P U B L I C A T I O N T R A N S M I T T A L

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DATE: Sep.14/04

V2500-A1 SERIES NACELLE SERVICE BULLETIN

This document transmits the Initial Issue of Service Bulletin NV2500-26-0002 and the Initial Issue of the Supplement

Bulletin Initial Issue

Remove	Incorporate	Reason for change
	Pages 1 to 6 of the Service Bulletin	Initial issue

Supplement Initial Issue

Remove	Incorporate	Reason for change
	Page 1	Initial issue

V2500-NAC-26-0002

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED
If any have not been received please advise Publication Services, Rolls-Royce plc, Derby, England

LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin are as follows:

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Bulletin		
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1		Sep.14/04

International Aero Engines

SERVICE BULLETIN

NACELLE - POWERPLANT - FIRE PROTECTION - OVERHEAT DETECTOR - REPLACEMENT OF

Printed in Great Britain

1. Planning Information

A. Effectivity

(1) Airbus A320

V2500-A1 Engine Build-up Unit Serial Nos. prior to 107.

B. Reason

(1) Condition

The Overheat Detector may encroach the minimum clearance requirements between itself and adjacent structure/tubes.

(2) Background

Not applicable.

(3) Objective

To ensure adequate clearance is maintained between the Overheat Detector and adjacent structure/tubes.

(4) Substantiation

Trial installation has shown the new configuration to be satisfactory.

(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

(6) Supplemental Information

The Engine Manual chapter 72-00-40 will be revised to include the new removal/installation instructions.

C. Description

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

(a) Clipping point CP5998 replaces clipping point CP5221 to accommodate the new Overheat Detector. The remaining clipping point (CP5223) is unaffected. Refer to Figure 1.

D. Compliance

Category Code 7

Accomplish when the supply of superseded parts has been depleted.

E. 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.

F. Manpower

Estimated man-hours to incorporate the intent of this Service Bulletin on each engine:

(1) In shop

(a) To embody - Not applicable (Parts are accessible at overhaul)

G. Material Price and Availability

Modification kit not required; parts supplied as single line items. Refer to Section 2. Material Information.

For prices and availability of future spares see Supplement to this Bulletin.

H. Tooling Price and Availability

None required.

I. Weight and Balance

(1) Weight Change

None

(2) Moment Arm

No effect

(3) Datum

Engine Front Mount Centreline (Power Plant Station PPS 100.00)

J. Electrical Load Data

Not affected.

K. References

(1) A320/V2500-A1, A320/A321/V2500-A5 Engine Manual, Chapter/Section 72-00-40.

(2) Auxitrol Service Bulletin No. 75-001 (Modification of Nacelle Temperature Sensor).

(3) Internal Reference No. - 89VN039/A.

(4) ATA Locators - 26-00-00, 75-00-00.

L. Other Publications Affected

(1) A320/V2500-A1 Powerplant Illustrated Parts Catalog (PIP-V2500-1IA), Chapter/Section 75-41-15.

(2) A320/V2500-A1 Engine Illustrated Parts Catalog (S-V2500-1IA), Chapter/Section 75-41-15.

2. Material Information

A. Kits associated with this bulletin:

None.

B. Parts affected by this Bulletin:

Applicability: For each V2500-A1 Nacelle to incorporate this Bulletin

72-41-15

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01-100	RP162-02	1	Overheat Detector	-	RP162-01	(A)(S1) (2D)(B)
01-130	AS21408	1	Bolt	-	-	(A)(B) (S1)
01-132	TA0250 22FT03	1	Clip	-	-	(A)(B) (S1)
01-135	TA0250 22FT08	1	Clip	-	-	(A)(B) (S1)
01-137	SP154D	1	Washer	-	-	(A)(B) (S1)
01-140	AS20624	1	Nut, self-locking dbl. hex	-	-	(A)(B) (S1)
01-120	-	1	Clip	-	TA0250 22FT03	(B)(1D) (S1)
01-118	-	1	Bolt	-	AS21428	(B)(1D) (S1)
01-121	-	1	Spacer	-	ST1698D48	(B)(1D) (S1)
01-122	-	1	Washer	-	SP154D	(B)(1D) (S1)
01-123	-	1	Nut, self-locking dbl. hex	-	AS20624	(B)(1D) (S1)

C. Instruction/Disposition Codes:

(A) New part currently available.

(B) Part transferred from ATA chapter 26-12-19.

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

(2D) Old part can be reworked to new part number (ref: Auxitrol Service Bulletin; Section 1 Paragraph k.).

