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V2500-A1/A5 PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 1 to Service Bulletin EV2500-70-0783

Document History

Service Bulletin Revision Status
 Initial Issue Jun.9/00

Supplement Revision Status

Bulletin Revision 1

Remove
 Pages 1 to 3 of the
 Service Bulletin

Incorporate
 Pages 1 to 5 of the
 Service Bulletin

Reason for change
 To revise engine
 effectivity, add concurrent
 requirement section and
 part price

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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 Publication 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 are as follows:

<u>Page</u>		<u>Revision Number</u>	<u>Revision Date</u>
	Bulletin		
R	1	1	Jul.31/01
R	2	1	Jul.31/01
R	3	1	Jul.31/01
R	4	1	Jul.31/01
R	5	1	Jul.31/01

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INFORMATION - ENGINE - TURBINE EXHAUST CASE GROUP - TO ANNOUNCE THE AVAILABILITY OF A
NEW TURBINE EXHAUST CASE ASSEMBLY

1. Planning Information

A. Effectivity

(1) Airbus A319

R V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V10906

(2) Airbus A320

(a) V2500-A1 Engines prior to Serial No. V0362

R (b) V2527-A5, V2527E-A5 Engines prior to Serial No. V10906

(3) Airbus A321

R V2530-A5, V2533-A5 Engines prior to Serial No. V10906

R (4) ATA Locator 72-50-00

R B. Concurrent Requirements

R None

C. Reason

R (1) Problem

The existing casting and welding process used in manufacturing the turbine exhaust case is timely and expensive.

(2) Background

Difficult manufacturing procedures have caused unnecessary rework and additional cost.

(3) Objective

Replacing numerous cast parts with forged parts will facilitate manufacturing by eliminating unnecessary stringent casting requirements.

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(4) Substantiation

Individual comparative analyses of the critical design functions of the turbine exhaust case demonstrates equal capability, strength and integrity. LCF concerns were verified with extensive use of various finite element models. Benefit from changing cast to forged properties of the same material also helped in the substantiation of the revisions.

D. Description

Replace the cast parts with forged parts to reduce rework and additional cost

E. Approval

R The part number changes and/or part modifications specified in the
R Accomplishment Instructions and Material Information sections of this Service
Bulletin have been shown to comply with the applicable Federal Aviation
Regulations and are FAA approved for the engine models listed.

F. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

R G. Manpower

R Estimated man-hours to incorporate the full intent of this bulletin

R In service

R Not applicable

R At overhaul

R Not applicable

H. Weight and Balance

(1) Weight Change

Minus 1.9lb (-0.86kg)

(2) Moment Arm

No effect

(3) Datum

Engine Front Mount Centreline (Power Plant Station - PPS 100).



I. References

- R (1) V2500 Engine Illustrated Parts Catalogue (S-V2500-1IA, S-V2500-2IA,
S-V2500-2IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB,
R S-V2500-7IA, S-V2500-7IB), Chapter/Section 72-50-53, Fig 21, Index 300.
- R (2) IAE Engineering Change 98VZ002

J. Other Publications Affected

- R V2500 Engine Illustrated Parts Catalogue (S-V2500-1IA, S-V2500-2IA,
R S-V2500-2IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA,
R S-V2500-7IB), Chapter/Section 72-50-53, Fig 21, Index 300, to add new part.

K. Interchangeability of Parts

- R Old and new parts are directly interchangeable.

L. General Information

- R The Material Information portion of this bulletin provides the latest
information concerning the availability and part hierarchy for the turbine
exhaust case assembly.



2. Material Information

R A. Material – Price and Availability

R (1) The estimated price of new material to do this Service Bulletin using new
R replacement parts is \$248,610.00.

R (2) There is no kit provided to do this Service Bulletin.

R (3) Part availability information is provided in material data Instructions
R disposition.

R B. Industry Support Program

R Not applicable

R C. New production parts:

R PART NO.	QTY	UNIT PRICE
R		US DOLLARS
R 2A3455-01	1	248,610.00

D. Parts affected by this bulletin:

R The material data that follows is for each engine

R NOTE: The prices shown are for estimating purposes only and as such are given
R in good faith without commercial liability for advanced planning
R purposes only. Refer to IAE Spares an/or current Price Catalog for
R current prices

R For V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5,
R V2533-A5 Engines

72-50-53

R FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
R ITEM	PART				PART	DISP
R NO.	NO.				NO.	
R 21300	2A3455-01	1	Case assy-Turb exh	-	2A3183-01	(2)(A)(N)

R E. Instructions Disposition Codes

R (2) The new part is a replacement part only, and cannot be obtained by
R modification of the old part.

R (A) The new part is available.

R (N) The old part is not available.



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SERVICE BULLETIN

R 3. Accomplishment Instructions

R Not applicable

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

