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V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin EV2500-72-0504 and the Initial Issue of the Supplement

Bulletin Initial Issue

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Supplement Initial Issue

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V2500-ENG-72-0504

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LIST OF EFFECTIVE PAGES

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Printed in Great Britain

ENGINE – MAIN GEARBOX ASSEMBLY – TO ANNOUNCE A NEW DEOILER CASING1. Planning InformationA. Effectivity

(1) Airbus A319.

(a) V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial Number V12176.

(2) Airbus A320.

(a) V2500-A1, Engines prior to Serial Number V0362.

(b) V2527E-A5, V2527-A5 Engines prior to Serial Number V12176.

(3) Airbus A321.

(a) V2530-A5, V2533-A5 Engines prior to Serial Number V12176.

B. Concurrent requirements

None.

C. Reason

(1) Problem

There is interference between the new bracket, P/N 6A8166 (72-60-10, 01-457) and the material around the flange of the deoiler housing.

(2) Evidence

A local rework of the deoiler housing is required.

(3) Objective

To avoid rework by hand, without written instructions.

(4) Substantiation

Local dimensions of the affected area of the housing were assessed.

(5) Effects of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not Affected.

(c) Overhaul

Affected (See Supplemental Information).

(d) Repair Schemes

Not Affected.

(e) Interchangeability

Affected.

(f) Fits and Clearances

Not Affected.

(6) Supplemental Information

(a) Refer to Rework Instruction.

D. Description

The changes introduced by this Service Bulletin are as follows:

(1) The new deoiler housing does not interfere with the new bracket.

(2) The old deoiler housing can be reworked to the new standard.

NOTE: Installation of the new bracket, P/N 6A8166 (72-60-10, 01-457) in accordance with Service Bulletin V2500-ENG-79-0088 requires incorporation of this Service Bulletin.

E. Compliance

Category Code 7

Accomplish when supply of superseded parts has been depleted.

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

Estimated man-hours to incorporate the full intent of this Service Bulletin:

(1) In Service

Not applicable.

(2) At Overhaul

To accomplish rework and re-ident of Deoiler Case Assembly (1 off):

2 hours, 15 minutes.

H. Material Availability

Modification Kit is not required.

For prices and availability of future spares, see Supplement to this Service Bulletin.

I. Tooling Availability

None.

J. Industry Support Information

Not applicable.

K. Weight and Balance

(1) Weight Change

None.

(2) Moment Arm

Not affected.

(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) Internal Reference No.

Engineering Change No. 05VF003

(2) V2500 Service Bulletin:

V2500-ENG-79-0088 - OIL - SCAVANGES OIL TUBES - RE-ROUTE OF NUMBER 4
BEARING SCAVANGE TUBE

(3) ATA Locator - 72-60-31.

O. Other Publications Affected

(1) V2500 Illustrated Parts Catalogue, Chapter/Section 72-60-31.

P. Interchangeability of Parts

Parts affected by this Service Bulletin are not interchangeable.

2. Material Information

A. The kit required consists of the following parts:

None.

B. Parts affected by this Service Bulletin:

For V2500-A1, V2522-A5, V2524-A5, V2527-A5, V2527E-A5, V2527M-A5, V2530-A5, V2533-A5 Engines:

72-60-31

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01170	4B7361	1	CASING, DEOILER, ASSEMBLY OF	-	4B7262	(A) (B) (S1) (1D)

C. Instructions disposition codes:

(A) The new part is currently available.

(B) The old part will be discontinued.

(S1) The new part can replace the old part but the old part cannot replace the new part.

(1D) The old part can be reworked and re-identified to the new part number.

