

**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: Oct. 7/02

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

V2500-A1/A5 SERIES PROPULSION SYSTEM SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0429

Bulletin Initial Issue

Remove

Incorporate
Pages 1 to 9 of the
Service Bulletin

Reason for change
Initial issue

V2500-ENG-72-0429
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		Oct.7/02
2		Oct.7/02
3		Oct.7/02
4		Oct.7/02
5		Oct.7/02
6		Oct.7/02
7		Oct.7/02
8		Oct.7/02
9		Oct.7/02

Printed in Great Britain

V2500-ENG-72-0429
Transmittal - Page 2



ENGINE – LP COMPRESSOR – INTRODUCTION OF A SMALLER DIAMETER WASHER

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5 Engines Prior to Serial Number V11500

(2) Airbus A319CJ

V2527M-A5 Engines Prior to Serial Number V11500

(3) Airbus A320

(a) V2500-A1 Engines Prior to Serial Number V0362

(b) V2527-A5, V2527E-A5 Engines Prior to Serial Number V11500

(4) Airbus A321

V2530-A5, V2533-A5 Engines Prior to Serial Number V11500

B. Concurrent Requirements

Service Bulletin V2500-ENG-72-0391 must be incorporated in conjunction with this Service Bulletin.

C. Reason

(1) Problem

There is some possibility that the washer is not seated on the front surface of the rear flange with counter bore hole. The diameter of selected washer is almost same as the diameter of counter bore.

Smaller size washer will be introduced. It is not appropriate to increase the diameter of counter bore, because there will be less material at outer area of the flange. This feature of counter bore has designed for introduction of aluminium support by SBE72-0391.

(2) Evidence

See Problem



(3) Substantiation

At introduction of this aluminium bearing support, smaller size washer was considered for the rig test and analysis and found no problem, as mentioned background above.

(4) Objective

The washer MS9549-11 with smaller outer diameter will provide appropriate clearance to the counter bore instead of current washer MS9321-11.

(5) Effect of Bulletin on:

(a) Removal/Installation:

Not Affected

(b) Disassembly/Assembly:

Not Affected

(c) Cleaning:

Not Affected

(d) Inspection/Check:

Not Affected

(e) Repair:

Not Affected

(f) Testing:

Not Affected

(6) Supplemental Information

None.

D. Description

The changes introduced by this Service Bulletin are as follows:

The nominal outer diameter of washer has been changed from 0.625inch (15,875 mm) to 0.562inch (14,275 mm).

E. Compliance

Category Code 6



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 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

The estimated man-hours shown below are applicable only to Sub-division 1 and 3 of this Service Bulletin.

(1) In service:

Not applicable.

(2) At overhaul:

No additional time is necessary to embody Service Bulletin.

NOTE: It is possible to get access to the parts affected by this Service Bulletin 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

Special tools are not required.

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) IAE V2500 Engine Manual (E-V2500-1IA); 72-32-00, Assembly-05

(2) IAE Overhaul Process and Consumable Index

(3) IAE Standard Practices/Procedures Manual

(4) IAE Service Bulletin V2500-ENG-72-0391

(5) Engineering Change Number 02VJ004

(6) ATA Locator 72-32-00

O. Other Publications Affected

(1) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-1IA), 72-32-00 to add new parts.

(2) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-2IA), 72-32-00 to add new parts.

(3) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-2IB), 72-32-00 to add new parts.

(4) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-5IA), 72-32-00 to add new parts.

(5) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-5IB), 72-32-00 to add new parts.

(6) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-6IA), 72-32-00 to add new parts.

(7) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-6IB), 72-32-00 to add new parts.

(8) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-7IA), 72-32-00 to add new parts.



- (9) IAE V2500 Engine Illustrated Parts Catalog (S-V2500-71B), 72-32-00 to add new parts.

P. Interchangeability of Parts

Current washer MS9321-11 shall not be used furthermore.

Printed in Great Britain



2. Material Information

A. The kit required consists of the following parts:

None

B. New production parts:

Part No.	Qty	Unit Price US Dollars
MS9549-11	42	0.35

C. Parts affected by this Bulletin:

V2500-A1 Engines Post SBE72-0391 and V2500-A5 Post SBE 72-0391

72-32-00

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02181	MS9549-11	42	Washer	-	MS9321-11	(S1)(A) (B)

D. Instructions disposition codes:

(S1) Old part and new part are not interchangeable.

