



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

DATE: Apr.15/04

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

V2500-A1 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 2 to Service Bulletin EV2500-73-0103 and Revision 2 to the Supplement

Document History

Service Bulletin Revision Status	
Initial Issue	Jun.13/97
Revision 1	Oct.24/97

Supplement Revision Status	
Initial Issue	Jun.13/97
Revision 1	Oct.24/97

Bulletin Revision 2

Remove
All pages of the
Service Bulletin

Incorporate
Pages 1 to 8 of the
Service Bulletin

Reason for change
Supplemental Information,
References and Parts Prices
revised.

Supplement Revision 2

Remove
All pages

Incorporate
Page 1

Reason for change
Supplemental Information,
References and Parts Prices
revised.

V2500-ENG-73-0103

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 following incorporation of Revision 2 to the Bulletin and Revision 2 to the Supplement are as follows:

<u>Page</u>		<u>Revision Number</u>	<u>Revision Date</u>
Bulletin			
R	1	2	Apr.15/04
R	2	2	Apr.15/04
R	3	2	Apr.15/04
R	4	2	Apr.15/04
R	5	2	Apr.15/04
R	6	2	Apr.15/04
R	7	2	Apr.15/04
R	8	2	Apr.15/04
Supplement			
R	1	2	Apr.15/04

Printed in Great Britain



ENGINE FUEL AND CONTROL – FUEL SYSTEM TUBES – INTRODUCTION OF REVISED CLIPPING FOR
THE HP SERVO EXTERNAL FUEL TUBE ASSEMBLY

1. Planning Information

A. Effectivity

- (1) Airbus A320

V2500-A1 Engines prior to Serial No. V0362

B. Concurrent Requirements

None.

C. Reason

- (1) Condition

Fretting of the HP servo external fuel tube assembly can occur, and in extreme cases, result in perforation of the tube.

The problem is attributed to clip point 5747 become loose and migrating towards the bend in the HP servo external fuel tube assembly.

- (2) Background

The problem has been observed on service engines.

- (3) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis and successful trial installation on a V2500 mock-up engine.

- (4) Objective

Incorporation of the changes introduced by this Service Bulletin is designed to maintain reliability.

- (5) Effect of Bulletin on:

- (a) Removal/Installation

Affected.

- (b) Disassembly/Assembly

Not affected.



(c) Cleaning

Not affected.

(d) Inspection/Check

Not affected.

(e) Repair

Not affected.

(f) Testing

Not affected.

R (6) Supplemental Information

R This Service Bulletin only applies to engines which incorporate Service
R Bulletin V2500-ENG-72-0132 (See 1.N. References).

D. Description

The changes introduced are:

(1) In order to provide improved gripping characteristics, Adel 400WSS range of clips have been replaced with AS62400 range of clips at the following points:

CP 5701, 5747 and 6058

(2) The quantity of washers at clip point 6058 has been reduced from 2 off to 1 off.

(3) The opportunity has been taken to optimise the attaching bolt length at clip point 5701.

E. Compliance

Category Code 4

Accomplish at the first visit of an engine or module to a maintenance base capable of compliance with the accomplishment instructions regardless of the planned maintenance action or the reason for engine removal.

F. Approval

The part number changes and/or part modification 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 model listed.



G. Manpower

In service

Not applicable.

At overhaul

15 minutes

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

- R (1) IAE V2500 Service Bulletin:
- R ENG-72-0132
- R Engine - LP Compressor - Removal of 6th Stage Buffer Air System.
- (2) Engineering Change No. - 96VR041.
- (3) ATA Locator - 73-11-49.

O. Other Publications Affected

- (1) The V2500-A1 Illustrated Parts Catalogue (IPC) Chapter/Section 73-11-49.
- (2) The V2500-A1 Engine Manual (EM) Chapter/Section, 72-00-40,
Installation-09, PB 401.



2. Material Information

A. Kits associated with this bulletin:

None.

B. Parts affected by this Service Bulletin:

Applicability: For each V2500-A1 engine to incorporate this bulletin
73-11-49

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
12149	4W0105	1	Bolt, machine double hex CP5701 (.190 dia x .625)	4W0107	(A)(B) (C)(S1)
12152	AS62406	1	Clip CP5701 (9,52 mm (0.375))	400WSS6	(A)(B) (C)(S1)
12168	AS62406	1	Clip CP5747 (9,52 mm (0.375))	400WSS6	(A)(B) (C)(S1)
12174	-	1	Washer CP6058	K8831	(A)(1D)
12176	AS62406	1	Clip CP6058 (9,52 mm (0.375))	400WSS6	(A)(B) (C)(S1)
16168	AS62405	1	Clip CP5747 (7,92 mm (0.312))	400WSS5	(A)(B) (C)(S1)

C. Instruction Disposition Codes:

(A) New part is currently available.

(B) Old part will be discontinued.

(C) Old part may be used up on other applications.

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

(1D) Quantity reduced from 2 off to 1 off.



3. Accomplishment Instructions

A. Rework Instructions

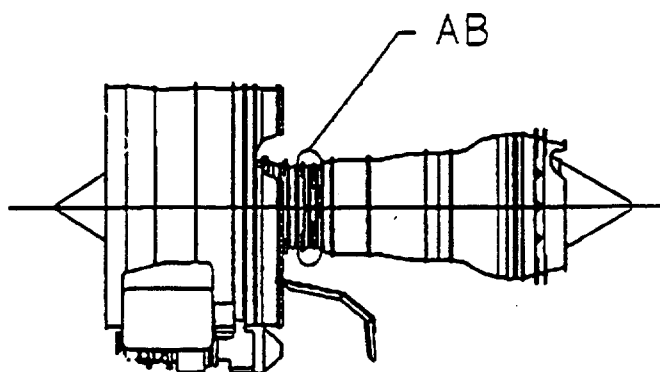
None.

