



400 MAIN STREET, MAIL STOP 121-10  
EAST HARTFORD, CT 06108, USA.  
TELEPHONE:- 860 565 5515  
FAX:- 860 565 0600

DATE: Nov.10/08

P.O. BOX 31, DERBY  
TELEGRAMS - 'ROYCAR' DERBY  
TELEX - 37645  
TELEPHONE:- 44 (0) 1332 242424  
FAX:- 44 (0) 1332 249936

## V2500-A1/A5 SERIES PROPULSION SYSTEM NON-MODIFICATION SERVICE BULLETIN

Printed in Great Britain

This document transmits the Revision 1 of Non-Modification Service Bulletin V2500-NAC-71-0298

### Document History

#### Service Bulletin Revision Status

Initial Issue Oct.21/08

#### Service Bulletin Revision 1

Remove	Incorporate	Reason for change
All pages of the Non-Modification Service Bulletin	Pages 1 to 10 of the Non-Modification Service Bulletin	To delete step C.(6) in the Accomplishment Instructions.

**V2500-NAC-71-0298**  
Transmittal - Page 1 of 1

CHECK THAT ALL PREVIOUS TRANSMITTALS HAVE BEEN INCORPORATED  
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NON-MODIFICATION SERVICE BULLETIN – NACELLE – FORWARD AND AFT ENGINE MOUNT ASSEMBLIES  
– BOLT IDENTIFICATION

Printed in Great Britain

1. Planning Information

A. Effectivity

- (1) Aircraft
  - (a) Airbus A319
  - (b) Airbus A320
  - (c) Airbus A321
- (2) Nacelle
  - (a) V2500-A1
  - (b) V2500-A5

B. Concurrent Requirements

None.

C. Reason

- (1) Problem

Engine mount bolts are identified with incomplete part number on bolt head.
- (2) Evidence

Engine mount bolts have been found in the field with various markings.
- (3) Substantiation

Not applicable.
- (4) Objective

To verify that the bolt heads are crossdrilled where required and reidentify all affected bolts to match the part number in its entirety.
- (5) Effect of Bulletin on:
  - (a) Operation: Not affected.
  - (b) Maintenance: Not affected.

- (c) Overhaul: Affected.
- (d) Repair Scheme: Not affected.
- (e) Interchangeability: Not affected.
- (f) Fits and Clearances: Not affected.

**D. Description**

This Non-Modification Service Bulletin provides instructions to inspect, and where necessary, re-mark engine mount bolt heads with complete part number and suffix.

**E. Approval**

The technical content of this Non-Modification Service Bulletin has been approved under the authority of the EASA Design Organization Approval No.EASA.21J.031.

The authorizing IAE document is EC 05VN177.

**F. Compliance**

Category 6

Inspect forward and aft engine mount bolts for complete part number at next engine shop visit.

**G. Manpower**

Estimated man-hours to incorporate the full intent of this Non-Modification Service Bulletin on one thrust reverser.

(1) In Service

Not applicable.

(2) At Overhaul

To inspect:

1 hour per nacelle (2 hours per aircraft).

**NOTE:** Man-hours estimate is provided for planning purposes only. No labor reimbursement is provided under the terms of this Non-Modification Service Bulletin offering.

#### H. Material Price and Availability

No parts or materials are required to accomplish this Non-Modification Service Bulletin.

#### I. Tooling and Availability

Not applicable.

#### J. Weight and Balance

##### (1) Weight Change

None.

##### (2) Moment Arm

No effect.

##### (3) Datum

Engine front mount centerline (Power Plant Station (PPS) 100).

#### K. Electrical Load Data

Not applicable.

#### L. References

- (1) IAE V2500 Standard Practices/Processes Manual (SPP-V2500-1IA), Chapter/Section 70-09-00.
- (2) Airbus A319/A320/A321 Aircraft Maintenance Manual, Chapter/Section 71-21-12 and 71-00-20.
- (3) Airbus A319/A320/A321 Component Maintenance Manual, Chapter/Section 71-21-12, 71-22-11, 71-13-00 and 78-32-00.
- (4) IAE NMSB V2500-NAC-71-0305 - Non-Modification Service Bulletin - Nacelle - Forward Engine Mount - Bolt Part Number, Inspection of.
- (5) IAE Engineering Change EC 05VN177.

