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**V2500-A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN**

This document transmits the Initial Issue of Service Bulletin EV2500-71-0148

**Bulletin Initial Issue**

Remove

Incorporate  
 Pages 1 to 7 of the  
 Service Bulletin

Reason for change  
 Initial issue

**V2500-ENG-71-0148**

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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 are as follows:

Page                      Revision Number      Revision Date

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ENGINE – POWERPLANT – MODIFICATION OF THE EEC HARNESS SUPPORT BRACKET

1. Planning Information

A. Effectivity

(1) Airbus A320

V2527–A5 Engines prior to Serial No. V10112

(2) Airbus A321

V2530–A5 Engines prior to Serial No. V10112

(3) ATA Locator 71–00–00

B. Concurrent Requirements

None

C. Reason

(1) Condition

Insufficient clearance may exist between a support bracket for the EEC harness and an adjacent bracket at clipping position CP1200

(2) Background

This condition has been observed during assembly of production engines. A review of the existing installation has shown the need to rework the support bracket to obtain the necessary clearance

(3) Objective

To ensure adequate clearance is maintained between the support bracket and adjacent hardware

(4) Substantiation

Trial installation showed that the new bracket introduced by this Service Bulletin gave the improved fit and necessary clearance

(5) Effect of Bulletin on:

(a) Removal /Installation

Not affected



(b) Disassembly/Assembly

Not affected

(c) Cleaning

Not affected

(d) Inspection/Check

Not affected

(e) Repair

Not affected

(f) Testing

Not affected

(6) Supplemental Information

None

D. Description

The change introduced by this Service Bulletin is as follows:

The existing bracket which supports clipping point CP1200 is removed and modified to the new configuration (refer to Fig 1)

E. Compliance

Category Code 6

Accomplish when the sub-assembly (i.e. Modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.

F. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification which is under DGAC (Direction Generale de L'Aviation Civile - France) approval

G. Manpower

(1) In Service

Not applicable



(2) At overhaul

Not affected

H. Material Price and Availability

Modification kit not required

I. Tooling Price and Availability

Special tools not required

J. Industry Support Information

None

K. Weight and Balance

(1) Weight Change

None

(2) Moment Arm

No effect

(3) Datum

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

L. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load

M. Software Accomplishment Summary

Not applicable

N. References

(1) Internal reference 93VN089A

(2) A320/A321 Aircraft Maintenance Manual, (AMM), 71-13-11

(3) IAE V2500 Standard Practices/Processes Manual, (SPP-V2500-1IA), 70-09-00

O. Other Publications Affected

(1) A320/A321/V2500-A5 Powerplant Illustrated Parts Catalogue (PIP-V2500-2IA), 71-51-50



(2) A320/V2500-A5 Engine Illustrated Parts Catalogue (S-V2500-2IA), 71-51-50

(3) A320/V2500-A1/A320/A321/V2500-A5 Engine Manual (E-V2500-1IA), 72-00-32

**P. Interchangeability of Parts**

The fuel flow transmitter support bracket and attaching bolts are only interchangeable with the existing parts as a complete set.

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## 2. Material Information

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

None

### B. Parts to be reworked:

None

### C. New production parts:

71-51-50

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01920	745-5997 -503	1	.Bracket	-	745-5997 -501	(A) (2D) (S1)

### D. Instructions disposition codes:

(A) New part currently available

(2D) Rework old part to new configuration and identify to new part number

(S1) New part may be used in place of old part but not vice versa

**NOTE:** The estimated 1997 unit price shown is provided for planning purposes only and does not constitute a firm quotation. Consult the Rohr Price Catalogue or contact Rohr's Spare Parts Sales Department for information concerning firm prices



### 3. Accomplishment Instructions

#### A. Rework Instructions

##### Consumable Materials

Metal marking ink CoMat 06-073

**NOTE:** To identify the consumable materials, refer to the Overhaul Processes and Consumable Index PCI-V2500-1IA

- (1) Trim the bracket 745-5997-501 as shown (Refer to Fig 1)
- (2) Use a file and remove any sharp corners or burrs
- (3) Identify the bracket to the new part number as shown with ink (CoMat 06-073) and a rubber stamp. Refer to IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (4) Install the bracket 745-5997-503 on the FA engine flange with two 4W0002 nuts and two AS21516 bolts as shown. Torque the bolts to 63 to 70 lbfin (7 to 8 Nm). Refer to the A320/A321 Aircraft Maintenance Manual, 70-23-11 on torque tightening techniques
- (5) Install clipping point CP1200 on the bracket 745-5997-503 as shown, with a 4W0132 bolt, SP154D washer, two TA025074-12 clamps, ST1698D51 spacer, ST1698D48 spacer, ST1698D-49 spacer and a 4W0001 nut. Torque the bolts to 20 to 25 lbfin (2 to 3 Nm). Refer to the A320/A321 Aircraft Maintenance Manual, 70-23-11 on torque tightening techniques

