

**International Aero Engines****RR-DERBY**

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~~ Feb.21/02**V2500-A1 SERIES PROPULSION SYSTEMS SERVICE BULLETIN**

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-72-0243

Document History

Service Bulletin Revision Status
 Initial Issue Jan.10/97

Supplement Revision Status

Bulletin Revision 1

Remove
 All pages of the
 Service Bulletin

Incorporate
 Pages 1 to 5 of the
 Service Bulletin

Reason for change
 To revise Compliance
 Category

V2500-ENG-72-0243
 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 are as follows:

<u>Page</u>		<u>Revision Number</u>	<u>Revision Date</u>
	Bulletin		
R	1	1	Feb.21/02
R	2	1	Feb.21/02
R	3	1	Feb.21/02
R	4	1	Feb.21/02
R	5	1	Feb.21/02

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ENGINE – HP COMPRESSOR BLADES – INTRODUCTION OF INCREASED STAGE 3 TO 6 ROTOR TIP
CLEARANCES

1. Planning Information

A. Effectivity

Airbus A320

V2500-A1 Engines prior to Serial No V0362

B. Concurrent Requirements

None.

C. Reason

(1) Condition

Material can be released from the HP compressor stage 3–6 abradable linings during low speed engine running conditions.

This can result in deterioration of compressor efficiency and downstream contamination by abradable deposits.

(2) Background

This condition has been noted on in service A1 models which have experienced heavy rotor tip rubs and grooving of the abradable rotor path linings.

(3) Objective

Incorporation of the changes introduced by this Service Bulletin are designed to maintain reliability.

(4) Substantiation

The changes introduced by this Service Bulletin have been the subject of extensive satisfactory testing on a development rig (252/2) and successful in service experience on A5 and D5 models which have identical cold build tip clearances.

(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) Supplemented Information

None.

D. Description

(1) The change introduced by this Service Bulletin is as follows:

- (a) A revised build procedure for the HP Compressor module is introduced similar to existing except the cold build clearance between the stage 3 to 6 rotor blade tips and rotor path abradable lining has been increased by 0.005in. (0,127 mm).

E. Approval

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

F. Compliance

R Category Code 5

R Accomplish when the Engine is disassembled sufficiently to afford access to the
R affected subassembly (i.e. modules, accessories, components, build groups) and
R to all affected spare subassemblies.

G. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

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(1) In service

Not applicable

(2) At overhaul

Not affected

H. Material – Price and Availability

(1) Modification Kit not required

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

I. Tooling – Price and Availability

Special tools are not required.

J. Weight and Balance

(1) Weight change

Not affected

(2) Moment arm

Not affected

(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) Internal Reference No.

95VR021

(2) V2500 Engine Manual, 72-41-10, Assembly.

M. Other Publications Affected

None.

**2. Material Information****A. Applicability:**

For each V2500 Engine to incorporate this Bulletin.

B. Kits associated with this Bulletin:

None.

C. Parts affected by this Service Bulletin:**72-41-15**

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
-	6A6458	REF	Instruction clearances, HP compressor rotor	-	6A3967 (99301)	-
-	6A6457	REF	Rotor clearances, HP compressor	-	6A3966 (99302)	-

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
-	6A6457	REF	Rotor clearances, HP compressor	-	6A3966 (99302)	-

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
-	6A6457	REF	Rotor clearances, HP compressor	-	6A3966 (99302)	-

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FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
-	6A6457	REF	Rotor clearances, HP compressor	-	6A3966 (99302)	-



3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

Refer to V2500 Engine Manual, 72-41-10, Assembly.

C. Recording Instructions

A record of accomplishment is necessary.

