



International Aero Engines

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V2500-A5/D5 PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-72-0328

Document History

Service Bulletin Revision Status
Initial Issue Feb.15/99

Supplement Revision Status

Bulletin Revision 1

Remove
All pages of the
Service Bulletin
All pages of
Appendix 1

Incorporate
Pages 1 to 7 of the
Service Bulletin
Page 1 and 2 of
Appendix 1

Reason for change
To revise Effectivity and
Supplemental Information.
To revise Effectivity and
Supplemental Information.

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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 following incorporation of Revision 1 are as follows:

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ENGINE – HIGH PRESSURE TURBINE ROTOR AND STATOR ASSEMBLY – INTRODUCE A NEW STAGE 2
HIGH PRESSURE TURBINE BLADE RETAINING PLATE

1. Planning Information

A. Effectivity

(1) Airbus A319

R V2522-A5, V2524-A5, V2527M-A5 Engines Serial No. V10001 thru V10502,
R V10504 thru V10514, V10516, V10518, V10519, V10521, V10523 thru V10528,
R V10530 and V10532.

(2) Airbus A320

R V2527-A5, V2527E-A5 Engines Serial No. V10001 thru V10502, V10504 thru
R V10514, V10516, V10518, V10519, V10521, V10523 thru V10528, V10530 and
R V10532.

(3) Airbus A321

R V2530-A5, V2533-A5 Engines Serial No. V10001 thru V11236 and including
R V11238, V11240, V11242, V11244, V11246, V11248, V11250, V11252, V11254 and
R V11256.

(4) Boeing Longbeach MD-90

R V2525-D5, V2528-D5 Engine Serial No. V20001 thru V20285.

(5) ATA Locator – 72-45-00

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason

(1) Condition: High operational stresses in the HP Turbine Stage 2 Blade Retaining Plate limit the potential life of the part.

(2) Background: Not applicable.

(3) Objective: The new parts will conform with a customer request for increased life.

(4) Substantiation: Redesign the HP Turbine Stage 2 Blade Retaining Plate to reduce operational stresses.



(5) Effects of Bulletin on:

Removal/Installation: Not affected

Disassembly/Assembly: Not affected

Cleaning: Not affected

Inspection/Check: Not affected

Repair: Not affected

Testing: Not affected

(6) Supplemental Information

R Chapter 5 Lives for the Second Stage HPT Blade Retaining Plate is
R increased from 15,000 to 20,000 cycles.

D. Description

1. This Service Bulletin introduces a new Stage 2 HPT Sideplate.
2. For effect on declared life, see Reference 3 or 4, Engine Manual, Chapter/Section 5-10-01.

E. Compliance

Category 7

Accomplish when supply of superseded parts has been depleted.

F. Approval Data

The part number changes and/or part modifications specified in the Accomplishment Instructions and Material Information sections of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the engine model(s) given.

The 'compliance' statement and the procedures described in 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

Estimated man-hours to incorporate the full intent of this Bulletin:

Venue	Estimated Manhours
In Service	Not Applicable
At Overhaul	Not Applicable

H. Weight and Balance

Weight Change	None
Moment	No Effect
Datum	Engine Front Mount Centerline (Power Plant Station (PPS) 100)

I. Electrical Load Data

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

J. Software Accomplishment Summary

Not Applicable.

K. References

1. IAE V2500 Service Bulletin V2500-ENG-72-0327 (Engine - HP Turbine Rotor And Stator Assembly - Introduce New Rotating Parts With Potential For Increased Cyclic Life).
2. V2500 Engine Illustrated Parts Catalogs (S-V2500-2IA, S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, and S-V2500-7IB), Chapter/Section 72-45-33.
3. V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-45-30, Assembly.
4. V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-45-30, Assembly.

L. Other Publications Affected

1. V2500 Engine Illustrated Parts Catalogs (S-V2500-2IA, S-V2500-2IB,, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB,, S-V2500-6IA, S-V2500-6IB, S-V2500-7IA, and S-V2500-7IB), Chapter/Section 72-45-33.
2. V2500 Engine Manuals (E-V2500-1IA and E-V2500-3IA), Chapter/Section 72-45-30 Cleaning, Inspection and Repair, to add the new part.



M. Interchangeability of Parts

Old and new parts are directly interchangeable.

N. Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (Yes)

Added Data (No)

Revision to Table of Limits (No)

Inspection Procedures (No)



2. Material Information

A. Material – Price and Availability

1. Part prices were not available at the time of Service Bulletin publication. Contact IAE's Spare Parts Sales Department for firm quotations.
2. There is no kit provided to do this Service Bulletin.
3. Part availability information is provided in material data Instructions-Disposition.

B. Industry Support Program

Not Applicable.

C. The material data that follows is for each engine.

NOTE: 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 Catalog for current prices.

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525-D5, V2528-D5 Engines:

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Instructions-Dis
2A3437	1	*	.Plate, Retaining, HPT, Stage 2	2A3426 (72-45-33-01-020)	(S1)(A)(B)

D. Instructions/Disposition Code Statements:

- (S1) Old and New Parts are freely and fully interchangeable.
(A) The new part is available.
(B) The old part will no longer be supplied.

E. Tooling – Price and Availability

Special tools are not required to accomplish this Service Bulletin.

F. Reidentified Parts

Not Applicable.

G. Other Material Information Data

Not Applicable.