(S1) New parts coded (S1) must replace old parts coded (S1) as a complete set.

3. Accomplishment Instructions

A. Pre-Requisite Instructions

(1) None.

B. Rework or Modification Instructions

(1) Install the RP162-02 Overheat Detector to the 740-5081-507 Bracket with the four A117-1A Bolts, four AS8623A Nuts, and four SP155-A Washers. Hand tighten the Nuts. Refer to Figure 1.

(2) Safety the Overheat Detector to the 5A9043 Tube (clipping point CP5998) with the TA025022FT03 Clamp, TA025022FT08 Clamp, AS2140B Bolt, SP154D Washer, and AS20624 Nut. Hand tighten the Nuts.

(3) Safety the Overheat Detector at clipping point CP5223 as shown, with the TA025022FT03 Clamp, AS2140B Bolt, SP154D Washer, and AS20624 Nut. Hand tighten the Nut.

(4) Make sure there is a minimum clearance of 0.25in (6,3 mm.) between the Overheat Detector and adjacent structure/tubes.

(5) Torque the Nuts in step (1) to 20 to 25 lbf in (2 to 3 Nm).

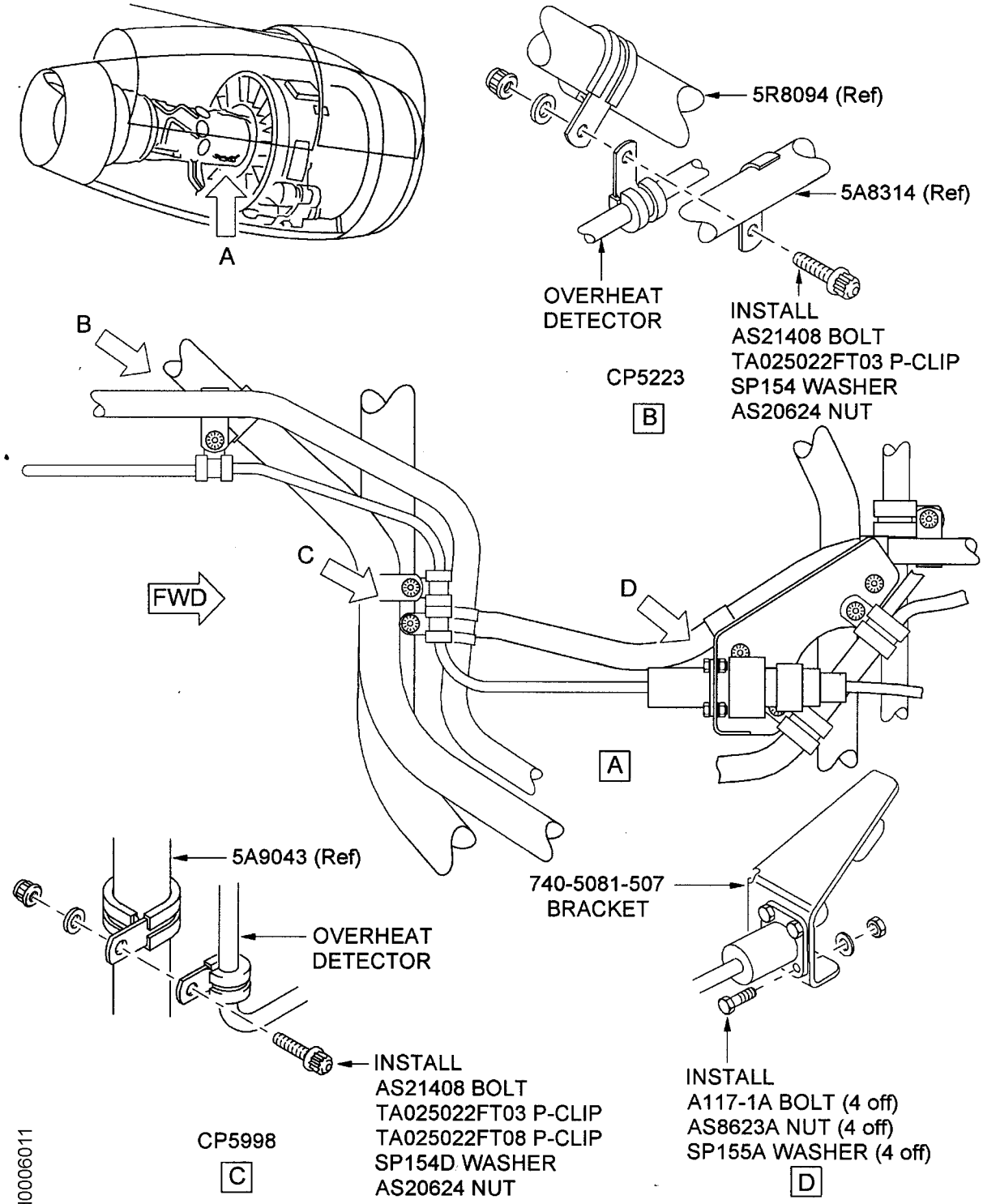
(6) Torque the Nuts in steps (2) and (3) to 40 lbf in (4,5 Nm).

