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## V2500-A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-70-0428 and Revision 1 to the Supplement

### Document History

Service Bulletin Revision Status  
Initial Issue Oct.15/95

Supplement Revision Status  
Initial Issue Oct.15/95

### Bulletin Revision 1

Remove  
Pages 1 to 5 of the  
Service Bulletin

Incorporate  
Pages 1 to 6 of the  
Service Bulletin

All pages of  
Appendix 1

Reason for change  
To update the Material  
Information and the  
Supplement.  
To update the Material  
Information and the  
Supplement.

### Supplement Revision 1

Remove  
All pages

Incorporate  
Page 1

Reason for change  
To update the Material  
Information and the  
Supplement.

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Transmittal - Page 1 of 2

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED

If any have not been received please advise Customer Data Services, Rolls-Royce plc, Derby, England

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# LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 1 to the Bulletin and Revision 1 to the Supplement are as follows:

<u>Page</u>		<u>Revision Number</u>	<u>Revision Date</u>
Bulletin			
R	1	1	Oct.16/06
R	2	1	Oct.16/06
R	3	1	Oct.16/06
R	4	1	Oct.16/06
R	5	1	Oct.16/06
R	6	1	Oct.16/06
Supplement			
R	1	1	Oct.16/06

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STANDARD PRACTICES – ENGINE – HP TURBINE ROTOR AND STATOR ASSEMBLY – TO ANNOUNCE THE  
AVAILABILITY OF NEW STAGE 2 HP TURBINE VANES

1. Planning Information

A. Effectivity Data

(1) For Airbus A319

Engine Models Applicable

V2522-A5, V2524-A5, V2527M-A5

Engine Serial Nos. – Any engine as applicable.

(2) For Airbus A320

Engine Models Applicable

V2527-A5, V2527E-A5

Engine Serial Nos. – Any engine as applicable.

(3) For Airbus A321

Engine Models Applicable

V2530-A5

Engine Serial Nos. – Any engine as applicable.

(4) For Boeing MD-90

Engine Models Applicable

V2525-D5, V2528-D5

Engine Serial Nos. – Any engine as applicable.

B. Reason

To announce the availability of new Stage 2 HP Turbine Vanes.

C. Compliance

Category 7

Accomplish when supply of superseded parts has been depleted.

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R Oct.16/06

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Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

**D. Approval Data**

The part number transactions shown under the Material Information portion of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

The compliance statement and the procedures described in this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model listed.

**E. References**

(1) V2500 Standard Practices/Processes Manual (E-V2500-1IA).

R (2) Internal Reference No. - 94VA099, 94VA099A, 94VA099B.

(3) ATA Locator - 72-45-24.

**F. Other Publications Affected**

(1) V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA, S-V2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA and S-V2500-7IB), Chapter/Section 72-45-24.

(2) V2500 Engine Manuals (E-V2500-1IA and E-V2500-3IA), Chapter/Section 72-45-24 Cleaning, Inspection and Repair, to add the new part.

**G. Interchangeability of Parts**

Old and new parts are directly interchangeable.

**H. Information in the Appendix**

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

**I. General Information**

(1) The Material Information section of this Service Bulletin provides the latest information concerning the availability of the affected parts.

- (2) The directionally solidified nickel alloy cast Stage 2 HPT Vanes are replaced with equiax nickel alloy cast vanes. The new material has improved repairability.
- (3) Mark the old parts with a -001 suffix when they will be mixed with new parts for use in engines.
  - (a) Use the vibration peen method given in Reference (2), Chapter/Section 70-09-00, Marking of Parts.

## 2. Material Information

### R A. Material – Price and Availability

R Modification kit is not required.

R For Price and availability of spares refer to the supplement of this Service  
R Bulletin.

### B. Industry Support Program

Not Applicable.

### C. The material data that follows is for each engine.

72-45-24

R For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2525-D5,  
V2528-D5 Engines:

FIG-ITEM NUMBER	NEW PART NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR-DISP
R 02-050	2A3372	17	Ring Segment and Vane Cluster Assembly, HPT, Stage 2	-	2A2272	(1) (A) (B)
R 02-130	2A3352	2	..Vane Assembly, HPT, Stage 2	-	2A2052	(1) (A) (B)
R 02-260	2A3472	2	Ring Segment and Vane Cluster Assembly, HPT, Stage 2	-	2A2372	(1) (A) (B)
02-350	2A3352	1	..Vane, HPT, Stage 2 Assembly	-	2A2052	(1) (A) (B)
02-420	2A3452	1	..Vane, HPT, Stage 2 Assembly	-	2A2152	(1) (A) (B)

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R	72-45-24						
R	For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2525-D5,						
R	V2528-D5 Engines with mixed Ring Segments:						
R	FIG-ITEM	NEW PART					
R	NUMBER	NUMBER	QTY	PART TITLE	MAT	OLD PN	INSTR-DISP
R	02-050	2A2272-001	17	Ring Segment and	-	2A2272	(1) (B) (M)
R				Vane Cluster			
R				Assembly,			
R				HPT, Stage 2			
R	02-260	2A2372-001	2	Ring Segment and	-	2A2372	(1) (B) (M)
R				Vane Cluster			
R				Assembly, HPT,			
R				Stage 2			

D. Instructions/Disposition Code Statements:

Parts Modification Conditions

(1) Old and New Parts are freely and fully interchangeable, both physically and functionally.

R (A) The new part is no longer available.

R (B) The old part is no longer available.

R (M) It is possible to get the new part only by modification.

R NOTE: The current production parts were introduced by Service Bulletin  
R 72-0368.

**3. Accomplishment Instructions**

Not applicable.



STANDARD PRACTICES – ENGINE – HP TURBINE ROTOR AND STATOR ASSEMBLY – TO ANNOUNCE THE AVAILABILITY OF NEW STAGE 2 HP TURBINE VANES

Supplement

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V2500 ALL

1. Modification Kit

A. There is no kit provided to do this Service Bulletin.

2. Material Cost

3. New Production Parts

	New Production Part Number	Description	Unit Price US Dollars
R	2A3352	..Vane Assembly, HPT, Stage 2	Not applicable.
R	2A3472	Ring Segment and Vane Cluster Assembly, HPT, Stage 2	Not applicable.
R	2A3452	..Vane, HPT, Stage 2 Assembly	Not applicable.
R	2A3372	..Vane, HPT, Stage 2 Assembly	Not applicable.
R	<u>NOTE:</u> The current new production parts were introduced by Service Bulletin 72-0368.		
R			

