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V2500-A1 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 3 to Service Bulletin EV2500-73-0040

Document History

Service Bulletin Revision Status		Supplement Revision Status
Initial Issue	Oct.23/92	
Revision 1	Oct.26/92	
Revision 2	Mar.10/93	

Bulletin Revision 3

Remove	Incorporate	Reason for change
All pages of the Service Bulletin	Pages 1 to 32 of the Service Bulletin	To alter Compliance Category and to delete Pre-requisite/Rempval instructions

V2500-ENG-73-0040

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise Publication Services, Rolls-Royce plc, Derby, England

LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 3 are as follows:

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International Aero Engines

SERVICE BULLETIN

ENGINE – FUEL AND CONTROL – FUEL TUBES – FUEL METERING UNIT TO FUEL DIVERTER VALVE SERVO TUBES RE-ROUTED

1. Planning Information

A. Effectvity

(1) Aircraft : Airbus A320

R (2) Engine : V2500 A1 Engines prior to Serial No.V0302 except V0292

R B. Concurrent Requirements

R None

C. Reason

(1) Condition

Cracking and fretting may take place on the two servo fuel tubes which run between the fuel metering unit and the diverter valve on the fuel cooled oil cooler.

(2) Background

Fretting is being experienced on the 0.250 in. diameter servo tubes which are manufactured in titanium. In several instances frettage has led to cracking of a tube with consequent fuel leakage.

(3) Objective

To prevent tube frettage and maintain engine reliability.

(4) Substantiation

Engineering assessment concludes that the items introduced by this Service Bulletin will be satisfactory.

(5) Effect of Bulletin on Workshop Procedures:

Removal/Installation	Affected
Disassembly/Assembly	Not affected
Cleaning	Affected
Inspection/Check	Not affected
Repair	Not affected
Testing	Not affected

(6) Supplemental Information

(a) The Engine Manual Removal and Installation procedures under 72-00-32 and 72-00-60 require to be revised to reflect the Post-Service Bulletin configuration.

(b) The Cleaning procedures in 73-11-49 in the Component Maintenance Manuals, Tubes, Hoses and Ducts and Miscellaneous Mechanical Components, require to be revised to reflect the Post-Service Bulletin configuration requirements.

D. Description

The two existing titanium servo fuel tubes are replaced by tubes produced in steel which has a far higher resistance to frettage.

The new tubes are re-routed closer to the fan case through new and existing clipping points. Existing clips are replaced by a type which has proved to have improved durability.

The tubes are now supported at new Clipping Points 1139, 1158 and 1159 and at existing Clipping Points 1050 and 1069. The tubes are no longer clipped at Clipping Point 0795 and existing Clipping Points 0325, 0328, 1082 and 1083 are deleted.

Three support brackets are required at Clipping Points 1139, 1158 and 1159. The bracket at Clipping Point 1139 is secured by the bolts that attach the FCOC to HP fuel pump tube to the FCOC. The brackets for Clipping Points 1158 and 1159 are secured to the fan case flange at each side of the existing bracket for Clipping Point 0795.

The EEC harness lead to the IDG oil cooler was clipped at Clipping Points 0300 and 0325 to lugs on the cooler to the IDG unit return tube. This lead is now clipped with the main EEC harness at Clipping Points 0789 and 0790. The tube lugs are no longer required and are deleted.

The EEC harness limb to the FMU which was supported at Clipping Point 1071 is now clipped at Clipping Point 1069. Clipping Point 1071 is therefore deleted.

E. Approval

R The part number changes and/or part modifications 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 Model listed.

F. Compliance

R Category Code 6

R Accomplish when the subassembly (i.e. Modules, Accessories, Components, Build
R groups) is disassembled sufficiently to afford access to the affected part and
R to all affected spare parts.

G. Manpower

Estimated manhours to incorporate the full intent of this Bulletin:

	Venue	Estimated Manhours
R (1)	In Service	Not applicable
R (2)	At overhaul	25 minutes

H. Material - Price and Availability

(1) Modification Kit not required.

(2) See 'Material Information' section for prices and availability of future spares.

I. Tooling - Price and Availability

Special tools are not required.

J. Weight and Balance

(1) Weight change .. .. Plus 0.3lb. (0.136kg.)

(2) Moment arm .. .. .. 7.0in. (178 mm) forward of datum

(3) Datum .. .. .. Engine front mount centreline (Power Plant Station (PPS) 100)

K. Electrical Load Data

This Service Bulletin has no effect on the aircraft electrical load.

L. References

(1) IAEV2500 Service Bulletin:

V2500-ENG-70-0143 - Information - Announcement of New EBU Oil System, IDG Cooling System and Drains System Tube Assemblies.

R (2) Internal Reference No. EC92VR091, EC92VR091A, EC92VR091B, EC92VR091C,
R EC92VR091D, ECM92VR091-01, ECM92VR091A-01, ECM92VR091B-01, ECM92VR091B-02,
R ECM92VR091C-01, ECM92VR091D-01.

R (3) ATA Locator - 71-00-00, 73-00-00, 79-00-00.

M. Other Publications Affected

(1) V2500 Illustrated Parts Catalog, 24-21-49, 71-51-41 and 73-11-49.

(2) V2500 Engine Manual, 72-00-32, Installation -01, Installation -03, Installation -04, Removal -02, Removal -03 and Removal -05.

(3) V2500 Engine Manual, 72-00-60, Installation -03, Installation -06, Removal -02 and Removal -06.

(4) V2500 Component Maintenance Manual, Tubes Hoses and Ducts, 24-21-49, Cleaning -00, Cleaning -01, Inspection/Check -01, Repair 006, Testing -00 and Testing -01.

(5) V2500 Component Maintenance Manual, Tubes, Hoses and Ducts, 73-11-49, Cleaning -00, Cleaning -04, Repair 009, Inspection/Check -05, Testing -00 and Testing -01.

(6) V2500 Component Maintenance Manual, Miscellaneous Mechanical Components, 73-11-49, Cleaning and Inspection.

(7) V2500 Maintenance Manual, 71-51-41, Removal/Installation, 71-51-43, Removal/Instalation, 71-51-44 Removal/Installation, 72-60-00, Removal/Installation, 73-22-52 - CONFIG 01, Removal/Installation and 79-21-43, Removal/Installation.

2. Material Information

A. Kits associated with this Bulletin:

None

B. Parts affected by this Bulletin:

Applicability: For each V2500 Engine to incorporate this Bulletin.

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword		Old Part No. (IPC No.)	Instructions Disposition
740-5727-513 (24-21-49)	1		Tube assy, oil - IDG FCOC to disconnect (Pre-SBE 70-0143)		740-5727-509 (01-100)	(A)(B)(K)
740-5727-513 (24-21-49)	1		Tube assy, oil - IDG FCOC to disconnect (Post-SBE 70-0143)		740-5727-511 (01-100)	(A)(B)(K)
AS43013-116 (24-21-49)	1		Packing		AS43013-116 (01-106)	(A)(L)
TA025074-08 (71-51-41)	1		Clip	) CP1069	- (02-272)	(A)(C)
AS61906 (71-51-41)	1		Clip	) CP1069	- (02-272)	(A)(C)
- (71-51-41)	1		Clip	) CP1071	TA025074-06 (02-272)	(D)
- (71-51-41)	1		Clip	) CP1071	AS61904 (02-272)	(D)
- (71-51-41)	1		Bolt	) CP 0300	4W0103 (01-278)	(D)
- (71-51-41)	1		Washer	) CP 0300	5W1086 (01-279)	(D)
- (71-51-41)	1		Clip	) CP 0300	AS61933 (01-281)	(D)
- (71-51-41)	1		Clip	) CP 0300	TA025074-03 (01-281)	(D)

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword		Old Part No. (IPC No.)	Instructions Disposition
- (71-51-41)	1		Nut		4W0001 (01-285)	(D)
- (71-51-41)	1		Bolt		4W0103 (01-294)	(D)
- (71-51-41)	1		Washer		5W1086 (01-295)	(H)
- (71-51-41)	1		Clip	CP 0325	AS61933 (01-297)	(D)
- (71-51-41)	1		Clip		TA025704-03 (01-297)	(D)
- (71-51-41)	1		Nut		4W0001 (01-301)	(J)
AS21434 (71-51-41)	1		Bolt		4W0107 (01-870)	(A)(D)(S1)
AS62516 (71-51-41)	1		Clip	CP 0789	AS61914 (01-873)	(A)(D)(S1)
- (71-51-41)	1		Clip		TA025074-16 (01-873)	(D)
6A4825 (71-51-41)	1		Spacer		- (01-874)	(A)(C)
AS21431 (71-51-41)	1		Bolt		4W0104 (01-878)	(A)(D)(S1)
AS62516 (71-51-41)	1		Clip	CP 0790	AS61914 (01-881)	(A)(D)(S1)
- (71-51-41)	1		Clip		TA025074-16 (01-881)	(D)
6A4825 (71-51-41)	1		Spacer		- (01-883)	(A)(C)
AS62504 (71-51-41)	1		Clip	CP 0789	- (02-566)	(A)(C)
AS62504 (71-51-41)	1		Clip	CP 0790	- (02-744)	(A)(C)

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword		Old Part No. (IPC No.)	Instructions Disposition
6A4584 (73-11-49)	1		Bracket assy		- (05-092)	(A)(C)
AS21021 (73-11-49)	2		Bolt		- (05-105)	(A)(C)
- (73-11-49)	2		Bolt	CP 1139	4W0168 (05-106)	(D)(E)
LK74669 (73-11-49)	2		Washer		- (05-107)	(A)(C)
AS20921 (73-11-49)	1		Bolt		AS20942 (05-133)	(A)(D)(S1)
AS62516 (73-11-49)	1		Clip	CP 0795	TA025074-16 (05-136)	(A)(D)(S1)
- (73-11-49)	1		Spacer		UP60481 (05-138)	(D)
- (73-11-49)	1		Bolt		4W0104 (06-525)	(D)
- (73-11-49)	2		Washer	CP1071	5W1086 (06-526)	(D)
- (73-11-49)	1		Clip		400WSS6 (06-528)	(L)
- (73-11-49)	1		Nut		4W0001 (06-532)	(D)
4W0119 (73-11-49)	1		Bolt		4W0103 (06-533)	(A)(D)
UP10482 (73-11-49)	1		Spacer	CP1069	- (06-538)	(A)(C)
- (73-11-49	1		Bolt		4W0103 (20-541)	(D)
- (73-11-49)	2		Washer		5W1086 (20-542)	(D)
				CP0328		

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
- (73-11-49)	1		Clip) Nut)	400WSS8 (20-544) 4W0001 (20-548)	(L) (D)
6A5306 (73-11-49)	1		Tube assy - Servo fuel to diverter valve	5R8127 (21-100)	(A)(B)(S1)
AS20908 (73-11-49)	1		Bolt) Washer) CP 1159	- (21-125) - (21-126)	(A)(C) (A)(C)
AS62404 (73-11-49)	1		Clip) Nut)	- (21-128) - (21-132)	(A)(C) (A)(C)
AS20908 (73-11-49)	1		Bolt) Washer) CP 1158	- (21-133) - (21-134)	(A)(C) (A)(C)
AS62404 (73-11-49)	1		Clip) Nut)	- (21-136) - (21-140)	(A)(C) (A)(C)
AS62404 (73-11-49)	1		Clip CP 1139	- (21-144)	(A)(C)
- (73-11-49)	1		Clip CP 0795	400WSS4 (21-160)	(L)
AS20908 (73-11-49)	1		Bolt) CP 1050	4W0104 (21-165)	(A)(D)(S1)
AS62404 (73-11-49)	1		Clip)	400WSS4 (21-168)	(A)(L)(S1)

