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V2500-A5/D5 SERIES PROPULSION SYSTEM SERVICE BULLETIN

This document transmits Revision 2 to Service Bulletin V2500-ENG-72-0447.
Document History

Service Bulletin Revision Status

Initial Issue. Jan.31/03.

Revision 1. Sep. 1/03.

Service Bulletin Revision 2

Remove
All pages of the
Service Bulletin.

Incorporate
Pages 1 to 16 of the
Service Bulletin.

Reason for change
To discontinue the Controlled
Service Use (CSU) plan and
allow unrestricted
incorporation of this Service
Bulletin on D5 engines.

To make all D5 engines
eligible for incorporation of
this Service Bulletin.

To make A5 and A5 SelectOne™
engines eligible for
incorporation of this Service
Bulletin.

V2500-ENG-72-0447

Transmittal - Page 1 of 1

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED

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ENGINE – INNER AND OUTER COMBUSTION CHAMBER LINERS WITH ADDITION OF SINGLE CRYSTAL MATERIAL ON ROWS 3 AND 4

1. Planning Information

A. Effectivity

(1) Airbus A319

NOTE: A5 Engines with Outer Combustion Chamber Assembly, PN 2A3442-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

NOTE: A5 Engines with Inner Combustion Chamber Assembly, PN 2A3344-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

(a) V2522-A5, V2524-A5, V2527M-A5 (A5 Standard and A5 SelectOne™ Retrofit Standard)

All Engines.

(b) V2522-A5, V2524-A5, V2527M-A5 (A5 SelectOne™ Production Standard)

Engine Serial Nos. – Any engine as applicable

(2) Airbus A320

NOTE: A5 Engines with Outer Combustion Chamber Assembly, PN 2A3442-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

NOTE: A5 Engines with Inner Combustion Chamber Assembly, PN 2A3344-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

(a) V2527-A5, V2527E-A5 (A5 Standard and A5 SelectOne™ Retrofit Standard)

All Engines.

(b) V2527-A5, V2527E-A5 (A5 SelectOne™ Production Standard)

All Engines.

(3) Airbus A321

NOTE: A5 Engines with Outer Combustion Chamber Assembly, PN 2A3442-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

NOTE: A5 Engines with Inner Combustion Chamber Assembly, PN 2A3344-01 installed must incorporate Reference 4, Non-Modification Service Bulletin No. V2500-ENG-72-0604 in order to be eligible for incorporation of this Service Bulletin.

(a) V2530-A5, V2533-A5 (A5 Standard and A5 SelectOne™ Retrofit Standard)

All Engines.

(b) V2530-A5, V2533-A5 (A5 SelectOne™ Production Standard)

All Engines.

(4) Boeing MD-90

(a) V2525-D5, V2528-D5

All Engines.

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason

(1) Condition

A Thermal Mechanical Fatigue Distress mode has been identified on Row 3 and 4 Combustor segments (referred to as 3ID, 4ID, 3OD and 4OD combustion chamber liner segments throughout this Service Bulletin). The distress has been limited to severe environment operators and has caused engine removals in this environment.

(2) Background

Severe environment operators have requested combustor segment durability enhancement for operation with combined severe temperatures and severe environmental contamination.

R (3) Objective

R Incorporate single crystal material on rows 3 and 4 inner and outer
R combustor segments for a limited number of severe environment operators
R based on field experience. The revised material will provide improved
R Thermal Mechanical Fatigue properties and oxidation resistance.

(4) 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.

(5) Supplemental Information

None.

D. Description

R Replace the combustion chamber liner segments on rows 3 and 4 of the inner and
R outer combustion chamber assemblies.

E. Compliance

Category 8

Accomplish based upon experience with the prior configuration.

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**(1) In Service**

Not Applicable.

(2) At Overhaul

NOTE: The parts affected by this Service Bulletin are accessible at overhaul.

(a) Necessary to Re-identify the Inner Combustion Chamber Assembly: 5 minutes

(b) Necessary to Re-identify the Outer Combustion Chamber Assembly: 5 minutes

(c) Total necessary Man-hours: 10 minutes

H. Weight and Balance**(1) Weight Change**

None.

(2) Moment Arm

None.

(3) Datum

Engine Front Mount Centreline (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.

