
Annex to Capability List of the Maintenance Organization (MTT197)

**DE.145.0019 (EASA Part 145)
CK5Y782M (14 CFR part 145)
813-22 (CAR 573)
valid for Munich facility**

**This List is a print-out of the computerized list of released operation
sheets which is developed and maintained in accordance with
MTT163-1**

*Abbreviations:
OAR = Overhaul Approval Record*

Note: This list was generated 23.01.2019. It shows all maintenance activities as per 23.11.2018

Engine Type V2500-A1-A5

ATA 72-32-41

Plan-No. V723241-01240R1

Description NO.1 BRG.SUPPORT

P/N 5W2048, 5W2323, 5W2088

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
0	INSP	MPI i.a.w. Inspection	X
1	VRS1270	Blend the Damaged Surface of the No1 Bearing Support	
2	VRS1271	Replace the Self Locking Nut	
4	VRS1267	Touch up Damaged Paint of the No1 Bearing Support	
7	VRS1242	Blend the Damaged Surface of the No1 Bearing Support	
8	VRS1243	Replace the Self Locking Clinch Nut	
9	VRS1244	Replace the Bracket of the No.1 Bearing Support Assembly	X
11	VRS1246	Apply Powder to the Snap Diameter of No1 Bearing Support Assembly	
12	VRS1960	Blend the Damaged Surface of the No1 Bearing Support Assembly	
13	VRS1962	Touch up the Damaged Paint of the No1 Bearing Front Support	
16	VRS1969	Replace the Insert of the No1 Bearing Rear Support Assembly	
17	VRS1968	Refit the Washer of the No1 Bearing Support Assembly	
18	VRS1961	Replace the Self Locking Clinch Nut	

ATA 72-44-50

Plan-No. V724450-01010R1

Description Cooling Duct

P/N 2A0008-01, 2A1997-01, 2A1997-001, 2A1997-002, 2A1997-003, 2A2141-01, 2A3180-01, 2A3329-01, 2A3487-01, 2A3487-001, 2A3491-01, 2A3914-01, 2A3914-001,

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X
2	VRS3180	Blend Repair	X
3	VRS3179	Replacement of Honeycomb Seal Rings.	X
4	VRS3183	Plasma Spray the Inner Liner Snap Diameter axial Dimension.	X
5	VRS3181	Plasma Spray the Inner Liner Snap Diameter.	X
6	VRS3178	Plasma Spray the Deflector Support Diameter	X
7	VRS3307	Plasma Spray Repair the Front Snap Diameter incl. the plane area for dimensional restoration.	X
9	VRS3506	Plasma Spray the outer Flange Axial Dimension.	X
10	VRS3177	Repair to adjust the Air Flow of the Cooling Duct. Note: This FC will only be required if the prior FC did not deliver satisfactory Flow Results.	X
11	VRS3558	Weld Repair of Cracks / Burns at the Outer Flange. Area "C".	X
12	VRS3587	General Weld Repair of Cracks and Nicks / Dents in all areas except areas "A"	X
16	VRS3660	Crack Weld Repair of the inner Liner Snap Diameter area: Area "B".	X
17	VRS3808	Weld the Air Pressure Passage Cracks	X
11	VRS3558	Pin Replacement only	X
	SB72-0046	Opening of the Air Passages to increase the cooling Air Flow for the HPT Blades. P/N Change: 2A0008-01 is going to be 2A1997-01	X
	SB72-0241	Machining of additional holes at the flanges and changing the Air Flow. P/N Change: 2A2141-01 is going to be 2A3180-01	X
	SB72-0325	FPI Inspection of the Groove between the Honeycomb Rings to guarantee freedom of Cracks.	X
	SB72-0340	Weld Build up of two Dimensions and one Diameter at the Aft Flange including Machining of a new Contour. P/N Change: 2A1997-01 is going to be 2A1997-001 2A1997-002 is going to be 2A1997-003	X
	SB72-0381	Machining off a part of the Honeycomb and add an Oil Drain Slot to avoid HPT - Fire. P/N Change: 2A3180-01 is going to be 2A3487-01 2A3329-01 is going to be 2A3491-01 2A1997-01 is going to be 2A1997-002 2A1997-001 is going to be 2A1997-003	X

Repair	Basic document	Description	OAR
	SB72-0475	Machining of 3 additional Holes and decreasing the cooling Air Flow for the HPT Blades. (Part 2 of Accomplishment Instructions) X P/N Change: 2A3487-01 is going to be 2A3914-01	
	SB72-0562	Machining of 3 additional Holes (only valid for P/N 2A3487-01) and Decreasing the cooling Air Flow to the HPT Blades. P/N Change: 2A3487-01 is going to be 2A3487-001 2A3914-01 is going to be 2A3914-001	X
	72-44-50-280-052	Air Flow Check i.a.w.:	X
	72-44-50-280-055	Air Flow Check i.a.w.:	X
	72-44-50-280-056	Air Flow Check i.a.w.:	X
	72-44-50-280-056	Air Flow Check	X
	70-35-28-350-501	Removal Of Broken Bolts Or Studs	X

ATA 72-50-21

Plan-No. V725021-01010R1

Description LPT Case

P/N 3A2183, 3A0991, 3A2447, 3A1908, 3A0807, 3A0990, 3A2265, 3A2533

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4001	Blend Repair.	X
2	VRS4002	Replace the Locating Pin.	X
6	VRS4009	Plasma Spray the Stg. 3 - 7 rear Vane Hook Diameters.	
7	VRS4010	Plasma Spray the forward Flange Snap Diameter.	X
8	VRS4011	Plasma Spray the Rear Flange Snap Diameter.	
9	VRS4012	Repair 009 / VRS4012 Rev. Date: A1-A5: / D5: Weld Repair of Cracks adjacent to the Boroscope Bosses.	

Repair	Basic document	Description	OAR
10	VRS4013	Replacement of the Boroscope Boss and / or damaged Rivets of the Boroscope Boss.	X
11	VRS4014	Replace Identity Bracket or the Clip Nuts.	X
12	VRS4015	Weld build up Repair the Low Pressure Turbine Case anti rotation Slots.	X
23	VRS4034	Nickel Plate the Location Pin Holes at the Front and/or Rear Flange of LPT Case.	
26	VRS4049	Replace the Screw Thread Inserts.	X
27	VRS4090	Plasma Spray the Stg. 3 - 7 rear Vane Hook Diameters.	
30	VRS4341	Replacement of the Boroscope Boss and / or damaged Rivets of the Boroscope Boss.	X
31	VRS4343	Stop Drill and plugging Repair of Cracks at the Outer Duct Support Hook.	X
32	VRS4344	Replacement of the Front Flange	X
33	VRS4403	Replacement of the Active Clearance Control (ACC) Mounting Boss(es).	X
36	VRS4474	Weld Repair of Cracks adjacent to the Boroscope Bosses.	
37	VRS4476	Replacement of the Front Flange.	X
38	VRS4471	Plasma Spray the Stg. 3 - 7 rear Vane Hook Diameters.	
40	VRS4490	Plasma Spray the Outer Duct Support Hook.	X

ATA 72-50-23

Plan-No. V725023-01010R1

P/N 3A0666

Manufacturer INTERNATIONAL AERO ENGINES

Description LPT Outer Air Seal Segment Stg. 7

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Repair	Basic document	Description	OAR
3	VRS4076	Blend Repair	X
6	VRS4080	Replacement of the Honeycomb Segment	X
7	VRS4081	Replace the Locating Key	X
19	VRS4097	Replacement of Sealing plate	X

Plan-No. V725023-01150R1

P/N 3A0727, 3A1920

Manufacturer INTERNATIONAL AERO ENGINES

Description Air Seal Segm. Stg. 5

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4028	Replacement of the Strip Seal	X
8	VRS4082	Blend Repair of Surface Damages.	X
10	VRS4084	Replacement of the Honeycomb Segments.	X
12	VRS4086	Metalspray the forward groove	X
34	VRS4275	Blend Repair of Surface Damages.	X
41	VRS4276	Replacement of the Honeycomb Segments.	X
47	VRS4421	Welding of cracks at the side faces.	X
48	VRS4422	Weld Repair of Cracks at the side Faces.	X
55	VRS4552	Weld repair the Rear Faces of the Stg. 5 Shroud Seal Segment.	X
56	VRS4553	Weld repair the Rear Faces of the Stg. 5 Shroud Seal Segment.	X

Plan-No. V725023-01250R1

Description Air Seal Segm. Stg. 4

P/N 3A0723, 3A1918

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Main Inspection i.a.w. E.M.:	X
014	VRS4091	Blend Repair of Surface Damages.	X
016	VRS4093	Replacement of the Honeycomb Segments.	X
018	VRS4095	Thermal Spray the front location groove.	X
035	VRS4277	Blend Repair of Surface Damages.	X
045	VRS4419	Weld Repair of Cracks at the side faces.	X
046	VRS4420	Weld Repair of Cracks at the side faces.	X
049	VRS4487	Replacement of the Honeycomb Segments.	X

Plan-No. V725023-01350R1

Description Air Seal Segm. Stg. 3

P/N 3A0719, 3A1916, 3A2050, 3A2234

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Repair	Basic document	Description	OAR
21	VRS4101	Blend Repair of Surface Damages.	X
23	VRS4103	Replacement of Honeycomb Segments.	X
25	VRS4105	Thermal Spray the front location groove.	X
27	VRS4283	Replacement of the Honeycomb Segments.	X
28	VRS4342	Blend Repair of Surface Damages.	X
30	VRS4335	Blend Repair of Surface Damages.	X
31	VRS4336	Replacement of the Honeycomb Segments.	X
33	VRS4373	Weld Repair of Side Face Cracks.	X
36	VRS4278	Blend Repair of Surface Damages.	X
37	VRS4279	Replacement of Honeycomb Segments.	X
42	VRS4416	Weld Repair of Side Face Cracks.	X
43	VRS4417	Weld Repair of Side Face Cracks.	X
44	VRS4418	Weld Repair of Side Face Cracks.	X

ATA 72-50-24

Plan-No. V725024-01010R1

P/N 3A2493, 3A0108, 3A0771

Manufacturer INTERNATIONAL AERO ENGINES

Description Inner Duct Segment

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4003	Thermal Spray the Location Diameter.	

Repair	Basic document	Description	OAR
3	VRS4110	Blend Repair of Surface Damages.	X
4	VRS4111	Touch up of the Aluminide Layer.	X
6	VRS4112	Weld build up of the Location slot.	X
9	VRS4115	Replacement of the Honeycomb Seal Segment.	X
11	VRS4117	Strip and Recoat the Aluminide Coating.	X
42	VRS4408	Strip and Recoat the Aluminide Coating.	X
43	VRS4409	Replacement of the Honeycomb Seal Segment.	X
44	VRS4410	Weld build up Repair of the locaton slot.	X
45	VRS4411	Blend Repair of Surface Damages.	X
46	VRS4412	Thermal Spray the Location Diameter.	
47	VRS4406	Touch up of the Aluminide Coating.	X
	SB72-0294	Remove the sealing plate - Rework 001 -	X

Plan-No. V725024-01100R1

Description Inner Diffuser Support

P/N 3A0104, 3A1564, 3A2201, 3A2202, 3A2525, 3A2529, 3A2693

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
013	VRS4119	Blend Repair of Surface Damages.	X
017	VRS4123	Replacement of the locating Pin.	X

Repair	Basic document	Description	OAR
018	VRS4124	Weld Build up Repair of the Inner Duct Stops.	X
019	VRS4125	Plasma Spray of the Inner Duct Locating Diameter.	X
032	VRS4322	Blend Repair of Surface Damages.	X
034	VRS4320	Weld Build up Repair of the inner Duct Stops.	X
035	VRS4321	Plasma Spray the Inner Duct Locating Diameter.	X
036	VRS4319	Replacement of the locating Pin.	X
037	VRS4318	Replacement of Clinch Nuts.	X
049	VRS4465	Replace Wear Resistant Coating at the Front Lip.	X
	SB72-0359	Application of Wear Resistant Coating.	X
	SB72-0125	Retrofit to partially silver plated Clinch Nuts.	X

Plan-No. V725024-01170R1

P/N 3A0113, 3A1560, 3A2523, 3A2527

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
21	VRS4127	Blend Repair of Surface Damages.	X
23	VRS4129	Plasma Spray the Rear Face.	X
24	VRS4130	Replace marked Spacer Key(s).	X
26	VRS4132	Weld Repair of Cracks.	X