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New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword		Old Part No. (IPC No.)	Instructions Disposition
- (73-11-49)	1		Bolt		4W0109 (21-173)	(D)
- (73-11-49)	2		Washer		5W1086 (21-174)	(D)
- (73-11-49)	1		Clip	CP 1082	400WSS4 (21-176)	(L)
- (73-11-49)	1		Spacer		5W1030 (21-178)	(D)
- (73-11-49)	1		Nut		4W0001 (21-180)	(D)
- (73-11-49)	1		Bolt		4W0107 (21-181)	(D)
- (73-11-49)	2		Washer		5W1086 (21-182)	(D)
- (73-11-49)	1		Clip	CP 1083	400WSS4 (21-184)	(L)
- (73-11-49)	1		Spacer		5W1029 (21-186)	(D)
- (73-11-49)	1		Nut		4W0001 (21-188)	(D)
6A3125 (73-11-49)	2		Bracket	CP 1158 and CP 1159	- (21-264)	(A)(C)
AS21011 (73-11-49)	2		Bolt	CP 1158	- (21-266)	(A)(C)
AS21013 (73-11-49)	2		Bolt	CP 1159	- (21-267)	(G)
LK74669 (73-11-49)	2		Washer	CP 1158	- (21-268)	(A)(C)
LK74669 (73-11-49)	4		Washer	CP 1159	- (21-269)	(A)(C)
4W0002 (73-11-49)	2		Nut	CP 1158	- (21-270)	(A)(C)

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword		Old Part No. (IPC No.)	Instructions Disposition
4W0002 (73-11-49)	2		Nut	CP 1159	- (21-270)	(G)
6A6002 (73-11-49)	1		Tube assy - Servo fuel from diverter valve		5R8137 (25-100)	(A)(B)(S1)
AS62404 (73-11-49)	1		Clip	CP 1159	- (25-136)	(A)(C)
AS20907 (73-11-49)	1		Bolt	)))	- (25-141)	(A)(C)
5W1086 (73-11-49)	1		Washer	))) CP 1139	- (25-142)	(A)(C)
AS62404 (73-11-49)	1		Clip	)))	- (25-144)	(A)(C)
4W0043 (73-11-49)	1		Nut, Clip	))	- (25-148)	(A)(C)
AS62404 (73-11-49)	1		Clip	CP 1158	- (25-152)	(A)(C)
- (73-11-49)	1		Clip	CP 0795	400WSS4 (25-168)	(L)
AS62404 (73-11-49)	1		Clip	CP 1050	400WSS4 (25-176)	(A)(L)(S1)
- (73-11-49)	1		Clip	CP 0328	400WSS4 (25-184)	(L)
AS62404 (73-11-49)	1		Clip	CP 1069	400WSS4 (25-192)	(A)(L)(S1)
- (79-21-49)	2		Nut	CP 1159	4W0002 (04-071)	(D)(F)
- (79-21-49)	2		Bolt	CP 1159	4W0164 (04-074)	(D)(F)
400WSS16 (73-11-49)	1		Clip	CP0795	400WSS16 (26-152)	(A)(L)

New Part No. (ATA No.)	Qty	Est'd Unit Price ($)	Keyword	Old Part No. (IPC No.)	Instructions Disposition
400WSS6 (73-11-49)	1	Clip	CP1069	400WSS6 (06-536)	(A)(L)
400WSS12 (24-21-49)	1	Clip	CP0929	400WSS12 (01-152)	(A)(L)
400WSS10 (24-21-49)	1	Clip	CP0929	400WSS10 (03-528)	(A)(L)

C. Instruction/Disposition Code Statements

(A) New parts are currently available.

(B) Old parts are no longer available.

(C) Additional part.

(D) Old part can be used up on other applications.

(E) Leaves quantity 1 off.

(F) Leaves quantity 2 off.

(G) These items replace items 04-071 and 04-074 in Chapter 79-21-49.

(H) Part now itemised 25-158 in Chapter 73-11-49.

(J) Part now itemised 25-164 in Chapter 73-11-49.

(K) Old part can be reworked and re-identified to the new part number.

(L) Discard. Do not use on other applications.

(S1) Old and new parts are not interchangeable either physically or functionally.

NOTE: The estimated 1993 unit prices shown are provided for planning purposes only and do not constitute a firm quotation. Consult the IAE Price Catalog or contact IAE's Spare Parts Sales Department for information concerning firm prices.

3. Accomplishment Instructions

R A. Deleted

R B. Deleted

C. Rework Instructions

(1) Rework IDG tube assembly. (Refer to 24-21-49, Figure 01 Items 100, 100A and 100B)

Standard Equipment

Basic workshop tools
Vibro-engraving equipment

Consumable Materials

None required

Procedure	Supplementary Information
(a) Find Clipping Points 0325 and 0300	See Figures 2 and 18
(b) Cut back lugs to align with tube	See Figure 18 Use basic workshop tools.
(c) Cancel the old part number and re-identify with the new part number	Old Part Number / New Part Number 740-5727-509 / 740-5727-513 740-5727-511 / 740-5727-513 See Figure 2 Refer to SPM, TASK 70-09-00-400-501, SUBTASK 70-09-00-400-001. Use vibro-engraving equipment.

D. Assembly Instructions

R (1) Install reworked 740-5727-513, IDG oil tube assembly, new 6A5306 and
R 6A6002 servo fuel tube assemblies to the fan case by the approved
R procedures in the Engine Manual, 72-00-32 and 72-00-60, Installation
R (Refer to Figure 3).

(2) Re-assemble existing Clipping Point 0929. Install new 400WSS12 clip to 740-5727-513 oil tube and new 400WSS10 clip to 740-5737-511 tube respectively using AS21408 bolt, SP154D washer and AS41104 clipnut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 9.

(3) Find the EEC harness lead to the IDG oil cooler previously clipped at Clipping Points 0300 and 0325. Refer to Figure 2.

(4) Secure the EEC harness lead at existing Clipping Point 0790. Remove 4W0001 nut, 4W0104 bolt, 5W1086 washer and AS61914 or TA 025074-16 clip, install replacement AS62516 clip and AS62504 clip on EEC harness, install AS62504 clip, AS21431 bolt, 6A4825 spacer, 5R8121 tube, AS62516 clip, 5W1086 weasher and 4W0001 nut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 7.

(5) Secure the EEC harness lead at existing Clipping Point 0789. Remove 4W0001 nut, 4W0107 bolt, 5W1086 washer, AS61914 or TA025074-16 clip and 5W1029 spacer. Install replacement AS62516 clip and AS62504 clip on EEC harness, install AS62504 clip, AS21434 bolt, 6A4825 spacer, 5R8121 tube, 5W1029 spacer, AS62516 clip, 5W1086 washer and 4W0001 nut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 6.

(6) At existing Clipping Point 0795 install AS62516 clip to 2A0615 tube, install new 400WSS16 clip to 5R8121 tube, AS20921 bolt, AN960XC10L or 5W1086 washer, new 400WSS16 clip, UP10481 spacer, AS62516 clip, 5W8331 bracket and 4W0043 nut clip. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 8.

(7) Secure 6A6002 fuel tube at existing Clipping Point 1069. Install AS62404 clip to 6A6002 tube, install new 400WSS6 clip to 2A0654 tube, install AS61906 or TA025074-08 clip to the EEC harness lead, install 4W0119 bolt, 5W1086 washer through AS62404 clip on 6A6002 tube, new 400WSS6 clip on 2A0654 tube UP10482 spacer, AS61906 clip on EEC harness lead, 5W1086 washer and 4W0001 nut. Torque the nut to 36 to 45 lbfin. (4 to 5 Nm). Refer to Figures 3 and 11.

(8) Secure 6A5306 and 6A6002 fuel tubes at new Clipping Point 1158. Install AS62404 clips to 6A5306 and 6A6002 tubes, install AS20908 bolt, 5W1086 washer through AS62404 clip on 6A5306 tube, 6A3125 bracket, AS62404 clip on 6A6002 tube and 4W0001 nut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 17.

(9) Secure 6A3125 bracket fo fan case flange using AS21011 bolt (2 off), LK74669 washer (2 off) and 4W0002 nut (2 off). Torque the nuts to 85 to 105 lbfin (10 to 12 Nm). Refer to Figures 3, 15, 16 and 17.

(10) Secure 6A5306 and 6A6002 fuel tubes at new Clipping Point 1159. Install AS62404 clips to 6A5306 and 6A6002 tubes, install AS20908 bolt, 5W1086 washer through AS62404 clip on 6A5306 tube, 6A3125 bracket, AS62404 clip on 6A6002 tube and 4W0001 nut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 17.

(11) Remove 4W0164 bolt (2 off) and 4W0002 nut from flange 'FE' bolt holes 67 and 68. Refer to Figures 15, 16 and 17.

(12) Secure 6A3125 bracket to fan case flange using AS21013 bolt (2 off), LK74669 washer (4 off) and 4W0002 nut (2 off). Torque the nuts to 85 to 105 lbfin (10 to 12 Nm). Refer to Figures 3, 15, 16 and 17.

(13) Secure 6A5306 and 6A6002 fuel tubes at existing Clipping Point 1050. Install AS62404 clips to 6A5306 and 6A6002 tubes, install AS20908 bolt through 740-5727-513 tube clip, AS62404 clip on 6A6002 tube, AS62404 clip on 6A5306 tube, 5W1086 washer and 4W0001 nut. Torque the nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 10.

(14) Secure 6A5306 and 6A6002 fuel tubes at new Clipping Point 1139. Install AS62404 clips to 6A5306 and 6A6002 tubes, install AS20907 bolt, 5W1086 washer through AS62404 clip on 6A6002 tube AS62404 clip on 6A5306 tube, 6A4584 bracket and 4W0043 clip nut. Torque the clip nut to 36 to 45 lbfin (4 to 5 Nm). Refer to Figures 3 and 14.

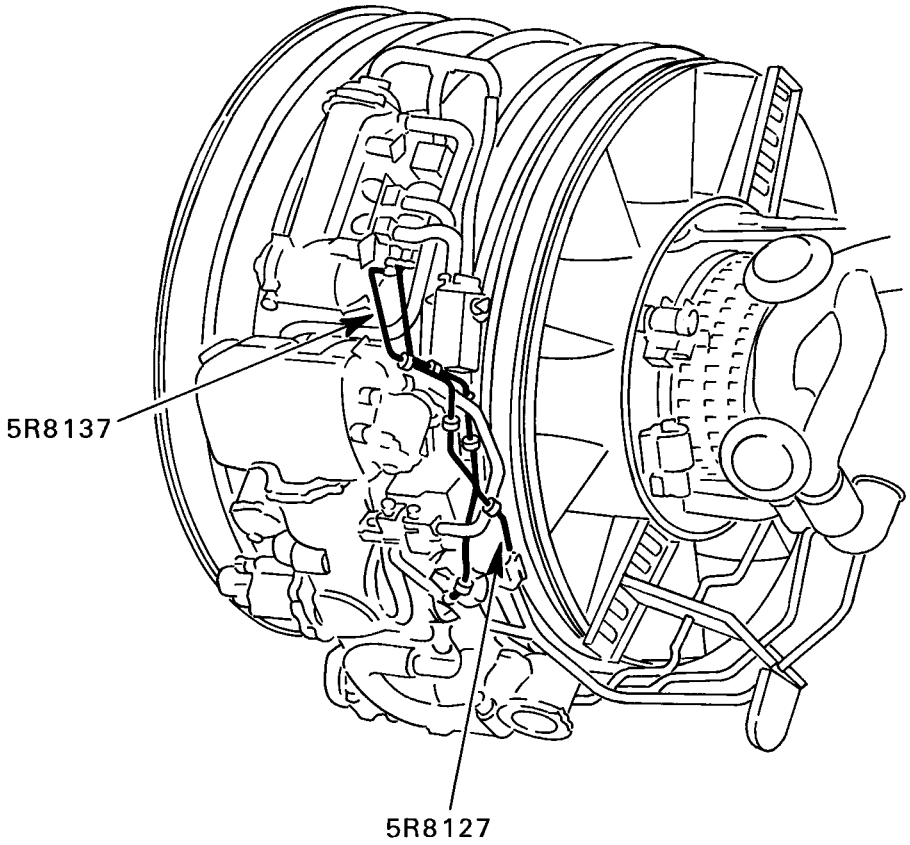
(15) Remove 4W0168 bolt (2 off) from FC0C. Refer to Figure 14.