#### B. Assembly Instructions

The parts introduced by this Service Bulletin are interchangeable as a set. Remove and install in accordance with current maintenance procedures (Aircraft Maintenance Manual, 71-13-11, Removal/installation)

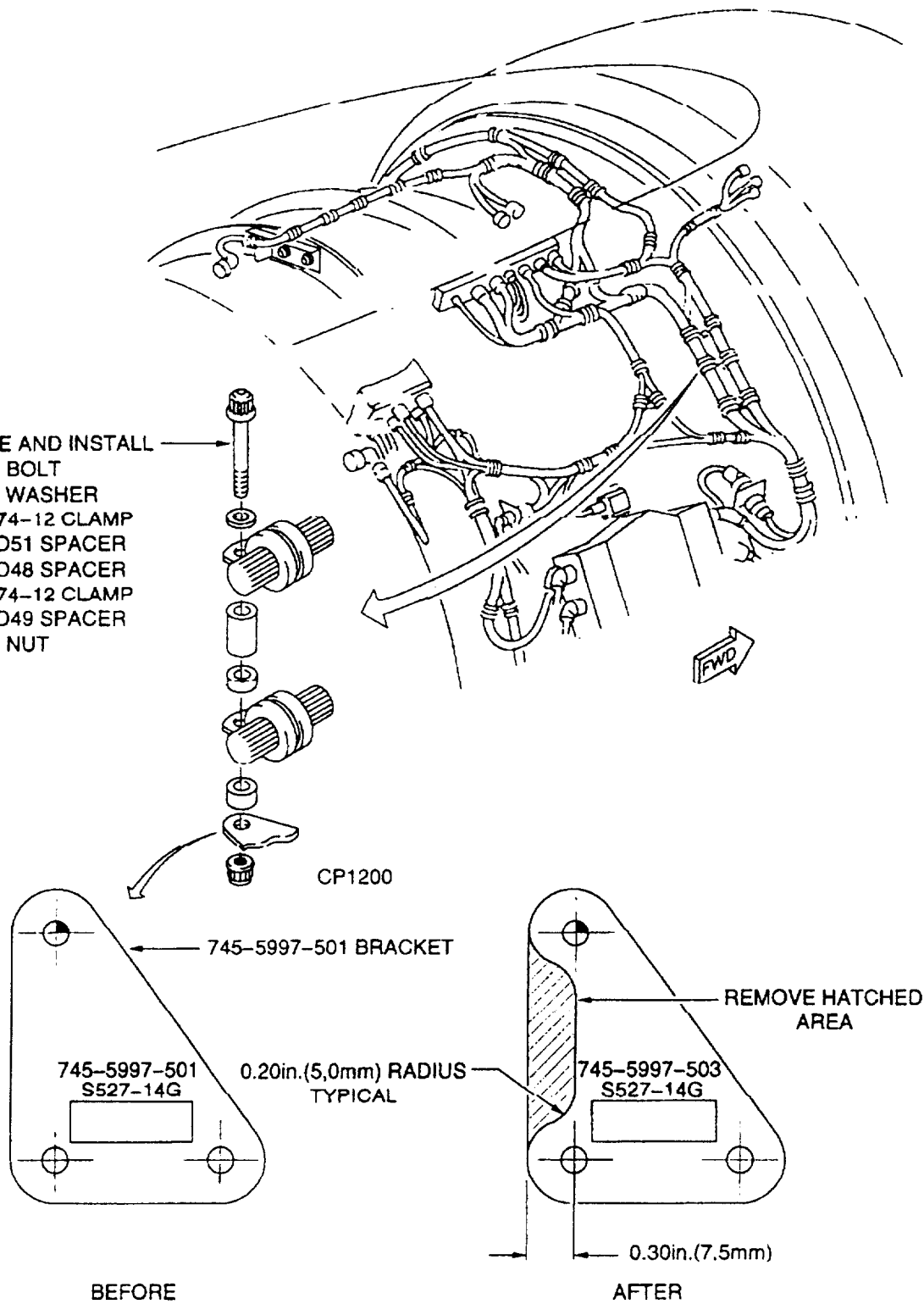
#### C. Recording Instructions

A record of accomplishment is necessary. Write in the engine log book that Service Bulletin V2500-ENG-71-0148 has been done





REMOVE AND INSTALL  
4W0132 BOLT  
SP154D WASHER  
TA025074-12 CLAMP  
ST1698D51 SPACER  
ST1698D48 SPACER  
TA025074-12 CLAMP  
ST1698D49 SPACER  
4W0001 NUT



Rework of harness support bracket  
Fig 1

