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V2500-A1 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 2 to Service Bulletin EV2500-72-0157 and Revision 2 to the Supplement

Document History

Service Bulletin Revision Status
Initial Issue Jul.29/94
Revision 1 Feb.17/06

Supplement Revision Status
Initial Issue Jul.29/94
Revision 1 Feb.17/06

Bulletin Revision 2

Remove	Incorporate	Reason for change
All pages of the Summary	Page 1 and 2 of the Summary	To revise the Material Information and to bring the Service Bulletin in line with the new format.
All pages of the Service Bulletin	Pages 1 to 6 of the Service Bulletin	To revise the Material Information and to bring the Service Bulletin in line with the new format.

Supplement Revision 2

Remove	Incorporate	Reason for change
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All pages

Page 1

To revise the Material
Information and to bring
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line with the new format.

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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 2 to the Bulletin and Revision 2 to the Supplement are as follows:

<u>Page</u>	<u>Revision Number</u>	<u>Revision Date</u>
Summary		
R 1	2	Aug.16/06
R 2	2	Aug.16/06
Bulletin		
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R 5	2	Aug.16/06
R 6	2	Aug.16/06
Supplement		
R 1	2	Aug.16/06

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ENGINE - LP TURBINE ASSEMBLY - INTRODUCTION OF LP TURBINE DISKS STAGE 3 TO 7 WITH
SHOTPEENED BLADE SLOTS

SUMMARY

1. PLANNING

A. EFFECTIVITY

Engine

V2500-A1 Engines V0001 to V0348

B. CONCURRENT REQUIREMENTS

None

C. REASON

Problem:

Some experimental engines have shown a potential of fretting at the LP Turbine disk slots at the blade retaining faces.

R Evidence:

R Fretting was seen on the disk slot fir tree on some experimental engines.

Objective:

To introduce an additional shot peen process during manufacturing to prevent fretting and increase surface durability

Substantiation

None.

D. DESCRIPTION

Introduction of new disks with shotpeened blade slots.

E. COMPLIANCE

Category Code 7

Accomplish when supply of superseded parts has been depleted.

F. MANPOWER

In Service

Not Applicable

At Overhaul

Not Applicable

G. INTERCHANGEABILITY OF PARTS

Refer to section 2 Material Information.

2. MATERIAL INFORMATION

Parts Prices

Refer to supplement to this bulletin.

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ENGINE - LP TURBINE ASSEMBLY - INTRODUCTION OF LP TURBINE DISKS STAGE 3 TO 7 WITH
SHOTPEENED BLADE SLOTS

1. Planning Information

A. Effectivity

(1) Airbus A320

V2500-A1 Engines prior to Serial No.V0349

B. Concurrent Requirements

None.

C. Reason

(1) Problem

Some experimental engines have shown a potential of fretting at the LP Turbine disk slots at the blade retaining faces.

(2) Evidence

Fretting was seen on the disk slot fir tree on some experimental engines.

(3) Substantiation

None.

(4) Objective

To introduce an additional shot peen process during manufacturing to prevent fretting and increase surface durability

(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Disassembly/Assembly

Not affected.

(c) Cleaning

Not affected.

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(d) Inspection/Check

Not affected.

(e) Repair Schemes

Not affected.

(f) Testing

Not affected.

(6) Supplemental Information

None.

D. Description

(1) The changes introduced are:

(a) Introduction of new disks with shotpeened blade slots.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

F. Approval

The part number changes and/or part modification described in Section 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA- APPROVED for the Engine Model listed.

G. Manpower

(1) In service

Not applicable.

(2) At overhaul

Not applicable.

H. Material Price and Availability

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

(2) 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**

None.

(2) Moment Arm

Not affected.

(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) Engineering Change Nos. 91VM005, 91VM005-01, 91VM005A

(2) V2500 Engine Illustrated Parts Catalogue

(3) V2500 Engine Manual E-V2500-1IA

(4) ATA Locator - 72-50-31

O. Other Publications Affected

(1) V2500 Engine Illustrated Parts Catalogue, Chapter/Section 72-50-31 to add the new Part Numbers.

(2) V2500 Engine Manual Chapter/Section 72-50-31, Cleaning to add the new Part Numbers.

(3) V2500 Engine Manual Chapter/Section 72-50-31, Inspection/Check to add the new Part Numbers.



(4) V2500 Engine Manual Chapter/Section 72-50-31, Repair to add the new Part Numbers.

(5) V2500 Engine Manual Chapter/Section 05-10-01, Group A Parts Lives

P. Interchangeability of Parts

Refer to section 2 Material Information.

2. Material Information

A. The kit required consists of the following parts:

Not applicable.

B. Parts to be reworked:

None.

C. Parts affected by this Bulletin:

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
01-100	3A2153	1	Disk, Turbine Stage 5	3A1665	(A)(S1)
01-200	3A2151	1	Disk, Turbine Stage 3	3A0713	(A)(S1)

D. Redundant parts:

None.

E. Instructions disposition codes:

(A) New part is available for sale.

(S1) Old and new parts are fully interchangeable.

3. Accomplishment Instructions

A. Rework Instructions

Not applicable.

B. Assembly Instructions

Assemble LP turbine module by the instructions given in Reference (3), Chapter/Section 72-50-10, Assembly.

C. Recording Instructions

A record of accomplishment is required.

ENGINE - LP TURBINE ASSEMBLY - INTRODUCTION OF LP TURBINE DISKS STAGE 3 TO 7 WITH
SHOTPEENED BLADE SLOTSSUPPLEMENT - PRICES AND AVAILABILITY

The prices 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. Parts required:

Part No.	Description	Unit Price US Dollars
3A2153	Disk, Turbine Stg 5	56,000.00
3A2151	Disk, Turbine Stg 3	50,700.00