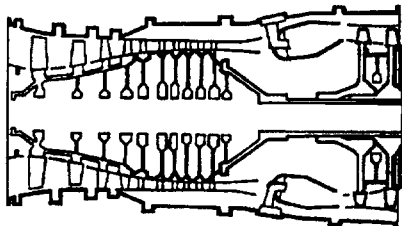


3. Accomplishment Instructions

- (1) Install the 2A3437 Stage 2 HPT Retaining Plate (1 off) by the procedure specified in Reference (3) or (4), Engine Manual, Chapter/Section 72-45-30, Assembly. See Figure 1.
- (2) Recording Instructions
 - (a) A record of accomplishment is required.

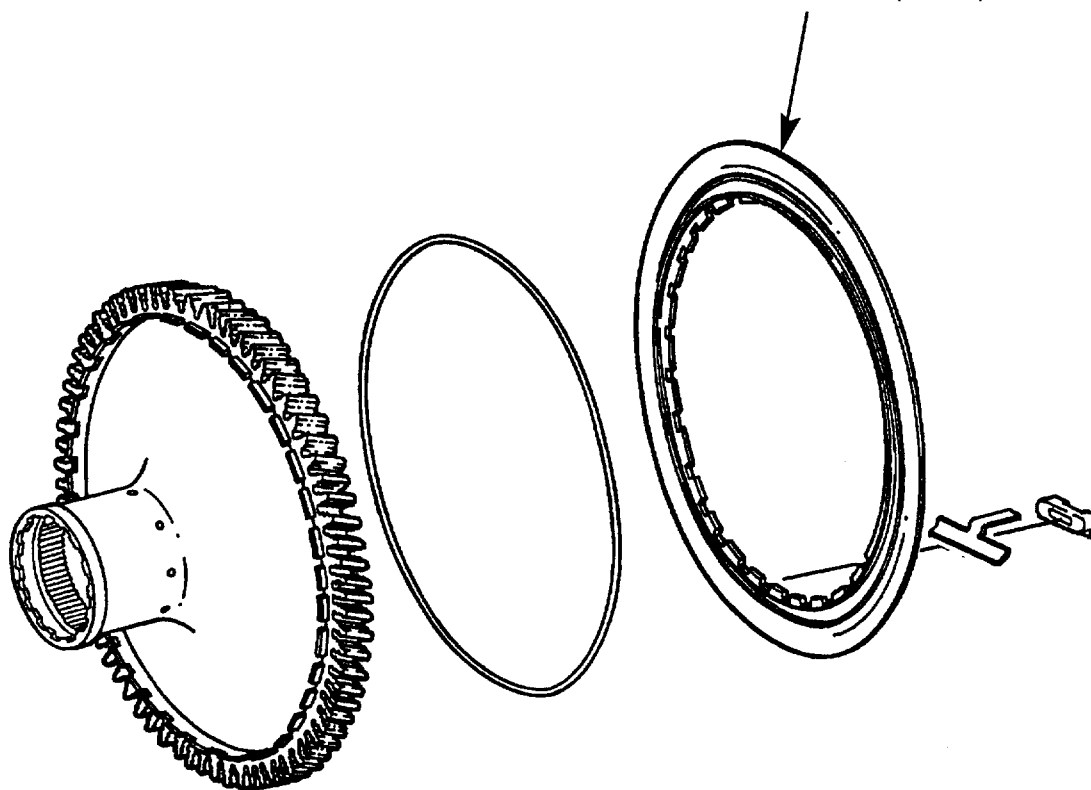


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MODULE 40

INSTALL THE 2A3437 STAGE 2
HIGH PRESSURE TURBINE BLADE
RETAINING PLATE (1 OFF)



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Location of the Stage 2 High Pressure Turbine Blade Retaining Plate
Figure 1

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SERVICE BULLETIN

APPENDIX 1

Parts Progression

R Parts progression to show the changed part in relation to other parts

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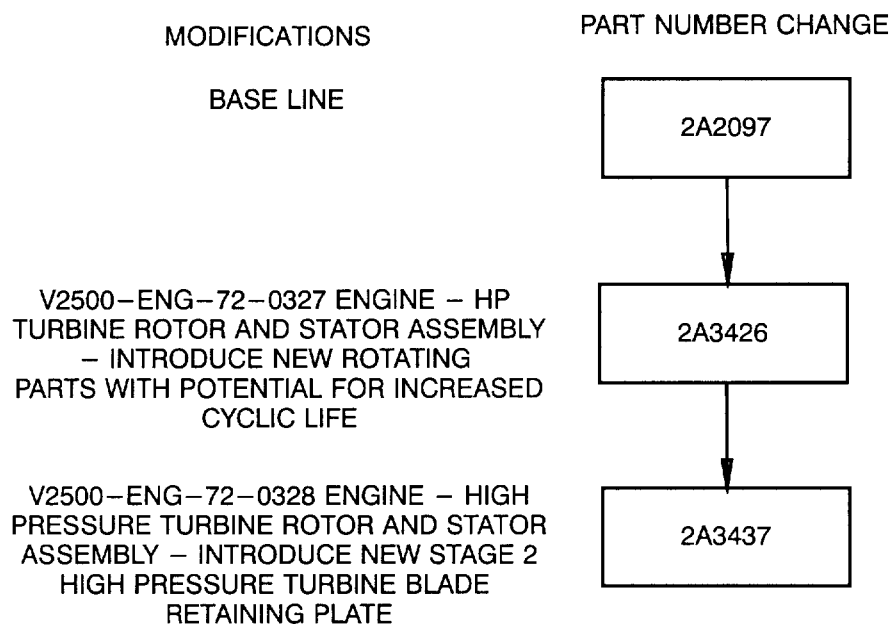
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Appendix

Parts Progression To Show the Changed Part in Relation to Other Parts



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Family Tree – Stage 2 High Pressure Turbine Sideplate Ref. Catalog Sequence No.
72-45-33. Fig. 01 Item 020
Figure 2

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