(16) Secure 6A4584 bracket to FC0C using AS21021 bolt (2 off) and LK74669 washer (2 off). Torque the bolts to 85 to 105 lbfin (10 to 12 Nm). Refer to Figures 3 and 14.

R E. Deleted

F. Recording Instructions

(1) A record of accomplishment is necessary.



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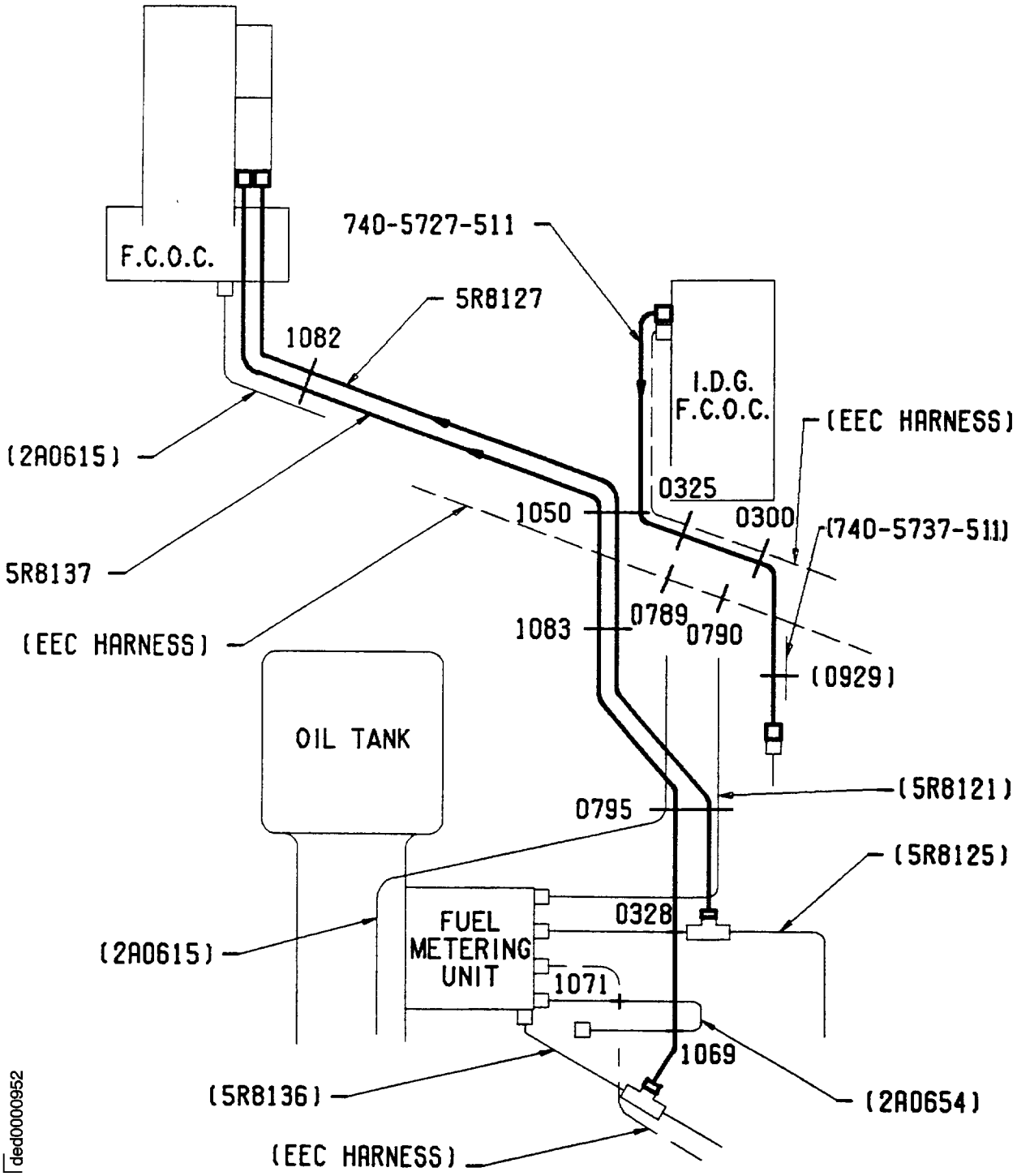
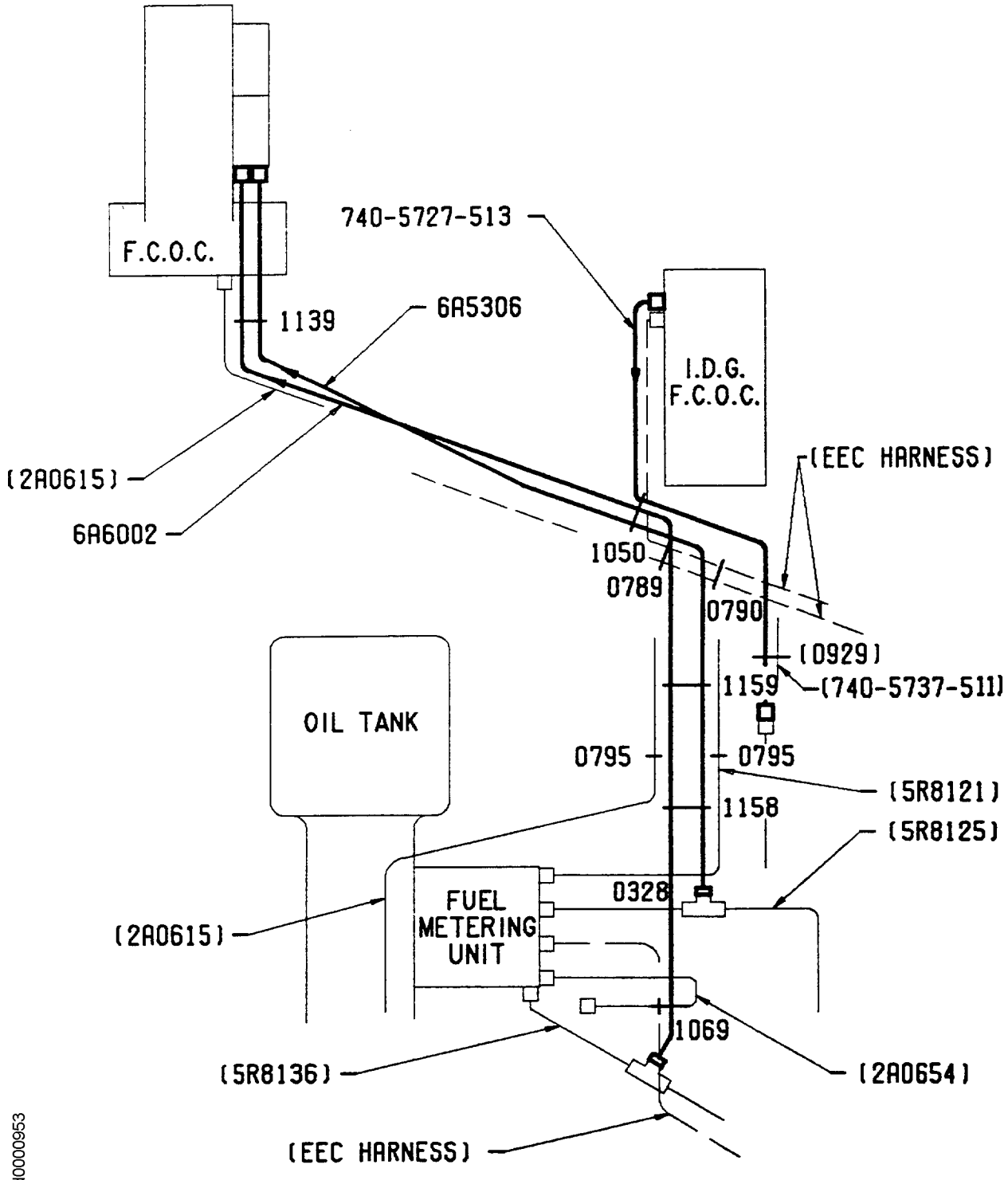
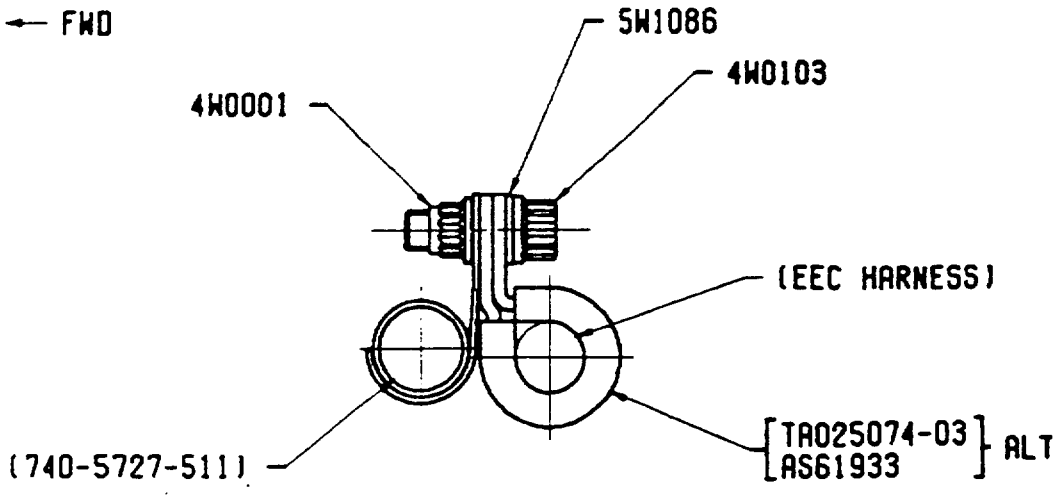
Location of servo fuel tubes - Before alteration
Figure 1