#### M. Other Publications Affected

None.

#### N. Interchangeability of Parts

Not applicable.

## 2. Material Information

### A. Part Prices

No parts required.

### B. Parts affected by this Service Bulletin:

The following table lists the affected engine mount bolts:

BOLT P/N	POSSIBLE HEAD MARKINGS	REQUESTED HEAD MARKING
275B0307-7H	275B0307 275B0307-7 275B0307-H 275B0307-7H 275B0307H 275B03077 275B03077H	275B0307-7H (Dash not required) NOTE: If required, cross out existing part number to ensure proper marking '275B0307-7H'.
83769H16-14	83769-16-14 83769H16-14	83769-16-14H 83769H16-14
83769H14-74	83769-14-74 83769H14-74	83769-14-74H 83769H14-74
83769H14-17	83769-14-17 83769H14-17	As indicated by Figure 1 Detail A: This location (4 places) calls for 83769-14-17 as primary and 83769H14-17 as an alternate. Both are acceptable.
121203-6H12	121203-612 121203-6H12	121203-612H 121203-6H12

**NOTE:** There has been one reported case of an incorrectly identified engine mount bolt, in this case, an 83769H14-74 bolt was misidentified as 87369-14-74. The engine mount bolt was fully compliant to the engine bolt design specifications other than the two digits in the part number being transposed. If an error of this nature is found in the part number during inspection refer to Service Bulletin V2500-NAC-71-0305 for action.

### C. Instructions/Disposition Code:

None.

D. Tooling – Price and Availability:

No special tools are required.

E. Materials Required to do this Non-Modification Service Bulletin:

None.

### 3. Accomplishment Instructions

- A. To remove the powerplant, refer to AMM 71-00-20.
- B. To disassemble the forward or aft engine mount, refer to CMM 71-21-12-000-001 and CMM 71-22-11-000-001, respectively.
- C. To be completed at next engine shop visit.
- (1) Refer to Table 1 and Figures 1 and 2 to locate affected bolts.
  - (2) Inspect the bolts per CMM 71-21-12-200-001 item 12.
  - (3) Use Table 1 to confirm required part number is stamped on bolt head, including any suffix. If the required part number exists on bolt head continue on to next bolt. For bolt 275B0307-7H only, the existing part number may need to be crossed out to ensure proper bolt marking. See Table 1.
  - (4) If part number is incomplete, verify that the head is crossdrilled, if missing, remove and replace the bolt. If the head is crossdrilled, remove bolt and electroetch the required part number on the bolt head at a depth of 0.010 in max. Refer to the IAE V2500 Standard Practices/Processes Manual, Chapter 70-09-00.
  - (5) For all bolts in which the part number was incomplete, electroetch "S298" on the bolt head to mark that Service Bulletin 71-0298 has been accomplished. Mark bolt head at a depth of 0.010 in max. Refer to the IAE V2500 Standard Practices /Processes Manual, Chapter 70-09-00.

**CAUTION:** DO NOT USE METAL STAMP OF VIBROETCH ON ENGINE MOUNT BOLTS.

**NOTE:** For bolt 275B0307-7H only:

If the '7' in the suffix is not stamped on the bolt head, remove bolt and measure grip length to ensure it is 0.4375 in +/- 0.010 in or 11.1 mm +/- 0.3 mm. Refer to Figure 1 Sheet 2 to measure griplength. If the length does not meet the requirements, replace bolts per AMM 71-21-12-410-064.

