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V2500-A1/A5 SERIES PROPULSION SYSTEMS SERVICE BULLETIN

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin NV2500-71-0293 and the Initial Issue of the Supplement

Bulletin Initial Issue

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Supplement Initial Issue

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Printed in Great Britain

NACELLE – POWERPLANT – FAN COWL DOOR – REWORK OF THE UPPER LOCATOR

SUMMARY

1. PLANNING

A. EFFECTIVITY

Nacelles

V2500–A1 and V2500–A5

B. CONCURRENT REQUIREMENTS

None.

C. REASON/PROBLEM

Problem

On some Nacelles the 'into-wind' step between the Nose Cowl and the Fan Cowl Doors may not be within the design specification.

Evidence

There have been several reports of an 'into-wind' step condition between the Nose Cowl and the Fan Cowl Doors.

Substantiation

This modification has been successfully carried out under concessionary cover. Additionally, stress substantiation demonstrates that the removal of material from the aft face of the upper-locator is acceptable to alleviate the condition.

Objectives

To remove the 'into-wind' step condition between the Nose Cowl and the Fan Cowl Doors.

D. DESCRIPTION

This Service Bulletin instructs the rework of the Upper Locator on the Fan Cowl Doors.

E. COMPLIANCE

Category 7

Accomplish when supply of superseded parts has been depleted.

F. MANPOWER

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

In Service

Not Applicable

At overhaul

1.5 M/Hr

G. INTERCHANGEABILITY OF PARTS

New part is interchangeable with old part but old part is not interchangeable with new part.

2. MATERIAL INFORMATION**A. PARTS PRICES**

None

NACELLE – POWERPLANT – FAN COWL DOOR – REWORK OF THE UPPER LOCATOR**1. Planning Information****A. Effectivity****(1) Airbus A319**

(a) V2522-A5, V2524-A5, V2527M-A5 Fan Cowl Doors prior to Serial Number 4074001.

(2) Airbus A320

(a) ALL V2500-A1 Fan Cowl Doors.

(b) V2527-A5, V2527E-A5 Fan Cowl Doors prior to Serial Number 4074001.

(3) Airbus A321

(a) V2530-A5, V2533-A5 Fan Cowl Doors prior to Serial Number 4074001.

B. Concurrent Requirements

None.

C. Reason**(1) Problem**

On some Nacelles the 'into-wind' step between the Nose Cowl and the Fan Cowl Doors may not be within the design specification.

(2) Evidence

There have been several reports of an 'into-wind' step condition between the Nose Cowl and the Fan Cowl Doors.

(3) Substantiation

This modification has been successfully carried out under concessionary cover. Additionally, stress substantiation demonstrates that the removal of material from the aft face of the upper-locator is acceptable to alleviate the condition.

(4) Objectives

To remove the 'into-wind' step condition between the Nose Cowl and the Fan Cowl Doors.

(5) Effect of Bulletin on:

(a) Operation

Not affected

(b) Maintenance

Not affected

(c) Overhaul

Not affected

(d) Repair Scheme

Not affected

(e) Interchangeability

Not affected

(f) Fits and Clearances

Not affected

D. Description

The changes introduced by this Service Bulletin are as follows:

- The Fan Cowl Doors are removed.
- The upper-locator is reworked.
- The exposed surface on the upper-locator is cleaned and painted.
- The reworked upper-locator and the Fan Cowl Doors are re-identified.
- The Fan Cowl Doors are installed.

E. Compliance

Category 7

Accomplish when supply of superseded parts has been depleted.

F. Approval

The technical content of this Service Bulletin has been approved under the authority of the EASA Design Organisation Approval No EASA.21J.031. The authorising IAE document is EC 04VN764.

G. Manpower

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

(1) In Service

Not Applicable

(2) At Overhaul

1.5 M/Hr

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

H. Material Cost and Availability

Not applicable.

I. Tooling – Cost and Availability

None.

