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V2500-A5 SERIES PROPULSION SYSTEM NON-MODIFICATION SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 2 to Service Bulletin EV2500-72-0474

Document History

Service Bulletin Revision Status	
Initial Issue	Mar.12/04
Revision 1	Jun.30/04

Supplement Revision Status

Bulletin Revision 2

Remove
Pages 1 to 6 of the
Service Bulletin

Incorporate
Pages 1 to 7 of the
Service Bulletin

Reason for change
To cancel the requirement
for the inspection of HPT
stage 2 hub, to incorporate
the requirements of EC
04VC039C.

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CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED

If any have not been received please advise Customer Data Services, Rolls-Royce plc, Derby, England

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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 2 are as follows:

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NON - MODIFICATION SERVICE BULLETIN - HIGH PRESSURE TURBINE (HPT) STAGE 2 HUB
INSPECTION

1. Planning Information

A. Effectivity Data (For Airbus A320)

Engine Models Applicable

V2527-A5

Engine Serial No.V11565

B. Concurrent Requirements

There are no concurrent requirements.

C. Reason

- R (1) Problem: The HPT stage 2 Hub P/N 2A4802 Serial Number PKLBEU5303 in engine
serial number V11565 may have been incorrectly marked during assembly.
The HPT stage 2 rotor assembly should be identified on the stage 2 blade
retaining plate. The assembly number may have been improperly marked on
R the web of the HPT stage 2 hub.
- R (2) Background: The stage 2 hub web is a critical location of the disk.
Recent structural analysis and specimen testing has determined that an
R improperly marked hub is acceptable to continue in service. Prior to the
R recent specimen testing it was determined that the disk will only be
R acceptable for 5,100 cycles and Non-Modification Service Bulletin (NMSB)
R required the hub to be checked for the improper marked hub before 5,100
R cycles had been achieved. Also the Engine Manual has incorporated an
R inspection and repair for improperly marked stage 2 hubs.
- R (3) Objective: Revise the NMSB to no longer require that the hub be inspected
prior to achieving 5,100 cycles.
- R (4) Substantiation: Structural analysis and specimen testing has determined
R that the improperly marked hub can continue in service until the next shop
R visit where the rear of the HPT is assessable. The Engine Manual requires
R that at shop visits where the HPT stage 2 hub rear web is assessable, the
R interface inspection checks for improperly marked hub. And if an improper
R marking is found the hub to be repaired per VRS3704.
- (5) Effects of Bulletin on:
- Removal/Installation: None.
- Disassembly/Assembly: None.

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

Cleaning: None.

Inspection/Check: None.

Repair: None.

Testing: None.

(6) Supplemental Information

R This Non-Modification Service Bulletin has been updated to effectively
R remove the inspection requirements for the HPT stage 2 hub on serial
R number V11565 engine.

D. Description

Repair any HPT stage 2 hub that is not marked correctly.

E. Compliance

R TD

R No longer required.

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

To gain access.

24 hours.

To inspect and replace hub.

24 hours.

To return engine to service.

28 hours.

Total

72 hours.

H. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

No Effect.

(3) 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.

K. References

1. V2500 Engine Illustrated Parts Catalogs (S-V2500-71A, and S-V2500-71B), Chapter/Section 72-45-31 Fig. 01 Item 011.
2. V2500 Engine Manual (E-V2500-11A), Chapter/Section 72-45-00.
3. V2500 Standard Practices/Processes Manual (E-V2500-11A), Chapter/Section 70-09-00.

- R
4. Internal Reference No. - 04VC039, 04VC039A, 04VC039C.
 5. ATA Locator - 72-45-00.

L. Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (No)

Added Data (No)

Revision to Table of Limits (No)

Inspection Procedures (No)

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2. Material Information

A. Material – Price and Availability

Not Applicable.

B. Industry Support Program

Not Applicable.

C. Reidentified Parts

Not Applicable.

