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V2500-A1/A5/D5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 2 to Service Bulletin EV2500-72-0336

Document History

Service Bulletin Revision Status
 Initial Issue Sep.29/99
 Revision 1 Oct.12/99

Supplement Revision Status

Bulletin Revision 2

Remove
 All pages of the
 Service Bulletin

Incorporate
 Pages 1 to 6 of the
 Service Bulletin

Reason for change
 To incorporate Material
 Information page

V2500-ENG-72-0336

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:

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R	5	2	Jun.9/00
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ENGINE - ACTUATING MECHANISM HP COMPRESSOR VARIABLE VANES - INTRODUCTION OF REVISED
VIGV ACTUATOR RING LEVERS WITH INCREASED BLEND RADIUS

1. Planning Information

A. Effectivity

(1) Airbus A319.

V2522-A5, V2524-A5 Engines prior to Serial No.V10600

(2) Airbus A320.

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

(b) V2527-A5, V2527E-A5 Engines prior to Serial No. V10600

(3) Airbus A321.

V2530-A5, V2533-A5 Engines prior to Serial No. V10600

(4) Boeing - Longbeach Product Division MD90

V2525-D5, V2528-D5 Engines prior to Serial No. V20286

(5) ATA Locator 72-41-00

B. Concurrent Requirements

None.

C. Reason

(1) Problem

After in-service problems with stage 3 and 4 Variable Stator Vane (VSV) lever assemblies, a review of the VSV system has concluded that all stages of lever assembly should be modified to maintain the integrity of the VSV system.

(2) Evidence

Refer to C.(1).

(3) Substantiation

A satisfactory engineering analysis has been done on the changes introduced by this Service Bulletin. In addition, a similar modification has been successfully introduced on the lever arm assemblies for the stage 3 VSV.



(4) Objective

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

(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

The lever arm assemblies for the VIGV have been revised, the changes are as follows:

(1) The blend radius on the lever arm has been increased from 0,90 – 1,50mm to 4,70 – 5,30mm

R (2) The surface of the blend radius has been vapour blasted to improve the surface finish.

E. Compliance

Category Code 7

Accomplish when there are no superseded parts remaining.



F. Approval

The part number changes and/or part modification described in sections 2 and 3 of this Service Bulletin (Modification) have been shown to comply with the applicable Federal Aviation Regulations and are FAA approved for the engine models listed.

G. Manpower

Estimate of manhours necessary to embody this Service Bulletin in full:

(1) In service

Not applicable.

(2) At overhaul

No additional time is necessary to embody this Service Bulletin.

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 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 EC98VR028
- (2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-00, Disassembly/Assembly-02.
- (3) This Service Bulletin is the subject of AIRBUS aircraft modification 21820/P6256.

M. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC) Chapter/Section 72-41-34.
- (2) A1/A5/D5 Engine Manual (EM), Chapter/Section 72-41-34, Cleaning, Inspection/Check and Repair.

R 2. Material InformationR A. Kits necessary for this Service Bulletin

R None.

R B. New production parts:

PART NO.	QTY	UNIT PRICE
6A7467	30	153.00
6A7469	8	153.00
6A7468	2	153.00

R 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 Catalogue or contact IAE's spare parts sales department.

R C. Parts affected by this Service Bulletin:

R 72-41-34

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
R 02100	6A7467	30	Lever assy, VIGV - HP compressor	6A3130	(A)(S1)
R 02120	6A7469	8	Lever assy, VIGV Bridge - HP compressor	6A3132	(A)(S1)
R 02140	6A7468	2	Lever assy, VIGV - HP compressor	6A3131	(A)(S1)

R D. Instructions disposition codes

R (1) (A) New part will be available from March 1999.

R (2) (S1) Old and new parts are freely and fully interchangeable.



3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

For the correct removal/instructions refer to A1/A5/D5 Engine Manual (EM),
Chapter/Section 72-41-00, Disassembly/Assembly-02

C. Recording Instructions

A record of accomplishment is required.