K. References

- R 1. IAE V2500 Service Bulletin V2500-ENG-72-0315 (Engine - Diffuser and Combustion
R Group and Stage 1 Turbine Nozzle Assembly - Provide New Inner and Outer
R Combustion Chamber Liners with Addition of PWA 281 Coating).
- R 2. IAE V2500 Service Bulletin V2500-ENG-72-0330 (Engine - Diffuser and Combustion
R Group - Provide New Bulkhead Liner Segment).
- R 3. IAE V2500 Service Bulletin V2500-ENG-72-0331 (Engine - Diffuser and Combustion
R Group - Provide New Fuel Nozzle Guides).
- R 4. IAE V2500 Service Bulletin V2500-ENG-72-0604 (Non-Modification Service
R Bulletin - Inspection of Outer and Inner Combustion Chamber Liner Shell).
- R 5. V2500 Engine Illustrated Parts Catalogs (S-V2500-2IA, S-V2500-2IB,
R S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA, S-V2500-6IB,
R S-V2500-7IA and S-V2500-7IB, Chapter/Section 72-42-61, Figure 01 and 72-44-30,
R Figure 01).
- R 6. V2500 Engine Illustrated Parts Catalogs (S-V2500-2SA, S-V2500-2SB,
R S-V2500-5SA, S-V2500-5SB, S-V2500-6SA, S-V2500-6SB, S-V2500-7SA and
R S-V2500-7SB), Chapter/Section 72-42-61, Figure 01 and 72-44-30, Figure 01.
- R 7. V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30.
8. V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30.
9. V2500 Standard Practices/Processes Manual, Chapter/Section 70-09-00.
- R 10. Internal Reference No. - EC 00VA027A and 00VA027S.
11. ATA Locator - 72-40-00.

L. Other Publications Affected

- R 1. V2500 Engine Illustrated Parts Catalogs (S-V2500-1IA, S-V2500-2IA,
R S-V2500-2IB, S-V2500-3IA, S-V2500-3IB, S-V2500-5IA, S-V2500-5IB, S-V2500-6IA,
R S-V2500-6IB, S-V2500-7IA and S-V2500-7IB), Chapter/Section 72-42-61, Figure 01
R and 72-44-30, Figure 01.
- R 2. V2500 Engine Manual (E-V2500-1IA), Chapter/Section 72-42-61 and 72-44-30,
R Cleaning, Inspection and Repair, to add the new part.
- R 3. V2500 Engine Manual (E-V2500-3IA), Chapter/Section 72-42-61 and 72-44-30,
R Cleaning, Inspection and Repair, to add the new part.

M. Interchangeability of Parts

R Old and new parts are directly interchangeable; however, to achieve the full
R benefit of this Service Bulletin it is recommended that new parts be
R incorporated in full sets.

N. Information in the Appendix

Alternate Accomplishment Instructions (No)

R Progression Charts (Yes)

R Added Data (Yes)

Revision to Table of Limits (No)

Inspection Procedures (No)

2. Material Information

A. Material – Price and Availability

1. Modification kit is not required.

For Price and availability of spares refer to the supplement of this Service Bulletin.

B. Industry Support Program

Not Applicable.

C. The material data that follows is for each engine.

For V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525D, V2528-D5, V2522-A5 (SelectOne™), V2524-A5 (SelectOne™), V2527-A5 (SelectOne™), V2527E-A5 (SelectOne™), V2527M-A5 (SelectOne™), V2530-A5 (SelectOne™), V2533-A5 (SelectOne™) Engines:

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3345-01	(1)(M) (R)
01-620	2A3804	10	.Liner Segment, Combustion Chamber, 30D	-	2A3316	(2)(A) (C)(I)
01-610	2A3805	10	.Liner Segment, Combustion Chamber, 40D or	-	2A3317	(2)(A) (C)(I)
01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3345-001	(1)(M) (R)
01-620	2A3804	10	.Liner Segment, Combustion Chamber, 30D	-	2A3316	(2)(A) (C)(I)
01-610	2A3805	10	.Liner Segment, Combustion Chamber, 40D or	-	2A3317	(2)(A) (C)(I)
01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3440-01	(1)(M) (R)
01-620	2A3804	10	.Liner Segment, Combustion Chamber, 30D	-	2A3316	(2)(A) (C)(I)

R R R	FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
R R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 40D or	-	2A3317	(2)(A) (C)(I)
R R	01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3440-001	(1)(M) (R)
R R	01-620	2A3804	10	.Liner Segment, Combustion - Chamber, 30D	-	2A3316	(2)(A) (C)(I)
R R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 40D or	-	2A3317	(2)(A) (C)(I)
R R	01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3440-002	(1)(M) (R)
R R	01-620	2A3804	10	.Liner Segment, Combustion - Chamber, 30D	-	2A3316	(2)(A) (C)(I)
R R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 40D or	-	2A3317	(2)(A) (C)(I)
R R	01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3442-01	(1)(M) (R)
R R	01-620	2A3804	10	.Liner Segment, Combustion - Chamber, 30D	-	2A3316	(2)(A) (C)(I)
R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 40D	-	2A3317	(2)(A) (C)(I)
R R	01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3442-001	(1)(M) (R)
R R	01-620	2A3804	10	.Liner Segment, Combustion - Chamber, 3 0D	-	2A3316	(2)(A) (C)(I)
R R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 4 0D or	-	2A3317	(2)(A) (C)(I)
R R	01-501	2A3442-003	1	Assembly, Combustion Chamber, Outer	-	2A3442-001	(1)(M) (R)