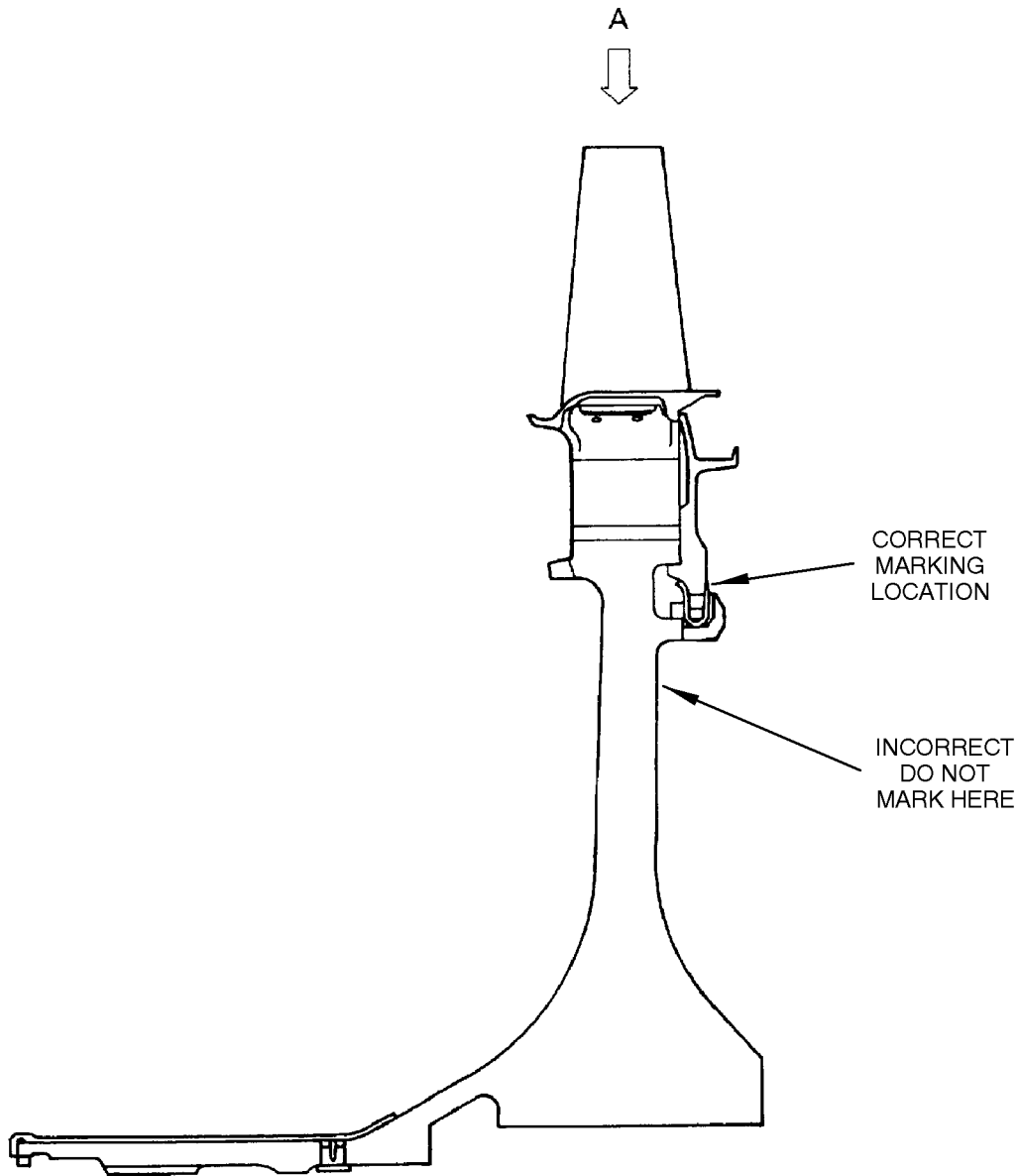
D. Other Material Information Data

Not Applicable.



3. Accomplishment Instructions

- R (1) Action per this NMSB is no longer required. The requirements for
R inspection the HPT stage 2 hub has been incorporated into the Engine
R Manual in Subtask 72-00-45-220-211, Subtask 72-45-30-220-088 and Subtask
R 72-45-31-220-113.
- (2) Recording Instructions
- R (a) A record of accomplishment is not required.



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HPT STAGE 2 ROTOR MARKING LOCATION
Figure 1