Repair	Basic document	Description	OAR
38	VRS4356	Replace marked Spacer Key(s).	X
39	VRS4309	Replace the Hard Face Coating on the Rear Face of the Support Ring.	X
40	VRS4310	Blend Repair of Surface Damages.	X
48	VRS4451	Weld Repair of Cracks.	X
51	VRS4497	Weld Repair of Cracks.	X
52	VRS4498	Weld Repair of Cracks.	X
53	VRS4466	Replacement of the Triballoy T800 hard face Coating at the Front Face.	X
56	VRS4499	Weld Repair the Front Faces of the Supp	X
57	VRS4531	Replacement of the Hard Face Coating with a higher Coating thickness on the Rear Face of the Support Ring.	X
58	VRS4550	Weld Repair the Front Faces of the Supp	X
59	VRS4454	Weld Repair the Front Faces of the Support Ring.	X
60	VRS4551	Weld Repair the Front Faces of the Supp	
P1	OH-PACKET, INCL SF38	Failure Code also includes Failure Code/s: 038 051 100 Replace marked Spacer Key(s). Repair: 38 Basic Document: VRS4356 Manual No./Eng.Vers: E-V2500-3IA PUB38626 Issue-Date: Aug.01/2015 ATA: 72-50-24 Repair: 38 Basic Document: VRS4356 Manual No./Eng.Vers: PN 2A4407 Issue-Date: Feb.01/2012 ATA: 72-50-24 Repair: 38 Basic Document: VRS4356 Manual No./Eng.Vers: PN 2A4416 Issue-Date: Feb.01/2012 ATA: 72-50-24 P/N: 3A1560 3A2523 Weld Repair of Cracks. Repair: 51 Basic Document: VRS4497 Manual No./Eng.Vers: E-V2500-3IA PUB38626 Issue-Date: Aug.01/2015 ATA: 72-50-24 Repair: 51 Basic Document: VRS4497 Manual No./Eng.Vers: PN 2A4407 Issue-Date: Jul.01/2005 ATA: 72-50-24 Repair: 51 Basic Document: VRS4497 Manual No./Eng.Vers: PN 2A4416 Issue-Date: May.01/2005 ATA: 72-50-24 P/N: 3A2523 Failure Code also includes Failure Code/s: 039 053 Replace the Hard Face Coating on the Rear Face of the Support Ring. - Note - If Work Step 400 is activated Repair 57 is applicable!!! Repair: 39 Basic Document: VRS4309 Manual No./Eng.Vers: E-V2500-3IA PUB38626 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 39 Basic Document: VRS4309 Manual No./Eng.Vers: PN 2A4407 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 39 Basic Document: VRS4309 Manual No./Eng.Vers: PN 2A4416 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 57 Basic Document: VRS4531 Manual No./Eng.Vers: E-V2500-3IA PUB38626 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 57 Basic Document: VRS4531 Manual No./Eng.Vers: PN 2A4407 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 57 Basic Document: VRS4531 Manual No./Eng.Vers: PN 2A4416 Issue-Date: Aug.01/2017 ATA: 72-50-24 P/N: 3A1560 3A2523 Replacement of the Triballoy T800 hard face Coating at the Front Face. Repair: 53 Basic Document: VRS4466 Manual No./Eng.Vers: E-V2500-3IA PUB38626 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 53 Basic Document: VRS4466 Manual No./Eng.Vers: PN 2A4407 Issue-Date: Aug.01/2017 ATA: 72-50-24 Repair: 53 Basic Document: VRS4466 Manual No./Eng.Vers: PN 2A4416 Issue-Date: Aug.01/2017 ATA: 72-50-24 P/N: 3A2523 3A2527 Cleaning and Inspection Basic Document: VALID FOR P/N: 3A0113 Task: 72-50-24-200-003-A00 Manual No./Eng.Vers: E-V2500-11A ATA: 72-50-24 Basic Document: VALID FOR P/N: 3A1560 Task: 72-50-24-200-003-B00 Manual No./Eng.Vers: E-V2500-11A ATA: 72-50-24	X

Repair	Basic document	Description	OAR
		Basic Document: VALID FOR P/N: 3A1560 Task: 72-50-24-200-003-A00 Manual No./Eng.Vers: E-V2500-3IA ATA: 72-50-24 Basic Document: VALID FOR P/N: 3A2523 Task: 72-50-24-200-003-D00 Manual No./Eng.Vers: E-V2500-11A ATA: 72-50-24 Basic Document: VALID FOR P/N: 3A2523 Task: 72-50-24-200-003-B00 Manual No./Eng.Vers: E-V2500-3IA ATA: 72-50-24 Basic Document: VALID FOR P/N: 3A2527 Task: 72-50-24-200-003-C00 Manual No./Eng.Vers: E-V2500-11A ATA: 72-50-24 P/N: 3A0113 3A1560 3A2523 3A2527	
	SB72-0359 RWK002	Application of wear resistant coating - Rework 002	X

Plan-No. V725024-01250R1

P/N 3A0961, 3A1566, 3A3108, 3A3109

Manufacturer INTERNATIONAL AERO ENGINES

Description LPT Air Seal Ring Stg. 3

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
5	VRS4053	Weld build up Repair the Seal Fin.	X
27	VRS4133	Blend Repair of Surface Damages.	X
28	VRS4134	Replacement of the Honeycomb Rings.	X
29	VRS4135	Plasma Spray the Vane Mating Face.	X
30	VRS4136	Plasma Spray both Diameters - D1 + D2.	X
30	VRS4136	Plasma Spray the Diameter D1.	X
30	VRS4136	Plasma Spray the Diameter D2.	X
61	VRS4564	Replace The Honeycomb Seal Segmente	X

ATA 72-50-25

Plan-No. V725025-01010R1

Description Outer Diffuser Support Segment

P/N 3A0084, 3A1907

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4138	Blend Repair of Surface Damages.	X
2	VRS4139	Plasma Spray the Rear Hook outer Diameter.	
3	VRS4140	Plasma Spray the Front Lip Diameter.	
4	VRS4141	Replacement of the Sealing Strip.	X
6	VRS4143	Replace the Locating Key.	X
17	VRS4316	Blend Repair of Surface Damages.	X
19	VRS4313	Replacement of the Sealing Strip.	X
20	VRS4314	Replacement of the Clinch Nuts.	X
21	VRS4315	Replacement of the Locating Key.	X
25	VRS4402	Plasma Spray the inner Front Flange.	
28	VRS4311	Plasma Spray the Rear Hook outer Diameter.	
29	VRS4477	Plasma Spray the Inner Front Flange.	X
30	VRS4599	Weld Repair Cracks on the Outer Diffuser Support Assembly	X
	SB72-0110	Replace the fully with partially silver plated Clinch Nuts. Valid for P/N: 3A0084 is going to be 3A1907	X

Plan-No. V725025-01200R1

Description Outer Diffuser Segment

P/N 3A0090, 3A0958, 3A2482, 3A1791

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
9	VRS4146	Blend Repair of Surface Damages.	X
10	VRS4147	Touch up of Aluminide Coating.	X
14	VRS4151	Strip and Recoat the Aluminide Coating.	X
15	VRS4152	Replacement of the Locating Pin.	X
18	VRS4308	Replacement of the Locating Pin.	X
23	VRS4280	Blend Repair of Surface Damages.	X
26	VRS4413	Replacement of the locating Pin.	X
27	VRS4414	Blend Repair of Surface Damages.	X

ATA 72-50-31

Plan-No. V725031-01010R1

Description LPT Disk Stg. 7

P/N 3A0717, 3A1987, 3A2512, 3A2514, 3A2424

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection including AD 2004-12-08 during FPI	X

Repair	Basic document	Description	OAR
0	CINSP	Hardness Check-only-	X
1	VRS4154	Blend Repair of Surface Damages. Decision if Shot Peening is required is done during Incoming Inspection.	X
2	VRS4155	Plasma Spray the Front Snap Diameters.	X
3	VRS4156	Rebalance the Disk.	X
21	VRS4282	Blend Repair of Surface Damages. Decision if Shot Peening is required is done during Incoming Inspection.	X
24	VRS4425	Plasma Spray the Front Snap Diameters.	
32	VRS4468	Blend Repair of Surface Damages. Decision if Shot Peening is required is done during Incoming Inspection.	X
34	VRS4488	Rebalance the Disk.	X
35	VRS4518	Blend Repair of Surface Damages. Decision if Shot Peening is required is done during Incoming Inspection.	X
42	VRS4603	Skim Machining	X
43	VRS4604	Outer Body Skim Machining	X

Plan-No. V725031-01050R1

Description LPT Disk Stg. 6

P/N 3A0066, 3A1986, 3A2996

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection including AD 2004-12-08 during FPI	X
0	CINSP	Hardness Check-only-	X
4	VRS4157	Blend Repair of Surface Damages.	X
5	VRS4158	Plasma Spray the Front Snap Diameters.	X

Repair	Basic document	Description	OAR
6	VRS4159	Rebalance the Disk.	X
7	VRS4160	Plasma Spray the Rear Snap Diameter.	X
8	VRS4162	Plasma Spray the front inner Snap Diameter.	X
41	VRS4545	Skim Machining.	X
04	VRS4157	- only shot peening -	X

Engine Type GE STANDARD PRACTICE MANUAL

ATA 72-51-01

Plan-No. A72-51-01R1
P/N 9082M94G10, 9173M39G01
Manufacturer

Description HPT NOZZ.SUPP.STG1

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Serviceability Inspection Incl NMSB According to Engine Manual and Return to Service Only	X
2		Weld Repair Aft Flange	
3		Locating Pin Replacement	
4		Removal of Silver Corrosion	
5		Replace Aft Flange	
	SB72-971	Move Weld Fwd To Lower Stress Area	

Engine Type V2500-A1-A5

ATA 72-50-31

Plan-No. V725031-01100R1
P/N 3A0795, 3A1665, 3A2153, 3A2430
Issue: 23.01.2019

Description LPT Disk Stg. 5

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection including AD 2004-12-08 during FPI	X
0	CINSP	Hardness Check-only-	X
9	VRS4164	Blend Repair of Surface Damages.	X
10	VRS4165	Plasma Spray the Front Snap Diameters.	X
11	VRS4166	Rebalance the Disk.	X
12	VRS4167	Plasma Spray the Rear Snap Diameter.	X
22	VRS4307	Blend Repair of Surface Damages.	X
25	VRS4378	Plasma Spray the Front Snap Diameters.	X
26	VRS4379	Plasma Spray the Rear Snap Diameter.	X
27	VRS4380	Blend Repair of Surface Damages.	X
40	VRS4544	Skim Machining of different Disk areas	X
40	VRS4544	Outer Body Skim Machining	X

Plan-No. V725031-01150R1

Description LPT Disk Stg. 4

P/N 3A0794, 3A1984

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection including AD 2004-12-08 during FPI	X

Repair	Basic document	Description	OAR
0	CINSP	Hardness Check-only-	X
13	VRS4169	Blend Repair of Surface Damages.	X
14	VRS4170	Plasma Spray the Front Snap Diameters.	X
15	VRS4171	Rebalance the Disk.	X
16	VRS4172	Plasma Spray the Rear Snap Diameter.	X
39	VRS4543	Skim Machining For this FC the applicable Blend Repair FC must always be taken additionally!!!	X

Plan-No. V725031-01200R1

Description LPT Disk Stg. 3

P/N 3A0713, 3A2151, 3A2508, 3A2428, 3A2513

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection including AD 2004-12-08 during FPI	X
0	CINSP	Hardness Check-only-	X
17	VRS4174	Blend Repair of Surface Damages.	X
18	VRS4175	Plasma Spray the Front Snap Diameter.	X
19	VRS4176	Rebalance the Disk.	X
20	VRS4177	Plasma Spray the Rear Snap Diameter.	X
28	VRS4381	Plasma Spray the Front Snap Diameter.	X
29	VRS4382	Plasma Spray the Rear Snap Diameter.	X
30	VRS4383	Blend Repair of Surface Damages.	X

Repair	Basic document	Description	OAR
33	VRS4469	Blend Repair of Surface Damages.	X
37	VRS4460	Inner Body Skim Machining.	X
38	VRS4542	Inner Body Skim Machining.	X

ATA 72-50-33

Plan-No. V725033-01010R1

Description LPT Rotating Air Seal Stg. 7

P/N 3A0797, 3A1741, 3A2522

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4212	Blend Repair of Surface Damages.	X
2	VRS4213	Blend Repair of Seal Fin Damages.	X
3	VRS4214	Weld build up Repair of the Seal Fins.	X
4	VRS4215	Plasma Spray the Snap Diameter.	X
5	VRS4216	Rebalance the Air Seal.	X
6	VRS4217	Plasma Spray the Knife Edge Seals.	X
7	VRS4218	Build up weld the Seal Wing mating Face.	X
36	VRS4004	Weld build up Repair of the Seal Fins.	X
37	VRS4005	Plasma Spray the Snap Diameter.	X
38	VRS4057	Rebalance the Air Seal.	X
39	VRS4060	Blend Repair of Surface Damages.	X

Repair	Basic document	Description	OAR
40	VRS4087	Plasma Spray the Knife Edge Seals.	X
41	VRS4089	Build up weld the Seal Wing mating Face.	X
56	VRS4449	Blend Repair of Seal Fin Damages.	X

Plan-No. V725033-01050R1

P/N 3A0796, 3A1988

Manufacturer INTERNATIONAL AERO ENGINES

Description LPT Rotating Air Seal Stg. 6

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
8	VRS4219	Blend Repair of Surface Damages.	X
9	VRS4220	Blend Repair of Seal Fin Damages.	X
10	VRS4221	Weld build up Repair of the Seal Fins.	X
12	VRS4223	Rebalance the Air Seal.	X
13	VRS4224	Plasma Spray the Knife Edge Seals	X
14	VRS4225	Build up weld the Seal Wing mating Face.	X