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R R R	FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
R R	01-620	2A3804	10	.Liner Segment, Combustion - Chamber, 30D		2A3316	(2)(A) (C)(I)
R R R	01-610	2A3805	10	.Liner Segment, Combustion - Chamber, 40D		2A3317	(2)(A) (C)(I)
R R	72-44-30 01-401	2A3344-002	1	Assembly, Combustion Chamber, Inner	-	2A3344-01	(1)(M) (R)
R R	01-600	2A3806	10	.Liner Segment Combustion - Chamber, 3ID		2A3326	(2)(A) (C)(I)
R R R	01-580	2A3807	10	.Liner Segment, Combustion - Chamber, 4 ID or		2A3322	(2)(A) (C)(I)
R R	01-401	2A3344-002	1	Assembly, Combustion Chamber, Inner	-	2A3344-001	(1)(M) (R)
R R	01-600	2A3806	10	.Liner Segment, Combustion - Chamber, 3ID		2A3326	(2)(A) (C)(I)
R R	01-580	2A3807	10	.Liner Segment, Combustion - Chamber, 4ID		2A3322	(2)(A) (C)(I)

D. Instructions/Disposition Code Statements:

Parts Modification Conditions

- (1) The new part can be obtained by modification of the old part as specified in the Accomplishment Instructions.
(2) The new part is a replacement part only, and cannot be obtained by modification of the old part.

Spare Parts Availability

- R (A) The new part is available.
(C) The old part will continue to be supplied.
(M) It is possible to get the new part only by modification.

Cleaning, Inspection and Repair Information

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

E. Tooling – Price and Availability

Special tools are not required to accomplish this Service Bulletin.

F. Reidentified Parts

Not Applicable.

Reidentified Parts		Data	
New PN		Keyword	Old PN
R		Outer Combustion	
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3345-01
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3445-001
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3440-01
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3440-001
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3440-002
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3442-01
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3442-001
R		Chamber Assembly	
R	2A3442-003	Outer Combustion	2A3442-002
R		Chamber Assembly	
R	2A3344-002	Inner Combustion	2A3344-01
R		Chamber Assembly	
R	2A3344-002	Inner Combustion	2A3344-001
R		Chamber Assembly	

G. Other Material Information Data

Not Applicable.

3. Accomplishment Instructions

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R CAUTION: DO NOT TIGHTEN THE COMBUSTION CHAMBER LINER SEGMENTS TO A TORQUE VALUE OF
R MORE THAN 50.0 LBF-IN (5,649 NM). OVERTIGHTENING CAN CAUSE THE STUD BASE
R AND THREADS TO CRACK.

R CAUTION: IF YOU TIGHTEN THE SEGMENTS TO MORE THAN 50.0 LBF-IN (5,649 NM) THEN YOU
R MUST VISUALLY EXAMINE THE STUD BASE AND THREADS FOR CRACKS UNDER WHITE
R LIGHT AND 20X MAGNIFICATION, AND REPLACE SEGMENTS THAT HAVE CRACKED STUDS.

R (1) Replace 10 30D Combustion Chamber Liner Segments, PN 2A3316 with PN 2A3804
R by the procedure in Reference 7 or 8, Engine Manual, Chapter/Section
R 72-42-61, Repair 015 (VRS 3540). See Figure 1, Sheet 1 for the location of
R the parts.

R CAUTION: DO NOT TIGHTEN THE COMBUSTION CHAMBER LINER SEGMENTS TO A TORQUE
R VALUE OF MORE THAN 50.0 LBF-IN (5,649 NM). OVERTIGHTENING CAN CAUSE
R THE STUD BASE AND THREADS TO CRACK.

R CAUTION: IF YOU TIGHTEN THE SEGMENTS TO MORE THAN 50.0 LBF-IN (5,649 NM) THEN
R YOU MUST VISUALLY EXAMINE THE STUD BASE AND THREADS FOR CRACKS UNDER
R WHITE LIGHT AND 20X MAGNIFICATION, AND REPLACE SEGMENTS THAT HAVE
R CRACKED STUDS.

R (2) Replace 10 40D Combustion Chamber Liner Segments, PN 2A3317 with PN 2A3805
R by the procedure in Reference 7 or 8, Engine Manual, Chapter/Section
R 72-42-61, Repair 015 (VRS3540). See Figure 1, Sheet 1 for the location of
R the parts.

