



400 MAIN STREET, MAIL STOP 121-10
EAST HARTFORD, CT 06108, USA.
TELEPHONE:- 860 565 5515
FAX:- 860 565 0600

DATE: Mar.31/04

P.O. BOX 31, DERBY
TELEGRAMS - 'ROYCAR' DERBY
TELEX - 37645
TELEPHONE:- 44 (0) 1332 242424
FAX:- 44 (0) 1332 249936

V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0440 and the Initial Issue of the Supplement

Bulletin Initial Issue

Remove	Incorporate Pages 1 to 8 of the Service Bulletin	Reason for change Initial issue
--------	--	------------------------------------

Supplement Initial Issue

Remove	Incorporate Page 1	Reason for change Initial issue
--------	-----------------------	------------------------------------

V2500-ENG-72-0440
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:

<u>Page</u>	<u>Revision Number</u>	<u>Revision Date</u>
-------------	------------------------	----------------------

Bulletin

1		Mar.31/04
2		Mar.31/04
3		Mar.31/04
4		Mar.31/04
5		Mar.31/04
6		Mar.31/04
7		Mar.31/04
8		Mar.31/04

Supplement

1		Mar.31/04
---	--	-----------

Printed in Great Britain



ENGINE – HP COMPRESSOR REAR OUTER CASE – INTRODUCTION OF A REVISED REAR OUTER CASE

1. Planning Information

A. Effectivity

(1) Airbus A319

V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No.V11700

(2) Airbus A320

V2500-A1 Engines prior to Serial No. V0362

V2527-A5, V2527E-A5 Engines prior to Serial No.V11700

(3) Airbus A321

V2530-A5, V2533-A5 Engines prior to Serial No.V11700

B. Concurrent Requirements

None.

C. Reason

(1) Problem

A design review of the HP Compressor has indicated that manufacture of the rear outer case may be optimised.

(2) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis and development engine testing.

(3) Objective

Incorporation of this Service Bulletin (Modification) is designed to simplify manufacture.

(4) Effect of Bulletin on:

(a) Operation

Not affected.



(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Affected (existing Repair Schemes will be updated to add the new Part Number).

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The changes introduced are:

- (a) A revised HP Compressor rear outer case is introduced similar to the existing item except that it can be produced from a centrispun casting as an alternative to the existing forging.

E. Compliance

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

F. Approval

The part number changes and/or part modifications described in Sections 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

In service

Not applicable.

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 Supplement to this Bulletin.

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

No effect.

(3) Datum

Engine Front Mount Centreline (Power Plant Station – PPS 100).

L. Electrical Load Data

The aircraft electrical load is not affected by this Service Bulletin.

M. Software Accomplishment Summary

Not applicable.



N. References

- (1) Engine Manual, Chapter/Section 72-41-20, Disassembly and Assembly.
- (2) Internal Reference No. - 02VR012.
- (3) ATA Locator - 72-41-23.

O. Other Publications Affected

- (1) Illustrated Parts Catalogue (IPC) Chapter/Section 72-41-23 will be revised.
- (2) Engine Manual, Chapter/Section 72-41-23, Cleaning and Inspection/Check.

P. Interchangeability of Parts

Not affected.



2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts to be reworked:

None.

C. New production parts:

All Engines

72-41-23

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02400	6A8162	1	.Case assembly, rear outer	-	6A5682	(A)(S1)
02550	6A8163	Ref	..Case, rear outer	-	6A5683	(B)

D. Instructions disposition codes:

(A) New standard of part will be made available from December 2003.

(B) Part of Case Assembly, 6A8162. Will not be made available as a spare for replenishment purposes.

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



3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

The revised HP Compressor Rear Outer Case introduced by this Service Bulletin is freely and fully interchangeable with the existing. Install in accordance with current overhaul procedures (Engine Manual, Chapter/Section 72-41-20, Assembly).

C. Recording Instructions

A record of accomplishment is necessary.



V2500-A1 HP Compressor Rear Outer Case Assy.

Service Bulletin Number

BASELINE

V2500-ENG-72-0025

Introduction of a HPC Rear Outer Case with reduced weight.

V2500-ENG-70-0368

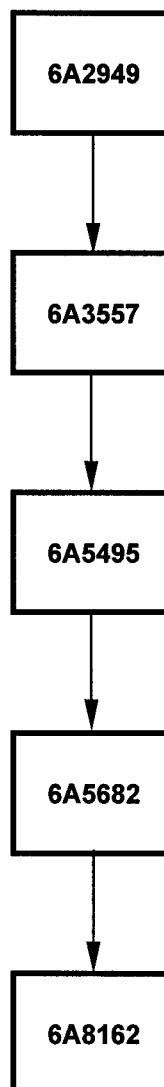
Introduction of a HPC Rear Outer Case common for both A1 and A5 models.

V2500-ENG-72-0263

Introduction of a HPC Rear Outer Case with integral rear seal land.

V2500-ENG-72-0440

Introduction of a HPC Rear Outer Case manufactured from centrifugal casting.



Family Tree - V2500-A1 - HP Compressor Rear Outer Case Assembly
Figure 1

Mar.31/04
Mar.31/04

V2500-ENG-72-0440

Page 7



V2500-A5 HP Compressor Rear Outer Case Assy.

Service Bulletin Number

BASELINE

V2500-ENG-70-0368

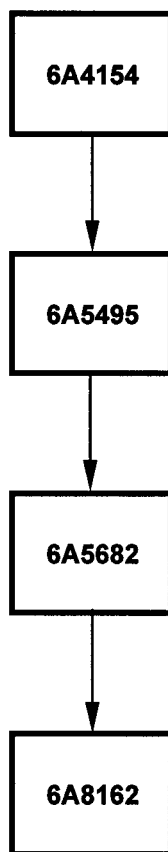
**Introduction of a HPC Rear Outer Case
common for both A1 and A5 models.**

V2500-ENG-72-0263

**Introduction of a HPC Rear Outer Case
with integral rear seal land.**

V2500-ENG-72-0440

**Introduction of a HPC Rear Outer Case
manufactured from centrispun casting.**



Printed in Great Britain

ded0005621

Family Tree - V2500-A5 - HP Compressor Rear Outer Case Assembly
Figure 2

Mar.31/04
Mar.31/04

V2500-ENG-72-0440

Page 8

ENGINE – HP COMPRESSOR REAR OUTER CASE – INTRODUCTION OF A REVISED REAR OUTER CASESUPPLEMENT – PRICES AND AVAILABILITY

The prices if 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.

1. Modification Kit:

Not applicable.

2. New Production Parts:

Part No.	Desc.	Unit Price US Dollars
6A8162	Case assembly, rear outer	112,320.00