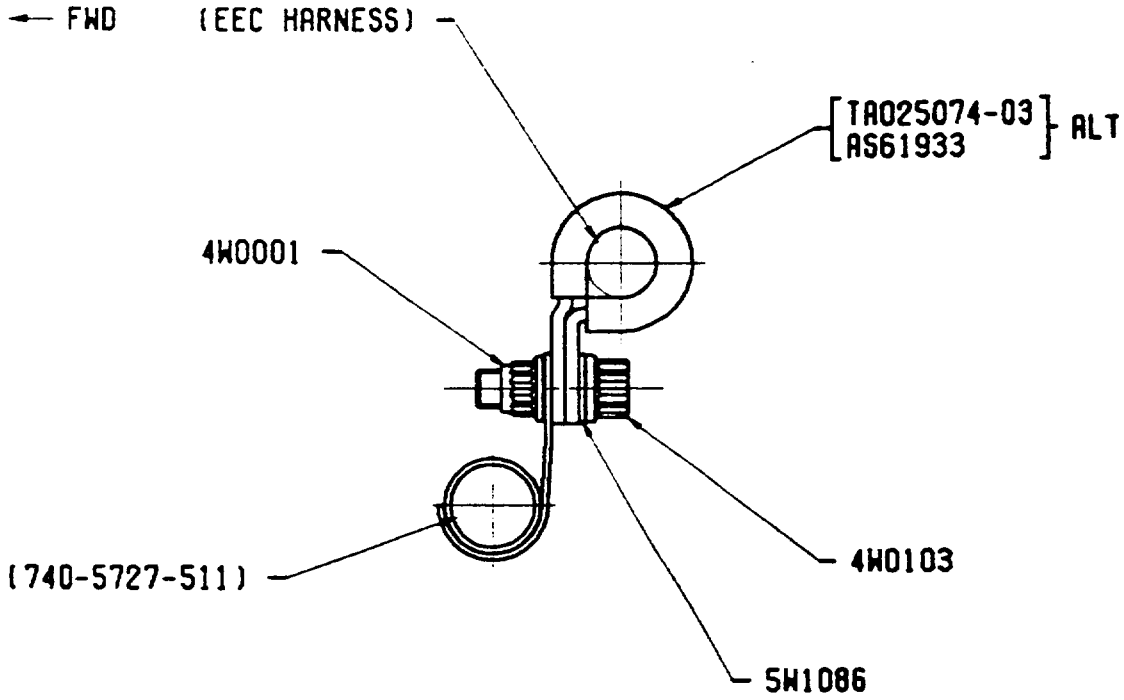
Schematic view of servo fuel tubes showing clipping point arrangement - Before alteration
Figure 2



Schematic view of servo fuel tubes showing clipping point arrangement - After alteration
Figure 3