R (3) Identify the modified outer combustion chamber assembly by the vibration
R peen method specified in Reference 9, Standard Practices Manual,
R Chapter/Section 70-09-00, Marking of Parts. See Figure 1, Sheet 2 for the
R part marking location. Part number identification is provided in the list
R that follows:

R Identification of the Inner Combustion Chamber Assembly

R New PN	R Old PN
R 2A3442-003	2A3345-01
R 2A3442-003	2A3345-001
R 2A3442-003	2A3440-01
R 2A3442-003	2A3440-001
R 2A3443-003	2A3440-002
R 2A3443-003	2A3442-01
R 2A3442-003	2A3442-001
R 2A3442-003	2A3442-002

CAUTION: DO NOT TIGHTEN THE COMBUSTION CHAMBER LINER SEGMENTS TO A TORQUE VALUE OF MORE THAN 50.0 LBF-IN (5,649 NM). OVERTIGHTENING CAN CAUSE THE STUD BASE AND THREADS TO CRACK.

CAUTION: IF YOU TIGHTEN THE SEGMENTS TO MORE THAN 50.0 LBF-IN (5,649 NM) THEN YOU MUST VISUALLY EXAMINE THE STUD BASE AND THREADS FOR CRACKS UNDER WHITE LIGHT AND 20X MAGNIFICATION, AND REPLACE SEGMENTS THAT HAVE CRACKED STUDS.

- (4) Replace 10 3ID Combustion Chamber Liner Segments, PN 2A3326 with PN 2A3806 by the procedure in Reference 7 or 8, Engine Manual, Chapter/Section 72-44-30, Repair 001 (VRS3173). See Figure 2, Sheet 1 for the location of the parts.

CAUTION: DO NOT TIGHTEN THE COMBUSTION CHAMBER LINER SEGMENTS TO A TORQUE VALUE OF MORE THAN 50.0 LBF-IN (5,649 NM). OVERTIGHTENING CAN CAUSE THE STUD BASE AND THREADS TO CRACK.

CAUTION: IF YOU TIGHTEN THE SEGMENTS TO MORE THAN 50.0 LBF-IN (5,649 NM) THEN YOU MUST VISUALLY EXAMINE THE STUD BASE AND THREADS FOR CRACKS UNDER WHITE LIGHT AND 20X MAGNIFICATION, AND REPLACE SEGMENTS THAT HAVE CRACKED STUDS.

- (5) Replace 10 4ID Combustion Chamber Liner Segments, PN 2A3322 with PN 2A3807 by the procedure in Reference 7 or 8, Engine Manual, Chapter/Section 72-44-30, Repair 001 (VRS3173). See Figure 2, Sheet 1 for the location of the parts.

- (6) Identify the modified outer combustion chamber assembly by the vibration peen method specified in Reference 9, Standard Practices Manual, Chapter/Section 70-09-00, Marking of Parts. See Figure 2, Sheet 2 for the part marking location. Part number identification is provided in the list that follows:

