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TRANSMITTAL INFORMATION
REVISION 2 TO SERVICE BULLETIN 72-0415
Revision 2 is issued to update paragraph 1., PLANNING INFORMATION.
Revision 1 was issued July 24, 2020. The original was issued April 24, 2020. Revision bars in the left margin identify changes.

1. PLANNING INFORMATION
A. Effectivity
   This Service Bulletin is applicable to GEnx-2B engines with the following stages 6-10 compressor rotor spools installed:
   - The stages 6-10 compressor rotor spools P/N 2357M30G02, P/N 2439M35G02, and P/N 2445M40G02 with all serial numbers are affected by this Service Bulletin.
   - The stages 6-10 compressor rotor spools P/N 2340M36G01 that have a serial number listed in paragraph 4., APPENDIX - A, Table 1 are affected by this Service Bulletin.
   - The stages 6-10 compressor rotor spools P/N 2628M56G01 that have a serial number listed in paragraph 4., APPENDIX - A, Table 2 or Table 3 are affected by this Service Bulletin.
   NOTE: The above listed stages 6-10 compressor rotor spools are installed on GEnx-2B engines, serial numbers 959-101 through 959-743 based on the best available data.

B. Description
   This Service Bulletin provides a one-time inspection of the affected stages 6-10 compressor rotor spool stages 6-8 webs for surface anomalies such as tool dents, nicks, gouges, or scratches.

C. Compliance
   Category 2
   This Service Bulletin provides an inspection that has the same pass/fail criteria as previously released tool dent Service Bulletins, but the stages 6-10 compressor rotor spool area that is inspected is larger. Therefore, stages
6-10 compressor rotor spools which complied with this Service Bulletin are in compliance with GEnx-2B S/B 72-0385 and GEnx-2B S/B 72-0398 for tool dent inspection.

*For the stages 6-10 compressor rotor spools P/N 2357M30G02, P/N 2439M35G02, P/N 2445M40G02 and engines listed in paragraph 4., APPENDIX – A, Table 1 and Table 2, GE recommends that you do this Service Bulletin at the next shop visit but before the stages 6-10 compressor rotor spool reaches 6,500 cycles since new (CSN). Engines that complied with the GEnx-2B S/B 72-0385 and GEnx-2B S/B 72-0398 for tool dent inspection, before Revision 1 of this Service Bulletin is released, are required to comply with Revision 1 of this Service Bulletin on next shop visit, with no CSN limit.

*For engines listed in paragraph 4., APPENDIX – A, Table 3, GE recommends that you do this Service Bulletin at the next shop visit but before the stages 6-10 compressor rotor spool reaches 6,500 CSN.

Impact A
This recommendation is to address a condition that may affect Flight Safety.

NOTE: This Service Bulletin can be done in shop.
This Service Bulletin is offered to improve the reliability or performance of your GE product, or to help prevent the occurrence of the event or condition described in this Service Bulletin. If the operator elects not to participate in the bulletin, that decision will be taken into consideration by GE in evaluating future product performance issues that may arise in the operator’s fleet.

D. Concurrent Requirements
None.

E. Reason
(1) Objective:
To reduce significant events.
(2) Condition:
It has been confirmed that the fluorescent penetrant inspection (FPI) has not been done on the stage 6, stage 7, and stage 8 webs on the affected population of stages 6-10 compressor rotor spools.
(3) Cause:
Potential surface anomalies in the stages 6-10 compressor rotor spool stage 6, stage 7, and stage 8 webs reduce the fatigue life of the stages 6-10 compressor rotor spool.
(4) Inspection:
The inspection is to be done one time in order to identify if the stages 6-10 compressor rotor spool has an unserviceable surface anomaly.
(5) Substantiation:
Substantiation is by analysis.

F. Approval
The data contained in this Service Bulletin has been reviewed by the FAA or authorized entity representing the FAA and the repair(s) and modification(s) herein comply with the applicable Aviation Regulations and are APPROVED for installation in the model(s) listed in this Service Bulletin.

G. Manpower
After you get access to the stages 6-10 compressor rotor spool, you will need approximately 5 man-hours to do the inspection portion of this Service Bulletin.

