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DATE: **May. 9/03****V2500-A1 SERIES NACELLE SERVICE BULLETIN**

Printed in Great Britain

This document transmits the Initial Issue of Service Bulletin NV2500-78-0208

Bulletin Initial Issue

|        |                      |                   |
|--------|----------------------|-------------------|
| Remove | Incorporate          | Reason for change |
|        | Pages 1 to 12 of the | Initial issue     |
|        | Service Bulletin     |                   |

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LIST OF EFFECTIVE PAGES

The effective pages to this Service Bulletin are as follows:

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NACELLE – EXHAUST – COMMON NOZZLE ASSEMBLY (CNA) – ADDITION OF NUTPLATES FOR  
ATTACHMENT TO ENGINE

1. Planning Information

A. Effectivity

- (1) Aircraft
  - (a) Airbus A320–231
- (2) Common Nozzle Assembly (C.N.A.)
  - (a) C.N.A.s with cum numbers 1 through 119.

B. Concurrent Requirements

None.

C. Reason

- (1) Problem
  - (a) Not applicable.
- (2) Evidence
  - (a) Not applicable.
- (3) Substantiation
  - (a) Not applicable.
- (4) Objective
  - (a) The changes in configuration recommended in this Service Bulletin are intended to improve maintainability of the C.N.A. by replacing the current attach bolts, nuts, and washers with nutplates, washers, and bolts.
- (5) Effect of Bulletin on:
  - (a) Operation
    - Not affected
  - (b) Maintenance
    - Affected

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(c) Overhaul

Not affected

(d) Repair Scheme

Affected

(e) Interchangeability

Not affected

(f) Fits and Clearances

Not affected

D. Description

This service bulletin provides instructions to install nutplates on the C.N.A. forward attach flange.

E. Compliance

Category 6

Accomplish when the nacelle subassembly is disassembled sufficiently to afford access to the affected part and all affected spare parts.

F. Approval

The part number changes and/or part modifications described in sections 2 and 3 of this Service Bulletin have been shown to comply with the applicable Federal Aviation Regulations and are FAA-APPROVED for the Engine Model(s) listed.

G. Manpower

Estimated Man-hours to incorporate the full intent of this bulletin:

(1) In Service

Not applicable

(2) At Overhaul

8 man-hours

NOTE: Man-hour estimate is provided for planning purposes only. No labor reimbursement is provided under the terms of this service bulletin offering.



#### H. Material Cost and Availability

The parts to accomplish this service bulletin are available from the manufacturer as kit V2578208-551.

Operators with units listed in Paragraph 1.A. should submit a charge purchase order for the applicable quantity of kits. The purchase order must specify this service bulletin number and only the kit and part numbers listed herein.

Operators will have one year from the issue date of this service bulletin to place an order. Upon receipt of purchase order, Rohr shall provide a delivery schedule for kits ordered. After one year, kits will no longer be available and operators will have to order parts individually at catalog prices if they desire to incorporate this change.

Direct Purchase Order to: Rohr, Inc. 850 Lagoon Drive Chula Vista, CA  
91910-2098 U.S.A.

Attn.: Regional Business Manager - MZ 107A (Ref Service Bulletin No.  
V2500-NAC-78-0208)

NOTE: Please do not submit orders for kits via the Spec 2000 ordering system.

#### I. Tooling and Availability

Special tools are not required.

#### J. Industry Support Information

Not applicable.

#### K. Weight and Balance

##### (1) Weight Change

None

##### (2) Moment Arm

No effect

##### (3) Datum

Engine front mount centreline (Powerplant Station PS 100)

#### L. Electrical Load Data

Not applicable

#### M. Software Accomplishment Summary

Not applicable



N. References

| Publication  | Chapter/Section |
|--|-----------------|
| A319/A320/A321 Aircraft Maintenance Manual                       | 78-11-11        |
| IAE V2500 Standard Practices/Processes Manual<br>(SPP-V2500-1IA) |                 |
| Internal Reference - IAE Engineering Change<br>(EC) 02VN607      |                 |
| ATA Locator Reference  | 78-11-00        |

O. Other Publications Affected

| Publication   | Chapter/Section |
|---|-----------------|
| A319/A320/A321 Aircraft Illustrated Parts<br>Catalog                      | 78-11-11        |
| Common Nozzle Assembly Component Maintenance<br>Manual (CMM-CN-V2500-1IA) | 78-11-11        |

P. Interchangeability of Parts

Not affected.