J. Industry Support Information

Not applicable.

K. Weight and Balance**(1) Weight change**

-0.08 lb (0,036 Kg)

(2) Moment arm

50.20 in (1275,08 mm) Aft of Datum

(3) Datum

Nacelle Forward Mount Centreline (Powerplant Station PPS 100.00)

L. Electrical Load Data

Not affected.

M. Software Accomplishment Summary

Not applicable.

N. References

- (1) A320/V2500-A1 A319/A320/A321/V2500-A5 Aircraft Maintenance Manual (M-V2500-1IA) Chapter/Sections 71-13-11 and 71-13-16.
- (2) Overhaul Processes And Consumable Index (IAE PCI-V2500-1IA) Section II.
- (3) Component Maintenance Manual (CMM-FC-V2500-1IA), Chapter 71-13-00
- (4) Standard Practices / Process Manual (SPP-V2500-1IA), Chapter 70-09-00, 70-11-26, 70-38-07.
- (5) IAE engineering change EC 04VN764.

O. Other Publications Affected

- (1) A320/V2500-A1/A5 Engine Illustrated Parts Catalog, Chapter/Sections 71-13-11 and 71-13-16 will be revised.

P. Interchangeability of Parts

- (1) New part is interchangeable with old part but old part is not interchangeable with new part.

2. Material information

A. Kits required consist of the following parts

None.

B. Parts to be reworked

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
N/A	740-4030-505	1	Upper Locator		740-4030-503	(S1)
N/A	740-4030-506	1	Upper Locator		740-4030-504	(S1)

C. New production parts

71-13-11

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01010	745-4001-507	1	Left hand Fan Cowl Door		745-4001-503	(A)(S1) (S2)

71-13-16

FIG ITEM NO.	NEW PART NO.	QTY	PART TITLE	MAT	OLD PART NO.	INSTR DISP
01010	745-4002-515	1	Right hand Fan Cowl Door		745-4002-511	(A)(S1) (S2)

D. Redundant Parts

None.

E. Instructions/Dispositions Code Statements

(A) Parts are currently available.

(S1) Old part can be reworked to new part as instructed in this Service Bulletin.

(S2) New part is interchangeable with old part, but old part is not interchangeable with new part.

F. Materials required to incorporate this Bulletin

CoMat	01-076 or 01-124	Solvent
CoMat	02-099	Lint free cloth
CoMat	06-131	Marking Pen
CoMat	07-080C	BMS 10-11, Type I Primer

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

3. Accomplishment Instructions

A. Pre-requisite Instructions

WARNING: DO NOT TOUCH THE ENGINE COMPONENTS FOR A SHORT TIME AFTER THE ENGINE IS SHUTDOWN. THE COMPONENTS STAY HOT AND CAN CAUSE INJURY.

WARNING: MAKE SURE THAT THE AIRCRAFT IS SAFE FOR MAINTENANCE. THIS WILL PREVENT INJURIES TO PERSONNEL AND/OR DAMAGE TO THE EQUIPMENT.

- (1) Remove the Left hand Fan Cowl Door. Refer to the Aircraft Maintenance Manual, task 71-13-11-000-010.
- (2) Remove the right hand Fan Cowl Door. Refer to the Aircraft Maintenance Manual, task 71-13-16-000-010.

B. Rework Instructions

- (1) Find the 740-4030-503/504 upper Locator on the Fan Cowl Door. Refer to Figure 1.

- (2) Use the marking pen (CoMat 06-131) to mark the new profile onto the Locator as follows:

- A line of the new aft edge 0.525 in. +0.0 -0.004 in. (13,3 mm +0 -0.1 mm) from the forward edge.

- Two new corner chamfers 0.07 in. (0,18 mm) x 45 Deg.

NOTE: When you remove the material from the upper-locator make sure that you do not damage the Fan Cowl Door. If necessary, remove and install the upper-locators as instructed in the Component Maintenance Manual, Chapter 71-13-00.