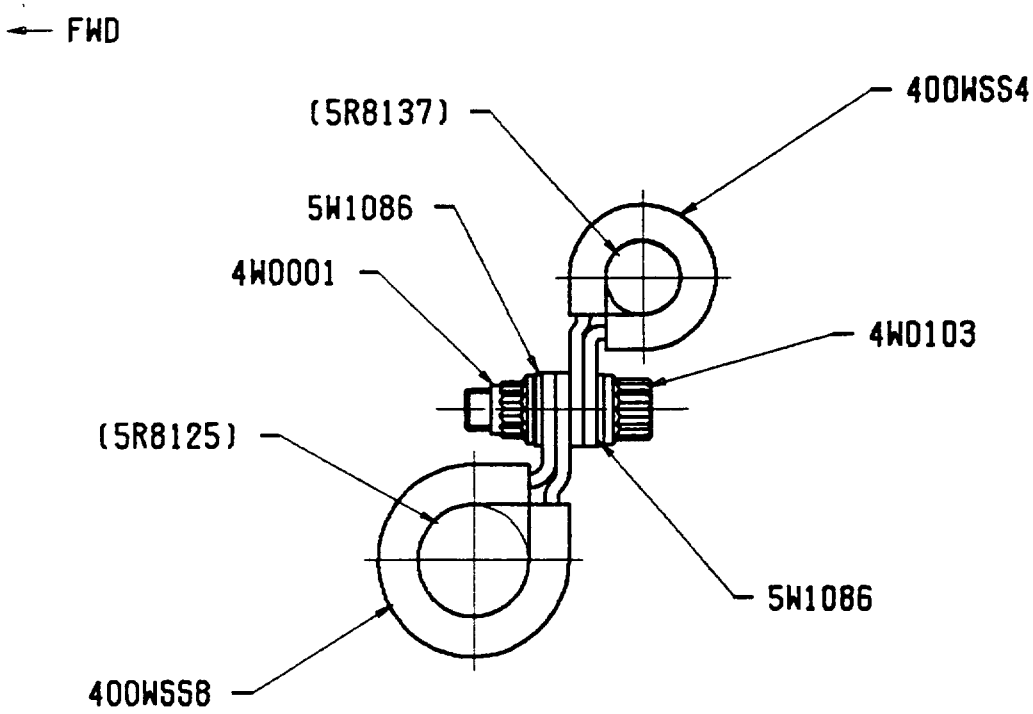


CLIPPING POINT 0300 - DELETED



CLIPPING POINT 0325 - DELETED

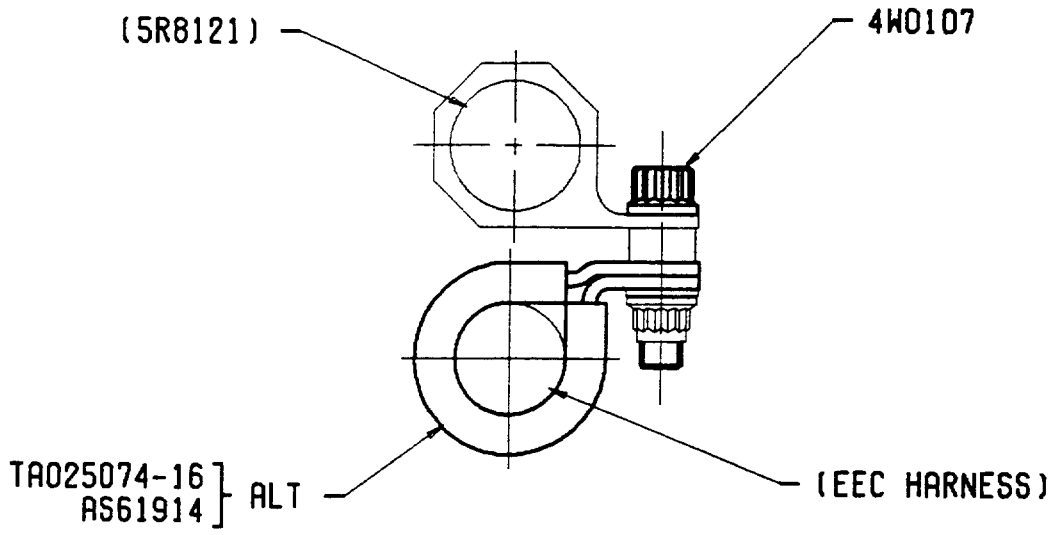
Servo tube clipping details
Figure 4



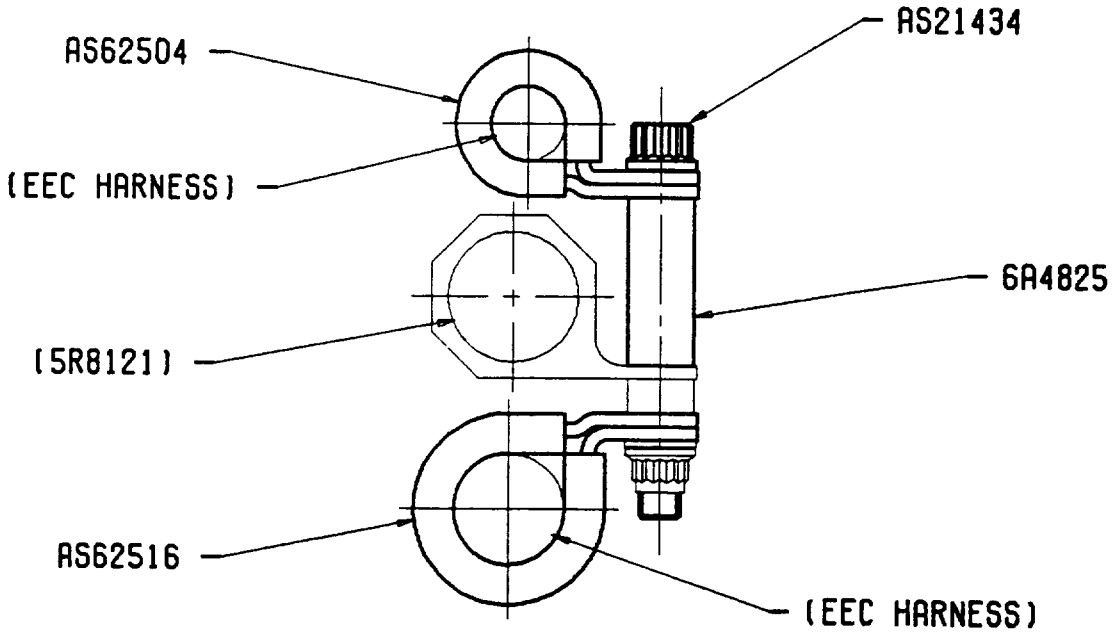
CLIPPING POINT 0328 - DELETED

ded0000955

Servo tube clipping details
Figure 5



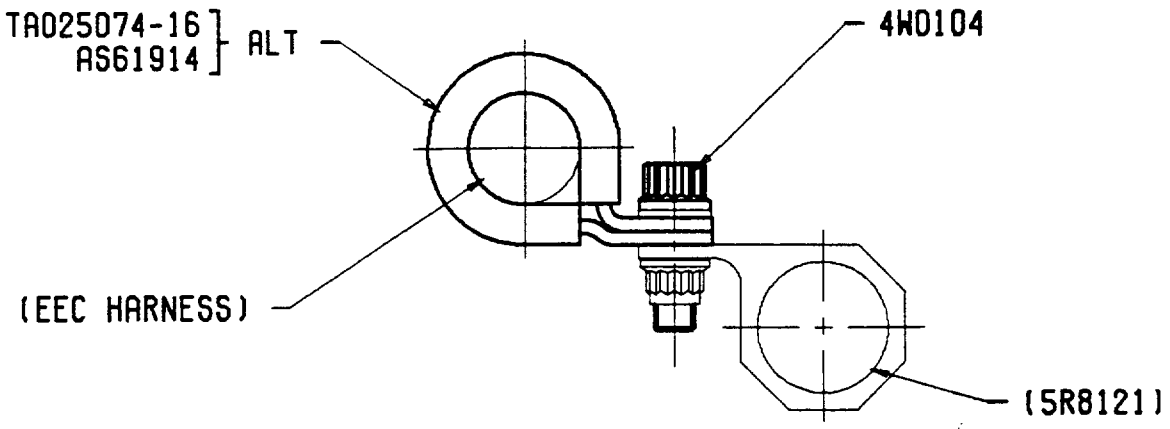
CLIPPING POINT 0789
BEFORE ALTERATION



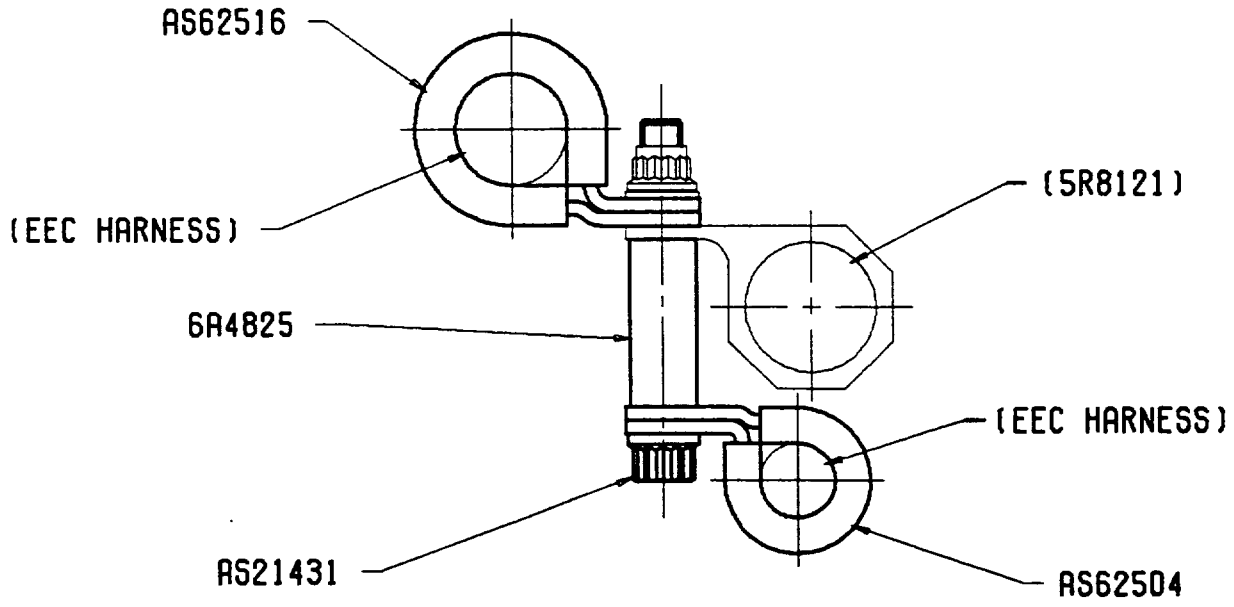
CLIPPING POINT 0789
AFTER ALTERATION

ded0000959

Servo tube clipping details
Figure 6



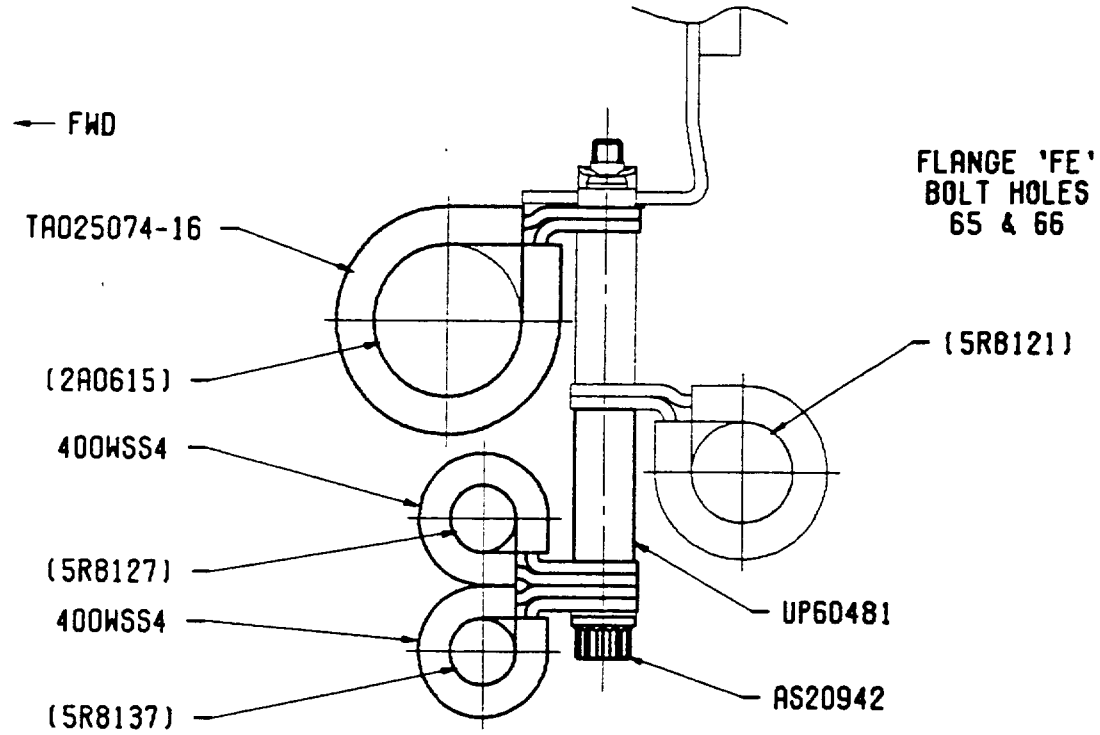
CLIPPING POINT 0790
BEFORE ALTERATION



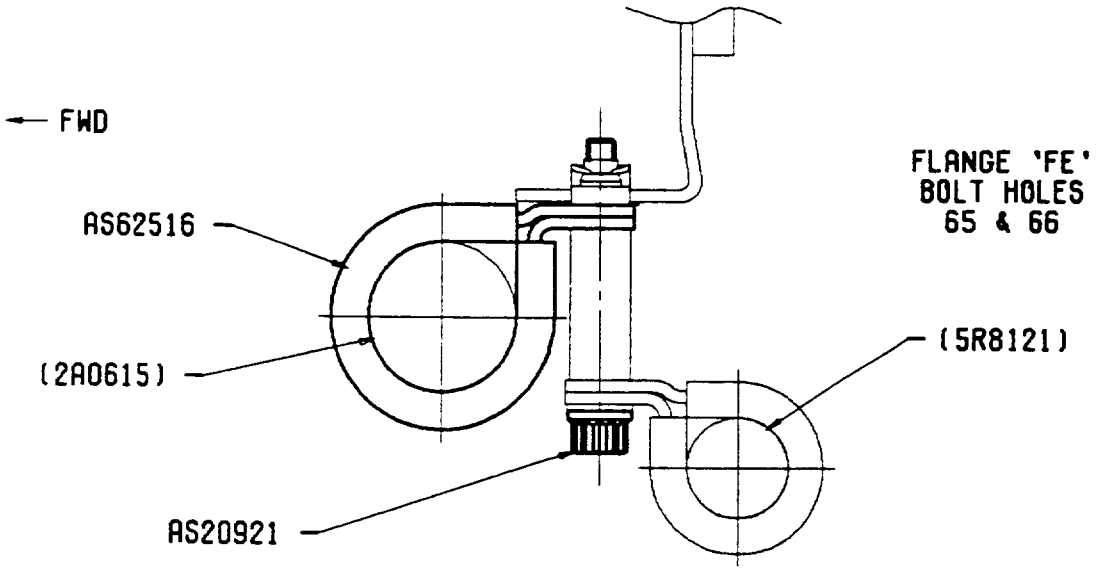
ded0000957

CLIPPING POINT 0790
AFTER ALTERATION

Servo tube clipping details
Figure 7



CLIPPING POINT 0795
BEFORE ALTERATION



CLIPPING POINT 0795
AFTER ALTERATION

Servo tube clipping details
Figure 8

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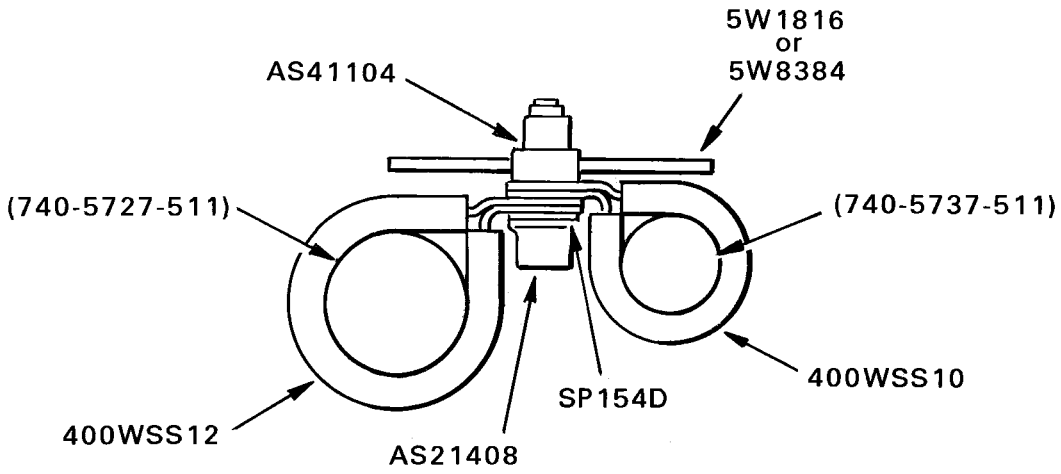
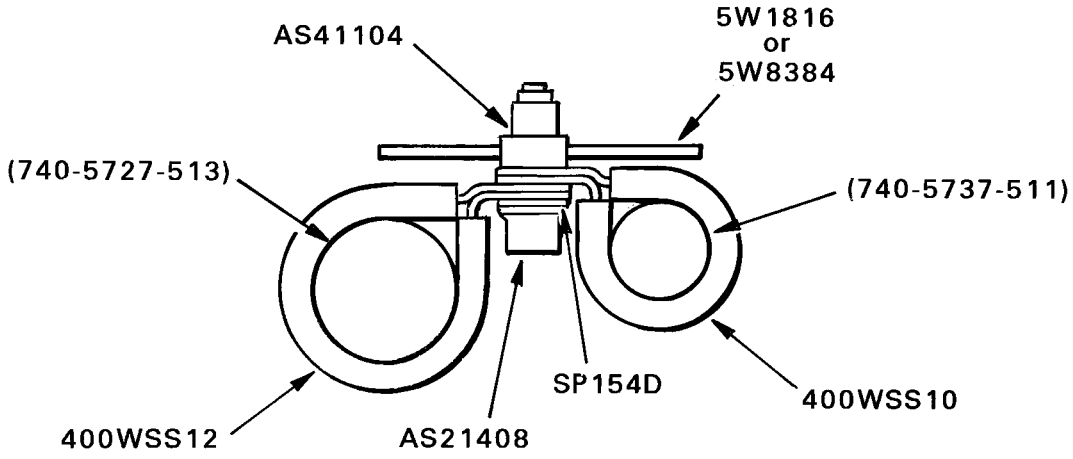