Identification of the Inner Combustion Chamber Assembly

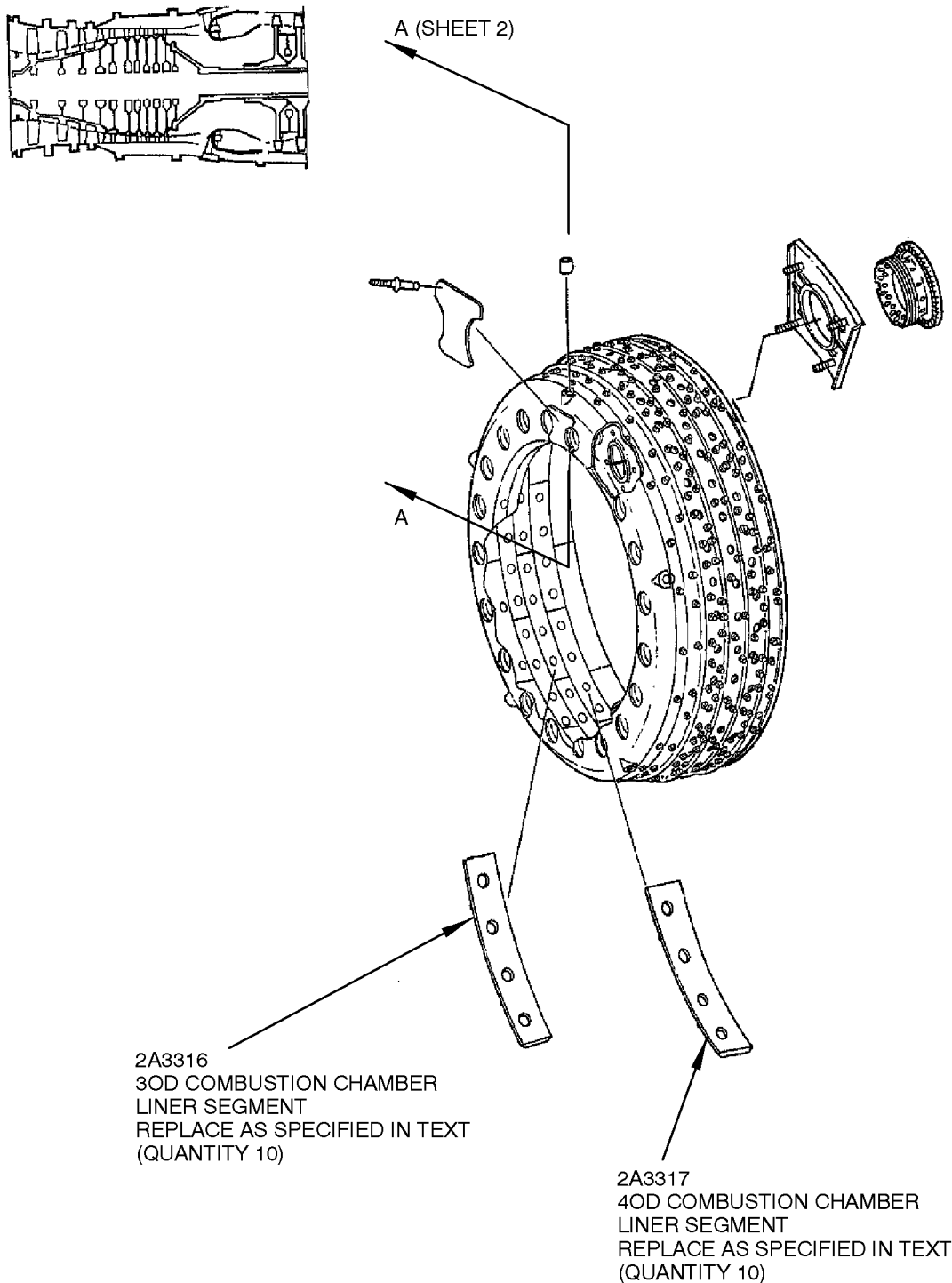
New PN	Old PN
2A3344-002	2A3344-01
2A3344-002	2A3344-001

- (7) Recording Instructions

(a) A record of accomplishment is required.

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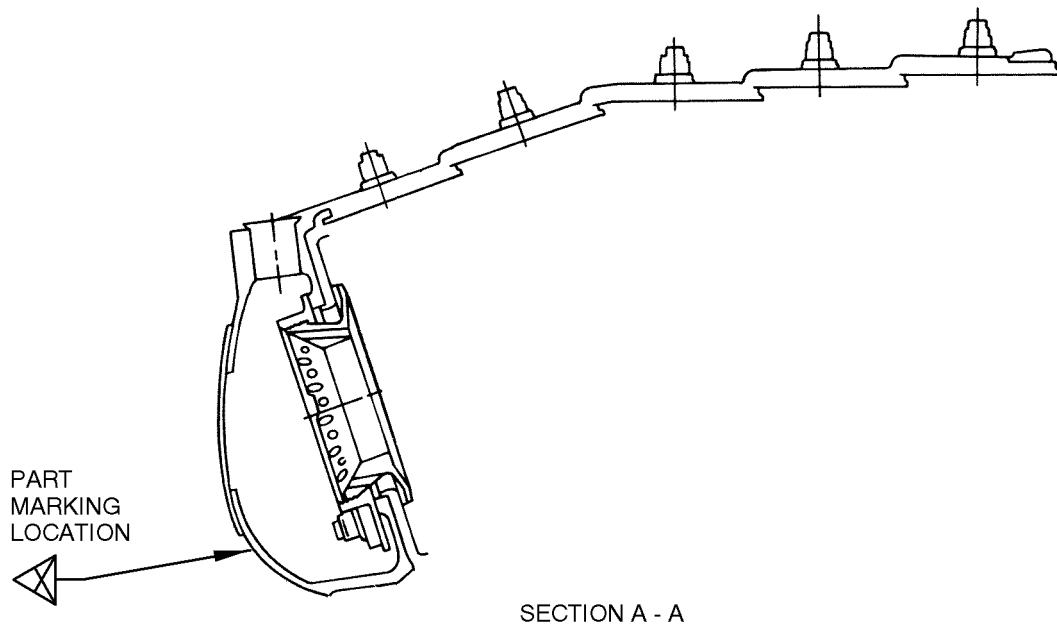
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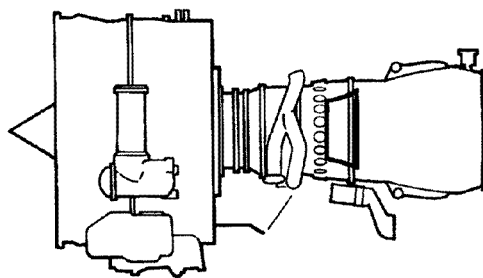
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Location and Identification of the 30D and 40D Combustion Chamber Liner Segments
Figure 1, Sheet 1



