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V2500-A5 PROPULSION SYSTEM SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-75-0037

Document History

Service Bulletin Revision Status
 Initial Issue Oct.24/01

Supplement Revision Status

Bulletin Revision 1

Remove
 All pages of the
 Service Bulletin

Incorporate
 Pages 1 to 7 of the
 Service Bulletin

Reason for change
 To revise engine
 incorporation

V2500-ENG-75-0037

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

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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin following incorporation of Revision 1 are as follows:

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R	6	1	Mar.27/02
R	7	1	Mar.27/02

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AIR TURBINE COOLING CONTROLLED AIR TUBES – REVISED STAGE 10 MAKE-UP AIR ADAPTOR
MOUNTED CLIPPING BRACKET

1. Planning Information

A. Effectivity

(1) Airbus A319

R V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No. V11425.

(2) Airbus A320

R V2527-A5, V2527E-A5 Engines prior to Serial No. V11425.

(3) Airbus A321

R V2530-A5, V2533-A5 Engines prior to Serial No. V11425.

(4) ATA Locator 75-23-48

B. Concurrent Requirements

None

C. Reason

(1) Condition

Insufficient clearance may exist between the HP Compressor stage 10 make-up air adaptor and the clipping bracket located on the adaptor face.

(2) Background

The problem has been encountered during engine assembly.

(3) Objective

Incorporation of the changes introduced by this Service Bulletin (Modification) is designed to ease engine build.

(4) Substantiation

The changes introduced by this Service Bulletin have been the subject of satisfactory engineering analysis and successful stress assessment.

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(5) Effect of Bulletin on:

(a) Operation

Not affected

(b) Maintenance

Affected

(c) Overhaul

Affected

(d) Repair Schemes

Not affected.

(e) Interchangeability

Not affected.

(f) Fits and Clearances

Not affected.

D. Description

The changes introduced are:

(1) A revised bracket which is similar to the existing bracket except for the following:

(a) The portion which seats on the face of the make-up air adaptor, has been re-profiled such that clearance is maintained under all tolerance conditions.

(b) A small change in profile has been made to the vertical portion of the bracket to blend it into the new base.

(c) The opportunity has been taken to optimise the length of bolt which attaches the bracket and the make-up air adaptor.

E. Compliance

Category Code 6.

Accomplish when the sub assembly (i.e. modules, accessories, components, build groups) is disassembled sufficiently to afford access to the affected part and to all affected spare parts.



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

(1) In service

Not applicable

(2) At overhaul

Not affected

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 2. Material Information

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

- (1) Internal reference 01VR012
- (2) Engine Manual 72-00-40:
 - (a) Removal 04 and Installation 07
 - (b) Removal 15 and Installation 15
- (3) Aircraft Maintenance Manual, 75-23-51, Removal/Installation

O. Other Publications Affected

- (1) Illustrated Parts Catalogue, (IPC) 2IA, 2IB, 5IA, 5IB, 6IA, 6IB, 7IA, 7IB, 75-23-48, will be revised.
- (2) Engine Manual 72-00-40:
 - (a) Removal 04 and Installation 07
 - (b) Removal 15 and Installation 15
- (3) Aircraft Maintenance Manual, 75-23-51, Removal/Installation
- (4) Component Maintenance Manual, 75-23-48, Cleaning, Inspection, Repairs

P. Interchangeability of Parts

Not affected



2. Material Information

A. New production parts:

PART NO.	QTY	UNIT PRICE US DOLLARS
6A7831	1	55.70
4W0227	1	11.30

NOTE: The unit prices, if shown, are an estimate and they are given for the purpose of planning only. For actual prices, refer to the IAE Price Catalogue or contact IAE's spare parts sales department.

B. The kit required consists of the parts that follow:

All Engines

75-23-48

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
04390	6A7831	1	.Bracket	-	6A7620	(A)(S1)
04410	4W0227	4	.Bolt, bihex head (0.3125in.dia x 0.875in.)	-	4W0226	(B)(S1) (1D)

C. Instructions disposition codes:

(A) Part will be made available from November 2001.

(B) New part is currently available.

(S1) New part may be used in place of old part, but not vice versa.

(1D) Old part may be used up on other applications.



3. Accomplishment Instructions

A. Rework Instructions

None

B. Assembly Instructions

The revised stage 10 make-up air adaptor mounted clipping bracket introduced by this Service Bulletin is interchangeable. Remove and install in accordance with current overhaul procedures and maintenance practices (Engine Manual, 72-00-40, Removal 04, Installation 07 and Removal 15, Installation 15. Aircraft Maintenance Manual, 75-23-51, Removal/Installation).

C. Recording Instructions

A record of accomplishment is required.



V2500-ENG-75-0081

Deletion of the HPC stage 10 make-up air valve and associated hardware.

6A7620



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Revised stage 10 make-up air adaptor bracket.

6A7831

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V2500-A5 family tree
Fig 1

