



ÚŘAD PRO CIVILNÍ LETECTVÍ  
ČESKÁ REPUBLIKA  
Sekce technická

letišťe Ruzyně, 160 08 Praha 6  
tel: 233320922, fax: 220562270

## PŘÍKAZ K ZACHOVÁNÍ LETOVÉ ZPŮSOBILOSTI

Číslo: CAA-AD-004/2003

Nahrazuje CAA-AD-137/1999, CAA-AD-087/2000

Datum vydání: 03. ledna 2003

**GENERAL ELECTRIC Comp.**  
CF6-45, -50, -80A, -80C2, -80E1

### MOTOR - ROTOR VYSOKOTLAKÉHO KOMPRESORU - KONTROLA

**Týká se:** motorů vyrobených firmou General Electric Company (GE) CF6-45, -50, -80A, -80C2 a -80E1, se zastavěným rotorem vysokotlakého kompresoru (HPCR) stupeň 3-9, katalogových čísel (P/Ns) uvedených v tabulce č. 1 FAA AD 2002-25-08 (příloha tohoto PZZ).

**Datum účinnosti:** 23. ledna 2003

**Provést v termínech:**

Jak je popsáno v FAA AD 2002-25-08, od data účinnosti tohoto PZZ.

**Postup provedení prací:**

Dle FAA AD 2002-25-08.

---

*Poznámky:*

- Provedení tohoto PZZ musí být zapsáno do motorové knihy.
- Případné dotazy týkající se tohoto PZZ adresujte na ÚCL sekce technická - Ing. Toman.
- Pokud to vyžaduje povaha tohoto PZZ, musí být zapracován do příslušné části dokumentace pro obsluhu, údržbu a opravy letadla.
- Tento PZZ byl vypracován na základě FAA AD 2002-25-08, který nahrazuje FAA AD 95-18-14, FAA AD 99-24-15, FAA AD 2000-16-12.

**Ing. Pavel MATOUŠEK**  
ředitel

**2002-25-08 General Electric Company (GE):** Docket No. 2001-NE-26-AD. Supersedes AD 95-18-14, Amendment 39-9361; AD 99-24-15, Amendment 39-11440; and AD 2000-16-12, Amendment 39-11868.

Applicability: This airworthiness directive (AD) is applicable to GE CF6-45, -50, -80A, -80C2, and -80E1 turbofan engines with high pressure compressor rotor (HPCR) stage 3-9 spools with part numbers (P/N's) listed in the following Table 1 installed:

**Table 1**

Engine model	HPCR stage 3-9 spool P/N
CF6-45/50 Series Engines	9136M89G02, 9136M89G03, 9136M89G06, 9136M89G07, 9136M89G08, 9136M89G09, 9136M89G17, 9136M89G18, 9136M89G19, 9136M89G21, 9136M89G22, 9136M89G27, 9136M89G29, 9253M85G01, 9253M85G02, 9273M14G01, 9331M29G01.
CF6-80A Series Engines	9136M89G10, 9136M89G11, 9136M89G20, 9136M89G21, 9136M89G22, 9136M89G27, 9136M89G28
CF6-80C2 Series Engines	1333M66G01, 1333M66G03, 1333M66G07, 1333M66G09, 1333M66G10, 1781M52P01, 1781M52P02, 1781M53G01, 1781M53G02, 1781M53G03, 1781M53G04, 1781M53G05, 1781M53G06, 1781M53G07, 1781M53G08, 1781M53G09, 1781M53G10, 1854M95P01, 1854M95P02, 1854M95P03, 1854M95P04, 1854M95P05, 1854M95P06, 1854M95P07, 1854M95P08, 9380M28P05.
CF6-80E1 Series Engines	1669M22G01, 1669M22G03, 1782M22G01, 1782M22G02, 1782M22G04.

These engines are installed on, but not limited to, Airbus A300, A310, and A330 series, Boeing 747 and 767 series, and McDonnell Douglas DC-10 and MD-11 series airplanes.

**Note 1:** This AD applies to each engine identified in the preceding applicability provision, regardless of whether it has been modified, altered, or repaired in the area subject to the requirements of this AD. For engines that have been modified, altered, or repaired so that the performance of the requirements of this AD is affected, the owner/operator must request approval for an alternative method of compliance in accordance with paragraph (p) of this AD. The request should include an assessment of the effect of the modification, alteration, or repair on the unsafe condition addressed by this AD; and, if the unsafe condition has not been eliminated, the request should include specific proposed actions to address it.

*Compliance:* Compliance with this AD is required as indicated, unless already done.

To detect cracks, which can cause separation of the HPCR stage 3-9 spool and possible uncontained engine failure, do the following:

**CF6-45 and -50 16-Inch Billet Spools**

- (a) For CF6 HPCR stage 3-9 spool, part numbers (P/N's) 9136M89G02 and 9136M89G06; and for P/N's

9136M89G08, 9253M85G02, 9273M14G01, 9331M29G01 with serial numbers (SN's) listed in the following Table 2, do the following:

