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V2500-A1/A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-70-0827 and Revision 1 to the Supplement

Document History

Service Bulletin Revision Status
Initial Issue Jul.20/03

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Initial Issue Jul.20/03

Bulletin Revision 1

Remove
Pages 1 to 6 of the
Service Bulletin

Incorporate
Pages 1 to 8 of the
Service Bulletin

Reason for change
To add V2500-A1 engine in
applicable engines.

Supplement Revision 1

Remove
All pages

Incorporate
Page 1

Reason for change
To add V2500-A1 engine in
applicable engines.

V2500-ENG-70-0827

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 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	Mar.23/04
R	2	1	Mar.23/04
R	3	1	Mar.23/04
R	4	1	Mar.23/04
R	5	1	Mar.23/04
R	6	1	Mar.23/04
R	7	1	Mar.23/04
R	8	1	Mar.23/04
Supplement			
R	1	1	Mar.23/04

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ENGINE - LP COMPRESSOR - TO ANNOUNCE THE PART NUMBER CHANGES ABOUT THE NO.3 ROTOR CENTRE DETAILS

1. Planning Information

A. Effectivity

- (1) Airbus A319
V2522-A5, V2524-A5 Engines
- (2) Airbus A320
V2500-A1, V2527-A5, V2527E-A5 Engines
- (3) Airbus A321
V2530-A5, V2533-A5 Engines
- (4) Boeing - Longbeach Division MD-90
V2525-D5, V2528-D5 Engines

B. Concurrent Requirements

None.

C. Reason

(1) Problem

It is required to change material control since the design and manufacturing responsibilities of the No.3 Bearing Rotor Centre details were transferred internally.

(2) Evidence

None.

(3) Substantiation

Not applicable.

(4) Objective

To announce the part number changes about the No.3 Bearing Rotor Centre details.



(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

(6) Supplemental Information

None.

D. Description

(1) The changes introduced by this Service Bulletin are as follows:

(a) The part numbers are changed as follows:

Old part number	New part number
UP10762	5A1878
UP10892	5A1879
UP11050	5A1876
UP11051	5A1877

(b) The designs of the above parts, Seal Ring, Washer, Locating Bolt and Spacer are not changed.

E. Compliance

Category Code 7

Accomplish when there are no original parts remaining.



F. Approval

The part number transactions are given in the Material Information section of this Service Bulletin. They comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine models listed.

G. Manpower

Not applicable.

H. Material Price and Availability

Modification kit not required; parts supplied as single line items.

For prices and availability of future spares see Supplement to this Bulletin.

I. Tooling Price and Availability

Not applicable.

J. Industry Support Information

Not applicable.

K. Weight and Balance

(1) Weight Change

Not affected.

(2) Moment Arm

Not affected.

(3) Datum

Engine front mount centreline (Power Plant Station - (PPS) 100).

L. Electrical Load Data

The aircraft electrical load is not affected by this Service Bulletin.

M. Software Accomplishment Summary

Not applicable.



N. References

- R (1) IAE Engineering Change No. 02VJ010 and 03VJ031.
- (2) ATA Locator - 72-32-00.

O. Other Publications Affected

- (1) V2500 Engine Illustrated Parts Catalogue (EIPC) Chapter/Section 72-32-23 Fig. 01 will be revised to add the new part number.
- (2) V2500 Engine Manual, (E-V2500-1IA and E-V2500-3IA) Chapter/Section 72-32-23, Repair 006 (VRS6267), Repair 009 (VRS6113) and Repair 013 (VRS6488) will be revised to add the new repair part number.

P. Interchangeability of Parts

Not affected.

2. Material InformationA. The kit required consists of the following parts:

None.

B. New production parts:

None.

C. Parts affected by this Service Bulletin:

R V2500-A1 Engines

R 72-32-23

R	FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
R	ITEM	PART				PART	DISP
R	NO.	NO.				NO.	
R	01700	6A3915	1	.Shaft, and Seal Assy	-	6A3915	(A)
R				Front - HPC			
R	01712	AS21013	18	..Bolt, Bihex hd	-	AS21013	(A)
R	01713	K8833	18	..Washer, Flat	-	K8833	(A)
R	01715	6A3901	1	..Plate, Spreader	-	6A3901	(A)
R	01718	4W0002	18	..Nut	-	4W0002	(A)
R	01720	6A3916	1	..Carrier, Assy Ring -	-	6A3916	(A)
R				Seal			
R	01724	6A1450	1	...Retainer, Ring Seal	-	6A1450	(A)
R	01726	5A1879	1	...Ring, Seal	-	UP10892	(B)(C)
R							(E)(S1)

R NOTE: Repair parts 5A1879 and UP10892 are required to accomplish Repair
R VRS6113.

