is as follows:

Remove the ACAC exhaust duct housing. Grind the flange from the duct. Remove the support ring, drill holes through the housing, and install a new support ring and backup ring in the housing.

E. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification which is under DGAC (Direction Generale de l'Aviation Civile -France) approval.

F. Compliance

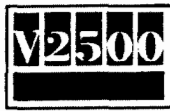
Category 6

Accomplish when the Nacelle or system is disassembled sufficiently to afford access to the affected subassembly (i. e., accessories, components) and to all affected spare subassemblies.

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G. Manpower

Estimated manhours to incorporate the intent of this Bulletin on each engine buildup unit:

VENUE	ESTIMATED MANHOURS
(1) In Service	Not Applicable
(2) In shop	
(a) To rework	<u>3.0 M/Hrs</u>
Total	3.0 M/Hrs

H. Material Cost and Availability

The parts to accomplish this Service Bulletin are available from the supplier as kit V2575058-551.

Formal prices and delivery schedules will be furnished to operators upon receipt of their written request. (Prices shown in Paragraph 3, "Material Information", are listed for planning purposes only, and are subject to change without notice.

Direct Purchase order to:
Rohr Inc.
850 Lagoon Drive
Chula Vista, CA 91910-2098
U.S.A.

Attn: Airline Support Manager -Bldg. 107A
 (Ref. Service Bulletin No. V2500-NAC-75-0058)

I. Tooling -Cost and Availability

None Required.

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J. Weight and Balance

- (1) Weight changeNegligible
- (2) Moment armNo effect
- (3) DatumEngine Front Mount Centerline
.....(Power Plant Station (PPS) 188.05)

K. Electrical Load Data

Not Affected.

L. References

Chapter/Section

IAE V2500 Standard Practices/Processes Manual 70-09-00

Overhaul Processes and Consumable Index
(PCI-V2500-1IA)

M. Other Publications Affected

A320/A321 Aircraft Maintenance Manual 78-11-11

A320/V2500-A1 Engine Illustrated Parts Catalog 75-22-48
(S-V2500-1IA)

A320/V2500-A5 Engine Illustrated Parts Catalog 75-22-48
(S-V2500-2IA)

A320/V2500A1 Power Plant Illustrated Parts 75-22-48
Catalog (PIP-V2500-1IA)

A320/A321/V2500A5 Power Plant Illustrated Parts 75-22-48
Catalog (PIP-V2500-2IA)

A320/V2500A1 Power Plant Build-Up Manual 71-00-02
(PPB-V2500-1IA)

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2. Accomplishment Instructions

A. Pre-requisite Instructions

None.

B. Rework and Modification Instructions

- (1) Remove the 740-1085-501 housing and S700S1085-1 support ring from the ACAC duct. Discard the support ring. Refer to Figure 1.
- (2) Remove the flange from the duct with a grinder so that any remaining flange material is no more than 0.010 inch (0.25 mm) above the adjacent surfaces of the duct. Refer to Figure 1. Remove all burrs and sharp edges.
- (3) Identify the modified 740-0361-507 duct as the 740-0361-509 duct with electroetch or vibroetch method. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (4) Mark two hole locations on the 740-1085-501 housing. Refer to Figure 2.
- (5) Drill two 0.218-0.229 inch (5.54-5.82 mm) holes in the 740-1085-501 housing at the marked locations. Remove the burrs from the drilled holes.
- (6) Identify the drilled 740-1085-501 housing as the 740-1085-503 housing with ink (CoMat 06-073) and a rubber stamp. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (7) Put the 740-0364-7 backup ring, the S700S1085-2 support ring, and 740-1085-503 housing on the ACAC duct.

