

**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

DATE: Jul.28/00

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

Printed in Great Britain

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

This document transmits the Initial Issue of Service Bulletin EV2500-72-0375

**Bulletin Initial Issue**

Remove

Incorporate  
 Pages 1 to 6 of the  
 Service Bulletin

Reason for change  
 Initial issue

**V2500-ENG-72-0375**

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

© Rolls-Royce plc (date as above) Printed in Great Britain

LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin are as follows:

Page                      Revision Number      Revision Date

Bulletin

1	Jul.28/00
2	Jul.28/00
3	Jul.28/00
4	Jul.28/00
5	Jul.28/00
6	Jul.28/00

Printed in Great Britain



ENGINE – LP COMPRESSOR BLADES AND FILLERS – INTRODUCTION OF A REVISED LP COMPRESSOR  
BLADE WITH METCO 58

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5 Engines prior to Serial No. V10825

(2) Airbus A319CJ

V2527M-A5 Engines prior to Serial No. V10825

(3) Airbus A320

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

(b) V2527-A5, V2527E-A5 Engines prior to Serial No. V10825

(4) Airbus A321

V2530-A5, V2533-A5 Engines prior to Serial No. V10825

(5) Boeing – Longbeach Division MD-90

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

B. Concurrent Requirements

None

C. Reason

(1) Problem

A design review of the LP compressor blade has indicated that the introduction of Metco 58 to the blade root bedding surfaces can maintain the retention properties of the dry film lubricant.

(2) Evidence

See Problem for full details

(3) Substantiation

The changes introduced by this Service Bulletin have been the subject of extensive engineering assessment and experience on other Rolls-Royce engines.



(4) Objective

Incorporation of the changes introduced by this Service Bulletin (Modification) 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

Affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The change introduced is:

- (a) A revised LP compressor blade is introduced similar to the existing item except for the introduction of Metco 58 to the blade root flank surfaces prior to the application of the dry film lubricant.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

F. Approval

The part number changes and/or part modification 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 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

Modification kit not required; parts supplied as single line items.

For prices and availability of future spares see 2. Material Information.

I. Tooling Price and Availability

None

J. Industry Support Information

None

K. Weight and Balance

(1) Weight Change

None

(2) Moment Arm

None

(3) Datum

Engine front mount centreline (Power Plant Station PPS 100)

L. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load

M. Software Accomplishment Summary

Not applicable



N. References

- (1) Engine Manual, 72-31-00, Disassembly and Assembly
- (2) Engine Maintenance Manual, 72-31-11, Config 1, Removal/Installation
- (3) Internal reference number 00VR004

O. Other Publications Affected

- (1) Illustrated Parts Catalogue (S-V2500-1IA, 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), 72-31-11, will be revised.

P. Interchangeability of Parts

It is recommended that the parts introduced by this Service Bulletin are introduced as a set.



## 2. Material Information

### A. The kit required consists of the following parts:

None

### B. New production parts:

PART NO.	QTY	UNIT PRICE
6A7613	22	Price on request
6A7614	22	Price on request

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 Catalogue for current prices.

### C. Parts affected by this Bulletin:

V2500-A1 Engines

72-31-11

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01300	6A7613	22	Blade assy rotor, LP compressor	-	6A6519	(A) (S1)

V2500-A5 and D5 Engines

01300	6A7614	22	Blade assy rotor, LP compressor	-	6A6521	(A) (S1)
-------	--------	----	------------------------------------	---	--------	-------------

### D. Instructions disposition codes:

(A) New part will be made available from June 2000.

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



### 3. Accomplishment Instructions

#### A. Rework Instructions

None

#### B. Assembly Instructions

The revised LP compressor blades introduced by this Service Bulletin are freely and fully interchangeable. Remove existing and install new in accordance with current overhaul procedures and maintenance practices (Engine Manual, 72-31-00, Disassembly and Assembly, and Engine Maintenance Manual, 72-31-11, Removal/Installation).

#### C. Recording Instructions

A record of accomplishment is required.