Plan-No. V725033-01100R1

P/N 3A0793, 3A1985, 3A2423

Manufacturer INTERNATIONAL AERO ENGINES

Description LPT Rotating Air Seal Stg. 5

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection for P/N: 3A0793; 3A1985 only	X
0	CINSP	Cleaning and Inspection for P/N:3A2423 only	X
015	VRS4226	Blend Repair of Surface Damages.	X
016	VRS4227	Blend Repair of Seal Fin Damages.	X
17	VRS4228	Weld build up Repair of the Seal Fins.	X
018	VRS4229	Plasma Spray the Snap Diameter.	X
019	VRS4230	Rebalance the Air Seal.	X
020	VRS4231	Plasma Spray the Seal Fins.	X
021	VRS4232	Build up weld the Seal Wing mating Face.	X
043	VRS4384	Blend Repair of Seal Fin Damages.	X
045	VRS4386	Plasma Spray the Seal Wing mating Face.	X
047	VRS4388	Plasma Spray the Knife Edge Seals.	X
048	VRS4389	Blend Repair of Surface Damages.	X
051	VRS4437	Rebalance the Air Seal.	X

Plan-No. V725033-01150R1

Description LPT Rotating Air Seal Stg. 4

P/N 3A0792, 3A1983, 3A2422

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection for P/N: 3A0792 and 3A1983 only	X
0	CINSP	Cleaning and Inspection for P/N:3A2422 only	X
22	VRS4233	Blend Repair of Surface Damages.	X
23	VRS4234	Blend Repair of Seal Fin Damages.	X
24	VRS4235	Weld build up Repair of the Seal Fins.	X
25	VRS4236	Plasma Spray the Snap Diameter.	X
26	VRS4237	Rebalance the Air Seal.	X
27	VRS4238	Plasma Spray the Seal Fins.	X
28	VRS4239	Build up weld the Seal Wing mating Face.	X
49	VRS4390	Blend Repair of Seal Fin Damages.	X
50	VRS4394	Plasma Spray the Seal Fins.	X
52	VRS4438	Rebalance the Air Seal.	X
53	VRS4461	Blend Repair of Surface Damages.	X
54	VRS4392	Plasma Spray the Seal Wing mating Face.	X

Plan-No. V725033-01200R1

P/N 3A0963

Manufacturer INTERNATIONAL AERO ENGINES

Description LPT Rotating Air Seal Stg. 3

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Repair	Basic document	Description	OAR
29	VRS4240	Blend Repair of Surface Damages.	X
30	VRS4241	Blend Repair of Seal Fin Damages.	X
31	VRS4242	Weld build up Repair of the Seal Fins.	X
33	VRS4244	Rebalance the Air Seal.	X
34	VRS4245	Renewal of the Plasmacoating on the Seal Fins	X
35	VRS4246	Build up weld the Seal Wing mating Face.	X

ATA 72-60-41

Plan-No. V726041-01300R1

Description Angle Gearbox Casing

P/N 4B2201, 4B0256, 4B0354

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS5097	REPAIR THE SURFACE OF THE ANGLE GEARBOX CASING	X
2	VRS5098	REPAIR THE SURFACE PROTECTION OF THE ANGLE GEARBOX SUPPORT	X
3	VRS5099	REPLACE THE DAMAGED STUDS IN THE ANGLE GEARBOX CASING.	X
4	VRS5100	REPLACE THE DAMAGED SCREW THREAD INSERTS IN THE ANGLE GEARBOX CASING ASSEMBLY	X
6	VRS5102	NICKEL PLATE THE MATING SURFACE OF THE ANGLE GEARBOX SUPPORT	
7	VRS5103	Nickel Plate the PTO Shaft Seal Tube of the Angle Gearbox Casing	X
8	VRS5104	Nickel Plate the Bearing Seat Diameter of the Angle Gearbox Casing	
9	VRS5105	NICKEL PLATE THE MATING SURFACE OF THE BEARING	X

Repair	Basic document	Description	OAR
11	VRS5107	Nickel Plate the Radial Gear Support Diameter of the Angle Gearbox Casing	
12	VRS5108	Nickel Plate the Support Seat Diameter of the Angle Gearbox Casing	X
13	VRS5109	Nickel Plate the Bearing Support Seat Diameter of the Angle Gearbox Casing	X
14	VRS5430	Repair the Chip Detector Housing Bore by Thread Insert in the Angle Gearbox Casing	
15	VRS5437	REPLACE THE DAMAGED OR LOOSE WIRE THREAD INSERTS IN THE ANGLE GEARBOX CASING	X
16	VRS5467	REPAIR THE SURFACE OF THE ANGLE GEARBOX CASING	X
17	VRS5468	REPAIR THE SURFACE PROTECTION OF THE ANGLE GEARBOX CASING	X
18	VRS5469	REPLACE THE DAMAGED STUDS IN THE ANGLE GEARBOX CASING	X
20	VRS5471	Repair the Ball bearing bore by bushing	
21	VRS5472	NICKEL PLATE THE TOWERSHAFT CASING SEAT DIAMETER OF THE ANGLE GEARBOX CASING	X
22	VRS5473	Repair the Radial gear support bore by bushing	
23	VRS5474	Repair the support seat diameter	
24	VRS5475	Repair the bearing support seat diameter	
51	VRS5690	REPAIR THE PTO SHAFT SEAL TUBE OF THE ANGLE GEARBOX CASING BY BUSHING	X
52	VRS5691	REPAIR THE TOWERSHAFT CASING SEAT BORE OF THE ANGLE GEARBOX CASING BY BUSHING	X
16	VRS5703	REPAIR THE PTO SHAFT SEAL TUBE OF THE ANGLE GEARBOX WITH STEEL BUSH	X
17	VRS5694	Replace the damaged or loose Helicoil Inserts in the Angle Gearbox Casing	X
9	VRS5105	NICKEL PLATE THE MATING SURFACE OF THE BEARING	X

ATA --

Plan-No. V725031-01200C1

P/N 3A0713, 3A2151, 3A2428, 3A2508, 3A2513

Description LPT Disk Stg. 3

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
		Harness Check - only - nach gültigem Engine Manual A1-A5-D5 72-50-31 Inspection / Check	X

Plan-No. V725031-01150C1 Description LPT Disk Stg. 4

P/N 3A0794, 3A1984

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
		CLINST	

Plan-No. V725031-01100C1 Description LPT Disk Stg. 5

P/N 3A2430, 3A0795, 3A1665, 3A2153

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
		CLINST	

ATA 72-41-31

Plan-No. V724131-01700R1 Description HPC Stg. 6 Rot. Path Segm. (A1)

Issue: 23.01.2019

P/N 6A3466, 6A3977

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
4	VRS6032	Blend Repair of Surface Damages.	X
	VRS6245	Replace the Rotor Path Lining with METCO 601.	X
	SB72-0463	Final Machining for A1 Engines only.	X
	ASSEMBLY	Final Machining to "Standardmaß" A1 - Only -	X

ATA 72-41-21

Plan-No. V724121-04700R1

Description HPC Stg. 12 Rotor Path Ring

P/N 6A3656, 6A4166

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
21	VRS6102	Blend Repair of Surface Damages.	X
22	VRS6024	Replace the Rotor Path Lining.	X
45	VRS6328	Renewal of the Surface Protection.	X
45	VRS6328	Touch up of the Surface Protection	X
86	VRS6172	Replacement of the Hard Coating on Surface "AD".	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A5/D5 - Only -	X

Repair	Basic document	Description	OAR
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 - Only -	X

ATA 72-60-28

Plan-No. V726028-01410R1

Description IDG Drive Gear

P/N 4P0207, 4P2221

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
18	VRS5161	Repair the Surfaces of the IDG Drive Gear.	X
19	VRS5162	Chromium Plate the Front Bearing Shoulder of the IDG Drive Gear.	
20	VRS5163	Chromium Plate the Front Bearing Journal	X
21	VRS5164	Chromium Plate the Rear Bearing Journal of the IDG Drive Gear.	X
22	VRS5165	Chromium Plate the Rotating Ring Journal of the IDG Drive Gear.	X
23	VRS5166VRS5166	Chromium Plate the Rear Bearing Shoulder of the IDG Drive Gear.	
38	VRS5595	Repair the Surface Damage of the VSCF Drive Gear.	
40	VRS5597	Chromium Plate the Rear Bearing Journal of the VSCF Drive Gear.	
41	VRS5598	Chromium Plate the Rear Bearing Shoulder of the VSCF Drive Gear.	
43	VRS5600	Chromium Plate the Mating Ring Journal of the VSCF Drive Gear.	

ATA 72-41-33

Plan-No. V724133-04200R1

Description HPC Stg. 5 Half Shroud Assy

P/N 6A3471, 6A7563, 6B1158

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
4	VRS6040	Replace the Lining	X
6	VRS6109	Repair the Surface Damage	X
18	VRS6631	Repair worn/damaged Bush location Holes	X
	T.O.SH 72-41-33 03	Revised Repair Limits of VRS6040 i.a.w. DER approval	X

ATA 72-60-22

Plan-No. V726022-01260R1

Description Starter Drive Gear

P/N 4P0006, 4P2224

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
14	VRS5127	Repair the Surface of the Starter Drive Gear	X
15	VRS5128	Chromium Plate the Rear Bearing Journal of the Starter Drive Gear	X
16	VRS5129	Chromium Plate the Front Bearing Journal of the Starter Drive Gear	X
17	VRS5130	Chromium Plate the Front Bearing Shoulder of the Starte Drive Gear	X

Repair	Basic document	Description	OAR
18	VRS5131	Chromium Plate the Rear Bearing Shoulder	X
19	VRS5132	Chromium Plate the Rotating Ring Journal.	X
36	VRS5564	Chromium Plate the Front Bearing Journal	
37	VRS5565	Chromium Plate the Rear Bearing Journal of the Starter Drive Gear	X
38	VRS5566	Chromium Plate the Rear Bearing Shoulder of the Starter Drive Gear	X
39	VRS5567	Chromium Plate the Front Bearing Shoulder	
40	VRS5568	Chromium Plate the Mating Ring Journal	X
	MTU TO NO SH 72-60-2	Chromium Plating at Front Shaft Journal adjacent to Rotating Journal	X

ATA 72-60-24

Plan-No. V726024-01140R1

P/N 4P0175, 4B0285, 4P0285, 4P0287, 4P0294, 4P2223

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
9	VRS5139	Repair the Surfaces of the Gearshaft	X
10	VRS5140	Chromium plate the Rear Bearing Journal of the Gearshaft	X
11	VRS5141	Verchromen des Inner Diameter.	X
12	VRS5142	Chromium plate the Rear Bearing Shoulder of the Gearshaft.	
13	VRS5143	Chromium plate the Front Bearing Shoulder of the Gearshaft.	
14	VRS5144	Chromium Plate the Front Bearing Journal of the Gearshaft	X

Repair	Basic document	Description	OAR
15	VRS5574	Repair the Surface of the Input Drive Gearshaft	X
16	VRS5575	Chromium plate the Front Bearing Journal of the Gearshaft.	X
17	VRS5576	Chromium plate the Rear Bearing Journal of the Gearshaft.	
18	VRS5577	Chromium plate the Rear Bearing Shoulder of the Gearshaft.	
19	VRS5578	Chromium plate the Front Bearing Shoulder of the Gearshaft.	
11	VRS5141	Chromium Plate the Inner Diameter of the Gearshaft	
	T.O. SH72-60-24 01	Non-OEM Repair Extended Pre-Grinding Limit for Repair 011 / VRS5141 i.a.w. DER approva	X

ATA 72-41-21

Plan-No. V724121-03450R1

Description HPC Stg. 7 Rotor Path Ring

P/N 6A3651, 6A4101, 6A5992, 6A7626, 6A4161, 6A5995, 6A7623

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
2	VRS6092	Blend Repair of Surface Damages	X
4	VRS6161	Renewal of the Surface Protection	X
4	VRS6161	Touch up of the Surface Protection	X
91	VRS6671	Replace the Rotor Path Lining with METCO 320 Lining Material	X
	SB72-0463	Final Machining of the Rotor Path Lining	X
	SB72-0369	Replace the old Rotor Path Lining with new METCO 320 Rotor Path Lining	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A1 -Only-	X

Repair	Basic document	Description	OAR
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-03600R1

Description HPC Stg. 8 Rotor Path Ring

P/N 6A3652, 6A4102, 6A5993, 6A7627, 6A4162, 6A5996, 6A7625

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
7	VRS6094	Blend Repair of Surface Damages.	X
59	VRS6146	Touch up of the Surface Protection	X
59	VRS6146	Renewal of the Surface Protection.	X
92	VRS6663	Replace the Rotor Path Lining with Metco 320 Lining Material.	X
	SB72-0369	Replace the old Rotor Path Lining with new METCO 320 Rotor Path Lining.	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A1 -Only-	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A5/D5 - Only -	X

Repair	Basic document	Description	OAR
	T.O. SH 72-41-21 07	Acceptance of saw tooth shaped Contour caused by erosion	X

Plan-No. V724121-03750R1

P/N 6A3653, 6A4163

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 9 Rotor Path Ring

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
011	VRS6096	Blend Repair of Surface Damages.	X
012	VRS6021	Replace the Rotor Path Lining.	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A1 - Only-	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-04300R1