C. Post-Requisite Instructions

(1) None.

D. Recording Instructions

(1) A record of accomplishment is necessary.



INSTALLATION OF THE OVERHEAT DETECTOR

Installation of the Overheat Detector
Figure 1

International Aero Engines

SERVICE BULLETIN

NACELLE - POWERPLANT - FIRE PROTECTION - OVERHEAT DETECTOR - REPLACEMENT OF

SUPPLEMENT - PRICES AND AVAILABILITY

The estimated unit price shown is provided for planning purposes only and does not constitute a firm quotation. Consult the BF Goodrich Aerospace Price Catalog or contact BF Goodrich Aerospace Spares Parts Sales Department for information concerning firm prices.

1. Modification Kit:

Not applicable.

2. Parts required:

Part No.	Description	Unit Price US Dollars
RP162-02	Overheat Detector	4512.00
AS21408	Bolt	5.00
TA025022FT03	Clip	20.00
TA025022FT08	Clip	44.00
SP154D	Washer	1.00
AS20624	Nut, self-locking	5.00

Esterline **AUXITROL**

SERVICE BULLETIN

TITLE: MODIFICATION OF NACELLE TEMPERATURE SENSOR

1. PLANNING INFORMATION

A. Effectivity

Nacelle temperature sensor P/N : RP162-01 installed on IAE V2500 Engine or stocked as spare parts are affected by this Service Bulletin.

B. Reason

To provide instructions to modify the shape of the rigid metal tube. The new configuration will become P/N : RP162-02.

C. Description

The temperature sensor is modified to the new configuration using a locally manufactured tool (see figure 2).

Accord pour diffusion avec mention "Agréé DGAC"

D. Approval

TBD.

BUREAU VERITAS REGISTRE INTERNATIONAL Région OUEST

E. Compliance Facultatif.

Accomplish based upon experience with prior configuration.

F. Manpower

An estimated 1 man-hour is required to raise P/N : RP162-01 to RP162-02.

G. Material Cost and Availability

Not applicable. Refer to Section 3."MATERIAL INFORMATION" for information concerning new part.

H. Tooling

Local manufacture two parts as defined in figure 1.

I. Electrical Load Data

Not affected.

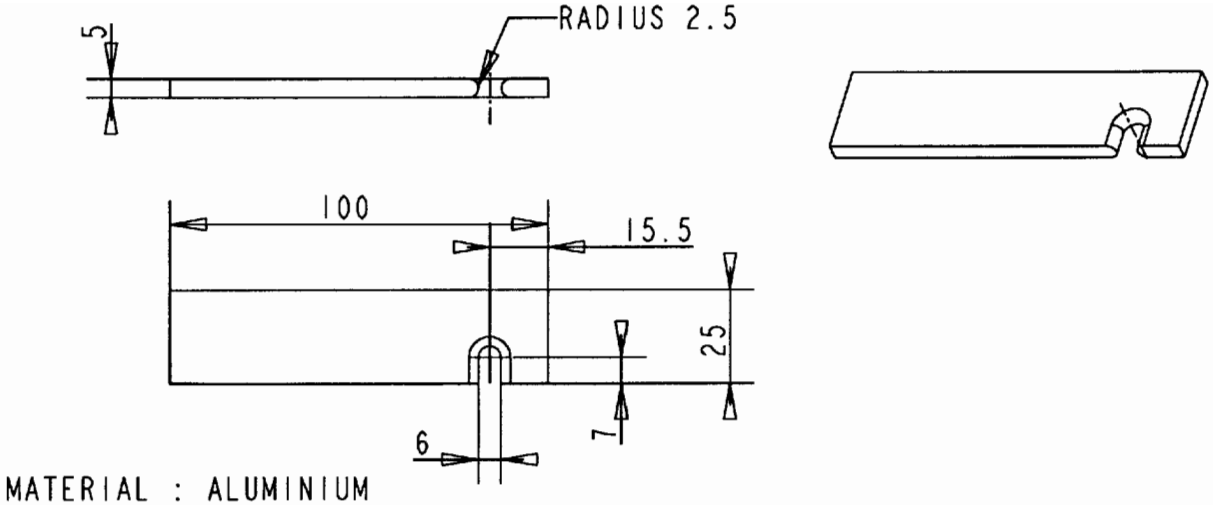


Figure 1

J. References

Equipment Modification Sheet AUXITROL N° 075/90.