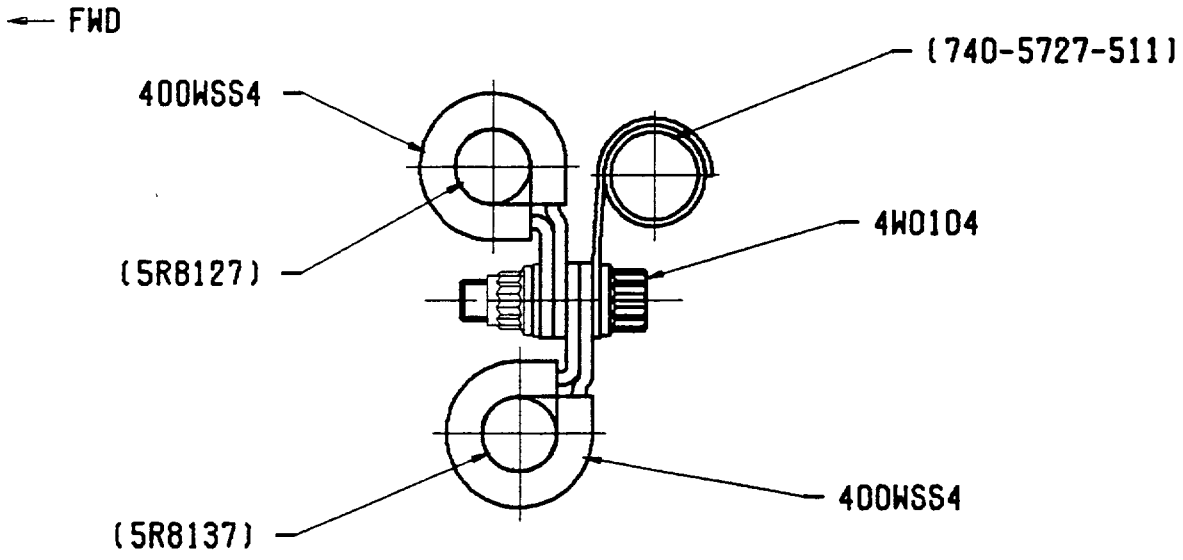
CLIPPING POINT 0929
BEFORE ALTERATION



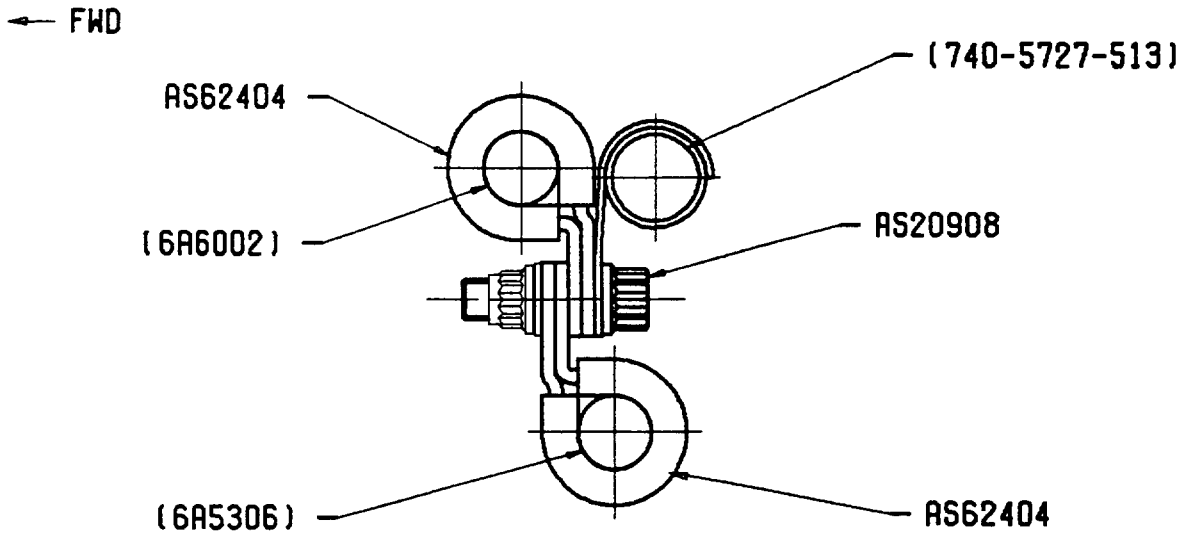
CLIPPING POINT 0929
AFTER ALTERATION

B3995

Servo tube clipping details
Figure 9

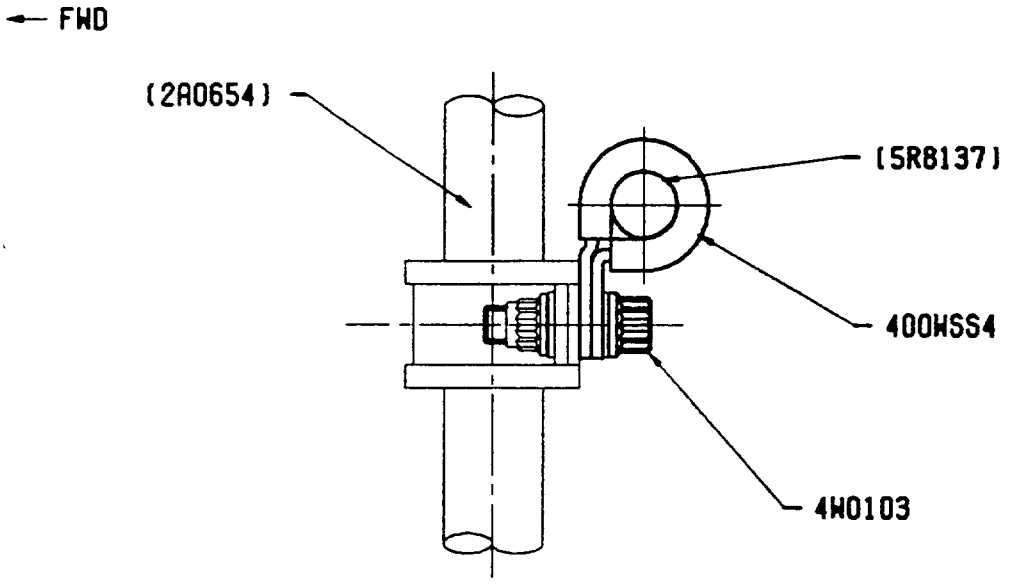


CLIPPING POINT 1050
BEFORE ALTERATION

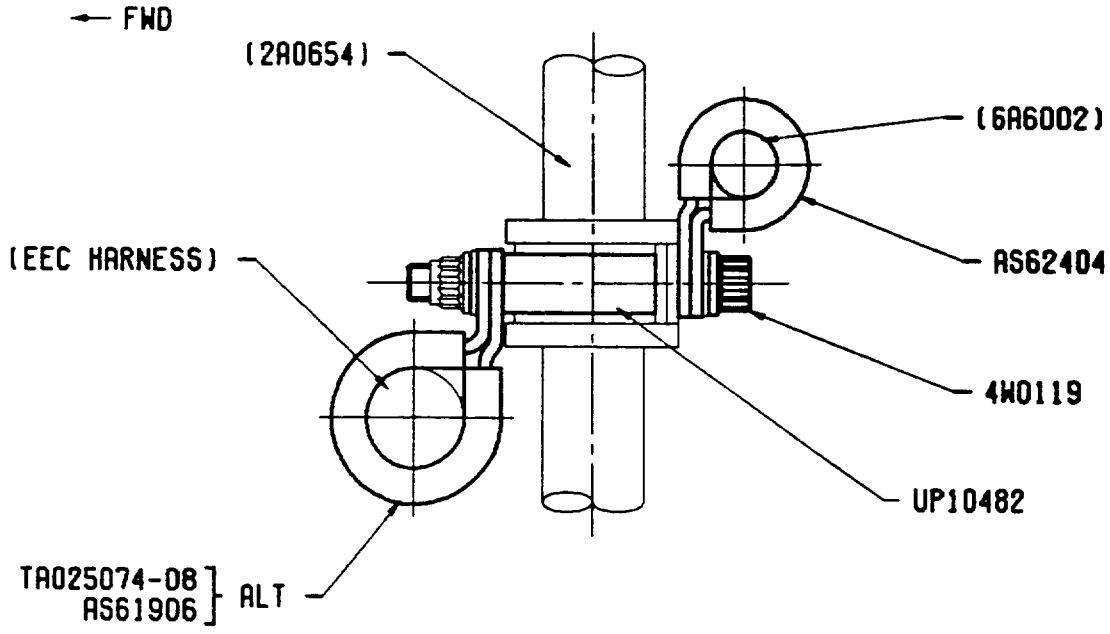


CLIPPING POINT 1050
AFTER ALTERATION

Servo tube clipping details
Figure 10



CLIPPING POINT 1069
BEFORE ALTERATION



CLIPPING POINT 1069
AFTER ALTERATION

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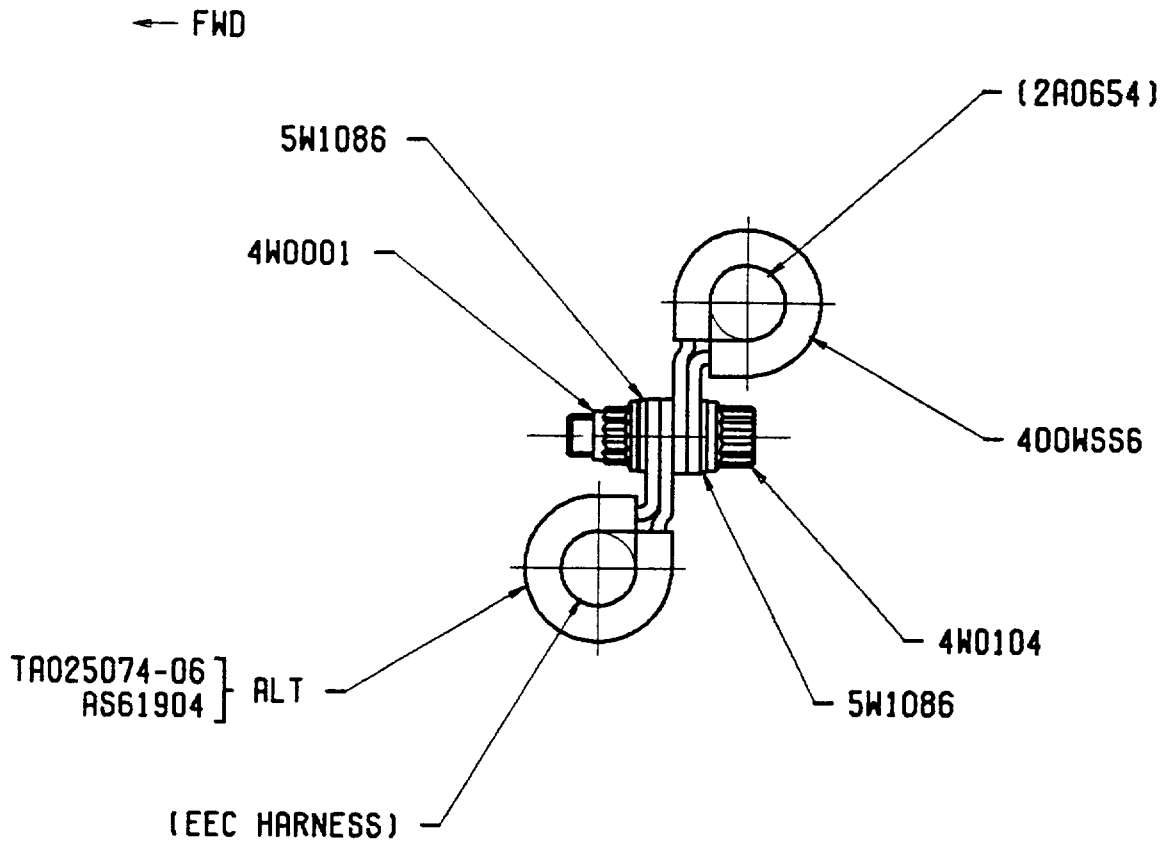
Servo tube clipping details
Figure 11