**TABLE 2**

MPOE3486	MPOE3487	MPOE3488	MPOE3489	MPOE3490	MPOE3491	MPOE3492
MPOG3832	MPOG3833	MPOG3834	MPOG3835	MPOG3836	MPOG3837	MPOG3838
MPOG3839	MPOG3840	MPOG3841	MPOG3842	MPOG3843	MPOG3844	MPOG3845
MPOG3846	MPOG3847	MPOG3848	MPOG3850	MPOG3851	MPOG5228	MPOG5230
MPOG5231	MPOG5232	MPOG6216	MPOG6727	MPOG6728	MPOG6729	MPOG6730
MPOG6731	MPOG6732	MPOG6733	MPOG6735	MPOG6736	MPOG6738	MPOG6739
MPOG6740	MPOG6741	MPOG6742	MPOG6743	MPOG6744	MPOG6745	MPOG6746
MPOG7713	MPOG7714	MPOG7715	MPOG7716	MPOG7717	MPOG7718	MPOG7719
MPOG7720	MPOG7721	MPOG7722	MPOG7723	MPOG7724	MPOG7725	MPOG7726
MPOG7727	MPOG7728	MPOG7729	MPOG7730	MPOG7731	MPOG7732	MPOG7733
MPOG7734	MPOG7735	MPOG7736	MPOG7737	MPOG7738	MPOG7739	MPOG7740
MPOG7741	MPOG7742	MPOG7743	MPOG7744	MPOG7819	MPOG7820	MPOG7821
MPOG7822	MPOG7823	MPOG7824	MPOG7825	MPOG7826	MPOG7827	MPOG7828
MPOG7829	MPOG7830	MPOG7831	MPOG7832	MPOG7833	MPOG7834	MPOG7835
MPOG7836	MPOG7837	MPOG7838	MPOG7839	MPOG8822	MPOG8823	MPOG8824
MPOG8825	MPOG8826	MPOG8827	MPOG8828	MPOG8829	MPOG8830	MPOG8831
MPOG8832	MPOG8833	MPOG8834	MPOG8835	MPOG8836	MPOG8837	MPOG9185
MPOG9186	MPOH0289	MPOH0290	MPOH0291	MPOH0292	MPOH0293	MPOH0294
MPOH0295	MPOH0296	MPOH0297	MPOH0298	MPOH0299	MPOH0300	MPOH0301
MPOH0302	MPOH0303	MPOH0304	MPOH0305	MPOH1805	MPOH2040	MPOH2041
MPOH2042	MPOH2043	MPOH2044	MPOH2045	MPOH2046	MPOH2047	MPOH2048
MPOH2049	MPOH2050	MPOH2051	MPOH2052	MPOH2053	MPOH2054	MPOH2055
MPOH2056	MPOH2057	MPOH2058	MPOH2059	MPOH2060	MPOH2061	MPOH2062
MPOH2829	MPOH2830	MPOH2831	MPOH2832	MPOH2833	MPOH2834	MPOH2835
MPOH2836	MPOH2837	MPOH2838	MPOH2839	MPOH2840	MPOH2841	MPOH2842
MPOH2843	MPOH2844	MPOH2845	MPOH2846	MPOH2847	MPOH2848	MPOH2849
MPOH2850	MPOH2851	MPOH2852	MPOH2853	MPOH2854	MPOH2855	MPOH2856
MPOH2857	MPOH2858	MPOH4307	MPOH4308	MPOH4309	MPOH4310	MPOH4311
MPOH4312	MPOH4313	MPOH5277	MPOH5278	MPOH5279	MPOH5280	MPOH5281
MPOH5282	MPOH5283	MPOH5520	MPOH5530	MPOH5531	MPOH5532	MPOH5533
MPOH5534	MPOH5535	MPOH5536	MPOH5537	MPOH5538	MPOH5539	MPOH5540
MPOH5541	MPOH5542	MPOH5543	MPOH5544	MPOH5545	MPOH5546	MPOH5547
MPOH5548	MPOH5549	MPOH5550	MPOH5551	MPOH5552	MPOH5553	MPOH5554
MPOH7020	MPOH7021	MPOH7022	MPOH7023	MPOH7024	MPOH7025	MPOH7026
MPOH7027	MPOH7028	MPOH7030	MPOH7960	MPOH7965	MPOH7966	MPOH7967
MPOH7968	MPOH7969	MPOH7970	MPOH7971	MPOH7972	MPOH7973	MPOH7974
MPOH7975	MPOH8638	MPOH8639	MPOH8640	MPOH8641	MPOH8642	MPOH8643
MPOH8644	MPOH8645	MPOH8646	MPOH8647	MPOH8648	MPOH8649	MPOH8650
MPOH8651	MPOH8652	MPOH8653	MPOH8654	MPOH8655	MPOH8656	MPOH8657
MPOH8658	MPOH8659	MPOH8677	MPOH8678	MPOH8679	MPOH8680	MPOH8682
MPOH8683	MPOH8684	MPOJ1796	MPOJ1797	MPOJ1798	MPOJ1799	MPOJ1800
MPOJ1801	MPOJ1803	MPOJ1804	MPOJ1806	MPOJ1930	MPOJ1931	MPOJ1932
MPOJ1933	MPOJ1934	MPOJ1935	MPOJ1936	MPOJ1938	MPOJ1939	MPOJ1940
MPOJ1941	MPOJ1942	MPOJ1943	MPOJ1944	MPOJ1945	MPOJ1946	MPOJ1947
MPOJ1948	MPOJ1949	MPOJ1950	MPOJ1951	MPOJ1953	MPOJ1954	MPOJ1955
MPOJ1956	MPOJ1957	MPOJ1958	MPOJ2420	MPOJ2421	MPOJ2422	MPOJ2423
MPOJ2424	MPOJ2425	MPOJ2426	MPOJ2427	MPOJ2428	MPOJ2429	MPOJ2430
MPOJ2431	MPOJ2432	MPOJ2433	MPOJ2434	MPOJ2435	MPOJ2436	MPOJ2437
MPOJ2438	MPOJ2439	MPOJ2440	MPOJ2441	MPOJ2442	MPOJ2443	MPOJ2444
MPOJ2445	MPOJ2446	MPOJ2447	MPOJ2448	MPOJ2449	MPOJ2450	MPOJ4173
MPOJ4174	MPOJ5185	MPOJ5186	MPOJ6035	MPOJ6036	MPOJ6039	MPOJ6040
MPOJ6041	MPOJ6042	MPOJ6043	MPOJ6044	MPOJ6045	MPOJ6046	MPOJ6047
MPOJ6048	MPOJ6049	MPOJ6050	MPOJ6051	MPOJ6052	MPOJ6053	MPOJ6054
MPOJ6055	MPOJ6056	MPOJ6057	MPOJ6058	MPOJ6059	MPOJ6060	MPOJ6061