R	FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
R	ITEM	PART				PART	DISP
R	NO.	NO.				NO.	
R	01728	6A3917	1	...Carrier	-	6A3917	(D)
R	01745	6A3899	1	..Shaft, Balancing and	-	6A3899	(A)
R				Assy			
R	01748	4W0002	4	...Nut	-	4W0002	(A)
R	01749	5A1876	4	...Washer	-	UP11050	(B)(C)
R							(S1)
R	01750	5A1878	4	...Bolt, Locating	-	UP10762	(B)(C)
R							(S1)(F)

R NOTE: Repair parts 5A1878 and UP10762 are required to accomplish Repair
R VRS6267.



R	FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
R	ITEM	PART				PART	DISP
R	NO.	NO.				NO.	
R	01760	5A1877	20	...Spacer	-	UP11051	(B)(C) (F)(S1)

R NOTE: Repair parts 5A1877 and UP11051 are required to accomplish Repair
R VRS6488.

R	FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
R	ITEM	PART				PART	DISP
R	NO.	NO.				NO.	
R	01770	6A3900	1	...Shaft, Front - HPC	-	6A3900	(D)

V2500-A5 and D5 Engines

R 72-32-23

FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
ITEM	PART				PART	DISP
NO.	NO.				NO.	
01700	6A8082	1	.Shaft, and Seal Assy Front - HPC	-	6A8082	(A)
01712	AS21013	18	..Bolt, Bihex hd	-	AS21013	(A)
01713	K8833	18	..Washer, Flat	-	K8833	(A)
01715	6A3901	1	..Plate, Spreader	-	6A3901	(A)
01718	4W0002	18	..Nut	-	4W0002	(A)
01720	6A4469	1	..Carrier, Assy Ring - Seal	-	6A4469	(A)
01724	6A1450	1	...Retainer, Ring Seal	-	6A1450	(A)
01726	5A1879	1	...Ring, Seal	-	UP10892	(B)(C) (E)(S1)

R NOTE: Repair parts 5A1879 and UP10892 are required to accomplish Repair
R VRS6113.

FIG	NEW	QTY	PART TITLE	MAT	OLD	INSTR
ITEM	PART				PART	DISP
NO.	NO.				NO.	
01728	6A4470	1	...Carrier	-	6A4470	(D)
01745	6A8083	1	..Shaft, Balancing and Assy	-	6A8083	(A)
01748	4W0002	4	...Nut	-	4W0002	(A)
01749	5A1876	4	...Washer	-	UP11050	(B)(C) (S1)



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01750	5A1878	4	...Bolt, Locating	-	UP10762	(B)(C) (S1)(F)

NOTE: Repair parts 5A1878 and UP10762 are required to accomplish Repair VRS6267.

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01760	5A1877	20	...Spacer	-	UP11051	(B)(C) (F)(S1)

NOTE: Repair parts 5A1877 and UP11051 are required to accomplish Repair VRS6488.

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01770	6A8084	1	...Shaft, Front - HPC	-	6A8084	(D)

D. Instructions disposition codes:

(A) New part is currently available.

(B) New part will become available when existing stock of old parts has been exhausted.

(C) Old parts will continue to be supplied until existing supplies have been depleted.

(D) New part is not spareable.

(E) Repair parts for Ring Seal Carrier (72-32-23, Fig/Item 01-720).

(F) Repair parts for Front Stub Shaft (72-32-23, Fig/Item 01-745).

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

3. Accomplishment Instructions



International Aero Engines

SERVICE BULLETIN

None

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

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R Mar.23/04



ENGINE - LP COMPRESSOR - TO ANNOUNCE THE PART NUMBER CHANGES ABOUT THE NO.3 ROTOR
CENTRE DETAILS

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:

	Part No.	Desc.	Unit Price US Dollars
R	6A3915	Shaft	28,820.00
R	6A3916	Carrier	3537.00
R	6A3899	Shaft	24,770.00
R	6A3900	Shaft	22,190.00
R	6A8082	Shaft	31,710.00
R	AS21013	Bolt	4.80
R	K8833	Washer	0.25
R	6A3901	Plate	1,266.00
R	4W0002	Nut	3.20
R	6A4469	Carrier	3,674.00
R	6A1450	Retainer	391.00
R	5A1879	Ring	711.00
R	6A8083	Shaft	28,740.00
R	5A1876	Washer	54.50
R	5A1878	Bolt	75.60
R	5A1877	Spacer	93.10