SECTION A - A

Location and Identification of the 30D and 40D Combustion Chamber Liner Segments
Figure 1, Sheet 2

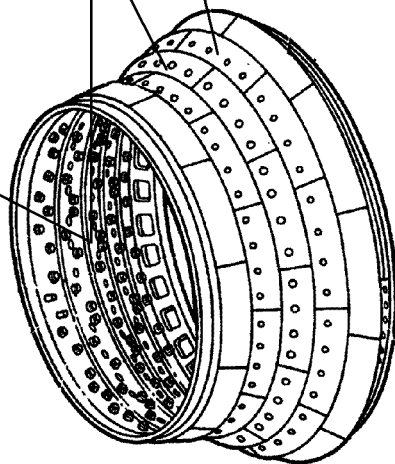


2A3322
4ID COMBUSTION CHAMBER
LINER SEGMENT
REPLACE AS SPECIFIED IN TEXT
(QUANTITY 10)

2A3326
3ID COMBUSTION
CHAMBER
LINER
SEGMENT
REPLACE AS
SPECIFIED IN TEXT
(QUANTITY 10)

B (SHEET 2)

B

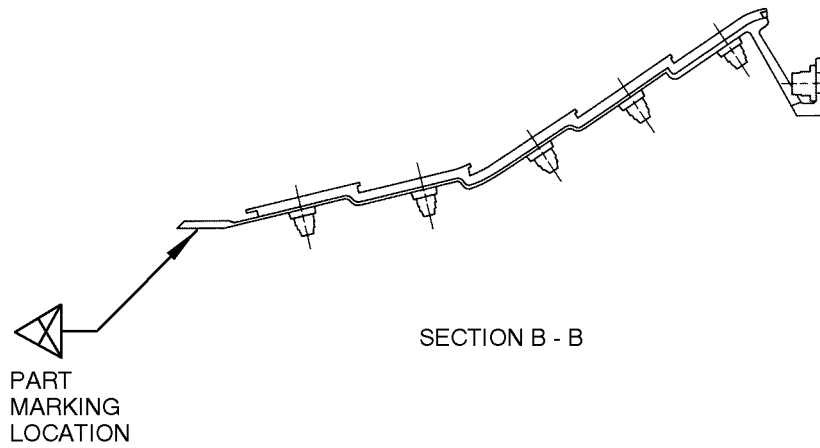


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R

Location and Identification of the 3ID and 4ID Combustion Chamber Liner Segments
72-44-30
Figure 2, Sheet 1

R



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R
R

Location and Identification of the 3ID and 4ID Combustion Chamber Liner Segments
Figure 2, Sheet 2

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

APPENDIX

R Parts Progression To Show the Changed Part in Relation to Other Parts

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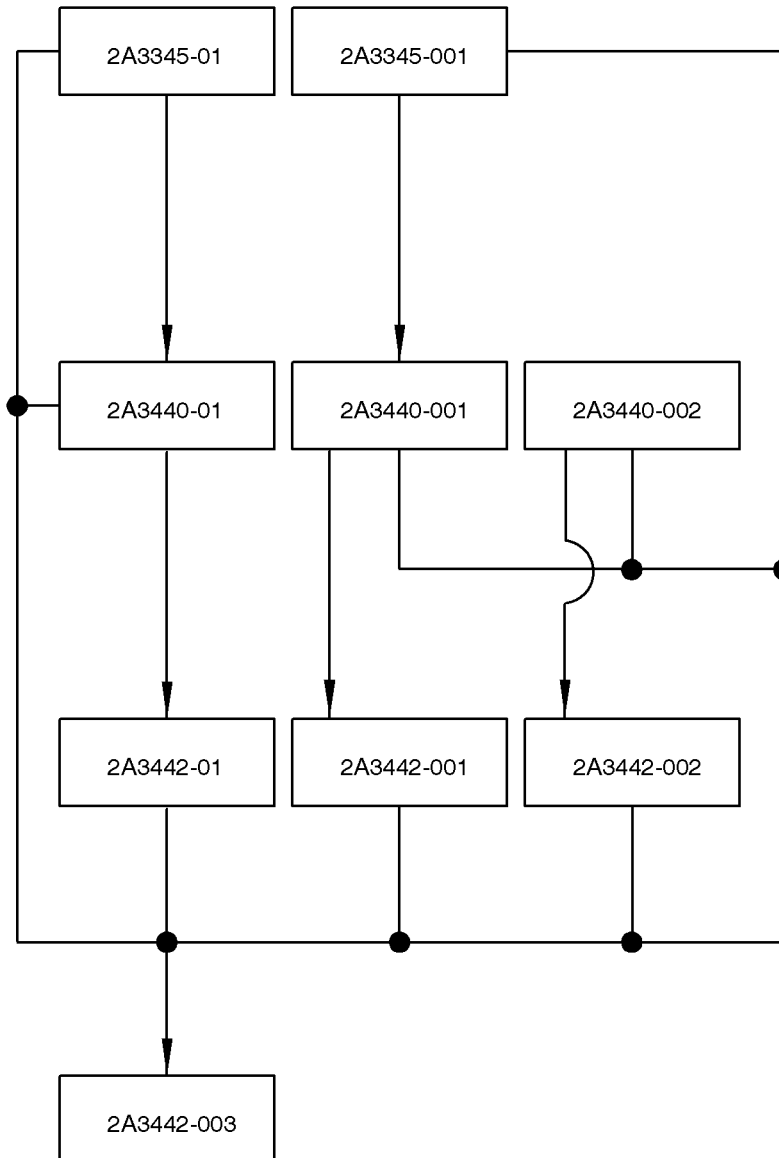
MODIFICATIONS