3. Accomplishment Instructions

A. Rework Instructions

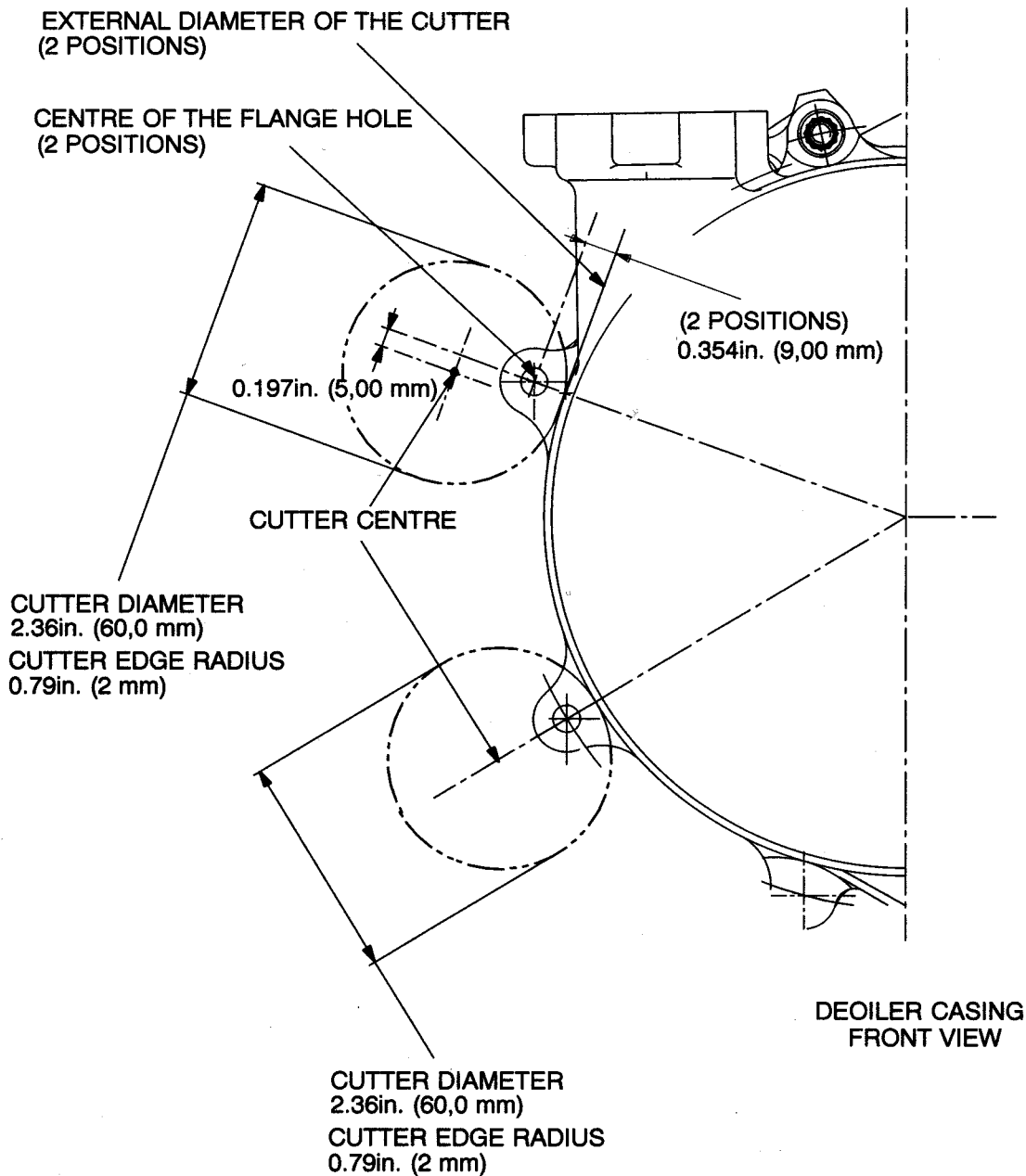
- (1) Remove the deoiler casing from the gearbox. Refer to Engine Manual instructions, Task 72-60-10-040-001 and Subtask 72-60-10-040-053.
- (2) Put the deoiler casing on a flat surface.
- (3) Use the center line of the air port as dimensional reference.
- (4) Machine the deoiler casing around the two flange holes at positions 8 and 10 o'clock, front view of the deoiler casing, looking afterwards. Refer to the scheme of Fig.1. Use a cutting tool with a diameter of 2.36in. (60,0 mm) and an edge radius of 0.08in. (2 mm). It is not required to use a specific tool. If the cutting tool touches the rough surface of the deoiler casing, the thickness of the casing will be equal or more than 0.35in. (9 mm). Make sure you do not decrease the thickness of the flange. Surface finish must be 1,6 micron.
- (5) A fluorescent penetrant inspection is not required. If you think that the inspection is required, do a local fluorescent inspection in accordance with Standard Practices Manual 70-23-05-230-501, use Comat 06-063 (medium post-emulsified). Cracks are not allowed.
- (6) Apply chromate conversion coating in accordance with Standard Practices Manual 70-38-02-300-503 to machined areas.
- (7) Cross out the old part number 4B7262 and mark the new and one 4B7361. Refer to Standard Practices Manual 70-09-400-501, vibration peening.
- (8) Install the deoiler casing on the gearbox. Refer to Engine Manual instructions, Task 72-60-10-440-001 and Subtask 72-60-10-440-065.

B. Assembly Instructions

None.

C. Recording Instructions

- (1) A record of accomplishment is required.



f100sb1001

ALL DIMENSIONS ARE IN IN. (MM)

Rework of the Deoiler Casing
Figure 1

ENGINE – MAIN GEARBOX ASSEMBLY – TO ANNOUNCE A NEW DEOILER CASINGSUPPLEMENT – 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, parts supplied as single line items.

2. New Production Parts:

Part No.	Description	Unit Price US Dollars
4B7361	Casing, Deoiler, Assembly of	Refer to IAE

3. Tools

None.