**2. Material Information****A. Kits necessary for this Service Bulletin:**

| NEW PART NO (ATA NO) | QTY | EST'D UNIT PRICE | KEYWORD                     | OLD PART NO (IPC NO) | INSTR/ DISPOS |
|----------------------|-----|------------------|-----------------------------|----------------------|---------------|
| V2578208-551         | 1   | \$7355.00        | Kit                         |                      |               |
| consisting of:       |     |                  |                             |                      |               |
| MS21060-4            | 49  |                  | Nutplate (alt to            |                      |               |
|                      |     |                  | S700N1362-4)                |                      |               |
| S700N1362-4          | 49  |                  | Nutplate (alt to MS21060-4) |                      |               |
| NAS1200-3-7          | 98  |                  | Rivet                       |                      |               |
| 275B0304-8           | 49  |                  | Bolt (alt to 77711-4-8)     |                      |               |
| 77711-4-8            | 49  |                  | Bolt (alt to 275B0304-8)    |                      |               |

**NOTE:** NOTE: Please do not order kits via Spec 2000 ordering system.

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

Applicability: For each V2500 A1 C.N.A. to incorporate this Bulletin.

78-11-11

| FIG ITEM UNIT | NEW PART NO | QTY | PART TITLE                  | MAT | OLD PART NO | INSTR DISP |
|---------------|-------------|-----|-----------------------------|-----|-------------|------------|
| TBD           | MS21060-4   | 49  | Nutplate (alt to            |     |             | (A)(S1)    |
|               |             |     | S700N1362-4)                |     |             |            |
| TBD           | S700N1362-4 | 49  | Nutplate (alt to MS21060-4) |     |             | (A)(S1)    |
| TBD           | NAS1200-3-7 | 98  | Rivet                       |     |             | (A)(S1)    |
| TBD           | 275B0304-8  | 49  | Bolt (alt to 77711-4-8)     |     |             | (A)(S1)    |
| TBD           | 77711-4-8   | 49  | Bolt (alt to 275B0304-8)    |     | -           | (A)(S1)    |

**C. Instructions/Disposition Codes:**

(A) New parts are available.

(S1) New parts must be used as a set.



D. Tooling – Price and Availability:

No special tools are required.

E. Materials Required to do this Service Bulletin:

CoMat 01-438 (or Solvent  
equivalent)

CoMat 02-099 (or Lint Free Cloth  
equivalent)

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





### 3. Accomplishment Instructions

**NOTE:** This service bulletin is written on the basis that the C.N.A. has been removed from the engine.

#### A. Install nutplates on the forward attach flange of the C.N.A.

**WARNING:**

SOLVENT (COMAT 01-438) IS CLASSIFIED AS A HAZARDOUS MATERIAL AND MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THIS PRODUCT SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO USE OF THIS PRODUCT, CAREFULLY READ THE APPLICABLE MATERIAL SAFETY DATA SHEET AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (1) Clean the flange with a lint free cloth (CoMat 02-099) made moist with solvent (CoMat 01-438). Wipe the surface dry before the solvent becomes dry.
- (2) Make the holes for the nutplate attach rivets. Refer to Figure 1 for nutplate positions. Use a 275B0304-8 or 77711-4-8 bolt to hold the nutplate in position while you make the holes for the rivets. Do not install nutplates over the three jet pipe holes. Refer to Figure 1.
- (3) Install the 49 MS21060-4 (or S700N1362-4) nutplates on the flange with the NAS1200-3-7 rivets. Refer to Figure 1.

