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**V2500-A1/A5 NACELLE SERVICE BULLETIN**

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin NV2500-24-0014

**Bulletin Initial Issue**

Remove

Incorporate  
Pages 1 to 7 of the  
Service Bulletin

Reason for change  
Initial issue

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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 are as follows:

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NACELLE – POWERPLANT – IDG COOLING TUBES – 'O' RING SEALS – REPLACEMENT OF

1. Planning Information

A. Effectivity

(1) Aircraft:

- (a) Airbus A319
- (b) Airbus A320
- (c) Airbus A321

(2) Nacelle:

- (a) V2500-A1 Engine build-up units (ebu) Cum units (c/u) 001 thru 318 and Serial numbers (s/n) 0319001 thru 0336001.
- (b) V2500-A5 (all variants) Engine build-up units (ebu) Cum units (c/u) 001 thru 025 and Serial numbers (s/n) 0026001 thru 0242001.

B. Reason

(1) Condition

The packing seals installed at the IDG inlet and outlet cooling tubes may experience compression set and become brittle and so reduce the effectiveness of the seals.

(2) Background

The packing seals installed at the IDG inlet and outlet ports were found to be of an inadequate specification for the operating temperature range of the IDG.

(3) Objective

To maintain reliability by providing an improved seal for use at the IDG inlet and outlet cooling tubes.

(4) Substantiation

Not applicable.



(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

(6) Supplemental Information

None

C. Description

(1) The change introduced by this Service Bulletin is as follows:

- (a) The packing seals at the IDG inlet and outlet cooling tubes are removed and replaced with new seals.

D. Approval

The technical content of this Service Bulletin is covered by an Airbus Industrie Modification which is under DGAC (Direction Generale de L'Aviation Civile - France) approval.

E. Compliance

Category 5

Accomplish when the nacelle or system is disassembled sufficiently to afford access to the affected sub-assembly (i.e. accessories, components) and to all affected spare sub-assemblies.



F. Manpower

Estimated man-hours to incorporate the full intent of this Service Bulletin:

(1) In Service

Not Applicable

(2) In Shop

0.5 M/Hrs

Total - 0.5 M/Hrs

NOTE: Manpower estimate is provided for planning purposes only. No labor allowance is provided under the terms of this service bulletin offering.

G. Material Cost and Availability

Modification kit not required. Parts supplied as single line items.

H. Tooling - Cost and Availability

None required.

I. Weight and Balance

(1) Weight change

None

(2) Moment arm

No effect

(3) Datum

Engine Front Mount Centreline (Powerplant Station PPS 100.00)

J. Electrical Load Data

Not affected.

K. References

- (1) IAE V2500 Aircraft Maintenance Manual, Chapter/Section 12-13-24



- (2) IAE V2500 Standard Practices/Processes Manual (SSP-V2500-1IA)  
Chapter/Section 70-41-02
- (3) Overhaul Processes and Consumable Index (PCI-V2500-1IA)
- (4) Internal Reference No. - 96VN211
- (5) ATA Locator - 24-00-00

**L. Other Publications Affected**

- (1) A320/V2500-A1 Engine Illustrated Parts Catalog(S-V2500-1IA),  
Chapter/Section 24-21-51
- (2) A321/V2500-A5 Engine Illustrated Parts Catalog (S-V2500-2IA),  
Chapter/Section 24-21-51



## 2. Material Information

### A. Kits associated with this Bulletin:

None.

### B. Parts affected by this Bulletin:

Applicability: For each V2500 Engine build up and QEC kit to incorporate this Bulletin.

24-21-51

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
02-114	M83248/ 1-912	1	.Packing seal	-	MS28778-12	(A)(B)
02-506	M83248/ 1-910	1	.Packing seal	-	MS28778-10	(A)(B)

### C. Instructions/Disposition Code Statements:

(A) New part currently available.

(B) New part may be used in lieu of old part number but not vice versa.

**NOTE:** The estimated 2003 Unit Price (if shown) is provided for planning purposes only and does not constitute a firm quotation. Consult the Goodrich Price Catalog or contact the Goodrich Spare Parts Sales Department for information concerning firm prices.

### D. Materials Required to Incorporate This Bulletin:

CoMat 02-138 - Lockwire

CoMat 10-077 - Approved Engine Oils

**NOTE:** To identify the consumable materials, refer to the Overhaul Processes and Consumable Index PCI-V2500-1IA.



### 3. Accomplishment Instructions

#### A. Pre-requisite Instructions

- (1) Drain the IDG oil system as instructed in the A320/V2500 Aircraft Maintenance Manual, Task 12-13-24-680-010.

#### B. Modification Instructions

- (1) Cut and remove the lockwire from the IDG 640018 inlet and the HTE 640017 outlet couplings on the IDG. Refer to Figure 1.
- (2) Remove and retain the circlips and disconnect the inlet and outlet couplings from the IDG.
- (3) Remove and discard the MS28778-10 and MS28778-12 packing seals.

**WARNING:** DO NOT GET ENGINE OIL ON YOUR SKIN FOR A LONG TIME. FLUSH THE OIL FROM YOUR SKIN WITH WATER. THE OIL IS POISONOUS AND CAN GO THROUGH YOUR SKIN AND INTO YOUR BODY.