CLIPPING POINT 1071 - DELETED

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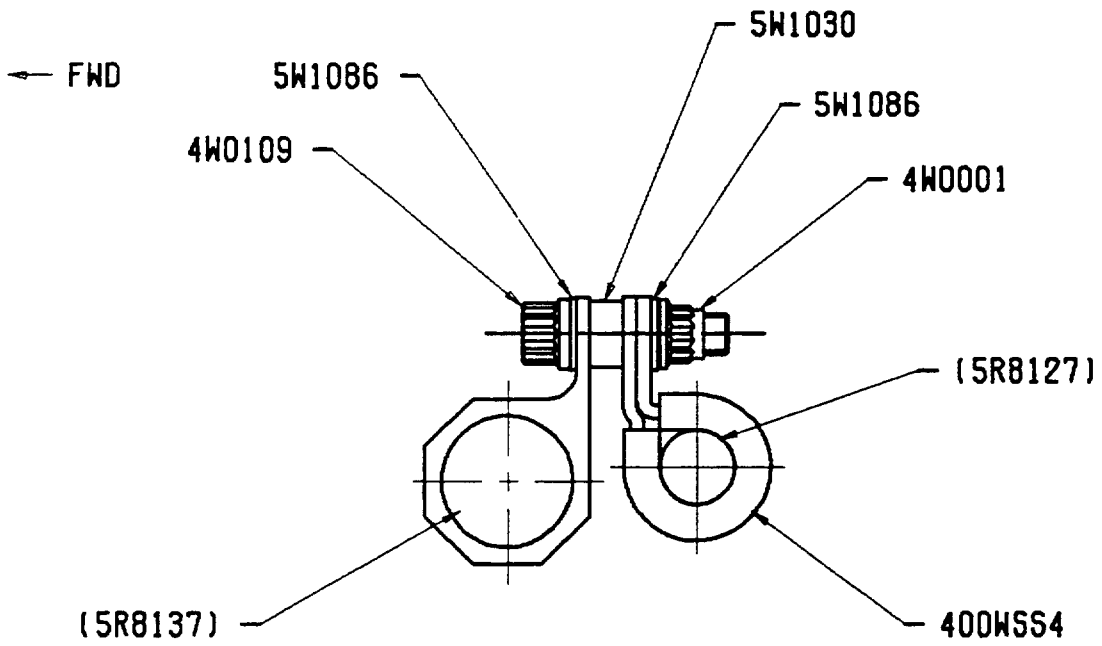
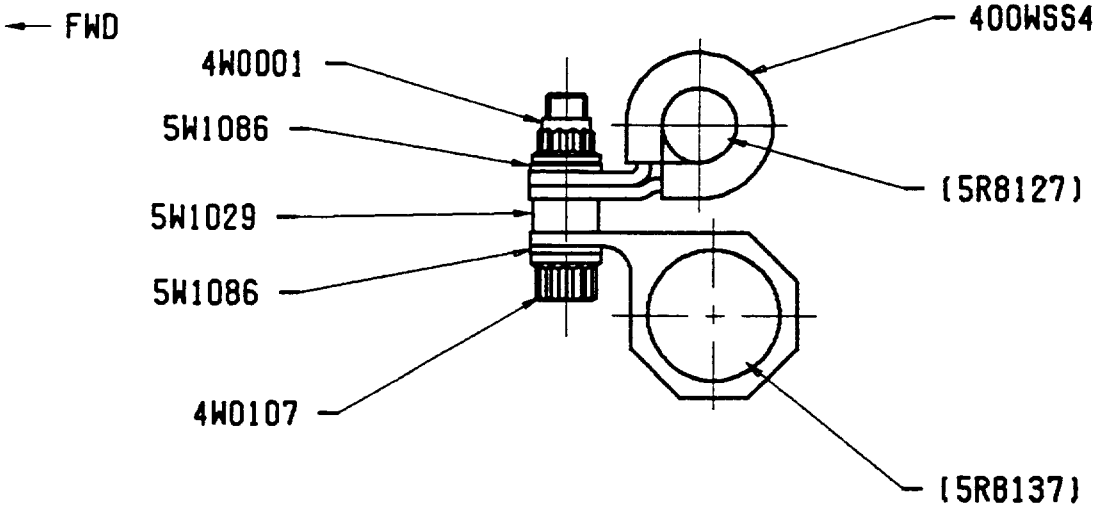
Servo tube clipping details
Figure 12



CLIPPING POINT 1082 - DELETED



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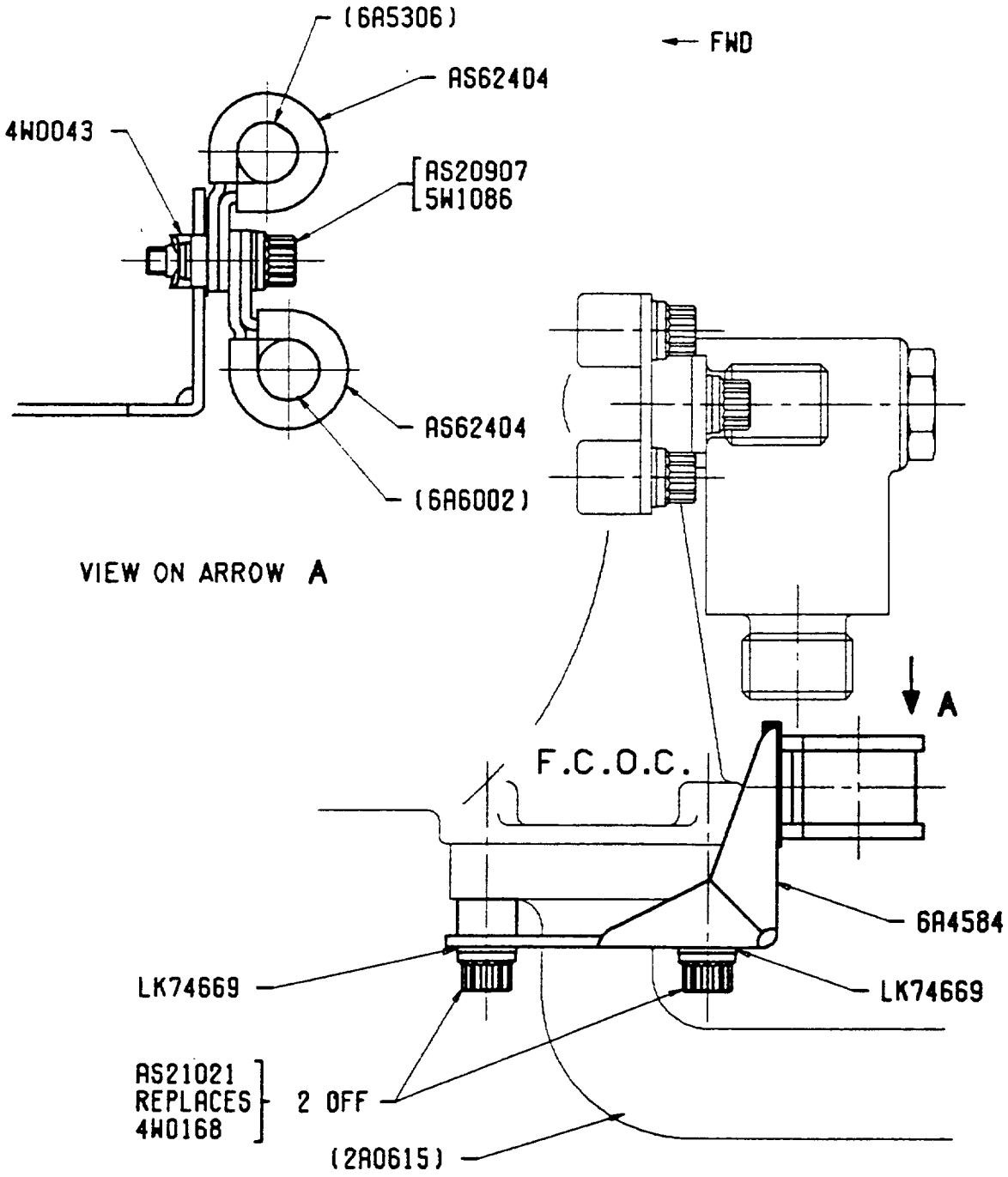
CLIPPING POINT 1083 - DELETED

Servo tube clipping details
Figure 13



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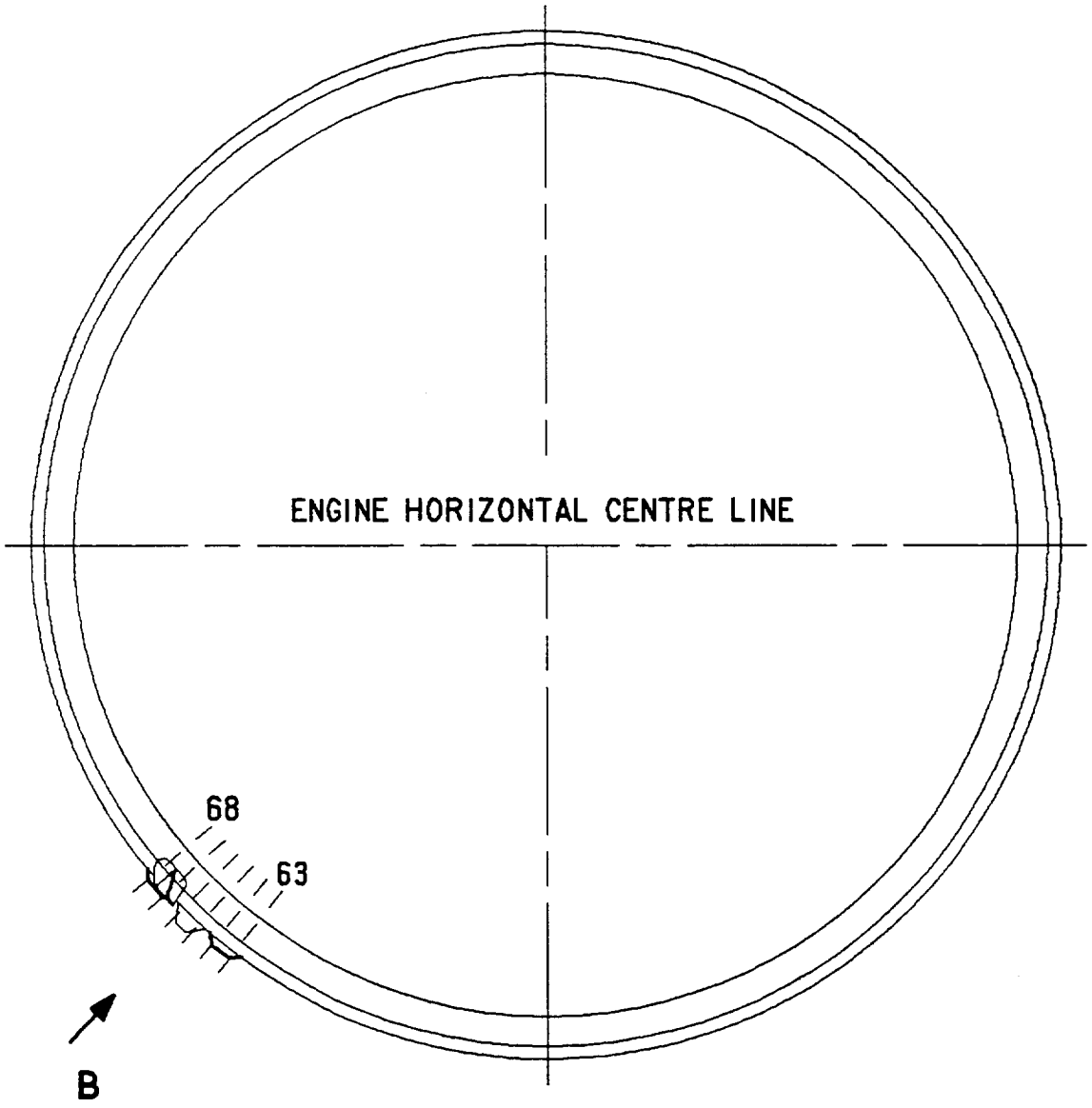
VIEW ON FUEL COOLED OIL COOLER
SHOWING CLIPPING POINT 1139 - ADDITIONAL

