P U B L I C A T I O N T R A N S M I T T A L

RR-DERBY

V2500 International Aero Engines

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

P.O. BOX 31, DERBY
TELEGRAMS - 'ROYCAR' DERBY
TELEX - 37645
TELEPHONE - DERBY 242424

DATE R Aug.21/02

V2500-A1/A5 PROPULSION SYSTEM SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-72-0176

Document History

Service Bulletin Revision Status		Supplement Revision Status
Initial Issue	Jul.26/96	

Bulletin Revision 1

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 7 of the Service Bulletin	Correction to torque loading figure in 3.B. Assembly Instructions

V2500-ENG-72-0176

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:

	Page	Revision Number	Revision Date
	Bulletin		
R	1	1	Aug.21/02
R	2	1	Aug.21/02
R	3	1	Aug.21/02
R	4	1	Aug.21/02
R	5	1	Aug.21/02
R	6	1	Aug.21/02
R	7	1	Aug.21/02

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ENGINE - HP COMPRESSOR - INTRODUCTION OF A HP SYSTEM MODULE SERIAL NUMBER IDENTIFICATION PLATE

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1. Planning Information

A. Effectivity

(1) Airbus A320, A321

V2500-A1 Engines prior to Serial No.V0339

V2527-A5 Engines prior to Serial No.V10009

V2530-A5 Engines prior to Serial No.V10009

B. Concurrent Requirements

None.

C. Reason

(1) Condition

At present the HP system module unique serial number is not marked on the module.

(2) Background

The individual sub-assemblies which comprise the HP system module have their unique serial number marked either on an identification plate or by vibro-engraving the number on one of the components. The total HP system module serial number is recorded on the associated documentation but not on the module itself.

This is regarded as unsatisfactory as it could result in fitment of the wrong module with incorrect life recording of serialised items in each sub-assembly.

Provision of a system module plate for serial number identification will permit proper management, tracking and control.

(3) Objective

To provide a means of recording the module serial number which will be readily visible on individual modules and on uninstalled engines.

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(4) Substantiation

No engine testing is considered necessary. The identification plate and support bracket are designed and installed in a position that will not affect module function or integrity.

The plate is identical to that currently fitted to the HP compressor module except for the module name.

(5) Effect of Bulletin on Workshop Procedures:

Removal/Installation	Not affected
Disassembly/Assembly	Affected (see Supplemental Information)
Cleaning	Not affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

(6) Supplemental Information

Disassembly/Assembly will be revised to add new configuration of this Service Bulletin.

D. Description

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

A stainless steel bracket is bolted to the front flange of the HP compressor rear outer case. A module identification plate having spaces for the serial number and module assembly number is bonded to the bracket.

The plate is additionally secured to the bracket by 2 bolts.

E. Approval

The part number changes and/or part modifications 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.

F. Compliance

V2500-A1 Model

Category Code 8

Accomplish based upon experience with the prior configuration.

V2527-A5 and V2530-A5 Models

Category Code 6

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

G. Manpower

(1) In Service

Not applicable.

(2) At Overhaul

Not affected.

H. Material - Price and Availability

(1) Modification Kit not required.

(2) See Material Information section for prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not required.

J. Weight and Balance

(1) Weight change

Plus 0.1 lb (0,045 kg)

(2) Moment arm

27.5in (698,5 mm.) rearward of datum

(3) Datum

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

K. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

L. References

(1) V2500 Standard Practices/Processes Manual (SPP-V2500-1IA)

(2) Internal reference numbers - 89VR014, 89VR014B, 92VR175

(3) ATA Locator - 72-41-00

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M. Other Publications Affected

(1) V2500 Illustrated Parts Catalog (S-V2500-1IA), Chapter/Section 72-41-00.

(2) V2500 Illustrated Parts Catalog (S-V2500-2IA), Chapter/Section 72-41-00.

(3) V2500 Engine Manual (E-V2500-1IA), 72-41-00, Assembly-02 Config-01 and Config-02, Cleaning-07 and Inspection/Check-01.

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2. Material Information

A. Kits associated with this bulletin:

None.

B. Parts affected by this bulletin:

For each V2500 Engine to incorporate this bulletin:

72-41-00

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
03010	6A4128	1	Plate, identification	-	-	(A)(S1)
03012	4W0001	2	Nut, self locking	-	-	(A)(S1)
03013	4W2621	2	Washer, flat	-	-	(A)(S1)
03014	4W0103	2	Bolt, bi-hex head	-	-	(A)(S1)
03020	6A4129	1	Bracket, identification plate	-	-	(A)(S1)

C. Instructions/Disposition Code Statements:

(A) New part currently available

(S1) Items coded (S1) must be fitted as a set

D. Consumable Materials

CoMat 08-013 - Cold Curing Silicone Compound

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3. Accomplishment Instructions

A. Rework Instructions

(1) There are no rework instructions necessary to accomplish this Service Bulletin.