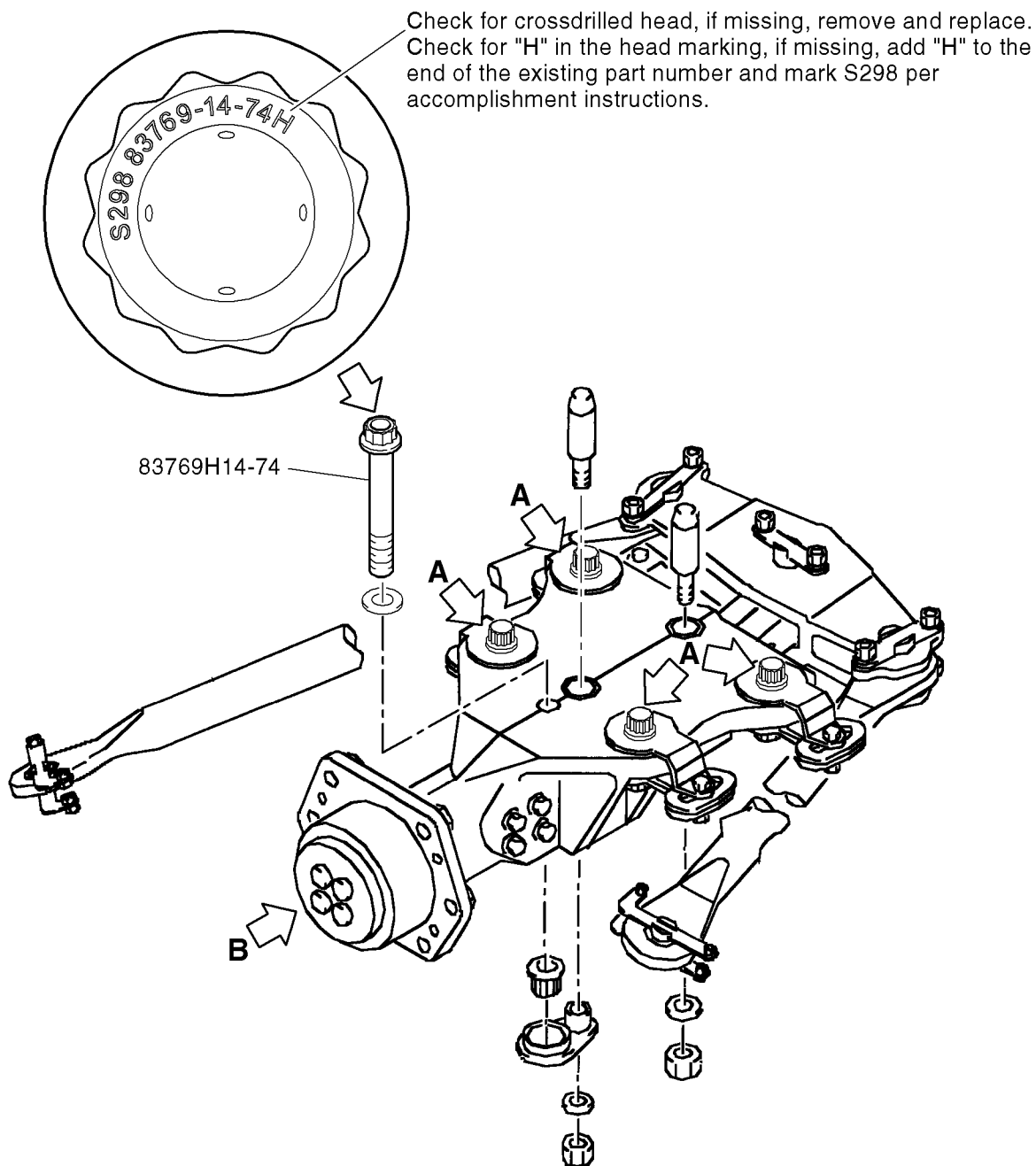
- D. To reassemble the forward or aft engine mount, refer to CMM 71-21-12-400-001 and CMM 71-22-11-400-001, respectively.
- E. To install the powerplant, refer to AMM 71-00-20.