MPOJ6062	MPOJ6063	MPOJ6064	MPOJ6065	MPOJ6066	MPOJ6067	MPOJ6068
MPOJ6500	MPOJ6501	MPOJ6502	MPOJ6503	MPOJ6505	MPOJ6506	MPOJ6507
MPOJ6508	MPOJ6509	MPOJ6510	MPOJ6511	MPOJ6512	MPOJ6513	MPOJ6514
MPOJ6515	MPOJ6516	MPOJ6517	MPOJ7632	MPOJ7633	MPOJ7634	MPOJ7635
MPOJ7636	MPOJ7637	MPOJ7638	MPOJ7639	MPOJ7640	MPOJ7641	MPOJ7642
MPOJ7643	MPOJ8046	MPOJ8047	MPOJ8048	MPOJ8049	MPOJ8050	MPOJ8051
MPOJ9308	MPOJ9309	MPOJ9310	MPOJ9311	MPOJ9312	MPOJ9313	MPOJ9314
MPOJ9315	MPOK1233	MPOK1234	MPOK1235	MPOK1236	MPOK1237	MPOK1238
MPOK1239	MPOK1240	MPOK1824	MPOK1825	MPOK1826	MPOK1827	MPOK1828
MPOK1829	MPOK1830	MPOK1831	MPOK1832	MPOK2694	MPOK2695	MPOK3067
MPOK3068	MPOK3069	MPOK3070	MPOK3071	MPOK4659	MPOK4660	MPOK4661
MPOK4662	MPOK4663	MPOK4664	MPOK4665	MPOK4666	MPOK4667	MPOK5082
MPOK5083	MPOK5084	MPOK5085	MPOK5086	MPOK5087	MPOK5088	MPOK5520
MPOK5521	MPOK5522	MPOK5955	MPOK5956	MPOK5957	MPOK5958	MPOK5959
MPOK5960	MPOK5961	MPOK5962	MPOK5963	MPOK5964	MPOK6247	MPOK6248
MPOK6249	MPOK6250	MPOK6251	MPOK6252	MPOK6253	MPOK6254	MPOK6255
MPOK6256	MPOK6257	MPOK6715	MPOK6716	MPOK6823	MPOK6824	MPOK6825
MPOK6826	MPOK6827	MPOK6828	MPOK6829	MPOK6830	MPOK6831	MPOK7226
MPOK7227	MPOK7228	MPOK7229	MPOK7230	MPOK7231	MPOK7232	MPOK7233
MPOK7234	MPOM2128	MPOM2129	MPOM2130	MPOM2131	MPOM2132	MPOM2133
MPOM2134	MPOM2135	MPOM2136	MPOM2137	MPOM2138	MPOM2357	MPOM2358
MPOM2359	MPOM2360	MPOM2361	MPOM2362	MPOM2363	MPOM2364	MPOM2365
MPOM2366	MPOM2461	MPOM2462	MPOM5521	MPOM5522	MPOM5523	MPOM5524
MPOM5525	MPOM5526	MPOM5527	MPOM5528	MPOM5529	MPOM5530	MPOM5531
MPOM5532	MPOM5533	MPOM5534	MPOM5535	MPOM5536	MPOM5537	MPOM6151
MPOM6152	MPOM6153	MPOM6154	MPOM6155	MPOM6156	MPOM6157	MPOM6158
MPOM6159	MPOM6160	MPOM6161	MPOM6162	MPOM7087	MPOM7088	MPOM7089
MPOM7091	MPOM7092	MPOM7093	MPOM7094	MPOM7095	MPOM7096	MPOM7097
MPOM7098	MPOM7099	MPOM7100	MPOM7101	MPOM7102	MPOM7103	MPOM7104
MPOM7105	MPOM7106	MPOM7107	MPOM7108	MPOM7109	MPOM8297	MPOM8298
MPOM8299	MPOM8300	MPOM8301	MPOM8302	MPOM9246	MPOM9257	MPOM9258
MPOM9259	MPOM9260	MPOM9261	MPOM9262	MPOM9265	MPOM9721	MPOM9722
MPOM9723	MPON0051	MPON0052	MPON0053	MPON0055	MPON0056	MPON0057
MPON0058	MPON0059	MPON0060	MPON0061	MPON0062	MPON0063	MPON0064
MPON0065	MPON0066	MPON0067	MPON0068	MPON0069	MPON0073	MPON0074
MPON0075	MPON0076	MPON1077	MPON1078	MPON1079	MPON1080	MPON1081
MPON1082	MPON1084	MPON1085	MPON1086	MPON1087	MPON1088	MPON1089
MPON1090	MPON1091	MPON1092	MPON1093	MPON1094	MPON1095	MPON1096
MPON1097	MPON1098	MPON1099	MPON1100	MPON1642	MPON4250	MPON4252
MPON4254	MPON4255	MPON4256				

*Initial Inspection*

(1) If the spool has not already been inspected using one of the alert service bulletins (ASB's) or service bulletins (SB's) listed in Column A of the following Table 3; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with alert service bulletin

(ASB) CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002, and the following compliance times:

**TABLE 3**

<b>CF6-45 and -50 SB No.</b>		<b>Procedures (70-32-XX) in Standard Practices Manual GEK9250</b>				
Column A	Column B	Column C	Column D	Column E		
SB 72-888, Revision 3, dated January 31, 1991.	70-32-09, Revision 71, dated October 1, 1995.	70-32-10, 71, Revision dated October 1, 1995.	70-32-13, Temporary Re- vision (TR), 70-25, dated August 26, 1996.	70-32-14, TR 70-26, dated August 26, 1996.		

SB 72-888, Revision 4, dated March 28, 1991.	70-32-09, Revision 72, dated November 15, 1996.	70-32-10, Revision 72, dated November 15, 1996.	70-32-13, Revision 72, dated November 15, 1996.	70-32-14, Revision 72, dated November 15, 1996.
SB 72-888, Revision 5, dated November 7, 1994.	70-32-09, Revision 74, dated May 1, 1998.	70-32-10, Revision 74, dated May 1, 1998.	70-32-13, Revision 73, dated November 1, 1997.	70-32-14, Revision 73, dated November 1, 1997.
SB 72-888, Revision 6, dated December 22, 1995.		70-32-10, Revision 75, dated December 15, 1998.	70-32-13, Revision 75, dated December 15, 1998.	70-32-14, Revision 75, dated December 15, 1998.
SB 72-1000, Original dated December 14, 1990.			70-32-13, TR 70-41, dated February 10, 1999.	70-32-14, TR 70-42, dated February 10, 1999.
SB 72-1000, Revision 1, dated March 28, 1991.			70-32-13, Revision 76, dated May 15, 1999.	70-32-14, Revision 76, dated May 15, 1999.
SB 72-1000, Revision 2, dated September 9, 1993.			70-32-17, TR 70-39, dated December 15, 1998.	70-32-18, TR 70-40, dated December 15, 1998.
SB 72-1000, Revision 3, dated December 22, 1995.			70-32-17, Revision 76, dated May 15, 1999.	70-32-18, Revision 76, dated May 15, 1999.
SB 72-1108, Original, dated November 6, 1995.			70-32-17, TR 70-47, dated October 28, 1999.	70-32-18, TR 70-48, dated October 28, 1999.
SB 72-1108, Revision 1, dated July 29, 1996.				
ASB 72-A1108, Revision 2, dated October 28, 1999.				
ASB 72-A1108, Revision 3, dated November 12, 1999.				
ASB 72-A1108, Revision 4, dated June 6, 2001.				
ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002.				

(i) For spools with greater than 3,500 cycles-since-new (CSN) on the effective date of this AD, inspect before further flight.

(ii) For spools with 3,500 or fewer CSN, on the effective date of this AD, inspect at the first piece-part exposure (PPE) after 1,000 CSN or before 3,500 CSN, whichever occurs earlier.

(2) For spools that have not been inspected using ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1131 or SB 72-1131, inspect the web and hub- to-web transition areas in accordance with the requirements of ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, at the first PPE after 1,000 CSN, but before 4,000 additional cycles in-service (CIS) after the effective date

of this AD.

(3) For spools that have not been inspected using ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1157, inspect the stage 3-5 dovetail slot bottoms in accordance with the requirements of ASB CF6-50 S/B 72- A1157, Revision 4, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1000 CSN, or

(ii) The first HPC rotor exposure after 1000 CSN, or

(iii) The next required inspection to ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002.

**Repetitive Inspection**

(4) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect the hub and bore in accordance with the requirements of ASB CF6-50 S/B 72- A1108, Revision 5, dated October 2, 2002, and the stage 3-5 dovetail slot bottoms in accordance with ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, at the earliest of:

(i) Each PPE with more than 1,000 cycles-since-last-inspection (CSLI) and 3,500 CSN, or

(ii) From July 29, 2001 through January 27, 2003, before the cycle limits of the following Table 4:

<b>TABLE 4</b>	
<b>CSN at last inspection</b>	<b>Repeat inspection by -</b>
(A) 6,000 or fewer CSN	3,500 CSLI.
(B) 6,001 to 7,000 CSN	9,500 CSN.
(C) 7,001 to 8,000 CSN	2,500 CSLI.
(D) 8,001 to 8,500 CSN	10,500 CSN.
(E) 8,501 or more CSN	2,000 CSLI.

