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V2500-A1/A5/D5 PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0432

Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 8 of the	Initial Issue
	Service Bulletin	
	Pages 1 to 3 of	Initial Issue
	Appendix 1	

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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 are as follows:

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ENGINE – PROVIDE IDENTIFICATION FOR NEAR NET SHAPE CASTINGS FOR HPT DUCT SEGMENTS

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5, V2527M-A5 Engines V10001 thru V11257

V2522-A5, V2524-A5, V2527M-A5 Engines V11347 thru V11391

(2) Airbus A320

V2500-A1 Engines V0001 thru V0361

V2527-A5, V2527E-A5 Engines V10001 thru V11257

V2527-A5, V2527E-A5 Engines V11347 thru V11391

(3) Airbus A321

V2530-A5, V2533-A5 Engines V10001 thru V11257

V2530-A5, V2533-A5 Engines V11347 thru V11391

(4) Boeing MD-90

V2525-D5, V2528-D5 Engines V20001 thru V20285

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason

(1) Problem: Engineering has provided for cast to size first stage HPT Duct segments.

(2) Background: These parts were not assigned new part number identification.

(3) Objective: Provide a part number identification for the First Stage HPT Duct Segments. This will allow traceability of parts in production and in customer engines.

(4) Substantiation: Satisfactorily completed by design analysis. This engineering change provides identification required to trace parts.



(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

None.

D. Description

Cast to size Duct segments available

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Accomplish when supply of superseded parts has been depleted.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.

See Vendor Supplier Service Bulletin.

K. References

1. IAE V2500 Service Bulletin V2500-ENG-72-0013 (Engine - Stage 1 Turbine Nozzle Assembly and HP Turbine Rotor and Stator Assembly - Replacement of the Stage 1 HPT Duct Segment and the Stage 1 HPT Airseal).
2. IAE V2500 Service Bulletin V2500-ENG-72-0113 (Engine - Stage 1 Turbine Nozzle Assembly - Provide New First Stage HPT Duct Segments and Duct Stops with Bolt Hole Chamfers).
3. IAE V2500 Service Bulletin V2500-ENG-72-0241 (Engine - Stage 1 Turbine Nozzle Assembly - Provide a New First Stage HPT Cooling Duct Assembly and Segments).
4. V2500 Engine Illustrated Parts Catalogs (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-V2500-71B), Chapter/Section 72-44-60 Figure 01 Item 010.
5. V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-44-00.
6. V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-44-00.
7. Internal Reference Number - 01VA016, 01VA016A, 01VA016B.
8. ATA Locator - 72-44-00.



L. Other Publications Affected

1. V2500 Engine Illustrated Parts Catalogs (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), Chapter/Section 72-44-60, to add the new part.
2. V2500 Engine Manuals (E-V2500-1IA and E-V2500-3IA), Chapter/Section 72-44-00, 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. The estimated price of new material to do this Service Bulletin using new replacement parts is US\$ 9260.00 for the A1 or US\$ 9960.00 for the A5/D5.
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 V2500–A1 Engines

72–44–60

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Inst – Disp
2A3569	20	463.00	.Duct Segment, HPT, 1Stg.	2A2364(01-010)	(2)(A)(L)(I)

For V2522–A5, V2524–A5, V2527–A5, V2527E–A5, V2527M–A5, V2530–A5, V2533–A5, V2525–D5, V2528–D51 Engines:

72–44–60

New PN	Qty	Estimate of Unit Price (\$)	Keyword	Old PN	Inst – Disp
2A3568	20	498.00	.Duct Segment, HPT, 1Stg.	2A31814(01-010)	(2)(A)(L)(I)



D. Instructions/Disposition Code Statements:

Parts Modification Conditions

(2) The new part is a replacement part only, and cannot be obtained by modification of the old part.

Spare Parts Availability

(A) The new part is available.

(L) The old part will be supplied until the supply is fully used.

Cleaning, Inspection and Repair Information

(I) The cleaning, inspection and repair requirements are the same for the old and new part. The applicable engine manuals will be revised.

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

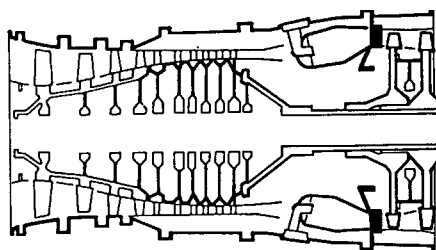
Not Applicable.