P/N 6A3654, 6A4164

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 10 Rotor Path Ring

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
015	VRS6098	Blend Repair of Surface Damages.	X
016	VRS6022	Replace the Rotor Path Lining.	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A1 - Only-	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-04550R1

P/N 6A3655, 6A4297

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 11 Rotor Path Ring

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
018	VRS6100	Blend Repair of Surface Damages.	X
019	VRS6023	Replace the Rotor Path Lining.	X
	ASSEMBLE	Pre Machining to 1mm below "Standardmaß" A1 -Only-	X

Repair	Basic document	Description	OAR
	ASSEMBLE	Pre Machining to 1mm below "Standardmaß" A1/A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLE	Final Machining to "Standardmaß" for A1 - Only -	X
	ASSEMBLE	Final Machining to "Standardmaß" for A5/D5 - Only -	X
	T.O. SH72-41-21 07		X

ATA 72-41-31

Plan-No. V724131-01695R1

P/N 6A3025, 6A3976, 6A4349, 6A7471, 6A7573

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 5 Rot. Path Segm. (A1-A5-D5)

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
9	VRS6235	Blend Repair of Surface Damages.	X
	VRS6244	Replace the Rotor Path Lining.	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" for A1 only	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" for A5/D5 only	X
	ASSEMBLY	Final Machining to "Standardmaß" A1 - Only -	X
	ASSEMBLY	Final Machining to "Standardmaß" A5/D5 - Only -	X

Plan-No. V724131-01690R1

P/N 6A4348, 6A7470

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 4 Rot. Path Segm. (A5-D5)

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
7	VRS6208	Blend Repair of Surface Damages.	X
6	VRS6243	Final Machining to "Standardmaß" A5/D5 - Only -	X
	VRS6243	Replace the Rotor Path Lining.	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" for A5/D5 only	X

ATA 72-41-33

Plan-No. V724133-03150R1

P/N 6A1427

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 4 Half Seal Ring

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
7	VRS6039	Replace the Lining.	X
10	VRS6277	Repair the Surface Damage by Dressing.	X
17	VRS6348	Repair the Surface Protection.	X
	T.O.SH 72-41-33 03	Revised Repair Limits of VRS6039 i.a.w. DER approval	X

ATA 72-41-21

Plan-No. V724121-03500R1

Description HPC Stg. 8 Rotor Path Case Assy

P/N 6A6548, 6A7529, 6A7578, 6A7624, 6A4569, 6A7019, 6A4310, 6A3500, 6B1432

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
5	VRS6093	Blend Repair of Surface Damages.	X
6	VRS6163	Replacement of the Surface Protection.	X
34	VRS6266	Replacement of Spacers.	X
92	VRS6663	Replace the Rotor Path Lining with Metco 320 Lining Material"with" removing Surface Protection	X
92	VRS6663	Replace the Rotor Path Lining with Metco 320 Lining Material"without" removing Surface Protection	X
	SB72-0369	Replace the old Rotor Path Lining with new METCO 320 Rotor Path Lining.	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" -Only- including Recess	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-03650R1

Description HPC Stg. 9 Rotor Path Case Assy

P/N 6A6549, 6B1433

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
0	CINSP	Cleaning and Inspection	X
009	VRS6095	Blend Repair of Surface Damages.	X
012	VRS6021	Replace the Rotor Path Lining.	X
036	VRS6218	Replacement of marked Shank Nuts.	X
038	VRS6249/1	Replacement of damaged Boroscope Access Port. 6A5870	X
038	VRS6249/2	Replacement of damaged or worn Rivets of the Boroscope Access Port - only -	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-03800R1

P/N 6A6550, 6B1434

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 10 Rotor Path Case Assy

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
0	CINSP	Cleaning and Inspection	X
013	VRS6097	Blend Repair of Surface Damages.	X
014	VRS6251	Replacement of the Location Dowel.	X
016	VRS6022	Replace the Rotor Path Lining.	X

Repair	Basic document	Description	OAR
028	VRS6162/1	Replacement of damaged Boroscope Access Ports.	X
028	VRS6162/2	Replacement of damaged Rivets of the Boroscope Access Port - only -.	X
039	VRS6252	Replace the Spacers	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre-Machining 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 - Only -	X

Plan-No. V724121-04350R1

Description HPC Stg. 11 Rotor Path Case Assy

P/N 6A6551, 6A7531, 6B1435

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
0	CINSP	Cleaning and Inspection	X
017	VRS6099	Blend Repair of Surface Damages.	X
019	VRS6023	Replace the Rotor Path Lining.	X
040	VRS6253	Replacement of damaged Spacers.	X
042	VRS6331/1	Replacement of Rivets at the Seal Ring - only -.	X
042	VRS6331/2	Replacement of the Seal Ring with a new Seal Ring.	X
093	VRS6533	Repair by the Replacement of the Seal Retainer Coating	X
	T.O. SH 72-41-21 006	Replacement of the Seal Ring with a K3 repaired Seal Ring.	X

Repair	Basic document	Description	OAR
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre Machining to 1mm below "Standardmaß" add. Recess	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 - Only -	X
	T.O. SH 72-41-21 07	Acceptance of saw tooth shape Contour caused by erosion and clearance Limit extension of the Seal Ring i.a.w. DER Approval: X MTU T.O. No. SH 72-41-21 07 R 00	X

Plan-No. V724121-04600R1

P/N 6A6552, 6A4328, 6B1436

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 12 Rotor Path Case Assy

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
0	CINSP	Cleaning and Inspection	X
20	VRS6101	Blend Repair of Surface Damages.	X
22	VRS6024	Replace the Rotor Path Lining.	X
33	VRS6219	Replacement of damaged Shank Nuts.	X
81	VRS6352/1	Replacement of the Boroscope Access Port. 6A5870	X
81	VRS6352/2	Replacement of the damaged Rivets of the Boroscope Access Port - only -.	X
	ASSEMBLY	Replacement of the Retainer Hard Coat.	X
	ASSEMBLE	Pre Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLE	Pre Machining to 1mm below "Standardmaß" add. Recess	X

Repair	Basic document	Description	OAR
	ASSEMBLE	Final Machining to "Standardmaß" for A5/D5 - Only	X
	VRS6172 / OTC	Replace the Hard Coat	X
	T.O. SH 72-41-21 07	Instruction of Inspection criteria for Dimension A i.a.w. DER Approval: MTU T.O. No. SH 72-41-21 07 R 00	X

ATA 72-41-33

Plan-No. V724133-02150R1

Description HPC Stg. 3 Half Seal Ring

P/N 6A1093

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
002	VRS6038	Replace the Lining.	X
011	VRS6276	Blend Repair of Surface Damages.	X
016	VRS6347	Repair the Surface Protection.	X
	T.O. SH 72-41-33 03	Revised Repair Limits of VRS6038 i.a.w. DER Approval: MTU T.O. No. SH 72-41-33 03 R 00	X

ATA 72-41-21

Plan-No. V724121-03300R1

Description HPC Stg. 7 Cone & Path Assy

P/N 6A2849, 6A4177, 6A6540, 6A7577, 6B1430

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
	CINSP	Cleaning and Inspection	X
2	VRS6092	Blend Repair of Surface Damages.	X
4	VRS6161	Renewal of the Surface Protection	X
50	VRS6342	Repair the Location Dowel	X
91	VRS6671	Replace the Rotor Path Lining with METCO 320 Lining Material "with" removing Surface Protection	X
91	VRS6671	Replace the Rotor Path Lining with METCO 320 Lining Material "without" removing Surface Protection	X
	SB72-0369	Replace the old Rotor Path Lining with new METCO 320 Rotor Path Lining. P/N: 6A6540 is going to be P/N: 6A7577	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" for A5/D5 -Only-	X
	ASSEMBLY	Pre - Machining to 1mm below "Standardmaß" - Only - Recess	X
	ASSEMBLY	Final - Machining to "Standardmaß" for A5/D5 - Only -	X

Engine Type GE STANDARD PRACTICE MANUAL

ATA 72-21-10

Plan-No. A72-21-10C001

Description Spinner Cone

P/N 9064M55G02, 9064M55G02S, 9064M55G06, 9064M55G08, 9064M55G08S, 9064M55G09, 9155M15G01, 9155M15G01S, 9155M15G02, 9155M15G02S, 9155M15G03, 9155M15G03S, 9155M15G04, 9155M15G04S

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
	CINSP	Vorlauf für MTU-HAN Entlacken-Reinigen-Rissprüfen	X

Engine Type PW500

ATA 72-52-11

Plan-No. P5725002-1030R2

Description LPT Disk St. 2

P/N 30H1332, 30H1226, 30H1322

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
	CINSP	Cleaning and Inspection	X
1		Removal of Surface Damages.	X
2		Plasma Spray of Snap Diameter "B".	
		Restoration of abradable Coating on Knife Edge Seals Diameters.	X

Plan-No. P5725002-1030R1

Description LPT Disk St. 2

P/N 30H3141, 30H3152, 30H3172

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
		Blend Repair of Surface Damages.	X
		Plasma Spray of Snap Diameter "B".	
		Restoration of abradable Coating on Knife Edge Seals Diameters.	X
		Cleaning and Inspection	X

ATA 72-52-13

Plan-No. P5725002-1330R1

Description LPT Disk St. 4

P/N 30H3154, 30H3144, 30H3174

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
	CINSP	Cleaning and Inspection	X
1		Blend Repair of Surface Damages	X
2		Plasma Spray of Snap Diameter "B"	X
1		Repair 01 - only Subtask 72-52-13-380-019-001 - Shot Peening blended area per SPOP501	X
		Restoration of abradable Coating on Knife Edge Seals Diameters. Attention, this is a Source Demonstration Repair. No Changings to the Plan are permitted without prior approval from P&W Canada.	X

Engine Type V2500-A1-A5**ATA 72-41-33**

Plan-No. V724133-03200R1

Description HPC Stg. 4 Half Shroud Assy

P/N 6A3469, 6A7561, 6B1175

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
005	VRS6108	Repair the Surface Damage.	X
7	VRS6039	Replace the Lining.	X
18	VRS6631	Repair the Bush Location Holes.	X
23	VRS6677	Replace the Dowel Pin.	X

Repair	Basic document	Description	OAR
	T.O.SH 72-41-33 03	Revised Repair Limits of VRS6039 i.a.w. DER approval: MTU T.O. No. SH 72-41-33 03 R 00	X

Plan-No. V724133-02200R1 Description HPC Stg. 3 Half Shroud Assy

P/N 6A3467, 6A7719, 6B1156

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
002	VRS6038	Replace the Lining.	X
003	VRS6107	Repair the Surface Damage.	X
009	VRS6085	Replace the Dowel Pins.	X
18	VRS6631	Repair the Bush Location Holes.	X
	T.O.SH 72-41-33 03	Revised Repair Limits of VRS6038 i.a.w. DER approval: MTU T.O. No. SH 72-41-33 03 R 00	X

Engine Type GE STANDARD PRACTICE
MANUAL

ATA 72-56-01

Plan-No. A725601-01220R1 Description LPT Case Halfs

P/N 1778M85G01, 1778M85G02, 1778M85G03, 1778M85G04, 1778M86G01, 1778M86G02, 1778M86G03, 1778M86G04, 1778M89G01, 1778M89G02, 1778M89G03, 1778M89G04, 2083M27G01, 2083M27G02, 2083M27G03, 2083M27G04, 2083M27G05, 2083M27G06, 2083M27G07, 2083M27G08, 2083M27G09, 2083M27G10, 2083M27G11, 2083M27G12, 2083M27G13, 2083M27G14, 2083M27G15, 2083M27G16, 2083M27G17, 2083M27G18, 2083M27G19, 2083M27G20, 2083M27G21, 2083M27G22, 2083M27G23, 2083M27G24, 2083M38G01, 2083M38G02, 2083M38G03, 2083M38G04, 2083M38G05, 2083M38G06, 2083M38G07, 2083M38G08, 9044M10G07, 9044M10G08, 9044M10G10, 9044M10G11, 9044M10G12, 9044M10G13

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Weld Repair of LPT Stator Casing Flange areas and Nicks and Scores in the Rail area. (General Weld Repair)	X
2		Weld Repair of the LPT Stator Casing Boroscope Bosses and area.	X
3		Weld Repair of the LPT Stator Casing forward Flange Radius and forward Flange circumferential Weld Seam.	X
4		Weld Repair of LPT Stator Casing Radial Cracks in the Casing wall.	X
5		Weld Repair of the LPT Stator Casing No. 1 Rail Nozzle Support Ring Axial Cracks which do not extend into the casing wall.	X
6		Weld Repair of LPT Stator Casing Axial Cracks in the Casing wall.	X
7		Weld Repair of LPT Stator Casing Cracks and Fretting in the Support Rings.	X
8		Thermal Spray Repair the No. 1 Support Ring (Rail) with Wear resistant Coating.	X
9		Replacement of LPT Stator Casing Flange Washers.	X
11		Replacement of Nozzle Lock Pins and if required Weld build up Repair of Nozzle Lock Pin Holes.	X
12		LPT Stator Casing Flange Snap Diameter sizing.	X
13		Thermal Spray - Forward and After Flanges	
1		Weld Repair of Cracks in the LPT Stator Casing Horizontal Flange Fit Bores.	X
	SB72-1054	Scalloping of Rail 1.	X
	SB72-1227	Inspection and perhaps correction of Stg. 2 Nozzle Lock Pin Holes.	X
	SB72-1201	Plug welding of pre SB72-1201 Nozzle Lock Holes	X
	SPM	Additional Heat Treatment if Rewelding followed by Heat Treatment is required.	