- (3) Carefully remove the material from the Locator to suit new spigot profile. Make sure that you blend the new spigot profile at the base of the locator with radius 0.06 in. +0.02 -0.00 in. (1,5 mm +0,5 -0,0 mm). Refer to Figure 1, view B 'Post Mod'.
- (4) Deburr the cut metal edges.

WARNING: COMAT 01-076 OR COMAT 01-124 SOLVENT IS FLAMMABLE AND THE VAPOUR IS HARMFUL. USE IN A WELL VENTILATED AREA. AVOID PROLONGED BREATHING OF VAPOURS OF PROLONGED OR REPEATED CONTACT WITH SKIN. HIGH CONCENTRATIONS MAY CAUSE IMPAIRED JUDGEMENT. PROTECTIVE GLOVES SHOULD BE WORN DURING USE. MAY CAUSE DERMATITIS BY REMOVING SKIN OILS. PRIOR TO USE OF THIS PRODUCT, READ THE 'MATERIAL SAFETY DATA SHEET' AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (5) Use a clean, lint free cloth dampened with CoMat 01-076 or CoMat 01-124 solvent to remove all oil, grease, dirt or other contaminants from the exposed surfaces of the upper Locator. Wipe the area dry with a clean, lint free cloth before the solvent evaporates. Refer to the IAE/V2500 Standard Practices / Process Manual, Task 70-11-26-300-503.

WARNING: IT IS THE RESPONSIBILITY OF THE OPERATOR TO OBTAIN AND OBSERVE THE MANUFACTURERS MATERIAL SAFETY DATA SHEETS FOR CONSUMABLE MATERIALS INFORMATION SUCH AS, HAZARDOUS INGREDIENTS, PHYSICAL/CHEMICAL CHARACTERISTICS, FIRE, EXPLOSION, REACTIVITY, HEALTH HAZARD DATA, PRECAUTIONS FOR SAFE HANDLING, USE AND CONTROL MEASURES AND ALSO TO TAKE LOCAL REGULATIONS INTO CONSIDERATION.

- (6) Apply one coat of BMS 10-11, Type I Primer (CoMat 07-080C) to the exposed surface areas and allow to dry. Refer to the IAE/V2500 Standard Practices / Process Manual, Task 70-38-07.
- (7) Use the marking pen (CoMat 06-131) to re-identify the 740-4030-503 upper Locator to 740-4030-505 and the 740-4030-504 upper Locator to 740-4030-506.
- (8) Reidentify the 745-4001-503 Left hand Fan Cowl Door to 745-4001-507 with a metal stamp or vibro-etch engraver. Refer to the IAE/V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (9) Reidentify the 745-4002-511 right hand Fan Cowl Door to 745-4002-515 with a metal stamp or vibro-etch engraver. Refer to the IAE/V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (10) For all other standards of A1 and A5 Left and right hand Fan Cowl Doors not referred to in step (8) or step (9) engrave this Service Bulletin number to the Mod Plates with a metal stamp or vibro-etch engraver. Refer to the IAE/V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
- (11) Make sure that the work area is clean and clear of tools and other items.