H. Weight and Balance
Weight and balance are not changed.

I. References (Use the latest version of these documents)
GEK 114119, GEnx-2B Engine Manual (EM)
GEK 114120, GEnx-2B Cleaning, Inspection, and Repair Manual (CIR)
GEK 114122, GEnx-2B Engine Illustrated Parts Catalog (EIPC)
GEnx-2B S/B 72-0385, ENGINE - High Pressure Compressor Rotor Assembly (72-31-00) - Inspection of the Stages 6-10 Compressor Rotor Spool Stage 8 Web for Dents
GEnx-2B S/B 72-0398, ENGINE - High Pressure Compressor Rotor Assembly (72-31-00) - Inspection of the Stages 6-10 Compressor Rotor Spool Stage 6 and Stage 7 Webs for Dents

NOTE: The reference document listed below is for the engine manufacturer’s internal use only:
BPP/EPEX No.: 20-72-31-89604

J. Publications Affected
None.
K. Interchangeability
   Not applicable.

L. Software Accomplishment Summary
   Not applicable.

2. MATERIAL INFORMATION
   A. Material - Price and Availability
      (1) Parts necessary to do this Service Bulletin:
          None.
      (2) Other Spare Parts:
          None.
      (3) Consumables:
          None.

   B. Industry Support Information
      Industry support is available for this Service Bulletin. Contact your Customer
      Support Manager (CSM) for more details and reference number D-1222-2IY.

   C. Configuration Chart
      None.

   D. Parts Disposition
      None.

   E. Tooling - Price and Availability
      Refer to the GENx-2B EM, 72-00-00, SPECIAL PROCEDURE 023.

3. ACCOMPLISHMENT INSTRUCTIONS
   A. General
      (1) Do one of the inspections of the stages 6-10 compressor rotor spool (1, Figure 1) that
          follow:
          (a) Do an inspection of the stages 6-10 compressor rotor spool (1) stage 6, stage 7, and
              stage 8 webs, web transitions, and bore faces as follows:
              1. Do the necessary disassembly of the engine for the inspection. Refer to the
                 GENx-2B EM, 72-00-00, SPECIAL PROCEDURE 023.
              2. Do an inspection of the stages 6-10 compressor rotor spool (1, Figure 1) stage 6, stage
                 7, and stage 8 webs, web transitions, and bore faces in accordance with
                 GENx-2B EM, 72-00-00, SPECIAL PROCEDURE 023, released on March 26, 2020 or a later
                 approved revision.
              3. Do the necessary engine assembly after the inspection. Refer to the GENx-2B EM,
                 72-00-00, SPECIAL PROCEDURE 023.
          OR
          (b) Do an inspection of the stages 6-10 compressor rotor spool (1, Figure 1) stage 6, stage
              7, and stage 8 webs, web transitions, and bore faces in accordance with GENx-2B
              CIR, 72-31-45, INSPECTION 001, Subtask 72-31-45-160-002, Revision 19, October 01, 2017
              with the incremental change (IC) released on October 13, 2017 or a later approved
              revision.

      NOTE: For compliance with piece-part level eddy current inspection, a check must be done of
      shop visit documentation, as in the inspection specified in GENx-2B CIR, 72-31-45,
      INSPECTION 001, Subtask 72-31-45-160-002.
LEGEND:
1. STAGES 6-10 COMPRESSOR ROTOR SPOOL

Stages 6-10 Compressor Rotor Spool Location
Figure 1 (Sheet 1)
4. APPENDIX - A

Table 1: Affected Population of Stages 6-10 Compressor Rotor Spools P/N 2340M36G01

<table>
<thead>
<tr>
<th>Serial Number</th>
<th>Serial Number</th>
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**NOTE:** This Table 1 stages 6-10 compressor rotor spool population is added from GEnx-2B S/B 72-0385 and GEnx-2B S/B 72-0398 for tool dent inspection. This population has been added to Revision 1 of this Service Bulletin.

Table 2: Affected Population of Stages 6-10 Compressor Rotor Spools P/N 2628M56G01

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<tr>
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6015809-00
GEnx-2B Service Bulletins (SBs)

SB 72-0415 R02 ENGINE - P1 HPC Rotor Assembly (72-31-00) - Inspection of the Stages 6-10 Compressor Rotor Spool Stages 6-8 Webs for Scratches

Date Printed: 2020/11/18

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GEnx-2B Service Bulletins (SBs)
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**NOTE:** This Table 2 stages 6-10 compressor rotor spool population is added from GEnx-2B S/B 72-0385 and GEnx-2B S/B 72-0398 for tool dent inspection. This population has been added to Revision 1 of this Service Bulletin.

### Table 3. Affected Population of Stages 6-10 Compressor Rotor Spool P/N 2628M56G01

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<th>Stages 6-10 Compressor Rotor Spool Serial Number</th>
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</tbody>
</table>

**NOTE:** This Table 3 stages 6-10 compressor rotor spool population is listed in the original of this Service Bulletin. There is no change in Revision 1 of this Service Bulletin.

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