Engine Type PW300

ATA 72-52-11

Plan-No. P3725002-3040R5

Description LPT Disk St. 3

P/N 30A1102, 30A1833, 30A1853, 30A2315, 30A2345, 30A1843

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
		Blend Repair of Surface Damages	X
		Plasma Spray of Snap Diameter "B".	
		Restoration of abradable Coating on Knife Edge Seals.	X
		Cleaning and Inspection	X

ATA 72-52-13

Plan-No. P3725002-3120R5

Description LPT Disk St. 5

P/N 30A1104, 30A1835, 30A1855, 30A1845

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
		Blend Repair of Surface Damages	X
		Plasma Spray of Snap Diameter "B".	X
		Restoration of abradable Coating on Knife Edge Seals Diameters.	X
		Cleaning and Inspection	X

ATA 72-52-11

Plan-No. P3725002-3040R6

Description LPT Disk St. 3

P/N 30A2281, 30A2303, 30A2323, 30A2313, 30A2343

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
1		Blend Repair of Surface Damages.	X
02		Plasma Spray of Snap Diameter "B".	X
		Restoration of abradable Coating on Knife Edge Seals Diameters.	X
		Cleaning and Inspection	X

ATA 72-50-13

Plan-No. P3725002-3120R6

Description LPT Disk St. 5

P/N 30A2283, 30A2305

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
		Blend Repair of Surface Damages.	X
		Plasma Spray of Snap Diameter "B".	
		Restoration of abradable Coating on Knife Edge Seals Diameters.	X
		Cleaning and Inspection	X

ATA 72-52-13

Plan-No. P3725002-3120R8

Description LPT Disk St. 3

P/N 30F1337-01, 30F1337-02, 30F1337-03, 30F1337-04, 30F1337-05, 30F1374-01, 30F1376-01

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Blend Repair of Surface Damages.	
2		Plasma Spray of Snap Diameter "B".	
	SRR 3725002-AL-001	Restoration of abradable Coating on Knife Edge Seals Diameters.	

Plan-No. P3725002-3040R8

Description LPT Disk St. 5

P/N 30F1006-06, 30F1006-07, 30F1006-08, 30F1006-09, 30F1006-10

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Blend Repair of Surface Damages.	
2		Plasma Spray of Snap Diameter "B".	
	SRR 3725002-AL-001	Restoration of abradable Coating on Knife Edge Seals Diameters.	X

Plan-No. P3725002-3040C6

Description LPT Disk Stg. 3

P/N 30A2281, 30A2303, 30A2323

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
	CINSP	Cleaning & Inspection	X

Engine Type V2500-A1-A5

Plan-No. V726029-01290C1

Description Deoiler Gearshaft

P/N 4B0004, 4B2222

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Engine Type GE STANDARD PRACTICE MANUAL

ATA 72-22-13

Plan-No. A722213-01090R1

Description Fan Stator Case Stg.2

P/N 9079M71G12, 9079M71G06, 9079M71G10, 9079M71G05, 9079M71G07, 9079M71G08, 9079M71G09, 1370M87G01

Manufacturer

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
7		Thermal Spraying	
5		Replace Honeycomb with Teflon	
6		Vane Retention Slot/Rail Repair	
7		Thermal Spraying of the shroud material only.	X
8		Metal Spray of the aft Rabbet Lip	
7		Thermal Spraying and Final machine of the shroud material - only	
	INSP	Blending Damages i.a.w. Inspection	
	SPM	Removal of High Metal per SPM70-42-00	
	SPM	Replacement of Damaged Nut Plates per Inspection Chapter	
	SPM	Replacement of Damaged Threaded Inserts of Stage 3 Case per SPM 70-48-11	
	SB72-0873	Repl. Worn or Damaged METCO 601 Shroud Material	

Plan-No. A722213-01115R1

Description Fan Stator Case Stg. 3

P/N 9079M72G08, 9079M72G09, 9079M72G10, 9079M72G11, 9079M72G13, 9079M72G14, 9079M72G15, 9079M72G17, 9196M27G01, 9196M27G02, 1370M88G01

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Weld Repair of Stage 2 and 3 Case	
6		Removal of High Metal from Vane Retention Slot/Rail per partial rep. 006	

Repair	Basic document	Description	OAR
7		Thermal Spraying of the shroud material only.	X
8		Metal Spray of the aft Rabbet Lip	
9		Locking Insert Boss Weld Repair of Stg. 3 Fan Case	
10		Bolthole Corrosion Repair Stg. 3	
7		Replace Worn or Damaged Thermal Spray Shroud Material	
7		Replace Worn Or Damaged Thermal Spray Shroud Matrial - only Thermal Spraying and Final Machining	
	SB72-873	Replace worn or damaged METCO 601 shroud material	
	SPM	Blending Damages i.a.w. Inspection	
	SPM	Removal of High Metal per SPM70-42-00	
	SPM	Replacement of Damaged Nut Plates per Inspection Chapter	
	SPM	Replacement of Damaged Threaded Inserts of Stage 3 Case per SPM 70-48-11	

ATA 72-21-11

Plan-No. A722111-01220R1

Description Stg. 1 Fan Blade Retainer + Spacer

P/N 9155M41P01, 9155M41P02, 9155M42P05, 9204M87P02, 9204M88P02, 9204M87P01, 9204M89P02

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Replacement of solid film Lubricant on Retainer and Configuration 01 Spacer.	
2		Replacement of electroless Nickel Plating on Retainer and Configuration 01 Spacer.	X

Engine Type V2500-A1-A5

ATA 72-60-42

Plan-No. V726042-01400R1

Description Bevel Radial Gearshaft

P/N 4B0196, 4B2202

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
002	VRS5193	Repair the Surfaces of the Bevel Radial Gearshaft	X
013	VRS5194	Chromium Plate the Upper Bearing Shoulder of the Bevel Radial Gearshaft	X
014	VRS5195	Chromium Plate the Upper Bearing Journal of the Bevel Radial Gearshaft	X
015	VRS5196	Chromium Plate the Lower Ball Bearing Journal of the Gearshaft	X
016	VRS5197	Chromium Plate the Lower Roller Bearing Journal of the Gearshaft	X
017	VRS5198	Chromium Plate the Lower Ball Bearing Shoulder of the Gearshaft	X
30	VRS5636	Repair the Surface of the Bevel Radial Gearshaft	
31	VRS5619	Chromium Plate the Lower Bearing Journal of the Bevel Radial Gearshaft	
32	VRS5621	Chromium Plate the Upper Bearing Journal of the Bevel Radial Gearshaft	
33	VRS5622	Chromium Plate the Lower Bearing Shoulder of the Bevel Radial Gearshaft	
34	VRS5623	Chromium Plate the Upper Bearing Shoulder of the Bevel Radial Gearshaft	

Engine Type PW2000

ATA 72-53-85

Plan-No. P725385-01060R1

Description Turbine Hub Retaining Nut

P/N 1A3620, 1B7100

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection per 72-53-85, INSP/CHK-00 and -01	X
1		Replace Silver Flash on Turbine Hub Retaining Nut.	X

Engine Type V2500-A1-A5

ATA 72-50-53

Plan-No. V725053-21300R1

Description Turbine Exhaust Case

P/N 2A3455-01, 2A3183-01, 2A3110-01, 2A3111-01, 2A4263-01, 2A4258-01, 4A8014, 4A8025, 4A8025-001, 4A8014-001, 2A3183-101

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
28	VRS5412	Nickel Plate the Oil Tube Mating Surfaces in the Turbine Exhaust Case Assembly	X
45	VRS3008	Blend Repair of Surface Damages	
57	VRS3111	Nickel Plate the Cover Bore	X
58	VRS3113	Chromium Plate the Bearing Bore.	X
59	VRS3114	Chromium Plate the No.5 Bearing Shoulder of the Turbine Exhaust Case	X
60	VRS3112	Chromium Plate the Seal Housing Bore of the Turbine Exhaust Case.	X

Engine Type PW2000

ATA 72-61-03

Plan-No. P726103-00010R1

Description Radial Drive Lower Shaft

P/N 7A2450, 7A2489, 7A2489-001, 7A2495, 7B0383, 7B0384, 7B0385

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
001		Blend Repair of Lower Radial Driveshaft Minor Surface Damage	X
002		Silver Plate the upper Splines.	X

Engine Type GE STANDARD PRACTICE MANUAL

ATA 72-23-21

Plan-No. H722503-05900R1

Description Fan Booster Stator Case Stg. 5

P/N 9385M26G05, 9385M26G06, 9385M26G07, 9385M26G08, 9385M26G10, 9385M26G11

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		REPAIR THE THERMAL SPRAY COATING	
8		Bolt Hole Corrosion Repair	
1		Application of abradable Lining - Subtask's: 72- 25-03-340-051 and 72-25-03-340-052 - only -	X
1		Application of Abradeable Lining and Final machining - only -	

ATA 72-25-03

Plan-No. H722503-05010R1

Description Fan Booster Stator Case Stg. 2-4

P/N 9385M68G10, 9385M68G04, 9385M68G05, 9385M68G06

Manufacturer

Issue: 23.01.2019

Repair	Basic document	Description	OAR
0	INSP	BLEND REPAIR Revision 87 einarbeiten AVO148 Blenden, PLU am 25.01.2018 erstellt Ernst	X
0	INSP	REPLACE INSERTS	X
001	REPAIR 001	REPAIR THE THERMAL SPRAY COATING	X

ATA 72-22-12

Plan-No. A722212-01050R1

Description Stg. 2 Outer Shroud

P/N 9079M70G05, 9079M70G06, 9079M70G07, 9079M70G08, 9079M70G09, 9079M70G10, 9079M70G12, 1370M86G01

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Weld Repair of Stg. 2 Outer Shroud	
6		Repl. Worn or Damaged METCO 601 Shroud Material	
4		Patch Repair of Aluminium Honeycomb	
5		Replace Honeycomb with Teflon	
6		Thermal Spraying of the Shroud Material only.	X
3		Repair of Aluminium Honeycomb Shroud	
	SPM	Remove High Metal and Blend i.a.w. Inspection	
	SB72-0873	SB72-0873 - Repl. Worn or Damaged METCO 601 Shroud Material	

Engine Type V2500-A1-A5

ATA 72-41-11

Plan-No. V724111-01200C1

Description HPC Stg. 3-8 Spool Assy

P/N 6A8316, 6A3508, 6A3648, 6A3934, 6A3936, 6A4189, 6A4900, 6A5467, 6A5592, 6A5594, 6A5659, 6A6473, 6A7379, 6A7380, 6A7382, 6A7383, 6A7384, 6A7385, 6A7401, 6A7705, 6A8236, 6A8318, 6A8350, 6B1386, 6B1384, 6B1385, 6B1404, 6B1406

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Special Cleaning TASK 72-41-11-110-001, SB72-0625, SB72-0637, AD2004-12-08, AD2015-10-04 Steps(h)(2) (3)	X
0	CINSP	Special Cleaning TASK 72-41-11-110-001, SB72-0625, SB72-0637, AD2004-12-08, AD2015-10-04 Steps(h)(2) (3)	X
0	CINSP	Cleaning incl. Special Cleaning; NMSB72-0625 ECI; AD 2015-10-04 Steps (h)(2)(3) With Masking of Lining	X
0	CINSP	Cleaning incl. Special Cleaning; NMSB72-0625 ECI; AD 2015-10-04 Steps (h)(2)(3) Without Masking of Lining	X
	EO-MTU-0108	Non-OEM Repair EO-0108 Inspection	X

Engine Type PW2000

ATA 72-51-01

Plan-No. P725101-01001R1

Description HPT First Stage Cooling Duct Assy

P/N 1B2571, 1B3290, 1B3568, 1B3569, 1B4464, 1B4464-001, 1B4465, 1B5206, 1B5206-001, 1B5206-002, 1B5896, 1B6276, 1B6276-001, 1B6276-002, 1B6380, 1B6380-001, 1B6380-002

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Air Flow Check i.a.w. E.M. Inspection/Check 03	X
0	CINSP	Cleaning and Inspection	X
1		Repair to adjust the Air Flow of the Cooling Duct.	X
2		Blend Repair of Nicks, Dents and Corrosion.	X

Repair	Basic document	Description	OAR
4		Plasma Spray Repair the worn outer Diameter.	X
5		Restore Worn Inner Diameter By Plasma Coating	X
6		Plasma Spray Repair the worn Front Outer Diameter.	X
11		Weld Repair of Outer Flange radially Outward and Bolthole Cracks.	X
13		Replace the threaded Inserts.	X
	SB72-0479	Modification of HPT First Stage Cooling Duct as per Table A Page 25.	X
	SB72-0479	Modification of HPT First Stage Cooling Duct as per Table B Page 26.	X