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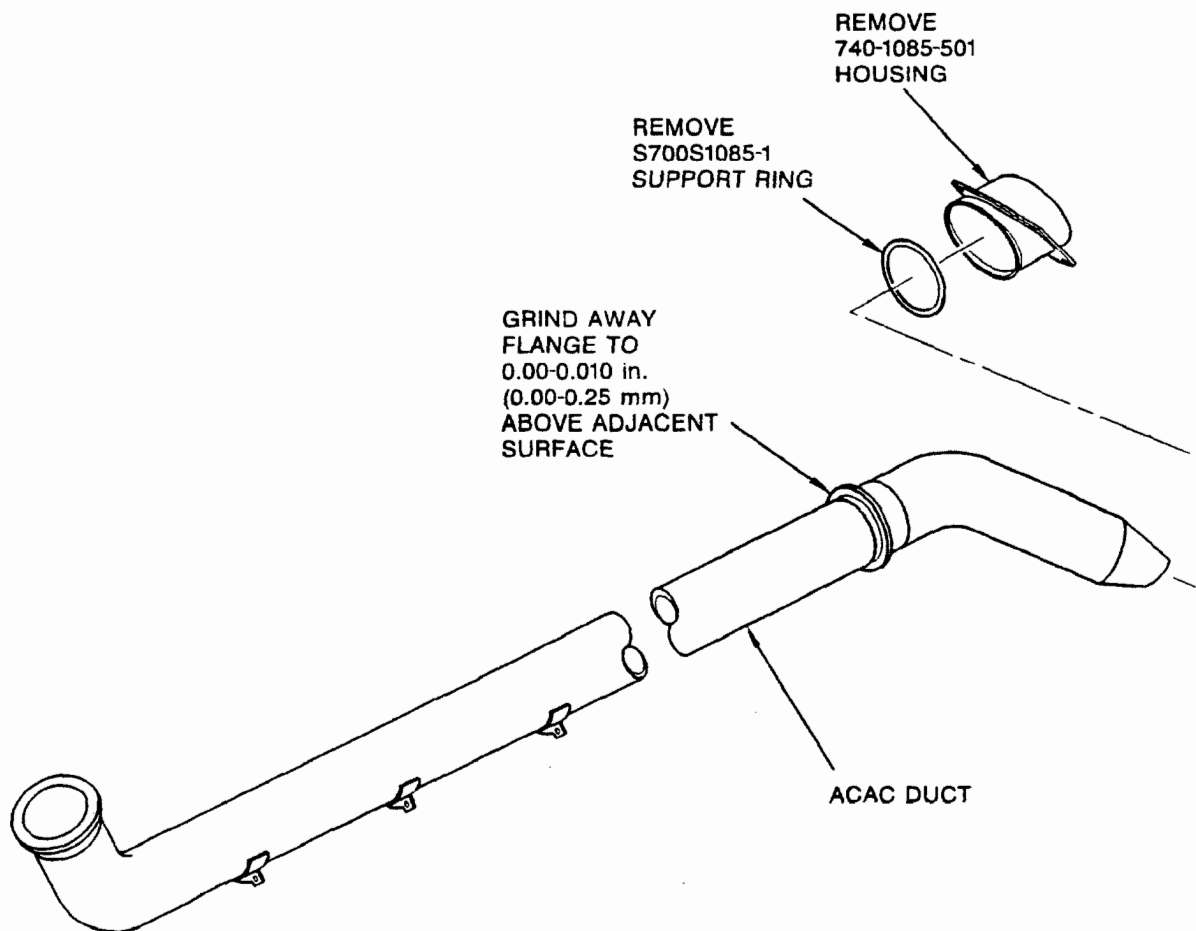
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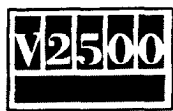
VSB445

Removal Of ACAC Duct Flange.
Figure 1.

