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V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits Revision 1 to Service Bulletin EV2500-75-0047 and Revision 1 to the Supplement

Document History

Service Bulletin Revision Status
Initial Issue Jan.21/03

Supplement Revision Status
Initial Issue Jan.21/03

Bulletin Revision 1

Remove
All pages of the
Service Bulletin

Incorporate
Pages 1 to 8 of the
Service Bulletin

Reason for change
Redundant part 5W8314 added
to Material Information.

Supplement Revision 1

Remove
All pages

Incorporate
Page 1

Reason for change
Redundant part 5W8314 added
to Material Information.

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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 to the Bulletin and Revision 1 to the Supplement are as follows:

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Bulletin

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Supplement

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AIR – HP COMPRESSOR STAGE 7 SOLENOID VALVE – INTRODUCTION OF A REVISED HP COMPRESSOR
BLEED CONTROL VALVE SOLENOID MOUNTING BRACKET

1. Planning Information

A. Effectivity

(1) Airbus A319

(a) V2522-A5, V2524-A5, V2527M-A5 Engines prior to Serial No.V11500

(2) Airbus A320

(a) V2500-A1 Engines prior to Serial No. V0362

(b) V2527-A5, V2527E-A5 Engines prior to Serial No.V11500

(3) Airbus A321

(a) V2530-A5, V2533-A5 Engines prior to Serial No.V11500

B. Concurrent Requirements

None.

C. Reason

(1) Problem

A design review has indicated that manufacture of the HP Compressor stage 7 solenoid bracket may be optimised.

(2) Evidence

See (1) Problem.

(3) Substantiation

The changes introduced by this modification have been the subject of satisfactory engineering and stress analysis and an assembly check has been successfully completed.

(4) Objective

Incorporation of this modification is designed to simplify the HPC stage 7 Bleed Control Valve solenoid mounting bracket.



(5) Effect of Bulletin on:

(a) Operation

Not affected.

(b) Maintenance

Not affected.

(c) Overhaul

Not affected.

(d) Repair Schemes

Not affected.

(e) Interchangeability

Affected.

(f) Fits and Clearances

Not affected.

D. Description

(1) The changes introduced are:

(a) A revised HP Compressor Bleed Control Valve solenoid mounting bracket is introduced similar to the existing item except for the following:

- (i) The two attaching brackets for CP0207 and CP0599 have been deleted as separate items and the main bracket has been re-profiled to incorporate these features.
- (ii) The bracket thickness has been reduced from 1.6 mm. to 1.2 mm. which results in the solenoid and clipping points sitting 0.4 mm. radially inwards compared to the existing bracket.
- (iii) The material has been changed from Titanium to Stainless Steel.
- (iv) The three circular cut-outs on the existing standard have been replaced by three rectangular cut-outs with a further three smaller rectangular cut-outs being added.
- (v) Nine of the captive floating anchor nuts have been deleted and replaced with separate nuts.



- (vi) The opportunity has been taken to optimise the length of the solenoid attaching bolt.

E. Compliance

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

F. Approval

The part number transactions shown in section 2. Material Information 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.

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

None.



(3) Datum

Engine Front Mount Centreline (Power Plant Station PPS100)

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 Engineering Change Number 02VR006 and 02VR006A

(2) ATA Locator - 75-32-51.

O. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC) SV2500-1IA, 2IA, 2IB, 5IA, 5IB, 6IA, 6IB, 7IA and 7IB Chapter/Section 75-32-51, will be revised.

(2) Engine Manual, 72-00-32 Config-01, Removal-05.

(3) Engine Manual, 72-00-32 Config-01, Installation-01, -03 and -04.

(4) Engine Manual, 72-00-32 Config-02, Removal-05.

(5) Engine Manual, 72-00-32 Config-02, Installation-01, -03 and -04.

(6) Component Maintenance Manual, Miscellaneous Mechanical, 1IA, Chapter/Section 75-32-51, Cleaning, Inspection and Repair.

P. Interchangeability of Parts

(1) The parts introduced by this Service Bulletin must be fitted as a set.

**2. Material Information****A. The kit required consists of the following parts:**

None.

B. Parts to be reworked:

None.

C. New Production Parts:

All Engines

36-11-57

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01102	4W0108	3	Bolt, (See Appendix 5) (.190 dia x .182)	-	4W0107	(B)(1D)(S1)
01106	4W0001	1	Nut, (See Appendix 5) (.190 dia)	-	-	(C)

75-32-51

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01102	4W0108	9	Bolt, (See Appendix 5) (.190 dia x .182)	-	4W0107	(B)(1D)(S1)
01106	4W0001	8	Nut, (See Appendix 5) (.190 dia)	-	-	(C)
01160	6A7731	1	Bracket, Assy Solenoid Mounting	-	6A5649	(A)(E)(S1)
01182	AS16445	6	Rivet, Solid Csk Head	-	AS16446	(B)(2D)(S1)

D. Redundant Parts:

All Engines

75-32-51

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01150	-	2	Bracket	-	6A4680	(E)
01150	-	2	Bracket	-	5W8314	(E)

R



FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01152	-	2	Nut, (See Appendix 5) (.190 dia)	-	4W0001	(1D)
01154	-	2	Bolt, (See Appendix 5) (.190 dia x .500)	-	4W0103	(1D)
01184	-	9	Nut, (See Appendix 5) (.190 dia)	-	4W0038	(3D)

E. Instruction Disposition Codes:

(A) New part will be made available from December 2002.

(B) New part is currently available.

(C) Additional.

(E) Old part becomes redundant upon embodiment of this modification.

(S1) New and old parts are not interchangeable.

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

(2D) Quantity reduced from 24 to 6.

(3D) Quantity reduced from 12 to 3.



3. Accomplishment Instructions

A. Rework Instructions

None.

B. Assembly Instructions

The revised HP compressor bleed control valve solenoid mounting bracket introduced by this Service Bulletin is not interchangeable with the existing item. Remove existing and Install new in accordance with current overhaul procedures (Engine Manual, 72-00-32 Config-01 and Config-02, Removal-05 and Installation-01).

NOTE: The revised mounting bracket and associated parts introduced by this Service Bulletin must be fitted as a set.

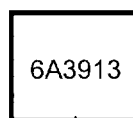
C. Recording Instructions

A record of accomplishment is necessary.

HP Compressor Bleed Control Valve Solenoid Mounting Bracket Family Tree

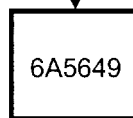
V2500 All Engines

Baseline



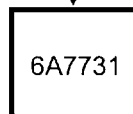
V2500-ENG-75-0036

Engine - Air - Incorporate a Revised Solenoid Support Bracket to Provide Improved Clearances between Bracket and Fan Case Assembly



V2500-ENG-75-0047

Air - HP Compressor Stage 7 Solenoid Valve - Introduction of a Revised HP Compressor Bleed Control Valve Solenoid Mounting Bracket



Family Tree
Fig.1

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AIR - HP COMPRESSOR STAGE 7 SOLENOID VALVE - INTRODUCTION OF A REVISED HP COMPRESSOR
BLEED CONTROL VALVE SOLENOID MOUNTING BRACKET

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. Parts supplied as single line items

2. New Production or Rework Parts

	Part No.	Desc.	Unit Price US Dollars
R	4W0001	Nut	3.78
R	4W0108	Bolt	11.90
R	6A7731	Bracket	928.00
R	AS16445	Rivet	0.97