ATA 72-53-04

Plan-No. P725304-06060R1

Description Turbine Outer Inter Duct Assy

P/N 8A2868, 8A2651, 8A2650, 8A2541, 8A2480, 8A2289, 8A1897, 8A1897-001, 8A1897-002, 8A1897-003, 8A1897-004, 1B5480, 8A1565, 8A1565-001, 8A1565-002, 8A1565-003, 8A1565-004

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
001		Blend,FPI,Corrosion Removal incl.Touch Up Coating	X
001		Touch Up Coating - only -	X

Engine Type V2500-A1-A5

ATA 72-60-28

Plan-No. V726028-01450R1

Description IDG Drive Housing

P/N 4B0312, 4B2282, 4B0161, 4B0271, 4B0281, 4B0348

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
6	VRS5059	Replace the Damaged Studs in the IDG Drive Housing.	
7	VRS5060	Replace the Damaged Screw Thread Inserts	X
8	VRS5061	Nickel Plate the Adapter Mating Surface of the Integrated Drive Generator (IDG) Drive Housing.	
9	VRS5064	Repair the IDG Seat by Bushing in IDG Housing	X
10	VRS5065	Repair the Seal Housing Seat by Bushing in IDG Housing.	
11	VRS5062	Repair the Seal Housing Mating Surface by Flanged Bushing in IDG Housing.	
12	VRS5066	Repair the Bearing Seat by Bushing in IDG Housing	X
13	VRS5067	Nickel Plate the Mounting Face of the Integrated Drive Generator (IDG) Drive Housing.	
14	VRS5063	Repair the Bearing Mating Surface by Flanged Bushing in IDG Housing.	
15	VRS5068	Nickel Plate the Large Piloting Diameter of the Integrated Drive Generator (IDG) Drive Housing	
16	VRS5069	Nickel Plate the Small Piloting Diameter of the Integrated Drive Generator (IDG) Drive Housing.	
17	VRS5558	Repair the Surfaces of the IDG Housing.	
27	VRS5525	Repair the Surface of the VSCF Housing	
28	VRS5526	Repair the Surface Protection of the VSCF Housing	
29	VRS5527	Replace the Damaged Inserts in the VSCF Housing	
30	VRS5528	Replace the Damaged Pins	
31	VRS5529	Replace the Damaged or Loose Helicoil Inserts in the VSCF Housing	
34	VRS5532	Nickel Plate the Seal Housing Bore Diameter of the VSCF Housing	X
35	VRS5533	Repair the VSCF Housing Bore by Bushing	
36	VRS5534	Nickel Plate the Hosuing Piloting Diameter of the VSCF Drive Housing	

Repair	Basic document	Description	OAR
37	VRS5535	Nickel Plate the mounting Face of the VSCF Housing	

ATA 72-50-00

Plan-No. V725000-01240R1

Description LPT Stg. 6 Inner Air Seal

P/N 3A0078, 3A3063, 3A3047

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS4018	Blend Repair the Knife Edge Seals of the LPT Stg. 6 Inner Air Seal.	X
3	VRS4020	Blend Repair the LPT Stg. 6 Inner Air Seal.	X
4	VRS4021	Plasma Spray the Snap Diameter of the LPT Stg. 6 Inner Air Seal.	
6	VRS4027	Rebalance the LPT Stg. 6 Inner Air Seal.	X
10	VRS4627	Blend Repair the Stg.6 Inner Air Seal	X
11	VRS4628	Blend Repair the Knife Edge Seal	X
13	VRS4630	Rebalance the Stage 6 Turbine Inner Air Seal	X
	VRS4585	Blend Repair of Surface Damages.	X

ATA 72-60-42

Plan-No. V726042-01130R1

Description Oil Duct

P/N 4B0297, 4B2203, 4B0259

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
36	VRS5662	Chromium Plate the Pilot Diameter	X
37	VRS5687	Repair the Pilot Diameter of the Oil Duct	X
38	VRS5688	Chromium Plate the Pilot Diameter	X
39	VRS5689	Chromium Plate the Pilot Diameter	X

ATA 72-41-31

Plan-No. V724131-01705R1

P/N 6A5994, 6A7576

Manufacturer INTERNATIONAL AERO ENGINES

Description HPC Stg. 6 Rot. Path Segm. (A5-D5)

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
004	VRS6032	Blend Repair of Surface Damages.	X
	VRS6670	Replace the Rotor Path Lining with Metco 320 Lining Material.	X
	SB72-0369	Replace the old Rotor Path Lining with new METCO 320 Lining Material. P/N Change: 6A5994 -> 6A7576	X
	ASSEMBLY	Pre-Machining to 1mm below "Standardmaß" for A5/D5 only	X
	ASSEMBLY	Final Machining to "Standardmaß" for A5/D5 Only	X

Plan-No. V724131-01690R2

Issue: 23.01.2019

Description HPC Stg. 4 Rot. Path Segm. (A1)

P/N 6A3531

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
6	VRS6243	Replace the Rotor Path Lining.	X
7	VRS6208	Blend Repair of Surface Damages.	X
6	ASSEMBLY	Final Machining to "Standardmaß" A1 - Only -	X
	T.O. SH 72-41-31 07	Non-OEM Repair Dimensional Restoration of HPC Rotor Path Segment Lands i.a.w. DER approval	X
	SB72-0449	Final Machining per SB72-0449 - only -	X

Plan-No. V724131-01685R2

Description HPC Stg. 3 Rot. Path Segm. (A1)

P/N 6A3758

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
3	VRS6031	Blend Repair of Surface Damages.	X
5	VRS6242	Replace the Rotor Path Lining.	X
5	VRS6242	Final Machining to "Standardmaß" A1 - Only -	X
	T.O. SH72-41-31 07	Non-OEM Repair Dimensional Restoration of HPC Rotor Path Segment Lands.	X

ATA 72-45-14

Plan-No. V72-45-14R001

Description V2500 HPT Blade Stg.1 (Pre Select)

P/N 2A9321, 2A9721

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
	EO-MTU-0052	New Configuration Full Repair	X

Engine Type GE STANDARD PRACTICE MANUAL

ATA 72-34-01

Plan-No. A723401-01001R1

Description CRF Case

P/N 1340M73G01, 1340M73G02, 1340M73G03, 1340M73G04, 1340M73G05, 1340M73G06, 1340M73G07, 1340M73G08, 1340M73G09, 1340M73G10, 1340M73G11, 1340M73G12, 1340M73G13, 1340M73G14, 1340M73G15, 1340M73G16, 1340M73G17, 1340M73G18, 1340M73G19, 1340M73G20, 1340M73G21, 1340M73G22, 1340M73G23, 1340M73G24, 2092M45G01, 2092M45G02, 2092M45G03, 2092M45G04, 2092M45G05, 2092M45G06, 2092M45G07, 2092M45G08, 2092M45G09, 2092M45G10, 2092M45G11, 2092M45G12, 2092M45G13, 2092M45G14, 2092M45G15, 2092M45G16, 2092M45G17, 2092M45G18, 2092M45G19, 2092M45G20, 2092M45G21, 2092M45G22, 2092M45G23, 2092M45G24, 2092M45G25, 2092M45G26, 2092M45G27, 2092M45G28, 2092M45G29, 2092M45G30, 2092M45G31, 9062M60G14, 9062M60G21, 9062M60G23, 9062M60G24, 9062M60G25, 9062M60G27, 9062M60G28, 9062M60G29, 9062M60G30, 9062M60G32, 9062M60G33, 9062M60G34, 9062M60G35, 9062M60G36, 9062M60G38, 9083M33G03, 9083M33G04, 9173M23G02, 9173M23G03, 9173M23G05, 9173M23G07, 9173M23G08, 9173M23G09, 9173M23G14, 9173M23G17, 9173M23G18, 9173M23G21, 9173M23G22, 9173M23G23, 9173M23G24, 9173M23G27, 9173M23G29, 1347M30G01, 9147M38G01, 9147M38G03, 9147M38G04, 9147M38G05, 9147M38G08, 9147M38G11, 9147M38G12, 9147M38G15, 9147M38G17

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		Weld Repair	X
5		Dimensional Restoration of Flanges.	X
6		Threaded Boss Repair.	

Repair	Basic document	Description	OAR
7		Rem. And Reinst. CRF Sump Vent Tube	
8		Oil Inlet Tube Replacement	
9		Oil Scavenge Tube Replacement	
10		Seal Drain Tube Replacement	
11		Replace Sump Pressure Tube	
12		Weld Repair of Hub and inner Flow Passage Flange Hole radial Cracks.	X
17		Weld Repair and dimensional Restoration of Fuel Nozzle and Ignitor Pads.	X
20		Shot peening of CRF fwd. and outer Casing Mid- Flange.	X
21		Bench and Weld Repair of CRF Mid-Flange Damage.	X
22		Replacement of CRF Lock Wire Tab.	X
24		Weld Repair of worn bolt holes in CRF aft-Flange.	X
25		Bleed Port Flange Weld Repair.	X
28		Replace Aft Inner Diffuser Ring And Flange	
29		Mid Flange Replacement	
30		Mid Flange Replacement Without Forward Flange	
31		Repair of Oil Tube Strut Openings.	X
32		CDP-Seal-Flange Replacement	X
33		Sump Flange Replacement Excl Material	
34		Dimensional Restoration of Bleed Port Flanges.	X
36		Vent Air Seal Flange (Surf. BX) Insert Repair.	X
38		Dimensional Restoration of Strut Pad Flanges.	X
	SB72-876	Replacement of the Forward Flange with thickened Flange thickness	X

Repair	Basic document	Description	OAR
	SB72-1296	Combuster Liner Cowl Mounting Pins with floating Pins improvement.	X
	SB72-639	Add Wear Sleeve To Scavange Tube	
	SB72-828	Enlargement of 16ea. fwd. Flange Bolt Holes.	X
	SB72-837	Mid Flange E/C Inspection	
	SB72-839	Ingniter Port E/C Inspection	
	SB72-984	Oil Inlet Tube Replacement	
	ASSEMBLY	Installation of Sump Housing, dimensional Inspection, Tubing Installation and Pressure Check.	X

Engine Type CF34-1A/-3A/-3A2 (BJ OLD)

ATA 72-21-09

Plan-No. B1072-21-09R001

P/N 45P1082

Manufacturer GENERAL ELECTRIC

Description Booster IGV Assy

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
2		Repair of the Inner Shroud Abradeable Coating	
3		Repair of the Outer Shroud Abradable Material	X

Plan-No. B1072-21-09R003

P/N 45P1169

Manufacturer GENERAL ELECTRIC

Description Stage 3 Vane Assy

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
2		Repair the Inner Shroud Abradeable Coating	
3		Repair of the Outer Shroud Abradable Material.	X

Plan-No. B1072-21-09R004

P/N 45P1075

Manufacturer GENERAL ELECTRIC

Description Stage 4 Vane Assy

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
2		Repair the Inner Shroud Abradeable Coating	
3		Repair of the Outer Shroud Abradable Material	X

Engine Type GE STANDARD PRACTICE
MANUAL

ATA --

Plan-No. H722321-35001R1

P/N 9385M26G05, 9385M26G06, 9385M26G07, 9385M26G08, 9385M26G10, 9385M26G11

Manufacturer

Description Fan Booster Stator Case Stg. 5

Repair	Basic document	Description	OAR
1	PARTLY REPAIR 1	Repair 1 partly	X

Repair	Basic document	Description	OAR
		BUMPER STRIP REPAIR	X
		REPLACEMENT OF WORN OR DAMAGED WEAR PADS	X
		BOLT HOLE CORROSION REPAIR	X
		BLEND SURFACE DAMAGE IAW INSPECTION	X

ATA 72-34-10

Plan-No. A723410-01140R1

Description CRF Sump Housing

P/N 9062M51G06, 9062M51G07, 9062M51G08, 9062M51G09, 9062M51G10

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1		WELD REPAIR VARIOUS AREAS OF CRF SUMP HOUSING.	X
2		METAL SPRAY/MACHINE CRF SUMP DIAMETERS AND SURFACES	X
3		REPLACE THREADED END FITTINGS.	X
4		CONE AND FLANGE REPLACEMENT	
5		WELD REPAIR OF INTERNAL LINEAR INDICATIONS.	X
6		REFACE TUBING FITTING SPHERICAL SEATING SURFACE	X
	SB72-0456	Drill/Countersink Flange Holes	

Engine Type PW206A PW206E PW207E**ATA 72-21-50**

Plan-No. P2-72-21-50R001

Description Compressor Inlet Case

P/N 3049536-01, 3123474-01, 02R3044117-01, 01R3044117-01, 3044117-01, 01R3120264-01, 02R3120264-01, 3120264-01, 3114468-01

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
15		Nickel Plating of the No.3 Bearing Housing Mating Diameter - only Subtask: 72-21-50-330-013-008 Nickel Plating SPOP43	X
15		Nickel Plating of the No.3 Bearing Housing Mating Diameter - only Subtask: 72-21-50-330-013-009 Nickel Plating SPOP43	X
15		Nickel Plate of the No.3 Bearing Housing Mating Diameter - only Subtask: 72-21-50-330-013-010 Nickel Plating SPOP43	X