**F. Recording Instructions**

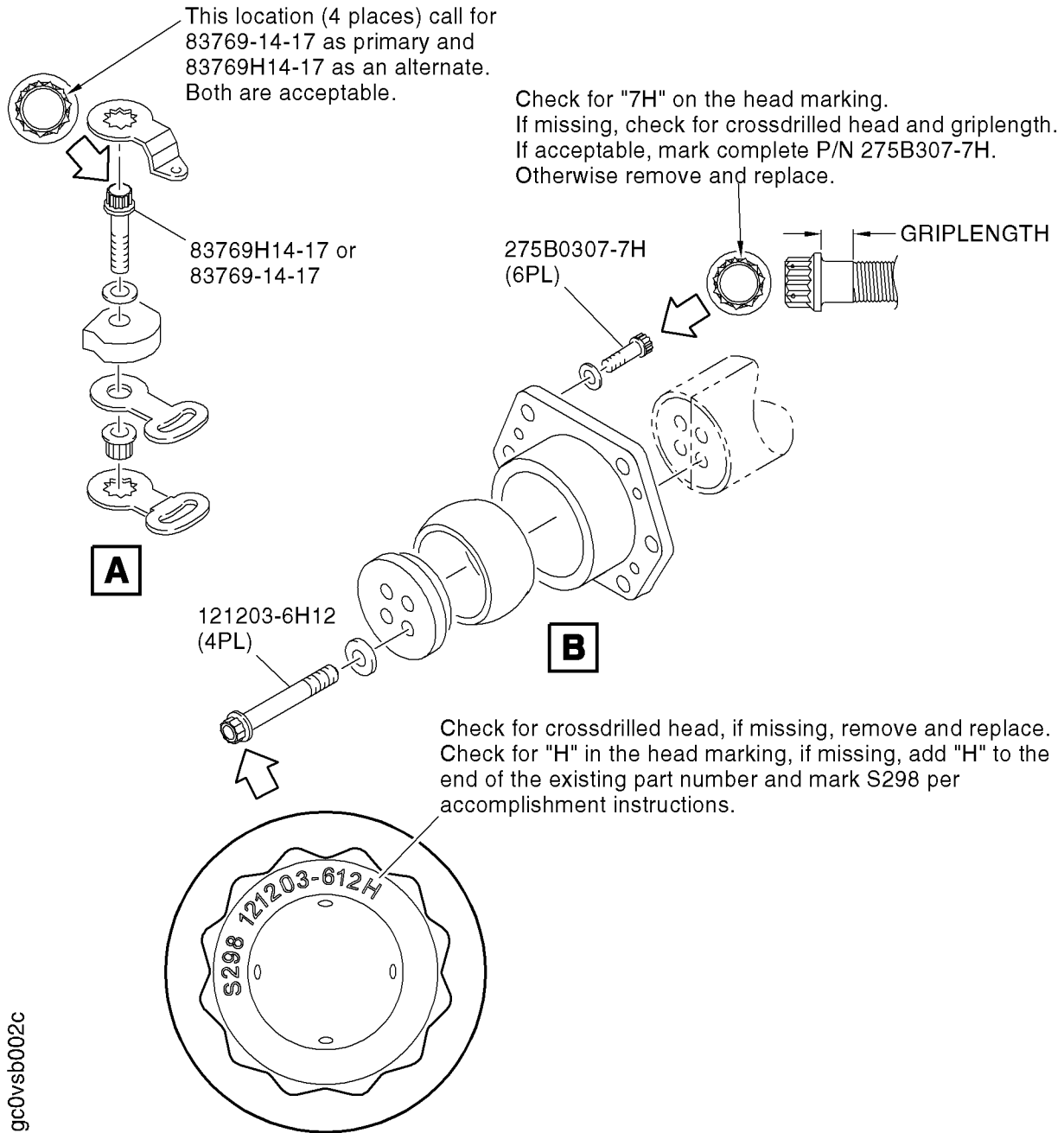
- (1) A record of accomplishment is necessary.

Write in the Aircraft Log Book that Service Bulletin V2500-NAC-71-0298 has been done.