B. Assembly Instructions

(1) Machine engrave the HP System Module Serial and part numbers on the 6A4128 identification plate in the spaces provided in accordance with References (1), TASK 70-09-00-400-501, SUBTASK 70-09-00-400-001.

(2) Apply CoMat 08-013, Cold Curing Silicone Compound, to the 6A4128 identification plate and bond the plate to the 6A4129 bracket as shown in Figure 1 and in accordance with Reference(1), TASK 70-36-02-360-501, SUBTASK 70-36-02-360-020.

(3) Secure the plate with the 4W0103 bolts, 4W2621 washers and 4W0001 nuts.
R Torque the bolts to 39.8 lbfin (4,5 Nm) minimum.

(4) Install the plate and bracket onto the rear face of flange FJ at the position shown in Figure 1 using the existing nuts and bolts. Torque the bolts to 180 to 220 lbfin (20 to 25 Nm).

C. Recording Instructions

(1) A record of accomplishment is necessary.

Applicability: For each V2500 Engine to incorporate this Bulletin.

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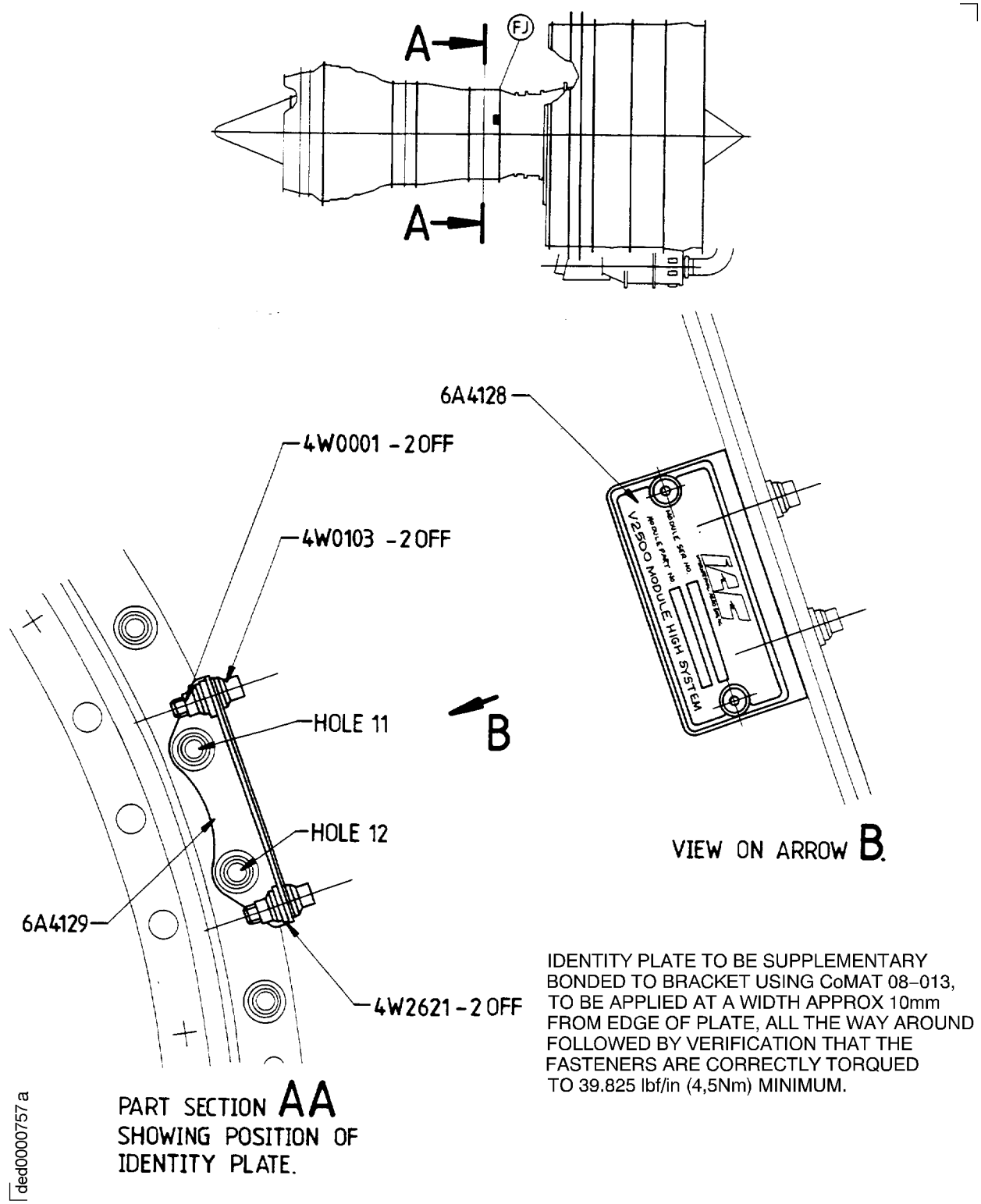

Location of identification plate and bracket
Fig.1

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