



400 MAIN STREET, MAIL STOP 121-10  
EAST HARTFORD, CT 06108, USA.  
TELEPHONE:- 860 565 5515  
FAX:- 860 565 0600

DATE: Jan.19/09

P.O. BOX 31, DERBY  
TELEGRAMS - 'ROYCAR' DERBY  
TELEX - 37645  
TELEPHONE:- 44 (0) 1332 242424  
FAX:- 44 (0) 1332 249936

## V2500-A1/A5/D5 PROPULSION SYSTEM INFORMATION SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 2 to Service Bulletin V2500-ENG-70-0805 and the Revision 2 of the Supplement

### Document History

Service Bulletin Revision Status  
Initial Issue Nov.29/02  
Revision 1 Feb.11/03

Supplement Revision Status  
Initial Issue Nov.29/02  
Revision 1 Feb.11/03

### Service Bulletin Revision 2

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 4 of the Service Bulletin	To revise Section 1.A. Effectivity and the Supplement and apply style changes.
All pages of the Supplement	Page 1 of the Supplement	To revise Section 1.A. Effectivity and the Supplement and apply style changes.

# V2500-ENG-70-0805

Transmittal - Page 1 of 1

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED

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

© Rolls-Royce plc (date as above) Printed in Great Britain



INFORMATION – ENGINE – LP TURBINE – INTRODUCTION OF CAST TO SIZE BLADES STAGES 3, 4  
AND 6

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5 Engines

(i) For LP turbine stage 3 blades:

Engines prior to Serial No. V11500.

(ii) For LP turbine stage 4 blades:

Engines prior to Serial No. V11460.

(iii) For LP turbine stage 6 blades:

Engines prior to Serial No. V11480.

(2) Airbus A320

(a) V2500-A1 Engines

(i) For LP turbine stages 3, 4 and 6 blades:

Engines prior to Serial No. V0362.

(b) V2524-A5, V2527-A5, V2527E-A5 Engines

(i) For LP turbine stage 3 blades:

Engines prior to Serial No. V11500.

(ii) For LP turbine stage 4 blades:

Engines prior to Serial No. V11460.

(iii) For LP turbine stage 6 blades:

Engines prior to Serial No. V11480.

- R (3) Airbus A321
- R (a) V2530-A5, V2533-A5 Engines
- R (i) For LP turbine stage 3 blades:
- R Engines prior to Serial No. V11500.
- R (ii) For LP turbine stage 4 blades:
- R Engines prior to Serial No. V11460.
- R (iii) For LP turbine stage 6 blades:
- R Engines prior to Serial No. V11480.

- R (4) Boeing MD-90
- R (a) V2525-D5, V2528-D5 Engines
- R (i) For LP turbine stages 3, 4 and 6 blades:
- R Engines prior to Serial No. V20286.

#### B. Reason

- R To introduce cast to size (CTS) LP Turbine Blades Stages 3, 4 and 6. This CTS  
R design reduces the grinding operation within manufacturing.
- R (1) The following changes on LP Turbine Blades Stages 3, 4 and 6 were  
R introduced:
- R (a) - Outer shroud will be CTS, only outer diameter of knife edges and  
R circumferential stiffener (dogbone) will be ground.
- R (b) - Radial lip at the platform edge was deleted. Both axial surfaces are  
R CTS.
- R (c) Additionally for Stage 6 only:
- R - Rear face of firtree will be CTS.

R **NOTE:** The CTS Configuration will be slightly different in appearance, but has  
R no effect on the interchangeability of the parts (see 2. Material  
R Information).

#### C. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

**D. Approval**

R The part number changes and/or part modification described in Section 2 of this  
R Service Bulletin have been shown to comply with the applicable Federal Aviation  
R Regulations and are FAA-APPROVED for the Engine Models Listed.

**E. General Information**

- R (1) The Material Information portion of this Bulletin provides the latest  
R information concerning the availability of the affected parts.
- R (2) Publications affected:
- R (a) The V2500-A1/A5/D5 Engine Illustrated Parts Catalogs (S-V2500-1IA,  
R S-V2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA,  
R S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, S-V2500-7IB) will  
R be revised to include the new part. Refer to Section 2. "Material  
R Information" for ATA Locations.

**F. References**

- R (1) Internal References EC94VM016, EC94VM016-01, EC94VM016-02, EC94VM016A,  
R EC94VM016A-01, EC94VM016A-02, EC94VM016B, EC94VM016B-01, EC94VM016B-02.
- R (2) ATA Location: 72-50-32.

## 2. Material Information

R A. The kit required consists of the following parts:

R None.

R B. New production parts:

R See supplement of this Service Bulletin.

R C. Parts affected by this Service Bulletin:

72-50-32

FIG ITEM NO.	NEW PART NO.	QTY	TITLE	OLD PART NO.	INSTR DISP
R 01200	3A2373	97	Turbine Blade Stage 3	3A2055	(A)(B)(S1)
01150	3A2374	99	Turbine Blade Stage 4	3A1804	(A)(B)(S1)
01050	3A2704	85	Turbine Blade Stage 6	3A1806	(A)(B)(S1)

### D. Instructions Disposition Codes

(A) New part is currently available for sale.

(B) Old part will continue to be supplied until existing stock is exhausted.

R (S1) Old and new parts are freely and fully interchangeable, both physically and functionally.

## 3. Accomplishment Instructions

None.

INFORMATION – ENGINE – LP TURBINE – INTRODUCTION OF CAST TO SIZE BLADES STAGES 3, 4  
AND 6

SUPPLEMENT – PRICES AND AVAILABILITY

The prices if shown are for estimating purposes only and as such are given in good faith, without commercial liability for advanced planning purposes only. Refer to IAE Spares and/or current price catalogue for current prices.

1. Modification Kit

Not applicable.

2. New Production Parts

R	Part No.	Description	Unit Price
			US Dollars
R	3A2373	Blade Stage 3	1,528.00
R	3A2374	Blade Stage 4	1,576.00
R	3A2704	Blade Stage 6	1,498.00