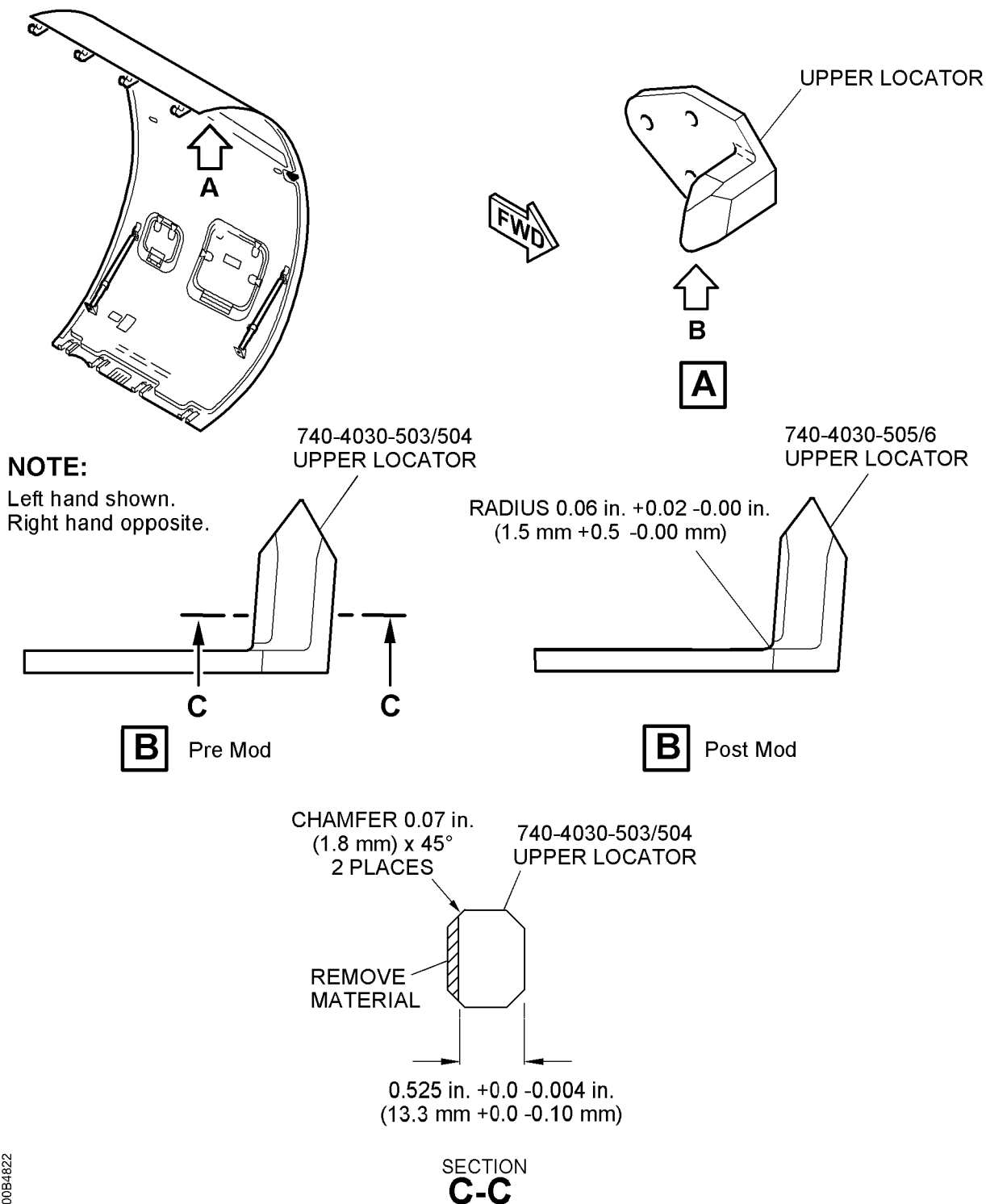
C. Post-requisite Instructions

- (1) Install the Left hand Fan Cowl Door. Refer to the Aircraft Maintenance Manual, task 71-13-11-400-010.

- (2) Install the right hand Fan Cowl Door. Refer to the Aircraft Maintenance Manual, task 71-13-16-400-010.

D. Recording Instructions

- (1) A record of accomplishment is necessary. Write in the Aircraft Log Book that Service Bulletin V2500-NAC-71-0293 has been done.



Rework of the Fan Cowl Door Upper Locator
Figure 1

NACELLE – POWERPLANT – FAN COWL DOOR – REWORK OF THE UPPER LOCATORSUPPLEMENT – 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 Goodrich Spares and/or current price catalogue for current prices.

1. Modification Kit:

Not applicable.

2. Parts Required:

Not applicable.