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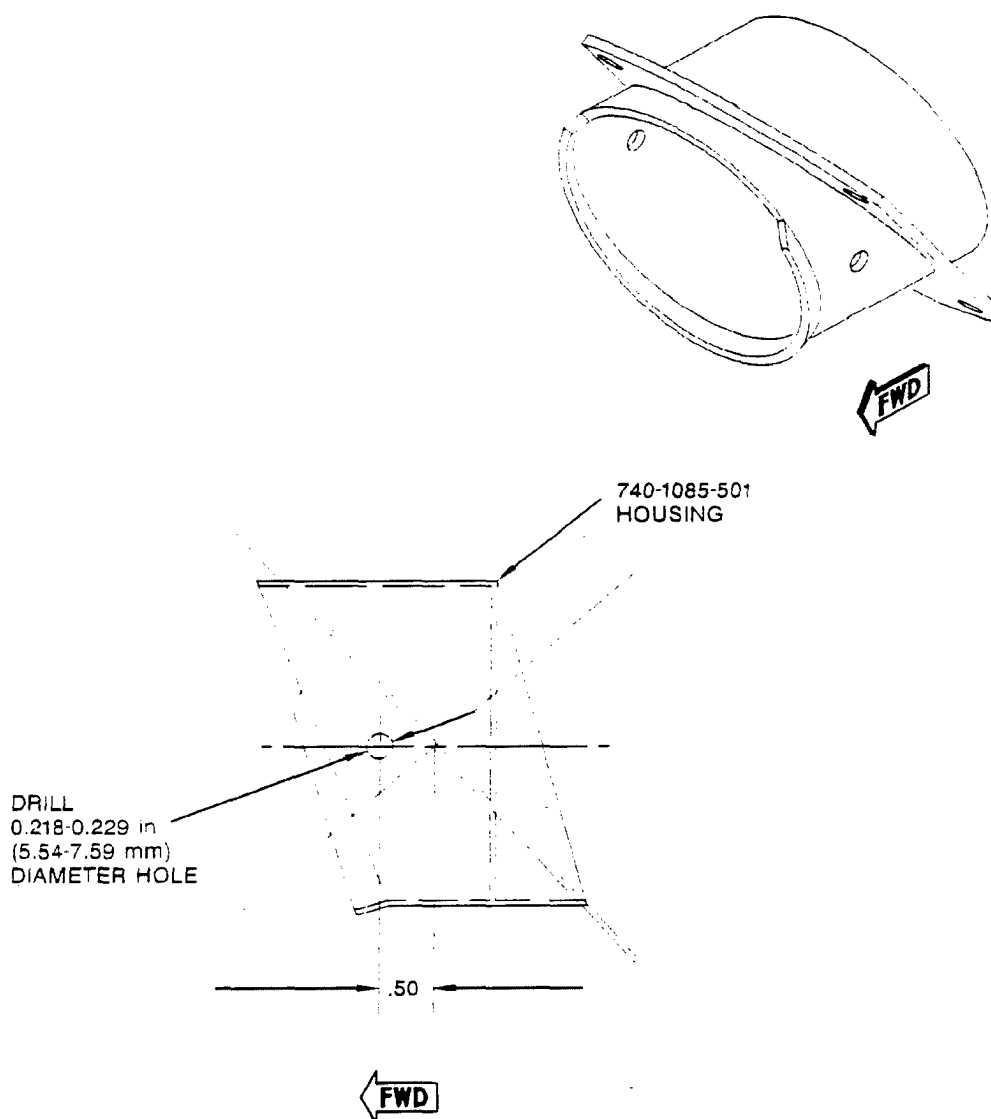
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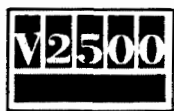
VSB371

ACAC Exhaust Duct Housing Modification
Figure 2.

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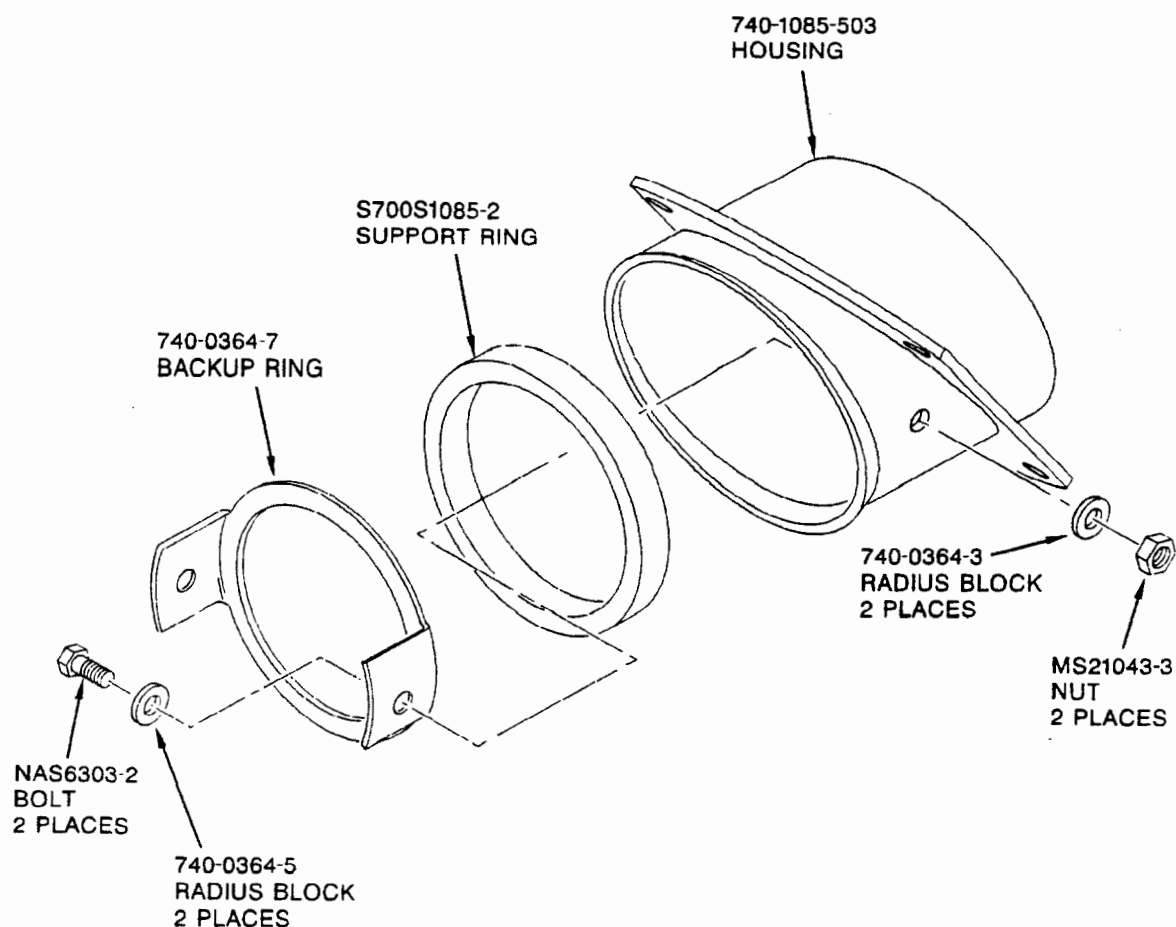
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VS372