2. ACCOMPLISHMENT INFORMATION

A. Pre-requisite Instructions

1. Manufacture two shaping tools from 5 mm thick aluminium plate (or similar materal), to the dimensions given in figure 1. Remove any burrs or sharp edges from the tools.

B. Rework instructions

CAUTION: USE A CLAMP WITH SMOOTH OR PROTECTIVE JAWS TO PREVENT DAMAGE TO THE SENSOR.

CAUTION: NEVER BENT THE RIGID METAL SHEATH IN THE STRAIGHT AREA 25 MM (0.98 IN). SEE FIGURE 2.

1. Insert the two shaping tools on both sides of each bending radius to the differents areas to be modified (Note positions of tools for area 2 on figure 2) curve lightly the rigid metal sheath and obtain dimensions defined figure 3.

2. Proceed step by step from area 1 to 5.

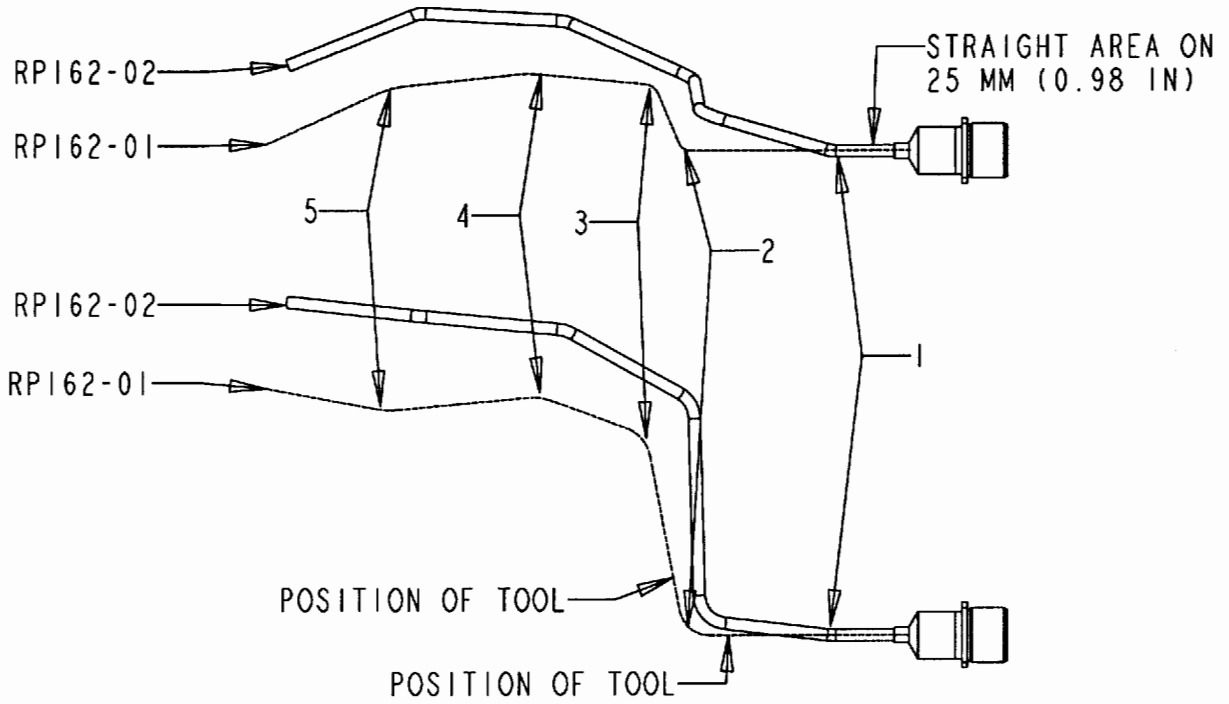
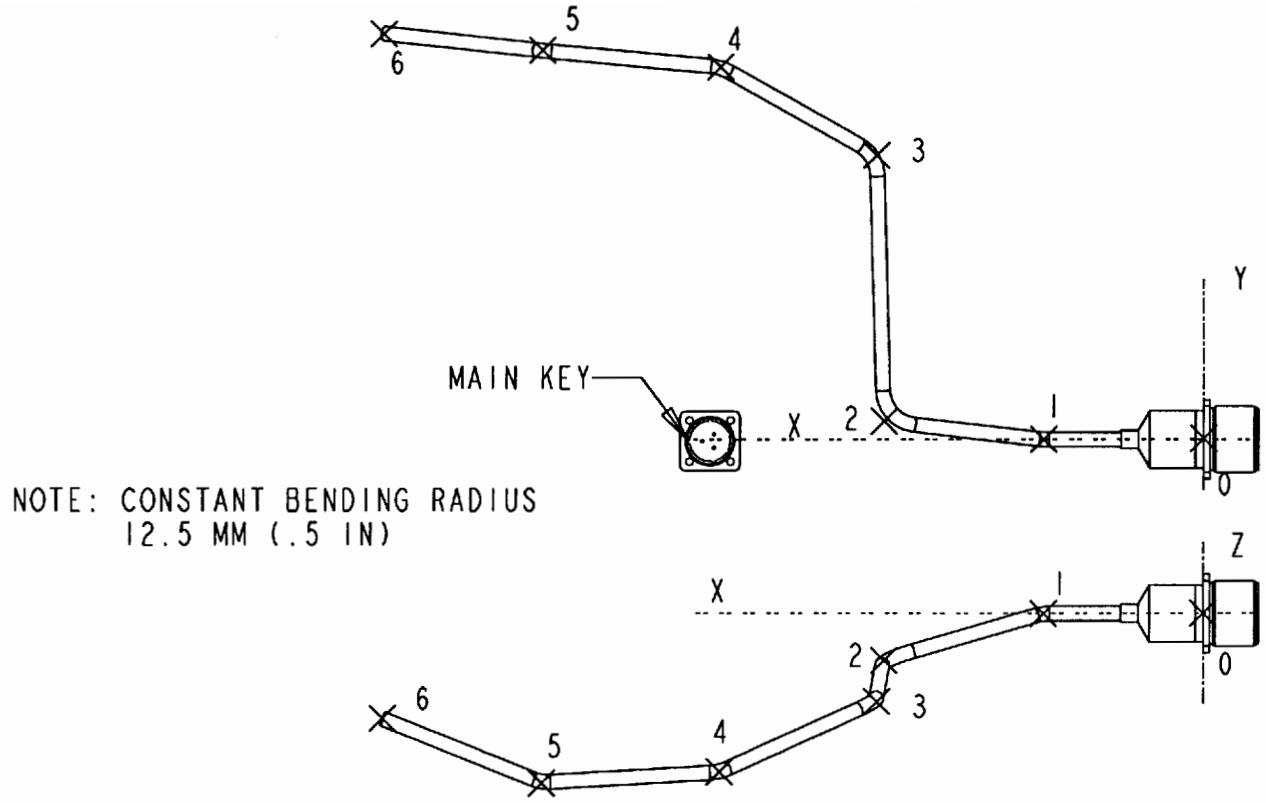


Figure 2

3. Inspect and test the sensor as per CMM 75-41-15.

4. Identify the new shape to the new Part Number by electrolytic marking. RP162-01 becomes RP162-02.



	MM X	INCH	MM Y	INCH	MM Z	INCH
0	0.0	0.0	0.0	0.0	0.0	0.0
1	52.50	2.07	0.0	0.0	0.0	0.0
2	105.26	4.14	6.05	0.24	-15.4	-0.61
3	107.69	4.24	94.66	3.73	-29.34	-1.15
4	159.38	6.27	123.79	4.87	-52.90	-2.08
5	218.05	8.58	129.34	5.09	-56.20	-2.21
6	270.57	10.65	135.07	5.32	-34.97	-1.38

Figure 3
RP162-02 Dimensions to be obtained

3. MATERIAL INFORMATION

NEW PART N° (ATA N°)	QTY	KEYWORD	OLD PART N° (IPC N°)	INSTR/ DISPOS
RP162-02	1	TEMPERATURE SENSOR	RP162-01	(A)(B)

Applicability: For each V2500 engine to incorporate this Bulletin

A. Kits associated with this Bulletin:

None.

B. Parts affected by this Bulletin:

C. Instructions/Dispositions Code Statements:

(A) New part is currently available for sale.

(B) Old part number can be reworked to new part number.