(iii) After January 27, 2003, before the cycle limits of the following Table 5:

<b>TABLE 5.</b>	
<b>CSN at last inspection</b>	<b>Repeat inspection by -</b>
(A) 5,000 or fewer CSN	3,500 CSLI.
(B) 5,001 to 5,500 CSN	8,500 CSN.
(C) 5,501 to 6,500 CSN	3,000 CSLI.
(D) 6,501 to 7,000 CSN	9,500 CSN.
(E) 7,001 to 8,000 CSN	2,500 CSLI.
(F) 8,001 to 8,500 CSN	10,500 CSN.
(G) 8,501 or more CSN	2,000 CSLI.

## **Spool Disposition**

(5) If inspection findings equal or exceed the reject limits established by ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002; or ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002; or ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, replace spool before further flight.

## **CF6-45 and -50 13-inch Billet Spools**

(b) For CF6 HPC Rotor Stage 3-9 Spool, P/N's 9136M89G03, 9136M89G07, 9136M89G09, 9136M89G17, 9136M89G18, 9253M85G01, and for P/N's 9136M89G08, 9253M85G01, 9273M14G01, and 9331M29G01 with serial numbers that are not listed in Table 2, do the following:

## **Initial Inspection**

(1) If the spool has greater than 7,000 CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002 before further flight.

(2) If the spool has 7,000 or fewer CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first engine shop visit (ESV) after 4,000 CSN, or

(iii) From July 29, 2001, through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 4,000 CSN.

(3) For spools that have not been inspected using ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1131 or SB 72-1131, inspect the web and hub- to-web transition areas in accordance with the requirements of ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

(4) For spools that have not been inspected using ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1157, inspect the stage 3-5 dovetail slot bottoms in accordance with the requirements of ASB CF6-50 S/B 72- A1157, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

## **Repetitive Inspection**

(5) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect the hub and bore in accordance with the requirements of ASB CF6-50 S/B 72- A1108, Revision 5, dated October 2, 2002, at the earliest of:

- (i) Each PPE with more than 1,000 CSLI and 4,000 CSN, or
- (ii) Each ESV with more than 2,000 CSLI and 4,000 CSN, or
- (iii) Before 4,000 CSLI.

### **Spool Disposition**

(6) If inspection findings equal or exceed the reject limits established by ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002; or ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002; or ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, replace spool before further flight.

### **CF6-45 and -50 9 and 10-Inch Billet Spools**

(c) For CF6 HPCR stage 3-9 spool, P/N's 9136M89G19, 9136M89G21, 9136M89G22 and 9136M89G27, do the following:

### **Initial Inspection**

(1) If the spool has greater than 7,000 CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect the hub and bore in accordance with ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002 before further flight.

(2) If the spool has 7,000 or fewer CSN on the effective date of this AD, and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect the hub and bore in accordance with ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 3,000 CSN, or

(iii) From July 29, 2001 through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 3,500 CSN.

(3) For spools that have not been inspected using ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1131 or SB CF6-50 S/B 72-1131, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

(4) For spools that have not been inspected using ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1157, inspect the stage 3-5 dovetail slot bottom in accordance with the requirements of ASB CF6-50 S/B 72- A1157, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

### **Repetitive Inspection**

(5) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 3;



OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect the hub and bore in accordance with the requirements of ASB CF6-50 S/B 72- A1108, Revision 5, dated October 2, 2002, at the earliest of:

(i) Each PPE with more than 1,000 CSLI and 3,500 CSN, or

(ii) From July 29, 2001, through January 27, 2003, before the cycle limits of the following Table 6, or:

<b>TABLE 6</b>	
<b>CSN at last inspection</b>	<b>Reinspect by</b>
(A) 3,500 or fewer CSN	7,000 CSN.
(B) 3,501 to 6,000 CSN	3,500 CSLI.
(C) 6,001 to 7,000 CSN	9,500 CSN.
(D) 7,001 to 8,000 CSN	2,500 CSLI.
(E) 8,001 to 8,500 CSN	10,500 CSN.
(F) 8,501 or more CSN	2,000 CSLI.

(iii) After January 27, 2003, before the cycle limits of Table 5.

**Spool Disposition**

(6) If inspection findings equal or exceed the reject limits established by ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002; or ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002; or ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002; replace spool before further flight.

**Spool Reinstallation Limit**

(7) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool, P/N's 9136M89G19, 9136M89G21, 9136M89G22, and 9136M89G27, installed where the spool has 10,500 or more CSN.

**CF6-45 and -50 8-Inch Billet 2-Piece spools**

(d) For CF6 HPCR stage 3-9 spool, P/N 9136M89G29, do the following:

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of Table 3; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with the piece-part level inspection of ASB CF6- 50 S/B 72-A1108, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(2) For spools that have not been inspected using ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, or an earlier revision of ASB CF6-50 S/B 72-A1131 or SB 72-1131, inspect the web and hub- to-web transition areas in accordance with the requirements of ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(3) For spools that have not been inspected using ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, or an earlier revision of ASB 72-A1157, inspect the stage 3-5 dovetail slot bottom in accordance with the requirements of ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

**Spool Disposition**

(4) If inspection findings equal or exceed the reject limits established by ASB CF6-50 S/B 72-A1108, Revision 5, dated October 2, 2002; or ASB CF6-50 S/B 72-A1131, Revision 4, dated October 2, 2002; or ASB CF6-50 S/B 72-A1157, Revision 4, dated October 2, 2002; replace spool before further flight.

**CF6-80A 16-Inch Billet Spools**

(e) For CF6 HPCR stage 3-9 spool, P/N's 9136M89G10 with SN's MPOM0054, MPOM7090, MPOM8303, MPOM8304, MPOM9263, MPOM9264, MPON0054, MPON0071, MPON0072, MPON1643, MPON4251, or MPON4253, do the following:

**Initial Inspection**

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of the following Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, and the following compliance times:

CF6-80A SB No.	Procedures (70-32-XX) in standard practices manual GEK9250			
Column A	Column B	Column C	Column D	Column E
SB 72-500, Revision 3, dated March 19, 1991.	70-32-09, Revision 71, dated October 1, 1995.	70-32-10, Revision 71, dated October 1, 1995	70-32-13, Temporary Revision (TR), 70-25, dated August 26, 1996. 70-32-13, Revision 72, dated November 15, 1996.	70-32-14, TR 70-26, dated August 26, 1996.
SB 72-500, Revision 4, dated July 1, 1991.	70-32-09, Revision 72, dated November 15, 1996.	70-32-10, Revision 72, dated November 15, 1996.	70-32-13, Revision 73, dated November 1, 1997	70-32-14, Revision 72, dated November 15, 1996.
SB 72-500, Revision 5, dated November 7, 1994.	70-32-09, Revision 74, dated May 1, 1998.	70-32-10, Revision 74, dated May 1, 1998.	70-32-13, Revision 75, dated December 15, 1998.	70-32-14, Revision 73, dated November 1, 1997. 70-32-14, Revision 75, dated December 15, 1998.
SB 72-500, Revision 6, dated December 22, 1995.		70-32-10, Revision 75, dated December 15, 1998.	70-32-13, TR 70-41, dated February 10, 1999	70-32-14, TR 70-42, dated February 10, 1999.
SB 72-583, Original, dated December 20, 1990.			70-32-13, Revision 76, dated May 15, 1999. 70-32-17, TR 70-39, dated December 15, 1998.	70-32-14, Revision 76, dated May 15, 1999.
SB 72-583, Revision 1, dated March 18, 1991. SB 72-583, Revision 2, dated July 15, 1991.			70-32-17, Revision 76, dated May 15, 1999. 70-32-17. TR	70-32-18, TR 70--40, dated December 15, 1998.
SB 72-583. Revision				70-32-18, Revision 76. dated Mav 15.

<p>3, dated July 24, 1991. SB 72-583, Revision 4, dated September 15, 1993. SB 72-583, Revision 5, dated December 22, 1995. SB 72-678, Original, dated November 6, 1995. SB 72-678, Revision 1, dated July 29, 1996. ASB 72-A678, Revision 2, dated October 28, 1999. ASB 72-A678, Revision 3, dated November 12, 1999. ASB 72-A0678, Revision 4, dated June 6, 2001. ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002.</p>			<p>70-47, dated October 28, 1999.</p>	<p>1999. 70-32-18, TR 70-48, dated October 28, 1999.</p>
--	--	--	---------------------------------------	--

(i) For spools with greater than 3,500 CSN on the effective date of this AD, inspect before further flight.

(ii) For spools with 3,500 or fewer CSN on the effective date of this AD, inspect at the first PPE after 1,000 CSN or before 3,500 CSN, whichever occurs earlier.

(2) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0691, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0691 or SB 72-0691, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS accumulated after the effective date of this AD.

(3) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0719, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0719, inspect the stage 3--5 dovetail slot bottom in accordance with the requirements of ASB CF6- 80A S/B 72-A0719, Revision 5, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first HPCR exposure after 1,000 CSN, or

(iii) The next required inspection to ASB

CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002.

### Repetitive Inspections

(4) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D and one from Column E, reinspect the hub and bore in accordance with the

requirements of ASB CF6-80A S/B 72- A0678, Revision 5, dated October 2, 2002; and the dovetail slot bottoms in accordance with the requirements of ASB CF6-80A S/B 72- A0719, Revision 5, dated October 2, 2002, at the earliest of:

- (i) Each PPE with more than 1,000 CSLI and 3,500 CSN, or
- (ii) From July 29, 2001 through January 27, 2003 before the cycle limits of Table 4, or
- (iii) After January 27, 2003, before the cycle limits of Table 5.

#### **Spool Disposition**

(5) If inspection findings equal or exceed the reject limits established by ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0719, Revision 5, dated October 2, 2002; replace spool before further flight.

#### **Spool Reinstallation Limit**

(6) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool P/N 9136M89G10 with serial numbers (SN's) MPOM0054, MPOM7090, MPOM8303, MPOM8304, MPOM9263, MPOM9264, MPON0054, MPON0071, MPON0072, MPON1643, MPON4251, or MPON4253, installed where the spool has 10,500 or more CSN.

#### **CF6-80A 13-Inch Billet Spools**

(f) For all other CF6 HPCR stage 3-9 spools, P/N 9136M89G10, with SN's that are not listed in paragraph (e) of this AD, and P/N 9136M89G11, do the following:

#### **Initial Inspection**

(1) If the spool has greater than 7,000 CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with ASB CF6-80A 72-A0678, Revision 5, dated October 2, 2002 before further flight.

(2) If the spool has 7,000 or fewer CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earliest of:

- (i) The first PPE after 1,000 CSN, or
- (ii) The first ESV after 5,000 CSN or
- (iii) From July 29, 2001, through January 27, 2003 before 7,000 CSN, and after January 27, 2003, before 5,000 CSN.

(3) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0691, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0691 or SB 72-0691, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002, at the earlier of:

- (i) The first PPE after 1,000 CSN, or
- (ii) Within 4,000 additional CIS after the effective date of this AD.

(4) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0719, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0719, inspect the dovetail slot bottom in accordance with

the requirements of ASB CF6-80A S/B 72- A0719, Revision 5, dated October 2, 2002, at the earlier of:

- (i) The first PPE after 1,000 CSN, or
- (ii) Within 4,000 additional CIS after the effective date of this AD.

#### **Repetitive Inspection**

(5) For spools installed in CF6-80A1 and CF6-80A3 engines that were inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, reinspect hub and bore in accordance with alert ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earliest of:

- (i) Each PPE with more than 1,000 CSLI and 5,000 CSN, or
- (ii) Each ESV with more than 2,000 CSLI and 5,000 CSN, or
- (iii) Within 4,000 CSLI and more than 5,000 CSN.

(6) Spools installed in CF6-80A and CF6-80A2 engines previously inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earliest of:

- (i) Each PPE with more than 1,000 CSLI and 5,000 CSN, or
- (ii) Each ESV with more than 1,500 CSLI and 5,000 CSN, or
- (iii) Within 4,000 CSLI and more than 5,000 CSN.

#### **Spool Disposition**

(7) If inspection findings equal or exceed the reject limits established by ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0719, Revision 5, dated October 2, 2002; replace spool before further flight.

#### **CF6-80A 9 and 10-Inch Billet Spools**

(g) For CF6 HPCR stage 3-9 spools, P/N's 9136M89G20, 9136M89G21, 9136M89G22 and 9136M89G27, do the following:

#### **Initial Inspection**

(1) If the spool has greater than 7,000 CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002 before further flight.

(2) If the spool has 7,000 or fewer CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, inspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earliest of:

- (i) The first PPE after 1,000 CSN, or
- (ii) The first ESV after 3,000 CSN or

(iii) From July 29, 2001, through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 5,000 CSN.

(3) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0691, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0691, or SB 72-0691, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

(4) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0719, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0719 inspect the dovetail slot bottom in accordance with the requirements of ASB CF6-80A S/B 72- A0719, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

**Repetitive Inspection**

(5) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect hub and bore in accordance with ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earliest of:

(i) Each PPE with more than 1,000 CSLI and 5,000 CSN, or

(ii) From July 29, 2001 through January 27, 2003, before the cycle limits of Table 6.