Support And Backup Ring Installation
Figure 3.

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- (8) Install the 740-1085-503 housing and 740-0361 ACAC exhaust duct into the common nozzle assembly . Refer to the A320/A321 Aircraft Maintenance Manual, Chapter 78-11-11, page block 401.
- (9) Put the S700S1085-2 support ring in the 740-1085-503 housing. Refer to Figure 3.
- R (10) Put the 740-0364-7 backup ring in the 740-1085-503 housing.
- R (11) Put the two 740-0364-5 radius blocks in the 740-1085-503 housing. Put the two NAS6303-2 bolts thru the 740-0364-5 radius blocks, 740-0364-7 backup ring, and the 740-1085-503 housing. Install the two 740-0364-3 radius blocks and MS21043-3 nuts on the NAS6303-3 bolts.

C. Post-requisite Instructions

None.

D. Recording Instructions

A record of accomplishment is necessary. Write in the engine log that Service Bulletin V2500-NAC-75-0058 has been done.

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3. Material Information

Applicability: For each V2500-A1/A5 engine build-up unit to incorporate this Bulletin.

A. Kits associated with this Bulletin:

NEW PART NO (ATA NO)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO (IPC NO)	INSTR/ DISPOS
V2575058-551	1	\$1,632.00	Kit		(A)
Consisting of:					
S700S1085-2	1		Support Ring		
740-0364-7	1		Backup Ring		
740-0364-3	2		Radius Block		
740-0364-5	2		Radius Block		
MS21043-3	2		Nut		
NAS6303-2	2		Bolt		

B. Parts affected by this Bulletin:

NEW PART NO (ATA NO)	QTY	EST'D UNIT PRICE	KEYWORD	OLD PART NO (IPC NO)	INSTR/ DISPOS
740-0361-509 (75-22-48)	1		Duct, ACAC	740-0361-507 (01-010)	(C)(1R) (S1)
740-1085-503 (75-22-48)	1		Housing	740-1085-501 (01-040)	(C)(1R) (S1)
S700S1085-2 (75-22-48)	1		Ring, Support	S700S1085-1 (01-060)	(B)(C) (1R)(S1)
740-0364-7 (75-22-48)	1		Ring, Backup	- - - (01-065)	(B)(S1)

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<u>NEW PART NO</u> <u>(ATA NO)</u>	<u>QTY</u>	<u>EST'D</u> <u>UNIT</u> <u>PRICE</u>	<u>KEYWORD</u>	<u>OLD PART NO</u> <u>(IPC NO)</u>	<u>INSTR/</u> <u>DISPOS</u>
MS21043-3 (75-22-48)	2		Nut	- - - (01-070)	(B)(S1)
740-0364-3 (75-22-48)	2		Block, Radius	- - - (01-075)	(B)(S1)
740-0364-5 (75-22-48)	2		Block, Radius	- - - (01-080)	(B)(S1)
NAS6303-2 (75-22-48)	2		Bolt	- - - (01-085)	(B)(S1)

C. Instructions/Disposition Code Statements:

- R
- (A) Kit will be available fourth quarter 1997.
 - (B) Part is supplied as a detail of the kit.
 - (C) Old part is no longer available.
 - (D) New part is currently available.
 - (1D) Discard old part.
 - (1R) Old part may be reworked and reidentified as the new part number.
 - (S1) Old and new parts coded S1 must be fitted as a set. Mixing of old and new parts is not acceptable.

D. Materials required to incorporate this Service Bulletin:

CoMat 06-073 Black Ink

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

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