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V2500-A1/A5/D5 PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 2 to Service Bulletin EV2500-72-0265

Document History

Service Bulletin Revision Status
 Initial Issue Apr.18/97
 Revision 1 May 15/98

Supplement Revision Status

Bulletin Revision 2

Remove
 All pages of the
 Service Bulletin

Incorporate
 Pages 1 to 7 of the
 Service Bulletin

Reason for change
 To correct part number in
 Material information and
 revise to latest format

V2500-ENG-72-0265

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 2 are as follows:

<u>Page</u>	<u>Revision Number</u>	<u>Revision Date</u>
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	Bulletin		
R	1	2	Sep.7/01
R	2	2	Sep.7/01
R	3	2	Sep.7/01
R	4	2	Sep.7/01
R	5	2	Sep.7/01
R	6	2	Sep.7/01
R	7	2	Sep.7/01

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ENGINE - HP COMPRESSOR SPLIT CASES - INTRODUCTION OF REVISED STAGE 5 BORESCOPE
BLANKING FEATURES

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V10273

(2) Airbus A320

(a) V2500-A1 Engines prior to Serial No. V0362

(b) V2527-A5, V2527E-A5 Engines prior to Serial No. V10273

(3) Airbus A321

V2530-A5, V2533-A5 Engines prior to Serial No. V10273

(4) Boeing - Longbeach Division MD-90

V2525-D5, V2528-D5 Engines prior to Serial No. V20156

B. Concurrent Requirements

None.

C. Reason

(1) Problem

The Stage 5 borescope blankin plug can be difficult to remove.

The problem is caused by the seizure of the countersunk screws that attach the plug.

(2) Evidence

The problem has been found on in-service engines.

(3) Substantiation

A satisfactory engineering analysis has been carried out on the changes introduced by this Service Bulletin.

(4) Objective

The purpose of this Service Bulletin is to improve maintainability.



(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

D. Description

(1) A1 Engine

The Stage 5 borescope blanking plug has a separate retaining plate and blanking plug. This Service Bulletin introduces a one-piece blanking plug. The changes are as follows:

(a) The two-piece blanking plug is deleted.

(b) The two countersunk holes are replaced by a single clearance hole for the installation of a 0.250 in diameter bolt.

(c) To make sure that the blanking plug is installed correctly, it has been scalloped to provide a baulking feature with the HP Compressor case.

R (d) The two countersunk screws have been replaced by a 0.250 in diameter bi-hexagonal head bolt.



(2) A5/D5 Engines

The changes introduced by this Service Bulletin are as follows:

- (a) The two countersunk holes are replaced by a single clearance hole for the installation of a 0.250 in diameter bolt.
- (b) To make sure that the blanking plug is installed correctly, it has been scalloped to provide a baulking feature with the HP Compressor case.
- (c) The two countersunk screws have been replaced by a 0.250 in diameter bi-hexagonal head bolt.

E. Compliance

Category Code 6.

- (1) This Service Bulletin can be accomplished when the subassembly (That is modules, accessories, components, build groups) is disassembled sufficiently to get access to all affected parts.

F. Approval

The part number changes and/or part modification are given in Section 2 and 3 of this Service Bulletin. They comply with the applicable Federal Aviation Regulations and are FAA approved for the engine models listed.

G. Manpower

- (1) In service

Not applicable

- (2) At overhaul

Not affected

NOTE: The parts affected by this Service Bulletin are accessible at overhaul

H. Material – Price and Availability

- (1) A modification kit is not necessary.
- (2) Refer to 2. Material Information for the prices and availability of future spares.

I. Tooling – Price and Availability

Special tools are not necessary.



J. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No effect.

(3) Datum

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

K. Electrical Load Data

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

L. References

(1) Internal Reference No.

EC96VR011

(2) Other References

IAE V2500 SB ENG 72-0027 ENGINE – HP COMPRESSOR – INTRODUCE A WEIGHT
REDUCED HP COMPRESSOR FRONT CASE ASSEMBLY

M. Other Publications Affected

(1) Illustrated parts catalogue (IPC), Chapter/Section 72-41-31.

(2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-00,
Assembly/Disassembly



2. Material Information

A. Kits associated with this Service Bulletin:

None

B. New production parts:

PART NO.	QTY	UNIT PRICE US DOLLARS
6A6477	1	225.00
AS21010	1	3.38
6A6476	1	261.00

C. Parts affected by this Service Bulletin

Applicability: For each V2500 engine for which this Service Bulletin is applicable

A1 Engine

For engines that have not had Service Bulletin ENG 72-0027 incorporated
72-41-31

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01140	6A6477	1	Plug - blanking, stage 5	-	6A3119	(B)(C)
			and 6 borescope			(S1)
01142	AS21010	1	Bolt, bihex head	-	4W2386	(B)(S1)
			(0.250 in dia x 0.625 in)			(1D)
						(2D)
A5/D5 engines						
01140	6A6476	1	Plug - blanking, stages 5	-	6A4598	(B)(C)
			and 6 borescope			(S1)
01142	AS21010	1	Bolt, bihex head	-	4W2387	(B)(C)
			(0.250 in dia x 0.625 in)			(S1)
						(2D)

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For information about actual prices, refer to the IAE Price Catalog or contact IAE's spare part sales department.

D. Instructions disposition codes

(A) Redundant part



(B) New part is available

(C) Old part will be discontinued

(S1) Old and new parts are not interchangeable

(1D) Old part can be used on other applications

(2D) Quantity at UIN is reduced from 2 off to 1 off



3. Accomplishment Instructions

A. Rework Instructions

None

B. Assembly Instructions

Remove the old borescope blanking plug (6A3119 A1 and 6A4598 A5/D5) and install the new borescope blanking plug (6A6477 A1 and 6A6476 A5/D5).

For the correct Removal and Installation procedures, refer to the A1/A5/D5 Engine manual (EM), Chapter/Section 72-41-00, Removal and Installation.

C. Recording Instructions

A record of accomplishment is required.