(iii) After January 27, 2003, before the cycle limits of the following Table 8:

<b>TABLE 8</b>	
<b>CSN at last inspection</b>	<b>Repeat inspection by -</b>
(A) 1,500 or fewer CSN	5,000 CSN
(B) 1,501 to 5,000 CSN	3,500 CSLI
(C) 5,001 to 5,500 CSN	8,500 CSN
(D) 5,501 to 6,501 CSN	3,000 CSLI
(E) 6,501 to 7,000 CSN	9,500 CSN
(F) 7,001 to 8,000 CSN	2,500 CSLI
(G) 8,001 to 8,500 CSN	10,500 CSN
(H) 8,501 or more CSN	2,000 CSLI

**Spool Disposition**

(6) If inspection findings equal or exceed the reject limits established by ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0719, Revision 5, dated October 2, 2002; replace spool before further flight.

**Spool Reinstallation Limit**

(7) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool, P/N's 9136M89G20, 9136M89G21, 9136M89G22, and 9136M89G27, installed where the spool has 10,500 or more CSN.

**CF6-80A 8-Inch Billet 2-Piece Spools**

(h) For CF6 HPCR stage 3-9 spool, P/N 9136M89G28, do the following:

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of Table 7; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with the piece-part level inspection of ASB CF6- 80A S/B 72-A0678, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(2) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0691, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0691, or SB 72-0691, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(3) For spools that have not been inspected using ASB CF6-80A S/ B 72-A0719, Revision 5, dated October 2, 2002, or an earlier revision of ASB CF6-80A S/B 72-A0719 inspect the stage 3--5 dovetail slot bottom in accordance with the requirements of ASB CF6-80A S/B 72-A0719, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

**Spool Disposition**

(4) If inspection findings equal or exceed the reject limits established by ASB CF6-80A S/B 72-A0678, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0691, Revision 5, dated October 2, 2002; or ASB CF6-80A S/B 72-A0719, Revision 5, dated October 2, 2002; replace spool before further flight.

**CF6-80C2 13-Inch Billet Spools**

(i) For CF6 HPCR stage 3-9 spool, P/N's 1781M52P01, 1854M95P02,1781M52P02, 1854M95P05 and 9380M28P05, do the following:

**Initial Inspection**

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of the following Table 9; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002, and the following compliance times:

**Table 9**

<b>CF6-80C2 SB No</b>	<b>Procedures (70-32-XX) in standard practices manual GEK9250</b>			
<b>Column A</b>	<b>Column B</b>	<b>Column C</b>	<b>Column D</b>	<b>Column E</b>
SB 72-418, Revision	70-32-09, Revision	70-32-10, Revision	70-32-13, Temporary	70-32-14, TR 70-26.

2, May 14, 1991. SB 72-418, Revision 3, November 7, 1994. SB 72-418, Revision 4, December 22, 1995. SB 72-758, Original, dated November 7, 1994.  SB 72-758, Revision 1, dated December 22, 1995. SB 72-812, Original, dated November 6, 1995. SB 72-812, Revision 1, dated January 30, 1998.  ASB 72-A0812, Revision 2, dated October 28, 1999. ASB 72-A0812, Revision 3, dated June 6, 2001. ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002..	71, dated October 1, 1995.  70-32-09, Revision 72, dated November 15, 1996.  70-32-09, Revision 74, dated May 1, 1998.	71, dated October 1, 1995.  70-32-10, Revision 72, dated November 15, 1996.  70-32-10, Revision 74, dated May 1, 1998.  70-32-10, Revision 75, dated December 15, 1998.	Revision (TR), 70-25, dated August 26, 1996. 70-32-13, Revision 72, dated November 15, 1996. 70-32-13, Revision 73, dated November 1, 1997 70-32-13, Revision 75, dated December 15, 1998. 70-32-13, TR 70-41, dated February 10, 1999  70-32-13, Revision 76, dated May 15, 1999.  70-32-17, TR70-39, dated December 15, 1998.  70-32-17, Revision 76, dated May 15, 1999.  70-32-17, TR 70-47, dated October 28, 1999.	dated August 26, 1996.  70-32-14, Revision 72, dated November 15, 1996.  70-32-14, Revision 73, dated November 1, 1997.  70-32-14, Revision 75, dated December 15, 1998.  70-32-14, TR 70-42, dated February 10, 1999.  70-32-14, Revision 76, dated May 15, 1999.  70-32-18, TR 70-40, dated December 15, 1998.  70-32-18, Revision 76, dated May 15, 1999.  70-32-18, TR 70-48, October 28, 1999.
---	--	---	--	---

(i) For spools with greater than 3,500 CSN on the effective date of this AD, inspect before further flight.

(ii) For spools with 3,500 or fewer CSN on the effective date of this AD, inspect at the first PPE after 1,000 CSN or before 3,500 CSN, whichever occurs earlier.

(2) For spools that have not been inspected using ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or an earlier revision of ASB 72-A0848 or SB 72-0848, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1000 CSN, or

(ii) The next required inspection to ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002, or

(iii) From July 29, 2001 through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 3,500 CSN.

(3) For spools that have not been inspected using ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, or an earlier revision of ASB 72-A0934, inspect the stage 3-5 dovetail slot bottom in accordance with the requirements of ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or



(ii) The first HPCR exposure after 1,000 CSN, or

(iii) The next required inspection to ASB

CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002.

### **Repetitive Inspection**

(4) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 9; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, reinspect the hub and bore in accordance with ASB 72-A812, Revision 4, dated October 2, 2002; the web and hub-to-web transition areas in accordance with ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002; and the stage 3-5 dovetail slot bottoms in accordance with ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, at the earliest of:

(i) Each PPE with more than 1,000 CSLI and 3,500 CSN, or

(ii) From July 29, 2001, through January 27, 2003, before the cycle limits of Table 4.

(iii) After January 27, 2003, before the cycle limits of Table 5.

### *Spool Disposition*

(5) If inspection findings equal or exceed the reject limits established by ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002, or ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002; replace spool before further flight.

### *Spool Reinstallation Limit*

(6) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool, P/N's 1781M52P01, 1781M52P02, 1854M95P02, 1854M95P05, and 9380M28P05, installed where the spool has 10,500 or more CSN.

### **CF6-80C2 9 and 10-Inch Billet Spools**

(j) For CF6 HPCR stage 3-9 spool, P/Ns 1333M66G01, 1333M66G03, 1333M66G07, 1333M66G09, 1781M53G01, 1781M53G02, 1781M53G03, 1781M53G04, 1781M53G06, 1781M53G07, 1781M53G08, 1781M53G09, 1854M95P01, 1854M95P03, 1854M95P04, 1854M95P06, and 1854M95P07, do the following:

### **Initial Inspection**

(1) If the spool has greater than 7,000 CSN on the effective date of this AD and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 9; OR a combination of one procedure from Column B AND one from Column C; OR a combination of one procedure from Column D AND one from Column E, or if the spool has not been inspected using ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or an earlier revision of ASB 72-A0848 or SB 72-0848, inspect the hub and bore in accordance with ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002; and the web and hub-to-web transition areas in accordance with ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, before further flight.

(2) If the spool has 7,000 or fewer CSN on the effective date of this AD, and has not already been inspected using one of the ASB's or SB's listed in Column A of Table 9; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect the hub and bore in accordance with ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 3,000 CSN, or

(iii) From July 29, 2001, through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 3,500 CSN.