B. Assembly Instructions

For the correct removal/installation procedures refer to the V2500 Engine Manual (EM) Chapter/Section 72-00-40, PB 401.

C. Recording Instructions

A record of accomplishment is necessary.



ded0002212

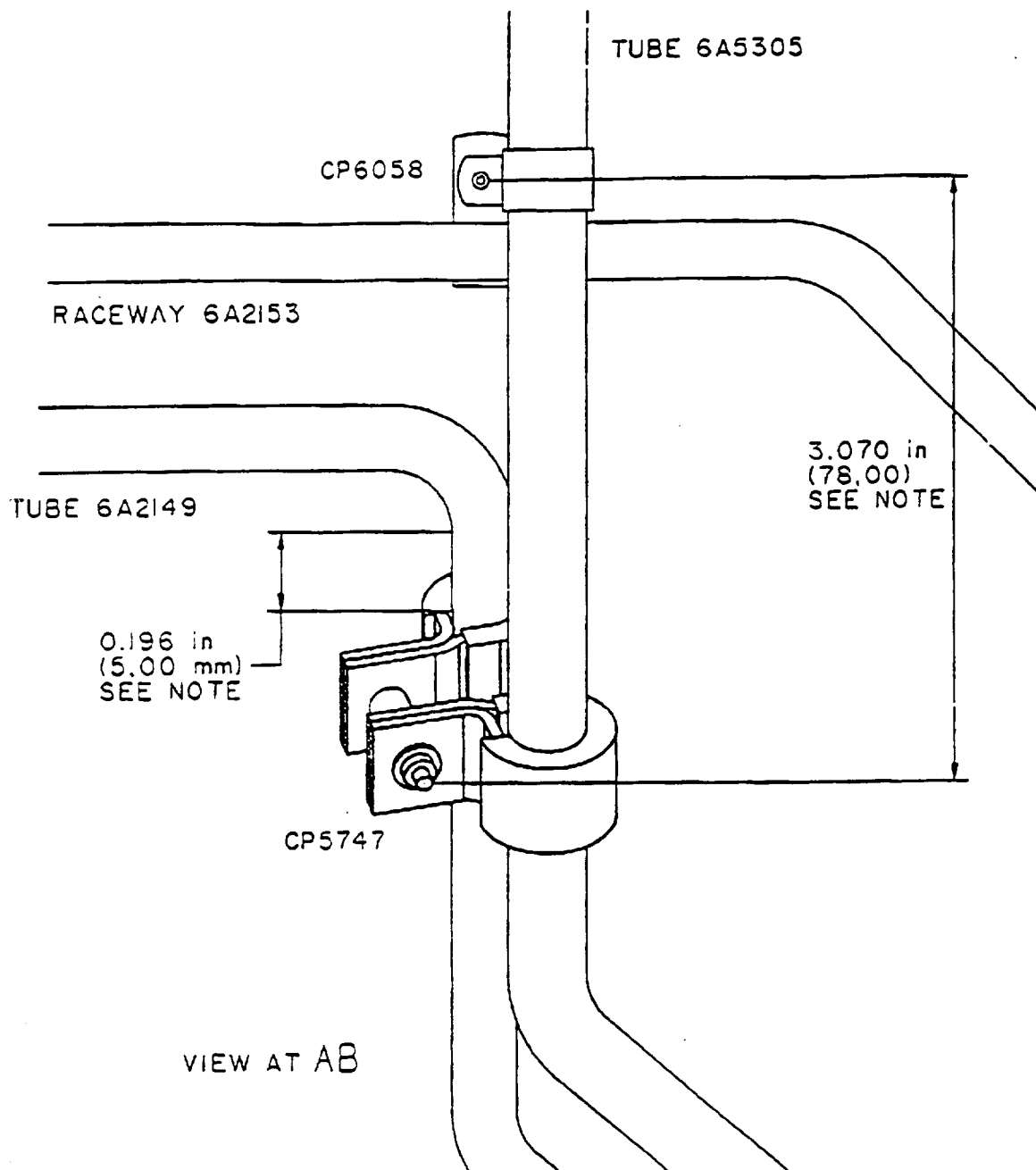
General View
Figure 1

Jun.13/97
R Apr.15/04

V2500-ENG-73-0103
Page 7

© Rolls-Royce plc

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



SHOULD ADVERSE BUILD TOLERANCES PREVENT THE 3.070 in (78.00 MM) DIMENSION BEING ACHIEVED ASSEMBLE TO 0.196 in (5.00 MM) ON TUBE 6A2I49

View at AB
Figure 2

V2500-ENG-73-0103



ENGINE FUEL AND CONTROL – FUEL SYSTEM TUBES – INTRODUCTION OF REVISED CLIPPING FOR
THE HP SERVO EXTERNAL FUEL TUBE ASSEMBLY

SUPPLEMENT – 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. Parts required:

	Part No.	Description	Unit Price US Dollars
R	4W0105	Bolt	6.61
R	AS62405	Clip	30.50
R	AS62406	Clip	31.90