Engine Type V2500-A1-A5**ATA 72-60-43**

Plan-No. V726043-01420R1

Description Gearshaft

P/N 4P0224, 4P2206

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
1	VRS5199	Repair the Surfaces of the Bevel Gearshaft	X
3	VRS5200	Chromium Plate the Ball Bearing Journal	X
4	VRS5201	Chromium Plate the Roller Bearig Journal	X
6	VRS5625	Repair the Surface of the Bevel Gearshaft	
7	VRS5626	Chromium Plate the Roller Bearing Journal of the Bevel Gearshaft	
8	VRS5627	Chromium Plate the Ball Bearing Journal of the Bevel Gearshaft	

Repair	Basic document	Description	OAR
9	VRS5628	Chromium Plate the Roller Bearing Shoulder of the Bevel Gearshaft	

ATA 72-41-11

Plan-No. V724111-01200R2

Description HPC Stg. 3-8 Spool

P/N 6A3934, 6A3936, 6A4189, 6A4900, 6A5467, 6A5592, 6A5594, 6A5659, 6A6473, 6A7379, 6A7380, 6A7382, 6A7383, 6A7384, 6A7385, 6A7401, 6A7705, 6A8236, 6A8318, 6A8316, 6A8350, 6B1379, 6B1380, 6B1381, 6B1382, 6B1383, 6B1384, 6B1385, 6B1386, 6B1387, 6B1391, 6B1392, 6B1393, 6B1401, 6B1402, 6B1403, 6B1404, 6B1405, 6B1406, 6A3648

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection incl. Special Cleaning TASK 72-41-11-110-001, SB72-0625, SB72-0637, AD2004-12-08, AD2015-10-04 Steps(h)(2)(3)	X
3	VRS6047	Repair the Surface Damage by Dressing	
11	VRS6220	Install new shank nuts	X
22	VRS6626	Repair the Damage to the HP Compressor Stage 3 to 8 Disks Shaft Assembly Damper Wire Grooves	X
	EO-MTU-0055	Removal of Fretting in the Stg. 6 Front to Stg. 8 Rear Damper Wire Grooves per EO-MUT-0055 Chapter 6	X
	EO-MTU-0108	Removal of Fretting in Stg. 6 Front Damper Wire Groove	X
	EO-MTU-0108	Removal of Fretting in Stg. 6 Rear Damper Wire Groove	X
	EO-MTU-0108	Removal of Fretting in Stg. 7 Front Damper Wire Groove	X
	EO-MTU-0108	Removal of Fretting in Stg. 7 Rear Damper Wire Groove	X
	EO-MTU-0108	Removal of Fretting in Stg. 8 Front Damper Wire Groove	X
	EO-MTU-0108	Removal of Fretting in Stg. 8 Rear Damper Wire Groove with milling and coating	X
	EO-MTU-0108	Removal of Fretting in Stg. 8 Rear Damper Wire Groove without milling and coating	X

Repair	Basic document	Description	OAR
	EO-MTU-0108	Repair of Fretting of Damper Wire Grooves Stg.6-8	X
	SB72-0606	Install new shank nuts	X

Engine Type GE STANDARD PRACTICE ATA 72-32-01
MANUAL

Plan-No. A723201-01001R1 Description HPC Front Case
P/N 1370M93G03, 1370M93G04, 1370M93G05, 1370M93G01, 9206M86G01, 9206M86G02, 9206M86G04, 9206M86G05, 9206M86G07, 9206M86G09, 1370M93G02
Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
3		Repair of Body-Bound Bolt Holes	
4		Repair of VSV Bolt Holes by installing interference fit bushings	
8		Thermal Spray Of Surface U and Dia Y	X
14		VSV Counterbore Face Repair by metal spray	
17		Thermal Spray of Forward Rabbet Dia R and Flange Surface AD	
19		Gaps between horiz. Flange	
25		Rub Coat Replacement	X
26		Replace of Corrosion Preventive Paint	
27		Thread Repair of Steel Cases	
28		Weld Repair on St. 7,8,10 Manifold	
29		Machining repair of the Stage 6-11 fixed vane dovetail slots	
32		Weld Repair of the Fixed Vane T-Slot	

Repair	Basic document	Description	OAR
33		Weld Repair of Mounting Pads	
34		Safety wire rip holes weld repair	
25		Thermal Spraying of the front stator rub coat material only.	X
	SPM	Repair of Surface Damages at horizontal Flanges by Blending and High Metal removal per Inspection	X
	SPM	Blend Nicks + Scratches on circum. FI mating Surf. per Inspection	
	SPM	Blend Repair on Casing ID parent metal per Inspection	
	SPM	Blend Nicks + Scratches on var. Vane Bore mating Faces per Inspection	
	SPM	Blend Nicks + Scratches on Manifolds Surfaces per Inspection	
	SPM	Blend Nicks + Scratches on Case OD Surfaces per Inspection	
	SPM	Remove high metal on wear caused f. VSV Actuator Ring Spacer per Inspection	
	SPM	Blend the thin edges of the boltholes to a radius per Inspection	
	SB72-0868	Scallop St.8 Manifolds Rips	

ATA --

Plan-No. A723301-01001R1

Description HPC Rear Case

P/N 1538M55G01, 1538M55G02, 1538M55G03, 1538M55G04, 1538M55G05, 1538M55G06, 9065M12G18, 9065M12G19, 9065M12G21, 9065M12G22, 9065M12G23, 9065M12G25, 9065M12G26, 9065M12G27, 9225M10G05, 9225M10G06, 9225M10G07, 9225M10G08

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	
1		Thermal spraying the casing ID	

Repair	Basic document	Description	OAR
2		WELD REPAIR	
4		Repair of Alignment Bolt Holes	
6		METAL SPRAY REPAIR THE ID	
15		THERMAL SPRAY REPAIR FORWARD FLANGE RABBET AND FORWARD FLANGE FACE THERMAL SPRAY	
9		THERMAL SPRAY AFT FLANGE RABBET	
11		Repair of Borescope Port Threads	
12		METAL SPRAY HORIZONTAL FLANGE GAPS	
14		T-Slot Lip Wear Repair by welding	
16		Aft Flange Face Thermal Spray Repair	
17		Weld Repair of the Fixed Vane T-Slots	
18		Repair of the forward and/or aft flanges splitline boltholes	
8		Repair of Forward Flange Rabbet	
1		Final machining of Rub Coat to standard Dimensions.	
1		Final machining of Rub Coat to minimum Standart-Dimensions required by Customer.	
1		Final machining of Rub Coat to 0,4 mm under Standart-Dim. required by Customer	
1		Final machining of Rub Coat to the Max.- standard Dimensions	
1		Final machining of Rub Coat to 0,2 mm under Standart-Dim. required by Customer	
	SPM	Blending of surface Damage on horizontal Flanges	
	SPM	Blending of surface Damage on fwd.circu. Flange.	
	SPM	Blending surface Damage on aft.circumferential Flange	
	SPM	Removal of high spots on Casing Flowpath surfaces	
	SB72-0898	Modification of Rear Case Aft Flange Bolt Hole Spot Face	

Repair	Basic document	Description	OAR
	SB72-0951	X-Ray Inspection of Aft Flange EB-Weld	

ATA 72-31-04

Plan-No. H72-31-04R002 Description HPC Disk Stg.1

P/N 1644M21P04, 1644M21P05, 9380M26P02, 9380M26P03, 9380M26P05, 9380M26P06

Manufacturer

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X
7		Repair the Locating Dia "K" per Thermal Spray.	
	SPM	Blending of surfaces per Inspection incl. Shotpeen per Repair001	X
	SPM	Blending of Seal Serrations and/or Locating Dia "K" without Shotpeen.	X
	SPM	Reaming and/or Blending the Boltholes per Inspection incl. Shotpeen Repair 001.	
	SPM	Dry Abrasive blast surface "A" after Inspection and/or Repair	X

Engine Type GP7000GE

ATA 72-09-76

Plan-No. G72-09-76C001 Description ACC Collector

P/N 5783001

Manufacturer ENGINE ALLIANCE

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Engine Type GE STANDARD PRACTICE ATA --

MANUAL

Plan-No. H72-31-00R001 Description HPC Blades Stg.1 - 11 1.Fahrt

P/N K024G01, K024G02, K024G03, K024G05, K157G02, K194G02, K212P03, K212P04, K215P01, K215P02, K645P17, K645P18, K645P19, K645P20, K645P21, K645P22, K645P23, K645P24, K615P01, K615P02, K615P03, K615P04, K615P05, K615P06, K615P07, K615P08, K615P09, K615P10, K615P11, K615P12, K615P13, K615P14, K615P15, K615P16, K818P05, K818P06, K818P07, K818P08, K818P09, K818P10, K818P11, K818P12, K818P13, K818P14, K818P15, K818P16, K818P17, K818P18, K818P19, K818P20, K658P01, K658P02, K658P03, K658P04, K658P05, K658P06, K658P07, K658P08, K088P07, K088P08, K088P09, K088P10, K090P01, K090P02, K090P03, K090P04, K090P05, K090P06, K090P07, K090P08, K090P09, K090P10, K090P11, K090P12, K090P13, K090P14, K090P15, K090P16, K188P15, K188P16, K188P17, K188P18, K188P19, K188P20, K188P21, K188P22, K190P01, K190P02, K190P03, K190P04, K190P05, K190P06, K190P07, K190P08, K190P09, K190P10, K190P11, K190P12, K190P13, K190P14, K190P15, K190P16, K645P13, K645P15, K645P16, K645P14

Manufacturer

Repair	Basic document	Description	OAR
		Application of MTU Plus ERCoat Erosion Coating on HPC Blades	X

Plan-No. H72-32-00R002 Description HPC Vanes Stg.3-8 3. Fahrt

P/N K086P04, K186P04, K231P02, K461P02, K461P03, K286P04, K232P01, K462P01, K462P02, K344P04, K233P01, K463P01, K463P02, K464P02, K464P01, K234P01, K445P04, K575P02, K235P01, K465P01, K465P03, K236P01, K236P02, K236P03, K236P04, K236P05, K236P06, K466P01, K466P02, K466P03, K466P04, K466P05, K466P06, K600P31, K600P32, K600P34, K600P35, K600P36, K600P38, K600P48, K600P49, K600P45, K600P46, K600P50, K600P52, K237P01, K237P02, K237P03, K237P04, K467P01, K467P02, K467P03, K467P04, K779P35, K779P34, K779P38, K779P62, K779P63, K779P64, K779P36, K779P66, K779P65, K779P37, K238P01, K238P02, K238P03, K238P04, K468P01, K468P02, K468P03, K468P04, K808P10, K808P11, K808P12, K808P09, K808P15, K808P17, K808P14, K808P16, K808P18

Manufacturer

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
		Application of MTU Plus ERCoat Erosion Coating on HPC Vanes	X

Engine Type GP7000GE

Plan-No. G72-09-76R001 Description ACC Collector
P/N 5783001
Manufacturer ENGINE ALLIANCE

Repair	Basic document	Description	OAR
4		Braze The Front and Rear Bracket Braze Jount(s) - ACC Collector	

Engine Type GE STANDARD PRACTICE MANUAL

Plan-No. H72-31-00R002 Description HPC Blades Stg.3;4;7;9;12- 14 2. Fahrt

P/N K643P24, K643P23, K643P22, K643P21, K643P20, K643P19, K643P18, K643P17, K644P17, K644P18, K644P19, K644P20, K644P21, K644P22, K644P23, K644P24, K715P05, K715P06, K715P07, K715P08, K715P09, K715P10, K715P11, K715P12, K715P13, K715P14, K715P15, K715P16, K715P17, K715P18, K715P19, K715P20, K657P01, K657P02, K657P03, K657P04, K657P05, K657P06, K657P07, K657P08, K717P05, K717P06, K717P07, K717P08, K919P05, K919P06, K919P07, K919P08, K919P09, K919P10, K919P11, K919P12, K919P13, K919P14, K919P15, K919P16, K919P17, K919P18, K919P19, K919P20, K289P07, K289P08, K289P09, K289P10, K289P11, K289P12, K289P13, K289P14, K289P15, K289P16, K289P17, K289P18, K388P11, K388P12, K388P13, K388P14, K388P15, K388P16, K388P17, K388P18, K488P09, K488P10, K488P11, K488P12, K488P13, K488P14, K488P07, K488P08, K644P13, K644P16, K644P14, K644P15

Manufacturer

Repair	Basic document	Description	OAR
		Application of MTU Plus ERCoat Erosion Coating on HPC Blades	X

Plan-No. H72-32-00R003

Description HPC Vanes Stg.9 - 13 4.Fahrt

P/N K239P02, K239P01, K239P03, K239P06, K469P02, K469P01, K239P04, K239P05, K900P09, K900P08, K469P03, K469P05, K900P10, K469P04, K469P06, K900P16, K900P11, K900P14, K900P12, K470P06, K012P02, K012P01, K012P07, K012P04, K240P06, K012P03, K240P01, K012P09, K012P05, K470P04, K240P02, K470P01, K240P03, K240P04, K470P05, K470P02, K470P03, K240P05, K182P37, K182P83, K182P36, K241P01, K182P41, K182P79, K241P03, K471P17, K182P38, K182P82, K182P63, K241P05, K182P42, K182P80, K241P04, K471P18, K182P65, K241P02, K182P81, K471P01, K182P68, K182P84, K241P07, K471P03, K182P64, K241P06, K471P15, K182P69, K182P85, K241P08, K471P04, K182P77, K471P02, K182P78, K471P16, K200P13, K200P12, K200P15, K200P16, K200P14, K472P01, K200P18, K200P17, K472P02, K242P01, K472P03, K472P04, K242P02, K242P03, K242P04, K472P06, K472P05, K242P06, K242P05, K027P06, K027P05, K027P04, K027P03, K027P02, K027P01, K027P07