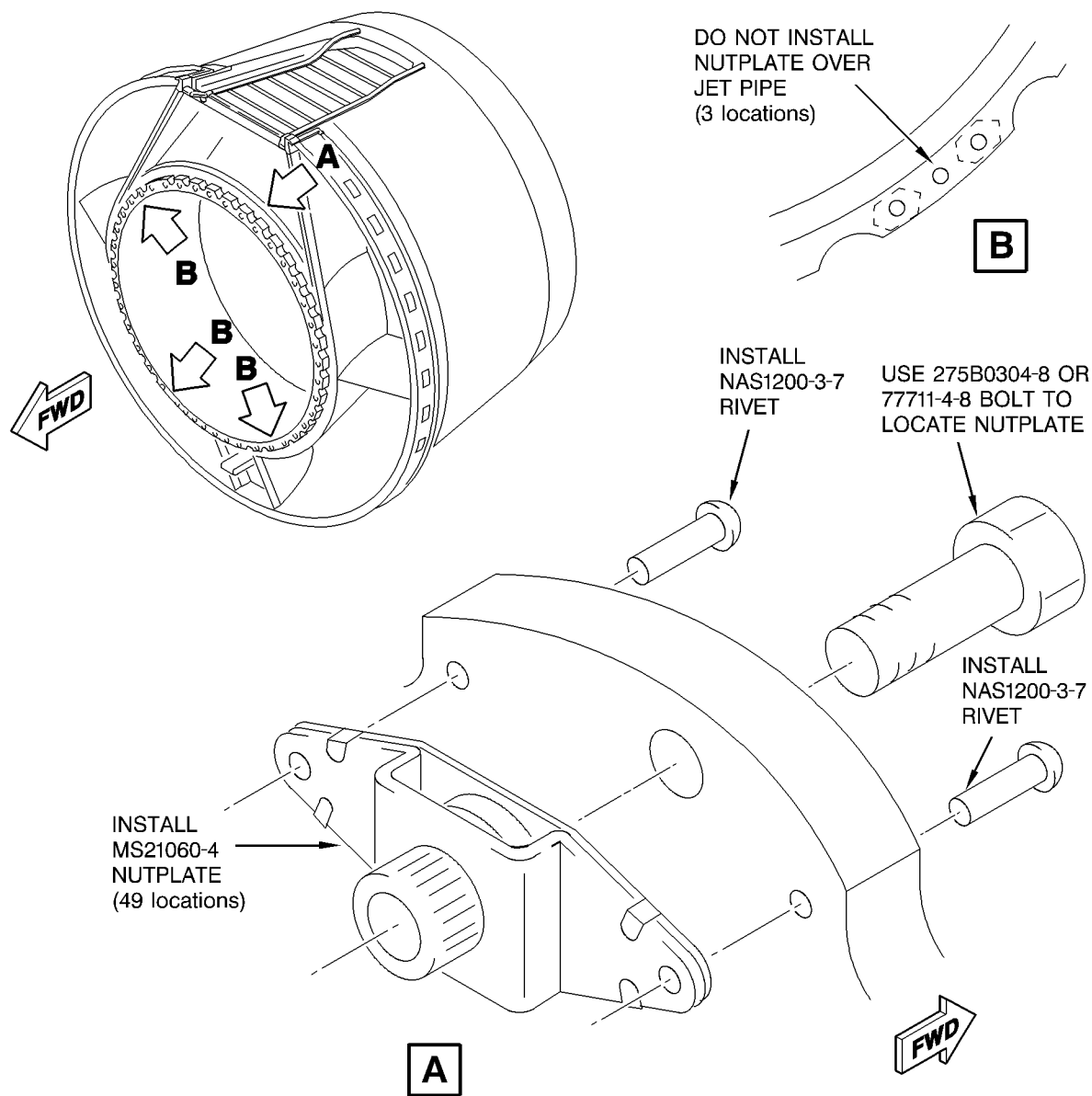
#### B. C.N.A. Installation.

**NOTE:** Before you modified the C.N.A. as instructed in this bulletin, the C.N.A. attach bolts may have been part number 84828-4-7 or 275B0304-8. After modification the C.N.A. attach bolts must be 275B0304-8 or 77711-4-8.

- (1) Refer to Figure 2 for C.N.A. installation before modification.
- (2) Refer to Figure 3 for C.N.A. installation after modification.