Servo tube clipping details
Figure 14



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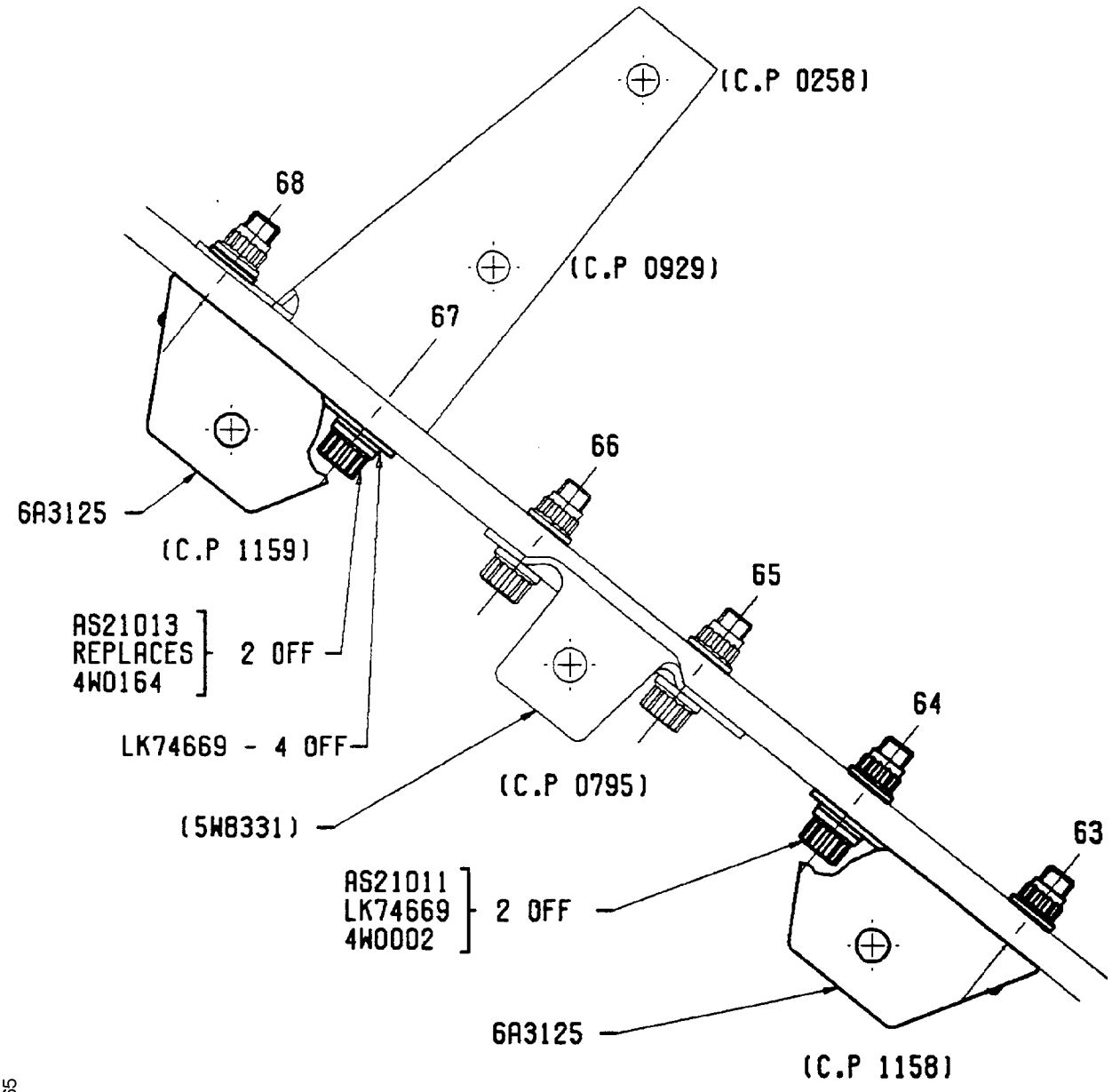
Diagrammatic view on flange 'FE' looking forward
showing position of Clipping Points 0795, 1158 and 1159
Figure 15



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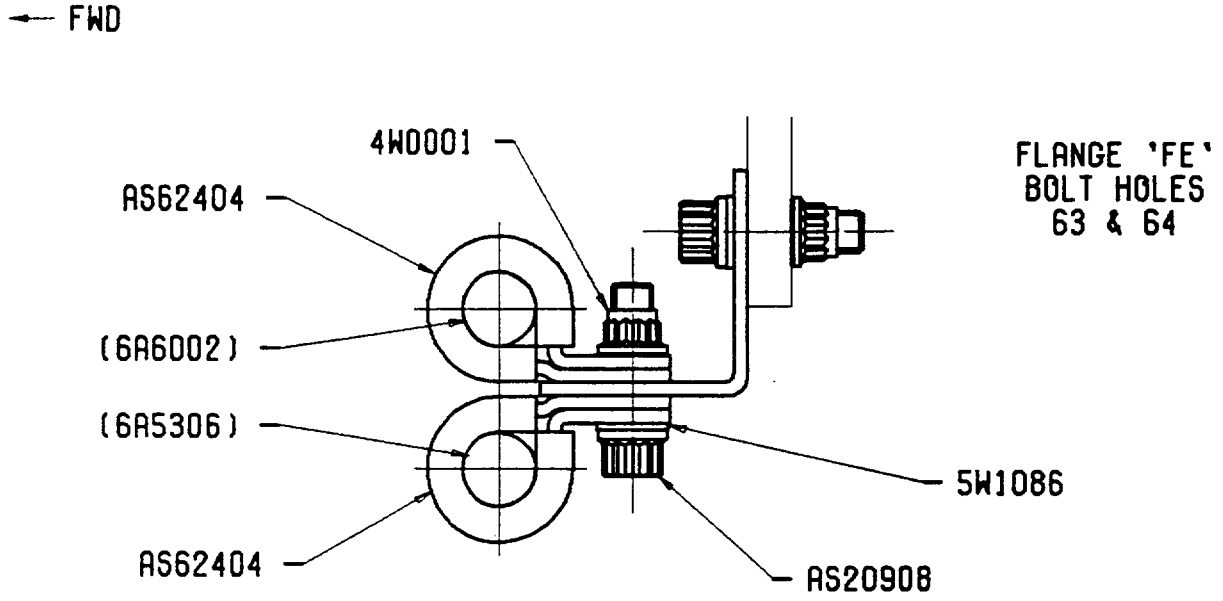
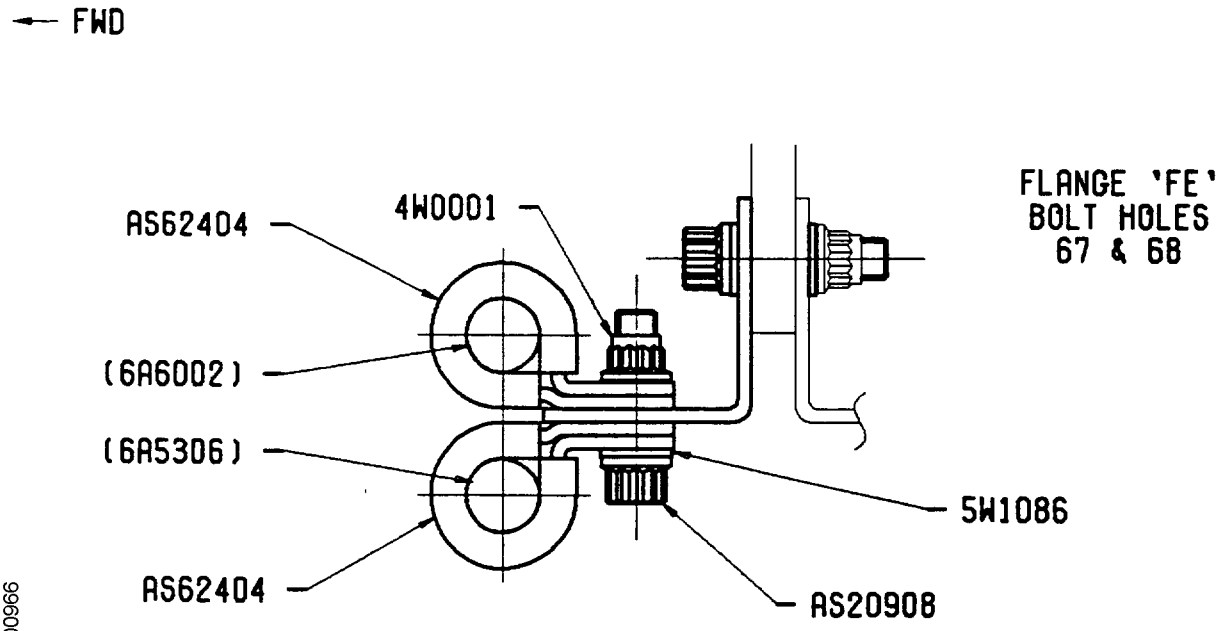
View on arrow B showing bracket information
Figure 16



CLIPPING POINT 1158 -ADDITIONAL



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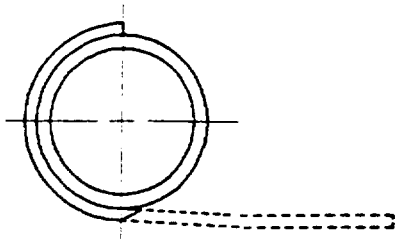
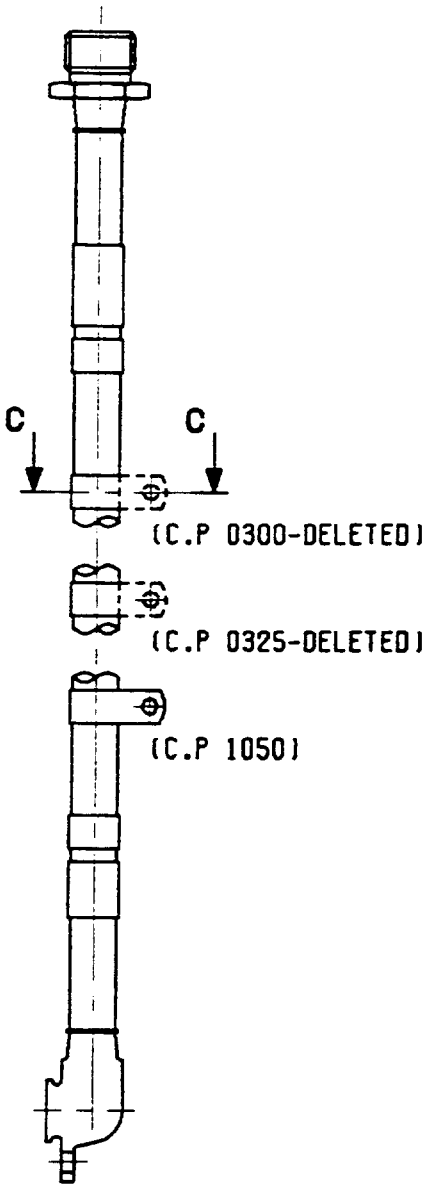
CLIPPING POINT 1159 -ADDITIONAL

Servo tube clipping details
Figure 17



ENLARGED SECTION **CC** SHOWING
EXISTING LUG CUT BACK FLUSH WITH TUBE.
TYPICAL 2 POSITIONS



NOTES
BREAK SHARP EDGES .012 ± .008 (0.30 ± 0.20)
DIMENSIONS ARE IN INCHES (MILLIMETRES).
CARE MUST BE TAKEN TO AVOID DAMAGE TO TUBE.

REWORK OF EXISTING I.D.G. COOLING TUBE ASSEMBLIES.
SHOWING POSITION OF DELETED LUGS

ded0000967

Rework of exisating IDG cooling tube assemblies
showing position of deleted lugs
Figure 18