V2500-ENG-72-0315
ENGINE - DIFFUSER
AND COMBUSTION
GROUP AND
STAGE 1 TURBINE
NOZZLE ASSEMBLY -
PROVIDE NEW
INNER AND OUTER
COMBUSTION
CHAMBER LINERS
WITH ADDITION OF
PWA 281 COATING

V2500-ENG-72-0330
ENGINE - DIFFUSER
AND COMBUSTION
GROUP - PROVIDE
NEW BULKHEAD
LINER SEGMENT

V2500-ENG-72-0331
ENGINE - DIFFUSER
AND COMBUSTION
GROUP - PROVIDE
NEW FUEL
NOZZLE GUIDES

V2500-ENG-72-0447
ENGINE - INNER
AND OUTER
COMBUSTION
CHAMBER LINERS
WITH ADDITION
OF SINGLE
CRYSTAL
MATERIAL
ON ROWS 3 AND 4



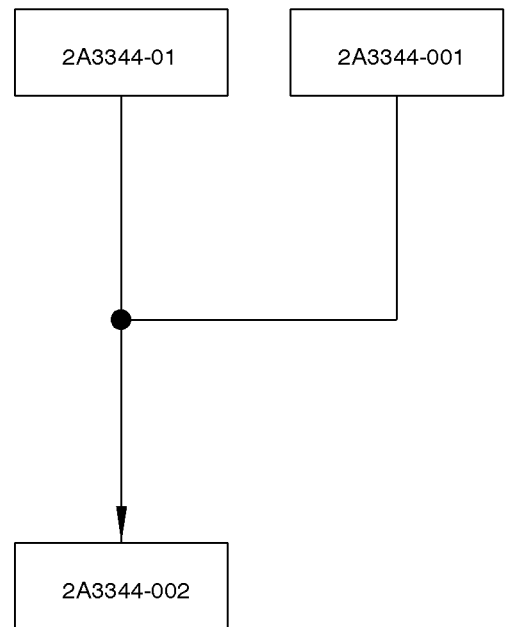
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Family Tree - Outer Combustion Chamber Assembly Ref. Catalog Sequence No.
72-42-61, Fig.1 Item 501
Chart A

MODIFICATIONS

V2500-ENG-72-0315
ENGINE - DIFFUSER AND
COMBUSTION GROUP AND
STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
PWA 281 COATING

V2500-ENG-72-0447
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
SINGLE CRYSTAL MATERIAL
ON ROWS 3 AND 4



pw0b521669

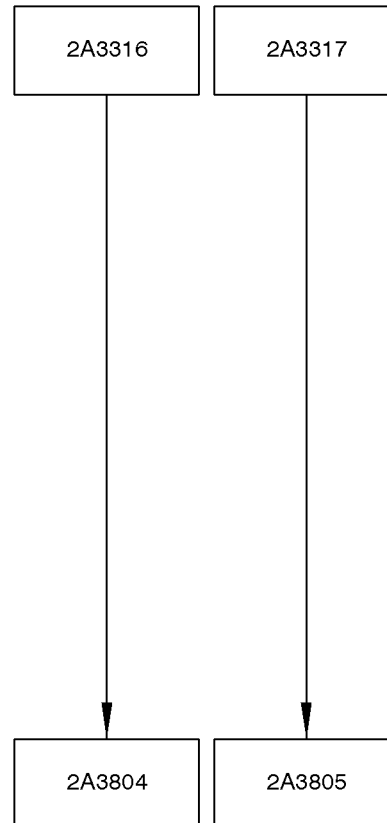
Family Tree - Inner Combustion Chamber Assembly Ref. Catalog Sequence No.
72-44-30, Fig.1 Item 401
Chart B

