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V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

This document transmits Revision 1 to Service Bulletin EV2500-75-0066

Document History

Service Bulletin Revision Status
 Initial Issue Oct.24/97

Supplement Revision Status

Bulletin Revision 1

Remove
 All pages of the
 Service Bulletin

Incorporate
 Pages 1 to 6 of the
 Service Bulletin

Reason for change
 To revise Section 1.A.
 Effectivity and to revise
 Instruction Disposition
 Code in section 2. Material
 Information.

V2500-ENG-75-0066

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:

<u>Page</u>	<u>Revision Number</u>	<u>Revision Date</u>
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	Bulletin		
R	1	1	Jul.7/00
R	2	1	Jul.7/00
R	3	1	Jul.7/00
R	4	1	Jul.7/00
R	5	1	Jul.7/00
R	6	1	Jul.7/00

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AIR - ENGINE AIR OFF-TAKE DUCTS - INTRODUCTION OF STAGE 7 HP COMPRESSOR BLEED VALVE
SUPPORT AIR DUCTS MANUFACTURED BY CASTING

1. Planning Information

A. Effectivity

(1) Airbus A319

R V2522-A5, V2524-A5 Engines prior to Serial No.V10825 but excluding V10744
R and V10746

(2) Airbus A320

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

R (b) V2527-A5 Engines prior to Serial No.V10825 but excluding V10744 and
R V10746

(3) Airbus A321

R V2530-A5, V2533-A5 Engines prior to Serial No.V10825 but excluding V10744
R and V10746

(4) ATA Location

75-00-00

B. Concurrent Requirements

None

C. Reason

(1) Condition

A design analysis has shown that method of manufacture of Stage 7 bleed-valve support air-ducts of the HP compressor can be better.

(2) Background

See Condition

(3) Objective

The purpose of this Service Bulletin is to make manufacture of support air-ducts better.



(4) Substantiation

A satisfactory engineering analysis has been done on changes introduced by this Service Bulletin.

(5) Effect of Bulletin on:

(a) Removal/Installation

Not affected

(b) Disassembly/Assembly

Not affected

(c) Cleaning

Not affected

(d) Inspection/Check

Not affected

(e) Repair

Not affected

(f) Testing

Not affected

D. Supplemental Information

None

E. Description

- (1) This Service Bulletin introduces different support air-ducts for the Stage 7 bleed-valve of the HP compressor. The new support air-ducts are cast units, not fabricated units.

The changes introduced are:

- (a) The material is changed from titanium (TEG/TCA) to alternative titanium for casting (TFF).
- (b) The thickness of wall is increased from 1,20 mm (plus or minus 0,10 mm) to 2,00 mm (plus or minus 0,40 mm).
- (c) To remove material that is not wanted, top and bottom flanges of duct are scalloped around bolt holes.



F. Approval

The part number changes and/or part modification are given in Section 2 and 3 of this Service Bulletin. They obey applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Models listed.

G. Compliance

Category Code 7

This Service Bulletin can be done when there are no initial parts remaining.

H. Manpower

Estimated manhours to incorporate the full intent of this bulletin:

(1) In Service

Not applicable

(2) At Overhaul

No more time is necessary to do this Service Bulletin

NOTE: It is possible to get access to parts affected by this Service Bulletin at overhaul.

I. Material – Price and Availability

(1) A modification kit is not necessary.

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

J. Tooling – Price and Availability

Special tools are not necessary.

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

This Service Bulletin has no effect on aircraft electrical load.

M. References

(1) Internal Reference No.

IAE Engineering Change Number 93VR073

N. Other Publications Affected

(1) Illustrated Parts Catalogue (IPC), Chapter/Section 75-00-49



2. Material Information

A. Kits associated with this Bulletin:

None.

B. New production parts:

PART NO.	QTY	UNIT PRICE
6A5759	2	Note

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.

C. Parts affected by this Bulletin:

Applicability: For each V2500 engine to incorporate this Bulletin:

75-00-49

	FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	OLD PART NO.	INSTR DISP
R	01-100	6A5759	2	Support, duct, air, HP7 - RH upper and lower	6A2281	(A)(B)(S1)

D. Instruction Disposition Codes

(A) New part is available.

R (B) Old part will be discontinued.

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



3. Accomplishment Instructions

A. Rework Instructions

None

B. Assembly Instructions

For correct removal/installation procedure refer to applicable A319/A320/A321 Aircraft Maintenance Manual (AMM), Chapter/Section 75-32-52, Removal/Installation.

C. Recording Instructions

A record of accomplishment is necessary.