3. Accomplishment Instructions

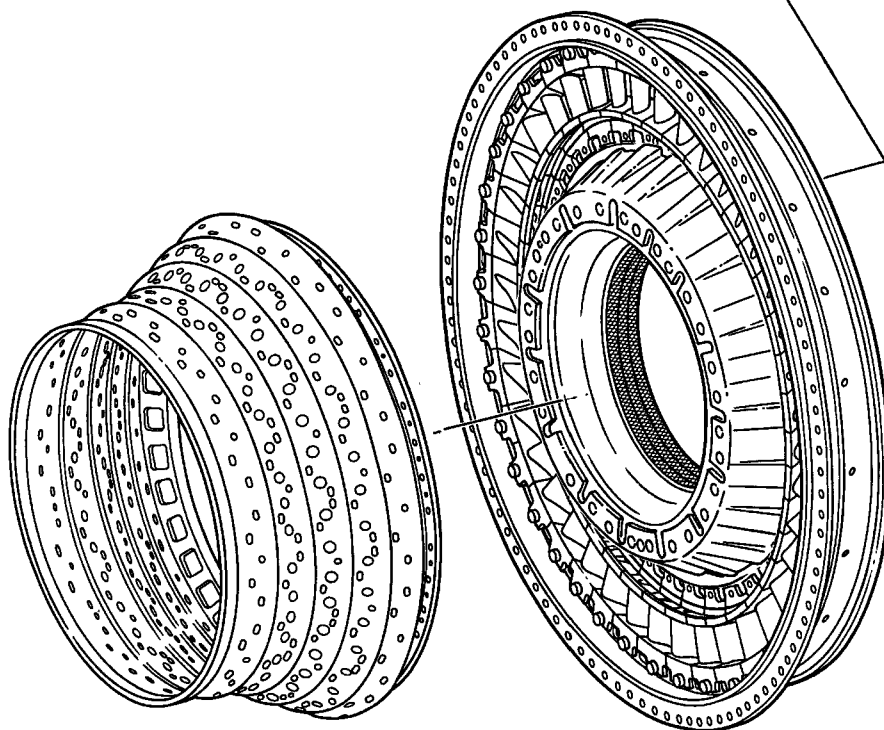
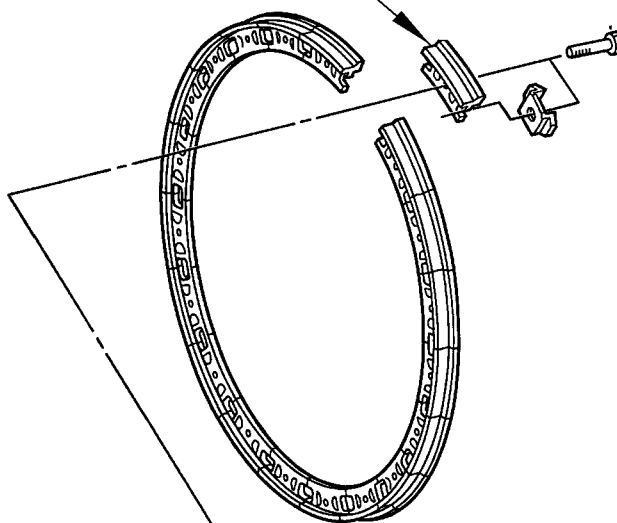
- (1) Install the new First Stage Duct Segments (20 off) PN 2A3569 for A1 or PN 2A3568 for A5/D5 in accordance with the current maintenance and overhaul procedure found in the Engine Manual 72-44-00. See Figure 1.
- (2) Recording Instructions
 - (a) A record of accomplishment is required.

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MODULE 40

REPLACE DUCT SEGMENT



B510717

Location of HPT Duct Segments
Figure 1

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APPENDIX 1

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

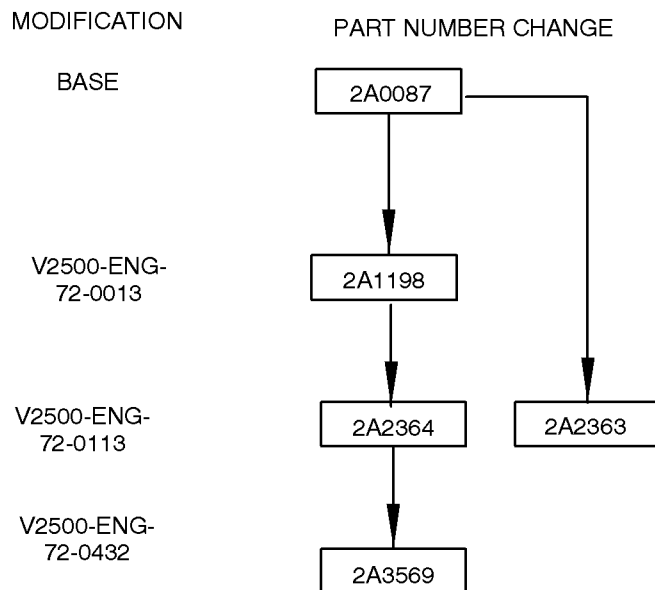
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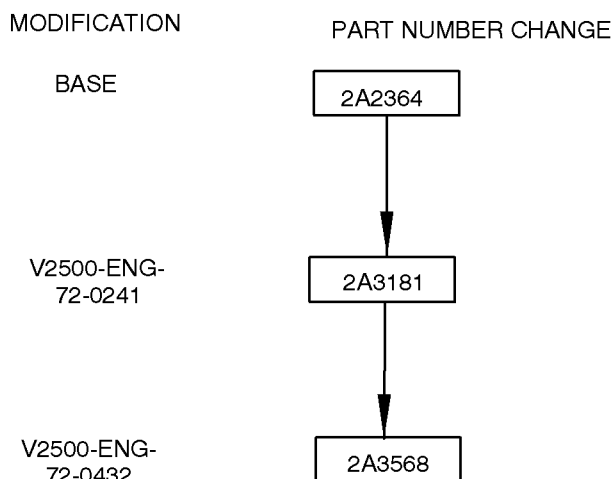
Family Tree
Figure 2

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Family Tree
Figure 3

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