(3) If the spool has 7,000 or fewer CSN on the effective date of this AD, and has not already been inspected using ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or an earlier revision of ASB 72-A0848 or SB CF6-80C2 72-0848, inspect the web and the web and hub-to-web transition areas in accordance with CF6-80C2 S/B 72- A0848, Revision 8, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 3,000 CSN, or

(iii) From July 29, 2001, through July 28, 2003, before 7,000 CSN and after July 28, 2003, before 3,500 CSN.

(4) For spools that have not been inspected using ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, or an earlier revision of ASB 72-A0934, inspect the stage 3-5 dovetail slot bottom in accordance with the requirements of ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) Within 4,000 additional CIS after the effective date of this AD.

#### **Repetitive Inspection**

(5) For spools that have already been inspected using one of the ASB's or SB's listed in Column A of Table 9; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, reinspect the hub and bore in accordance with the requirements of ASB CF6-80C2 S/B 72- A0812, Revision 4, dated October 2, 2002, and the web and hub-to-web transition areas in accordance with ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, at the earlier of:

(i) Each PPE with more than 1,000 CSLI and 3,500 CSN, or

(ii) From July 29, 2001, through January 27, 2003, before the cycle limits of Table 6, and after January 27, 2003, before the cycle limits of Table 5.

#### *Spool Disposition*

(6) If inspection findings equal or exceed the reject limits established by ASB CF6-80C2 S/B 72-A0812, Revision 4, dated Revision 4, dated October 2, 2002, or ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or ASB CF6-80C2 S/B 72\A0934, Revision 4, dated October 2, 2002; replace spool before further flight.

#### *Spool Reinstallation Limit*

(7) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool, P/N's 1333M66G01, 1333M66G03, 1333M66G07, 1333M66G09, 1781M53G01, 1781M53G02, 1781M53G03, 1781M53G04, 1781M53G06, 1781M53G07, 1781M53G08, 1781M53G09, 1854M95P01, 1854M95P03, 1854M95P04, 1854M95P06 and 1854M95P07, installed where the spool has 10,500 or more CSN.

#### **CF6-80C2 8-Inch Billet 2-Piece Spools**

(k) For CF6 HPCR stage 3-9 spool, P/N's 1333M66G10, 1781M53G05, 1781M53G010, and 1854M95P08, do the following:

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of Table 9; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with the piece-part level inspection

of ASB 72- A0812, Revision 4, dated October 2, 2002, at the earlier of:

- (i) The first PPE after 1,000 CSN, or
- (ii) The first ESV after 6,000 CSN.

(2) For spools that have not been inspected using ASB 72-A0848, Revision 8, dated October 2, 2002, or an earlier revision of ASB 72- A0848, or SB 72-0848, inspect the web and hub-to-web transition areas in accordance with the requirements of ASB CF6-80C2 S/B 72- A0848, Revision 8, dated October 2, 2002, at the earlier of:

- (i) The first PPE after 1,000 CSN, or
- (ii) The first ESV after 6,000 CSN.

(3) For spools that have not been inspected using ASB CF6-80C2 S/B 72-A0934, Revision 3, dated October 2, 2002, or an earlier revision of ASB 72-A0934, inspect the stage 3-5 dovetail slot bottom in accordance with the requirements of ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002, at the earlier of:

- (i) The first PPE after 1,000 CSN, or
- (ii) The first ESV after 6,000 CSN.

**Spool Disposition**

(4) If inspection findings equal or exceed the reject limits established by ASB CF6-80C2 S/B 72-A0812, Revision 4, dated October 2, 2002, or ASB CF6-80C2 S/B 72-A0848, Revision 8, dated October 2, 2002, or ASB CF6-80C2 S/B 72-A0934, Revision 4, dated October 2, 2002; replace spool before further flight.

**CF6-80E1 9&10-Inch Billet Spools**

(1) For CF6 HPCR stage 3-9 spool, P/N's 1669M22G01, 1669M22G03, 1782M22G01 and 1782M22G02, do the following:

*Initial Inspection*

(1) If the spool has greater than 7,000 CSN and has not already been inspected using one of the ASB's listed in Column A of the following Table 10; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, OR if the spool has not been inspected using ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002, or an earlier revision of ASB 72-A0126, or SB 72-0126, inspect the hub and bore in accordance with ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002; and the web and hub-to-web transition areas in accordance with ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002, before further flight.

**Table 10**

CF6-80E1 SB No. Column A	Procedures (70-32-XX) in standard practices manual GEK9250			
	Column B	Column C	Column D	Column E
ASB 72-A0135, dated August 13, 1998.	70-32-09, Revision 71, dated October 1, 1995.	70-32-10, Revision 71, dated October 1, 1995.	70-32-13, Temporary Revision (TR), 70-25, dated August 26, 1996.	70-32-14, TR 70-26, dated August 26, 1996.
ASB 72-A0135, Revision 1, dated October 28, 1999.	70-32-09, Revision 71, dated November 15, 1996.	70-32-10, Revision 71, dated November 15, 1996.	70-32-13, Revision 72, dated November 15, 1996.	70-32-14, Revision 71, dated November 15, 1996.
ASB 72-A0135.	70-32-09, Revision	70-32-10, Revision	70-32-13, Revision	70-32-14, Revision

Revision 2, dated June 6, 2001.  ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002.	74, dated May 1, 1998.	74, dated May 1, 1998.  70-32-10, Revision 75, dated December 15, 1998.	73, dated November 1, 1997  70-32-13, Revision 75, dated December 15, 1998.  70-32-13, TR 70-41, dated February 10, 1999 70-31-13, Revision 76, dated May 15, 1999.  70-31-17, TR 70-39, dated December 15, 1998.  70-31-17, Revision 76, dated May 15, 1999.  70-31-17 TR 70-47, dated October 28, 1999.	73, dated November 1, 1997.  70-32-14, Revision 75, dated December 15, 1998.  70-41, TR 70-42, dated February 10, 1999. 70-31-14, Revision 76, dated May 15, 1999.  70-31-18, TR 70-40, dated December 15, 1998.  70-31-18, Revision 76, dated May 15, 1999.  70-31-18 TR 70-48, dated October 28, 1999.
--	------------------------	---	---	---

(2) If the spool has 7,000 or fewer CSN and has not already been inspected using one of the ASB's listed in Column A of Table 10; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, OR if the spool has not been inspected using ASB CF6-80E1 S/B 72- A0126, Revision 5, dated October 2, 2002, or an earlier revision of ASB 72- A0126, or SB 72-0126, inspect the hub and bore in accordance with ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002; and the web and hub-to-web transition areas in accordance with ASB CF6-80E1 S/B 72- A0126, Revision 5, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 3,000 CSN, or

(iii) From July 29, 2001, through January 27, 2003, before 7,000 CSN, and after January 27, 2003, before 3,500 CSN.