(A) Part will be available from November 2002.

(B) Old part can be used up on the other applications.



3. Accomplishment Instructions

A. For V2500-A1 and V2500-A5 for Post SBE 72-0391 Engines

(1) Rework Instructions for POST SBE 72-0391 Engines

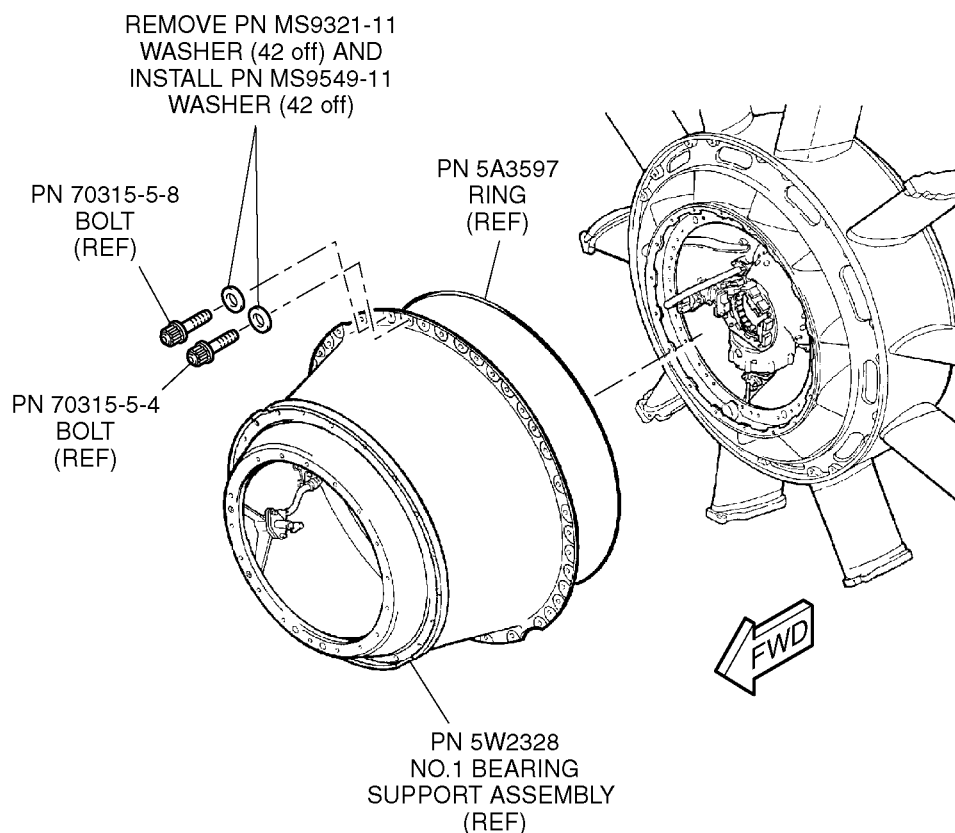
None.

(2) Assembly Instructions for POST SBE 72-0391 Engines

Install the new MS9549-11 washer (42 off) to the No.1 bearing support assembly by the procedure given in reference (1), Engine Manual (E-V2500-1IA), 72-32-00, Assembly-05

(3) Recording Instructions

A record of accomplishment is necessary.



Location of the Washer that connects the No.1 Bearing Support to the Fan Frame
Figure 1

Oct. 7/02
Oct. 7/02

V2500-ENG-72-0429

Page 8

© Rolls-Royce plc

Not subject to the EAR per 15 C.F.R. Chapter 1, Part 734.3(b)(3).

jaz00e1913



MODIFICATION

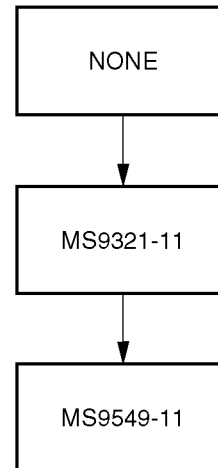
PART NUMBER CHANGES

For V2500-A1 and V2500-A5

Base line

Introduction of the new separate
type No.1 bearing support assembly
SBE 72-0391

Introduction of the new washer
SBE 72-0429



jaz00a1914

Family Tree - Washer for V2500-A1 and V2500-A5 Ref. Catalog Sequence No. 72-32-00
Fig. 02 Item 181
Figure 2

Oct. 7/02
Oct. 7/02

V2500-ENG-72-0429

Page 9