MODIFICATIONS

V2500-ENG-72-0315
ENGINE - DIFFUSER AND
COMBUSTION GROUP AND
STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
PWA 281 COATING

30D
COMBUSTION
CHAMBER
LINER SEGMENT
PROGRESSION

40D
COMBUSTION
CHAMBER
LINER SEGMENT
PROGRESSION



V2500-ENG-72-0447
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
SINGLE CRYSTAL MATERIAL
ON ROWS 3 AND 4

Printed in Great Britain

R

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R

R

Family Tree - 30D and 40D Combustion Chamber Liner Segments Ref. Catalog Sequence
No. 72-42-61, Fig. 1 Items 620 and 610
Chart C

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Appendix - Page 4

MODIFICATIONS

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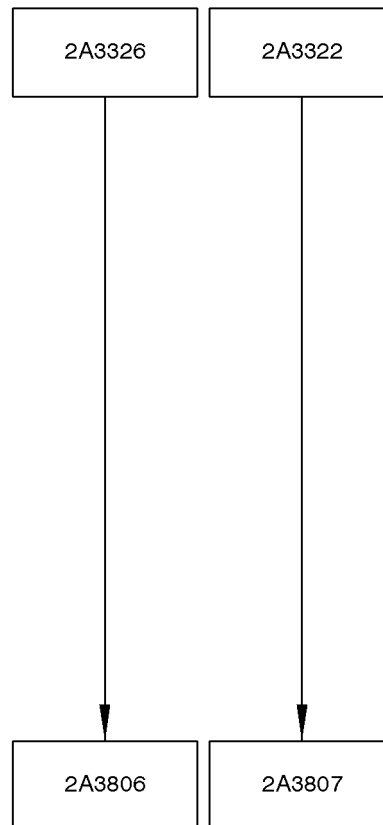
V2500-ENG-72-0315
ENGINE - DIFFUSER AND
COMBUSTION GROUP AND
STAGE 1 TURBINE NOZZLE ASSEMBLY -
PROVIDE NEW INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
PWA 281 COATING

R

V2500-ENG-72-0447
ENGINE - INNER AND OUTER
COMBUSTION CHAMBER LINERS
WITH ADDITION OF
SINGLE CRYSTAL MATERIAL
ON ROWS 3 AND 4

3ID
COMBUSTION
CHAMBER
LINER SEGMENT
PROGRESSION

4ID
COMBUSTION
CHAMBER
LINER SEGMENT
PROGRESSION



pw0b521671

R

Family Tree - 3ID and 4ID Combustion Chamber Liner Segments Ref. Catalog Sequence
No. 72-44-30, Fig. 1 Items 600 and 580
Chart D

R

R Added Data

R Internal Reference Information

R	Revision No.	Reference Document	Origination
R	Original	EC 00VA027A	RG/MN
R	1	EC 00VA027A	RG/MN
R	2	EC 00VA027S	RG/JDH

R Number values shown in parentheses adjacent to U.S. values are International System
R of units (SI) equivalents.

Printed in Great Britain

ENGINE – INNER AND OUTER COMBUSTION CHAMBER LINERS WITH ADDITION OF SINGLE CRYSTAL MATERIAL ON ROWS 3 AND 4

Printed in Great Britain

R

Supplement

R V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5, V2525-D5,
R V2528-D5, V2522-A5 (SelectOne™), V2524-A5 (SelectOne™), V2527-A5 (SelectOne™),
R V2527E-A5 (SelectOne™), V2527M-A5 (SelectOne™), V2530-A5 (SelectOne™), V2533-A5
R (SelectOne™)

R 1. Modification Kit:

R A. There is no kit provided to do this Service Bulletin.

R 2. Material Cost

R NOTE: The prices shown are for estimating purposes only and as such are given in
R good faith without commercial liability for advanced planning purposes
R only. Refer to IAE Spares and/or current price catalogue for current
R prices.

R A. The estimated price of new material is \$137,200.00 to do this Service
R Bulletin when the part modification procedure is used.

R B. There is no kit provided to do this Service Bulletin.

R 3. New Production Parts

		Unit Price US Dollars
R	New Production	Description
R	Part Number	
R	2A3804	30D Combustion Chamber Liner Segment
R		3,430.00
R	2A3805	40D Combustion Chamber Liner Segment
R		3,430.99
R	2A3806	31D Combustion Chamber Liner Segment
R		3,430.00
R	2A3807	41D Combustion Chamber Liner Segment
R		3,430.00