(3) Spools not previously inspected using ASB CF6-80E1 S/B 72- A0137, Revision 4, dated October 2, 2002, or an earlier revision of ASB 72-0137, or SB 72-0137, inspect stage 3-5 dovetail slot bottoms in accordance with the requirements of ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002, at the earliest of:

(i) The first PPE after 1,000 CSN, or

(ii) The first HPCR exposure after 1,000 CSN, or

(iii) The next required inspection to ASB

CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002.

### **Repetitive Inspection**

(4) For spools that have already been inspected using one of the ASB's listed in Column A of Table 10; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure

from Column D and one from Column E, inspect the hub and bore in accordance with the requirements of ASB CF6-80E1 S/B 72- A0135, Revision 3, dated October 2, 2002, the web and hub-to-web transition areas in accordance with ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002, and the stage 3-5 dovetail slot bottoms in accordance with ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002, at the earlier of:

(i) Each PPE with more than 1,000 CSLI and 3,500 CSN, or

(ii) From July 29, 2001, through January 27, 2003, before the cycle limits of Table 6, and after January 27, 2003, before the cycle limits of Table 5.

#### *Spool Disposition*

(5) If inspection findings equal or exceed the reject limits established by ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002; ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002; and ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002; replace spool before further flight.

#### *Spool Reinstallation Limit*

(6) After the effective date of this AD, do not install any engine that has an HPCR stage 3-9 spool, P/N's 1669M22G01, 1669M22G03, 1782M22G01, and 1782M22G02, installed where the spool has 10,500 or more CSN.

#### **CF6-80E1 8-Inch Billet 2-Piece Spools**

(m) For CF6 HPCR stage 3-9 spool, P/N 1782M22G04, do the following:

(1) If the spool has not already been inspected using one of the ASB's or SB's listed in Column A of the following Table 9; OR a combination of one procedure from Column B and one from Column C; OR a combination of one procedure from Column D and one from Column E, inspect hub and bore in accordance with the piece-part level inspection of ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(2) For spools that have not been inspected using ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002, or an earlier revision of ASB 72-A0126, or SB 72-0126, inspect the web and hub-to- web transition areas in accordance with ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

(3) For spools that have not been inspected using ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002, or an earlier revision of ASB 72-A0137, or SB 72-0137, inspect the stage 3-5 dovetail slot bottoms in accordance with ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002, at the earlier of:

(i) The first PPE after 1,000 CSN, or

(ii) The first ESV after 6,000 CSN.

#### **Spool Disposition**

(4) If inspection findings equal or exceed the reject limits established by ASB CF6-80E1 S/B 72-A0135, Revision 3, dated October 2, 2002; ASB CF6-80E1 S/B 72-A0126, Revision 5, dated October 2, 2002; and ASB CF6-80E1 S/B 72-A0137, Revision 4, dated October 2, 2002; replace spool before further flight.

#### **Reporting Requirements**

(n) Within five calendar days of inspection, report the results of inspections that equal or exceed the reject criteria to: Engine Certification Office, FAA, Engine and Propeller Directorate, 12 New England Executive park, Burlington, MA 01803-5299; telephone (781) 238-7147; fax (781) 238-7199. Reporting requirements have been approved by the Office of Management and Budget and assigned OMB control number 2120-0056. Be sure to include the following information:

- (1) Part Number.
- (2) Serial Number.
- (3) Spool CSN.
- (4) Spool CSLI.
- (5) Date and location where inspection was done.

### **Definitions**

(o) For the purpose of this AD, the following definitions apply:

- (1) A module level exposure is a separation of the fan module from the engine.
- (2) An HPC rotor exposure is a HPC top or bottom case removal.
- (3) A PPE is a disassembly and removal of the stage 3-9 spool from the HPCR structure, regardless of any blades, locking lugs, bolts or balance weights assembled to the spool.
- (4) An ESV is the introduction of an engine into the shop where the separation of a major engine flange will occur after the effective date of this AD.
- (5) The following maintenance actions, or any combination, are not considered ESV's for requiring repeat inspections:
  - (i) Introduction of an engine into a shop solely for removal of the compressor top or bottom case for airfoil maintenance or variable stator vane bushing replacement.
  - (ii) Introduction of an engine into a shop solely for removal or replacement of the Stage 1 Fan Disk.
  - (iii) Introduction of an engine into a shop solely for replacement of the Turbine Rear Frame.
  - (iv) Introduction of an engine into a shop solely for replacement of the Accessory and/or Transfer Gearboxes.
  - (v) Introduction of an engine into a shop solely for replacement of the Fan Forward Case.

### **Alternative Methods of Compliance**

(p) An alternative method of compliance or adjustment of the compliance time that provides an acceptable level of safety may be used if approved by the Manager, Engine Certification Office (ECO). Operators must submit their request through an appropriate FAA Principal Maintenance Inspector, who may add comments and then send it to the Manager, ECO.

**Note 2:** Information concerning the existence of approved alternative methods of compliance with this airworthiness directive, if any, may be obtained from the ECO.

### **Special Flight Permits**

(q) Special flight permits may be issued in accordance with Sec. Sec. 21.197 and 21.199 of the Federal Aviation Regulations (14 CFR 21.197 and 21.199) to operate the airplane to a location where the requirements of this AD

can be done.

**Documents That Have Been Incorporated By Reference**

(r) The inspections must be done in accordance with the following GE Aircraft Engines alert service bulletins (ASB's):

Document No.	Pages	Revision	Date
ASB CF6-50 S/B 72-A1108. Total pages: 7	All	5	October 2, 2002. Do
ASB CF6-50 S/B 72-A1131 Total pages: 43.	All	4	Do
ASB CF6-50 S/B 72-A1157 Total pages: 38	All	4	Do
ASB CF6-80A S/B 72-A0678 Total pages: 7	All	5	Do
ASB CF6-80A S/B 72-A0691 Total pages: 43	All	5	Do
ASB CF6-80A S/B 72-A0719 Total pages: 38	All	5	Do
ASB CF6-80C2 S/B 72-A0812 Total pages: 6	All	4	Do
ASB CF6-80C2 S/B 72-A0848 Total pages: 43	All	8	Do
ASB CF6-80C2 S/B 72-A0934 Total pages: 38	All	4	Do
ASB CF6-80E1 S/B 72-A0126 Total pages: 44	All	5	Do
ASB CF6-80E1 S/B 72-A0135 Total pages: 6	All	3	Do
ASB CF6-80E1 S/B 72-A0137 Total pages: 38	All	4	

This incorporation by reference was approved by the Director of the Federal Register in accordance with 5 U.S.C. 552(a) and 1 CFR part 51. Copies may be obtained from General Electric Company via Lockheed Martin Technology Services, 10525 Chester Road, Suite C, Cincinnati, Ohio 45215, telephone (513) 672-8400, fax (513) 672- 8422. Copies may be inspected at the FAA, New England Region, Office of the Regional Counsel, 12 New England Executive Park, Burlington, MA; or at the Office of the

**Effective Date**

(s) This amendment becomes effective on January 23, 2003.