Manufacturer

Repair	Basic document	Description	OAR
		Application of MTU Plus ERCoat Erosion Coating on HPC Vanes	X

Engine Type V2500-A1-A5

ATA 72-60-23

Plan-No. V726023-01460R1

Description Hydraulic Pump Drive Housing

P/N 4B2281, 4B0350

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS5034	Repair the Surfaces of the Hydraulic Pump Drive Housing	
2	VRS5035	Replace the Damaged Studs in the Hydraulic Pump Drive Housing	
3	VRS5036	Replace the Damaged Screw Thread Inserts in the Hydraulic Pump Drive Housing	
4	VRS5037	Nickel Plate the Hydraulic Pump Mating Surface of the Hydraulic Pump Housing	
5	VRS5038	Repair the Seal Housing Mating Surface by Flanged Bushing in Hydraulic Pump Housing	
6	VRS5039	Repair the Roller Bearing Mating Surface of the Hydraulic Pump Drive Housing by Bushing	

Repair	Basic document	Description	OAR
7	VRS5040	Repair the Seal Housing Bore by Bushing in Hydraulic Pump Housing	
8	VRS5041	Repair the Seal Housing Bore by Bushing in Hydraulic Pump Housing	
9	VRS5042	Repair the Roller Bearing of the Hydraulic Pump Drive Housing by Bushing	
10	VRS5043	Nickel Plate the Mounting Face of the Hydraulic Pump Housing	
11	VRS5044	Nickel Plate the Piloting Diameter of the Hydraulic Pump Housing	
19	VRS5416	Replace the Damaged Inserts in the Hydraulic Pump Drive Housing	
20	VRS5417	Replace the Damaged Sleeve in the Hydraulic Pump Drive Housing	
23	VRS5494	Repair the Surface of the Hydraulic Pump Drive Housing	X
24	VRS5495	Repair the Surface Protection of the Hydraulic Pump Drive Housing	X
25	VRS5496	Replace the Damaged Studs in the Hydraulic Pump Drive Housing	
27	VRS5498	Replace the Damaged Inserts in the Hydraulic Pump Drive Housing	
30	VRS5501	Nickel Plate the Seal Housing Bore Diameter of the Hydraulic Pump Drive Housing	X
31	VRS5502	Nickel Plate the Housing Piloting Diameter of the Hydraulic Pump Housing	
32	VRS5503	Nickel Plate the Mating Flanged Surface of the Hydraulic Pump Housing	

ATA 72-32-71

Plan-No. V723271-02300R1

P/N 5A0474

Manufacturer INTERNATIONAL AERO ENGINES

Description LPC Bleed Valve Upper Power Arm

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X

Repair	Basic document	Description	OAR
25	VRS1719	Repair the Damaged Pin Hole by Chromium Plate	X
		Repair Surface Damage by Blending	X

Engine Type PW6000

ATA 72-35-58

Plan-No. P6-72-35-58R001 Description Compressor Inner Front Case Stg.11
P/N 5495421
Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
01		Blend The Surface Damage	X
02		Replace The Shank Nut	X
04		Plasma Spray The Stage 10 Inner Case Front Mating Diameter	X
05		Plasma Spray the Rear Mating Diameter	X

Engine Type V2500-A1-A5

ATA 72-60-27

Plan-No. V726027-01140R1 Description Idler Gear
P/N 4B0182, 4B2226
Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
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Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS5156	Blend Repair	X
2	VRS5157	Chromium Plate the Front Bearing Shoulder of the Idler Gear	
3	VRS5158	Chromium Plate the Front Bearing Journal	X
4	VRS5159	Chromium plate the Rear Bearing Journal	X
5	VRS5160	Chromium Plate the Rear Bearing Shoulder of the Idler Gear	
6	VRS5590	Repair the Surface of the Idler Gear	
7	VRS5591	Chromium Plate the Front Bearing Journal of the Idler Gear	
8	VRS5592	Chromium Plate the Rear Bearing Journal of the Idler Gear	
9	VRS5593	Chromium Plate the Rear Bearing Shoulder of the Idler Gear	
10	VRS5594	Chromium Plate the Front Bearing Shoulder of the Idler Gear	

ATA 72-60-25

Plan-No. V726025-01210R1

P/N 4B0087, 4B0351, 4B2214

Manufacturer INTERNATIONAL AERO ENGINES

Description Fuel Pump Drive Housing

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
1	VRS5046	Repair the Surfaces of the Fuel Pump Drive Housing	
2	VRS5047	Replace the Damaged Studs in the Fuel Pump Drive Housing	
3	VRS5048	Replace the Damaged Screw Thread Inserts in the Fuel Pump Drive Gear Assembly	

Repair	Basic document	Description	OAR
4	VRS5177	Repair the Surfaces of the PMA Driveshaft	
6	VRS5051	Repair the Bearing Mating Surface by Flanged Bushing in the Fuel Pump Drive Housing	
7	VRS5052	Repair the Adapter Seat by Bushing in the Fuel Pump Drive Housing	
8	VRS5053	Repair the Seal Housing Seat by Bushing in the Fuel Pump Drive Housing	
9	VRS5054	Repair the Bearing Seat by Bushing in the Fuel Pump Drive Housing	
10	VRS5055	Nickel Plate the Mounting Face of the Fuel Pump Drive Housing	
11	VRS5056	Nickel Plate the Large Piloting Diameter of the Fuel Pump Drive Housing	
12	VRS5057	Nickel Plate the Small Piloting Diameter of the Fuel Pump Drive Housing	
21	VRS5504	Repair the Surface pf the Cover	
22	VRS5629	Repair the Surface of the PMA Shaft and Rotor	
25	VRS5508	Replace the Damaged Pins	
26	VRS5509	Replace the Damaged Inserts in the Cover	
29	VRS5512	Nickel Plate the Seal Housing Bore Diamater of the Cover	X

ATA 72-60-22

Plan-No. V726022-01300R1

P/N 4B0248, 4B0349, 4B2213

Manufacturer INTERNATIONAL AERO ENGINES

Description Starter Drive Housing

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
24	VRS5484	Repair the Surface of the Starter Drive Housing.	

Repair	Basic document	Description	OAR
25	VRS5485	Repair the Surface Protection of the Starter Drive Housing.	
26	VRS5486	Replace the Damaged Studs in the Starter Drive Housing.	
27	VRS5487	Replace the Damaged Inserts in the Starter Drive Housing.	
30	VRS5490	Nickel Plate the Seal Housing Bore Diameter	X
31	VRS5491	Nickel Plate the Housing Piloting Diameter of the Starter Drive Housing.	
32	VRS5492	Nickel Plate the Mounting Face of the Starter Drive Housing.	
33	VRS5493	Repair the Starter Housing Adapter Bore by Bushing.	

ATA 72-45-31

Plan-No. V724531-01011C1

Description HPT Stage 2 Hub

P/N 2A4802

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
	NMSB72-0661 / AD2016	Over Inspection for Manufacturing Defects / AD 2016-18-10 inclusive Cleaning	X
	NMSB72-0661 / AD2016	Over Inspection for Manufacturing Defects / AD 2016-18-10	X

ATA 72-45-11

Plan-No. V724511-01011C1

Description HPT Stage 1 Hub

P/N 2A5001

Manufacturer INTERNATIONAL AERO ENGINES

Repair	Basic document	Description	OAR
Repair	Basic document	Description	OAR
		NMSB72-0661 / AD2016 Over Inspection for Manufacturing Defects / AD 2016-18-10 inclusive Cleaning	X
		NMSB72-0661 / AD2016 Over Inspection for Manufacturing per SB72-0661 / AD 2016-18-10 - without cleaning	X

Engine Type PW206A PW206E PW207E ATA 72-11-51

Plan-No. P2-72-11-51R001 Description Reduction-Gearbox Rear Housing
P/N 3044635-01, 3123478-01, 3073222-01, 3073225-01, 3123128-01
Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
16		Nickel Plating of Seal-mating Diameter	X
18		Repair of Slot "F"	X

Engine Type PW1100G ATA 72-53-4111

Plan-No. P11-72534111R1 Description LPT Disk Stg. 2
P/N 5387522, 5387382, 5387512
Manufacturer IAE LLC

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Full Inspection	

Repair	Basic document	Description	OAR
0	CLEANING	Cleaning DMC:PW1000G-C-72-53-0000-00A-250A-C	X
0	FP INSPECTION	FP INSPECTION DMC:PW1000G-C-72-53-4111-00A-351A-C	X
0	EC INSPECTION	EC INSPECTION DMC:PW1000G-C-72-53-4111-00A-353A-C	X
0	DIMENSION CHECK	DIMENSION CHECK DMC:PW1000G-C-72-53-4111-00A-361A- C	X
0	HARDNESS TEST	HARDNESS TEST DMC:PW1000G-C-72-53-4111-00A-356A-C i.a.w. EA12CM183D, dated 10/23/2018	X

Engine Type PW6000

ATA 72-53-44

Plan-No. P6-72-53-44C001

P/N 5482245

Manufacturer PRATT AND WHITNEY

Description LPT Rotating Air Seal Stg.2

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X

ATA 72-53-53

Plan-No. P6-72-53-53C001

P/N 5482047

Manufacturer PRATT AND WHITNEY

Description LPT Rotating Air Seal Stg.3

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X

ATA 72-53-63

Plan-No. P6-72-53-63C001

Description LPT Front Rotating Air Seal Stg.4

P/N 5482049

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X

ATA 72-53-41

Plan-No. P6-72-53-41C001

Description LPT Disk Stg.2

P/N 5482252

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X

ATA 72-53-61

Plan-No. P6-72-53-61C001

Description LPT Rotor Hub Stg.4

P/N 5482234

Manufacturer PRATT AND WHITNEY

Repair	Basic document	Description	OAR
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ATA 72-35-3117

Plan-No. P11-72353117R1

P/N 32A4202

Manufacturer IAE LLC

Description HPC 2nd Stage IBR

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X
4	MR15CM217A	Plasma Spray the Front Knife Edge Seals	X
5	MR15CM221A	Plasma Spray the Rear Knife Edge Seal	X
10	MR15CM193	Balance the Rotor (Vendor Application)	X
	SB 72-00-0109	INSPECTION AND REPAIR OF PARTS, WHICH HAVE BEEN CLEANED WITH SPOP18 OR EQUIVALENT	X

ATA 72-35-3123

Plan-No. P11-72353123R1

P/N 32A4204

Manufacturer IAE LLC

Description HPC 4th Stage IBR

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X
4	MR15CM218A	Plasma Spray The Front Knife-Edge Seals	X
9	MR15CM195	Balance the Rotor	X
	SB 72-00-0109	INSPECTION AND REPAIR OF PARTS, WHICH HAVE BEEN CLEANED WITH SPOP18 OR EQUIVALENT	X

Engine Type PW300

ATA --

Plan-No. P3-72-34-12R006

Description HPC Rotor Stg.2

P/N 30B6082-01

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
	CINSP	Cleaning & Inspection	X
1		Removal of Surface Damage	X
		Restoration of CPW 33-11 Coating on Knife Edge Seals	X

Plan-No. P3-72-34-13R006

Description HPC Rotor Stg.3

P/N 30B3933-01

Manufacturer PRATT AND WHITNEY CANADA

Repair	Basic document	Description	OAR
1		Removal of Surface Damage	X
		Restoration of CPW 33-11 Coating on Knife Edge Seals	X

Engine Type PW1100G

ATA 72-35-3120

Plan-No. P11-72353120R1

Description HPC 3rd Stage IBR

P/N 32A4203

Manufacturer IAE LLC

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	X
5	MR15CM194	Balance Repair	X

Engine Type PW1500G

ATA 72-35-3114

Plan-No. P15-72353114R1

Description HPC 1st Stage (IBR)

P/N 32A2001

Manufacturer PRATT & WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	
5	MR09CM004	Balance The Rotor	

ATA 72-35-3117

Plan-No. P15-72353117R1

Description HPC 2nd Stage IBR

P/N 32A2002

Manufacturer PRATT & WHITNEY

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	
10	MR09CM010	Balance the Rotor (Vendor Application)	

ATA 72-35-3120

Plan-No. P15-72353120R1
P/N 32A2323, 32A2053
Manufacturer PRATT & WHITNEY

Description HPC 3rd Stage IBR

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	
5	MR09CM015	Balance Repair	

ATA 72-35-3123

Plan-No. P15-72353123R1
P/N 32A2054
Manufacturer PRATT & WHITNEY

Description HPC 4th Stage IBR

Repair	Basic document	Description	OAR
0	CINSP	Cleaning & Inspection	
9	MR09CM021	Balance the Rotor (Vendor Application)	

Engine Type PW1100G

ATA 72-53-5111

Plan-No. P11-72535111R1
P/N 5387483
Manufacturer IAE LLC

Description LPT Disk Stg. 3

Repair	Basic document	Description	OAR
0	CINSP	Cleaning and Inspection	X