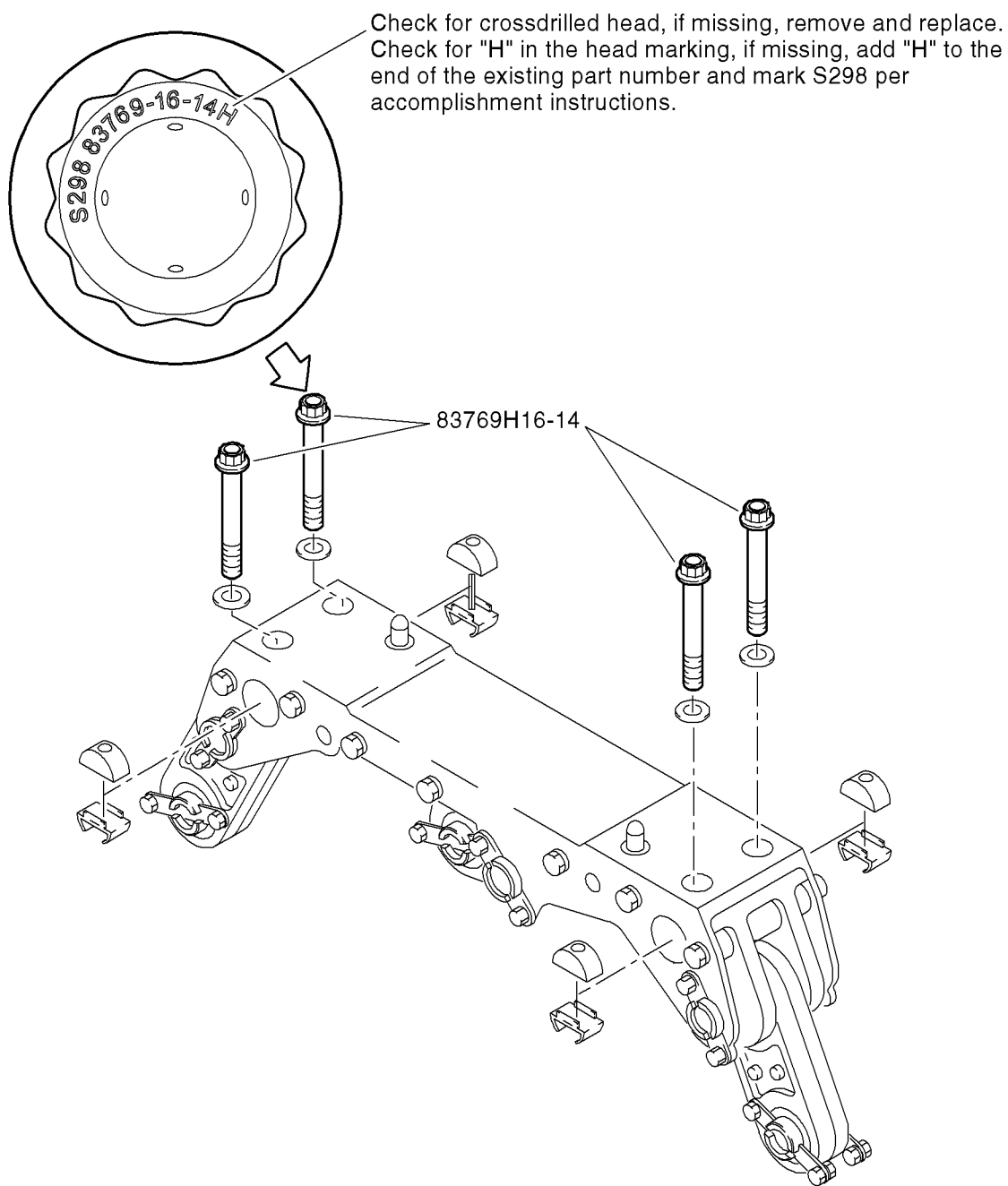
Forward Mount Assembly  
Figure 1 (Sheet 1 of 2)

gc0vrb001c



gc0vsb002c

Forward Mont Assembly  
Figure 1 (Sheet 2 of 2)



Aft Mount Assembly and Detail  
Figure 2

gc0vsb003b