- (4) Lubricate the new M83248/1-912 packing seal with clean system oil (CoMat 10-077) and install to the HTE 640018 inlet coupling. Connect the HTE 640018 inlet coupling.
- (5) Torque the HTE 640018 inlet coupling to 550-600 LBFIN (62-68 NM) and install the circlip removed in step 2.B.(2). Refer to the Standard Practices/Processes Manual, Task 70-41-02-410-501.
- (6) Lubricate the new M83248/1-910 packing seal with clean system oil (CoMat 10-077) and install to the HTE 640017 outlet coupling. Connect the HTE 640017 outlet coupling.
- (7) Torque the HTE640017 outlet coupling to 380-405 LBFIN (43-48 NM) and install the circlip removed in step 2.B.(2). Refer to the Standard Practices/Processes Manual, Task 70-41-02-410-501.
- (8) Safety the inlet and outlet couplings with lockwire (CoMat 02-138).

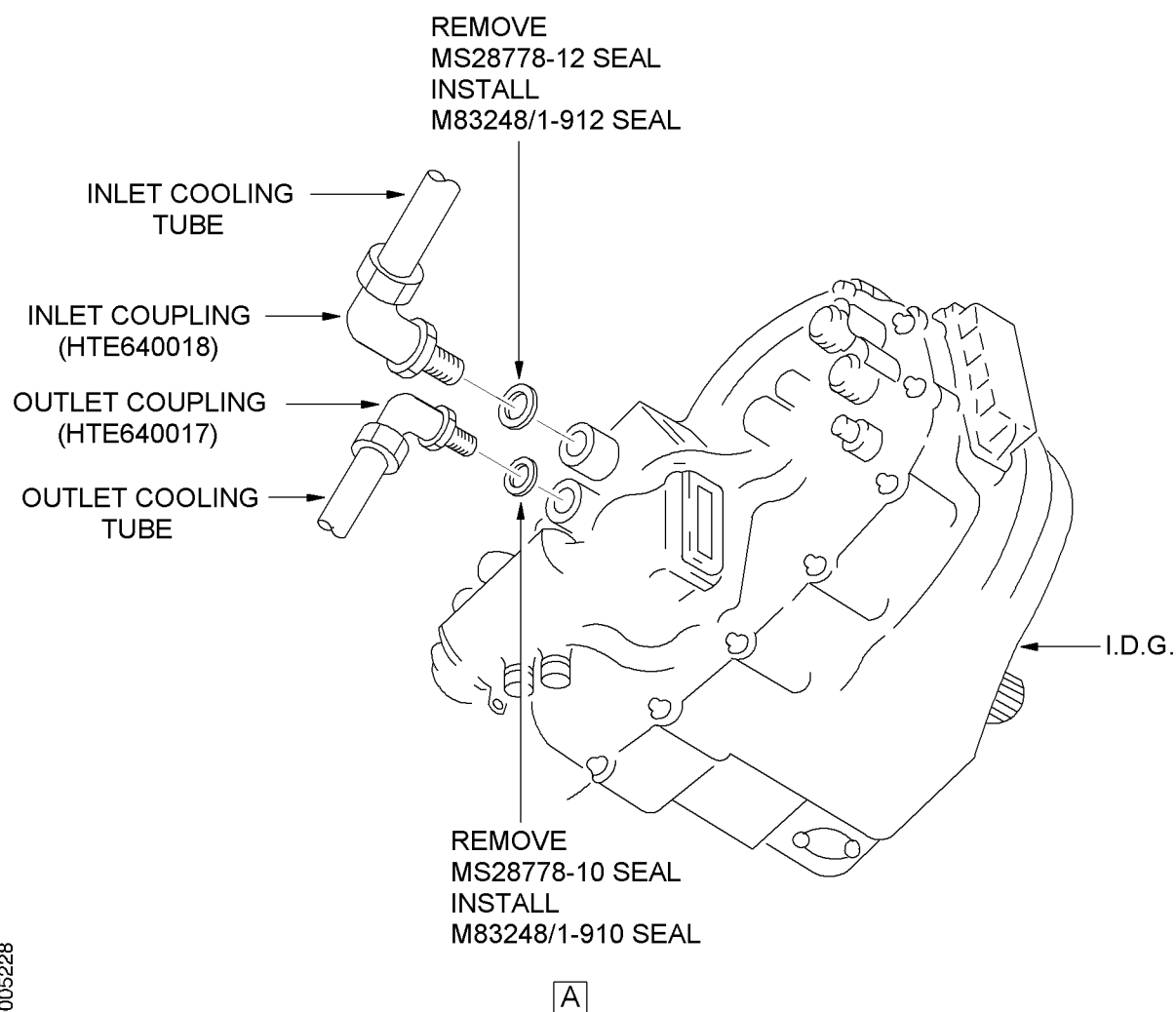
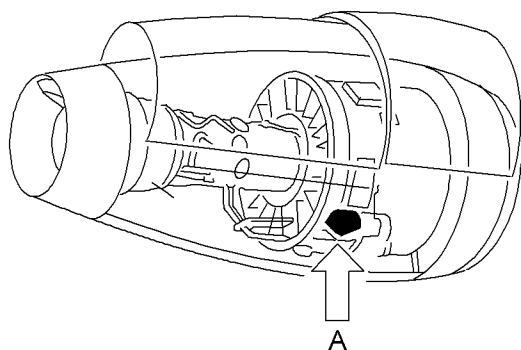
#### C. Post-requisite Instructions

- (1) Replenish the Integrated Drive Generator with clean system oil (CoMat 10-077). Refer to the A320/V2500 Aircraft Maintenance Manual, Task 12-13-24-612-011.

#### D. Recording Instructions

- (1) A record of accomplishment is necessary. Write to the applicable records that Service Bulletin V2500-NAC-24-0014 has been done.





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Replacement of IDG Cooling Tube Seals - L/H and R/H  
Figure 1