#### C. Recording Instructions

- (1) A record of accomplishment is required. Write in the applicable records and metal stamp, electroetch, or vibroetch on the C.N.A. data plate that Service Bulletin V2500-NAC-78-0208 has been done. Refer to the Standard Practices/Processes Manual (SPP-V2500-1IA), Chapter 70-09-00.



VSB933A

CNA Attach Ring Nutplate Installation  
Figure 1

V2500-NAC-78-0208

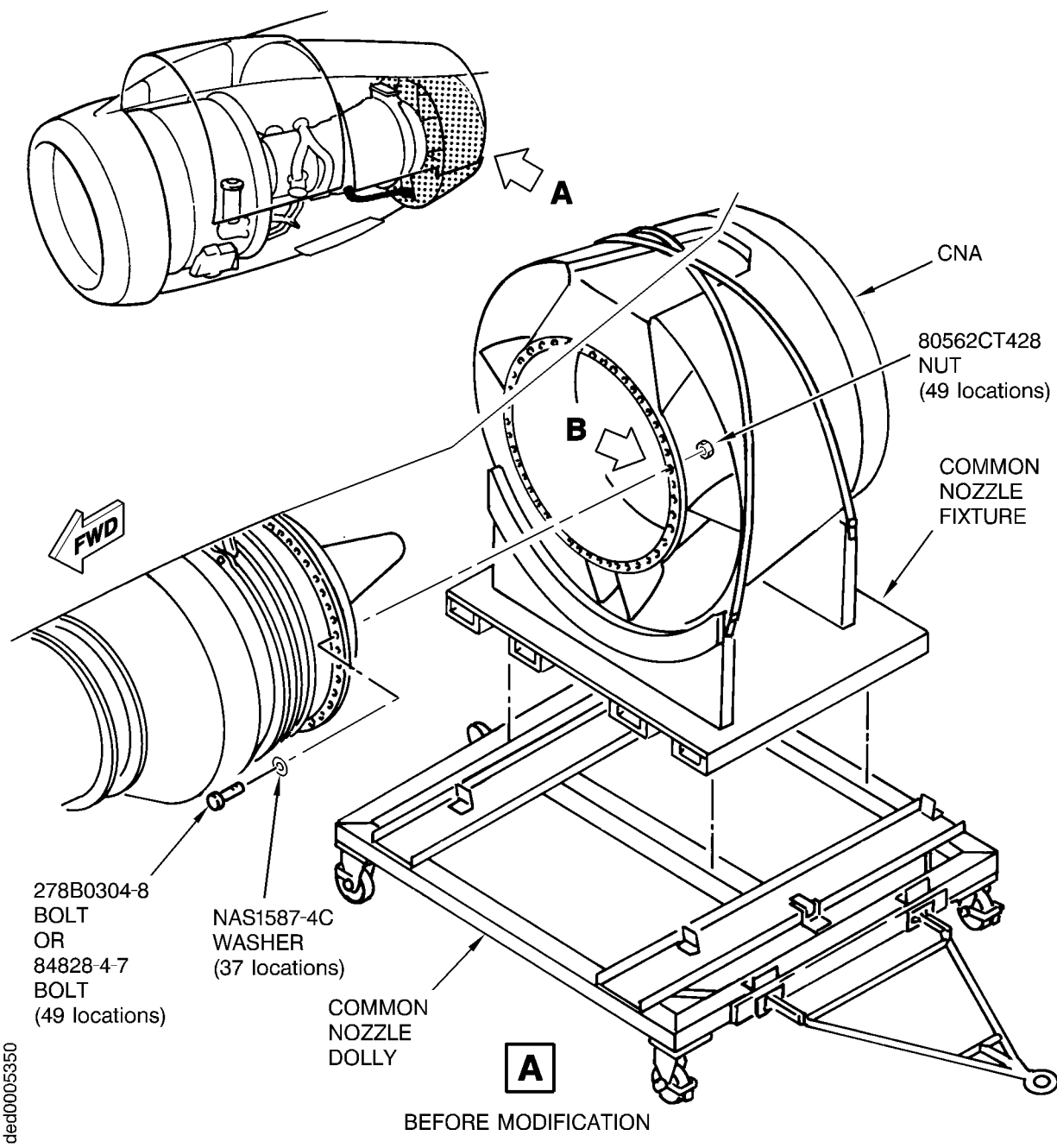
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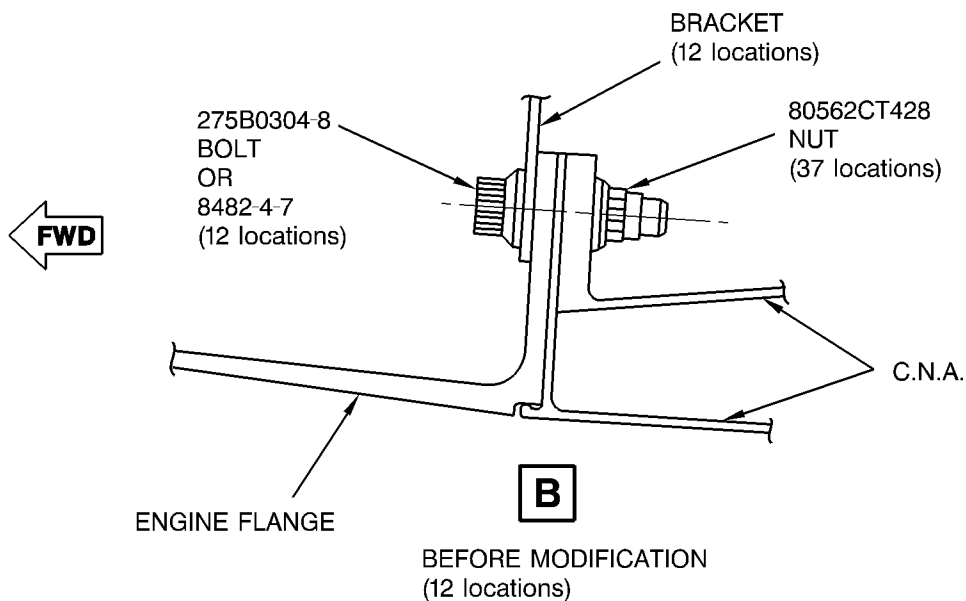
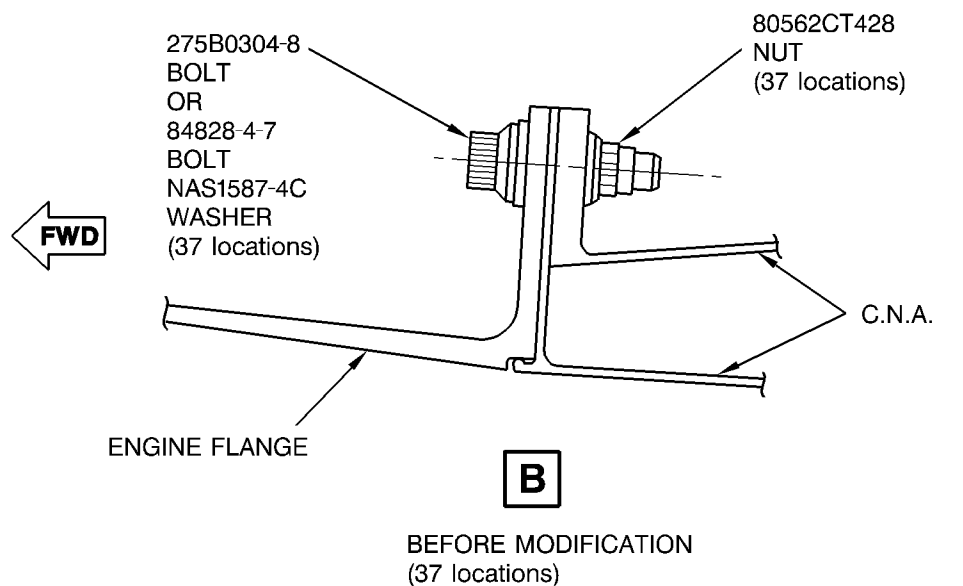
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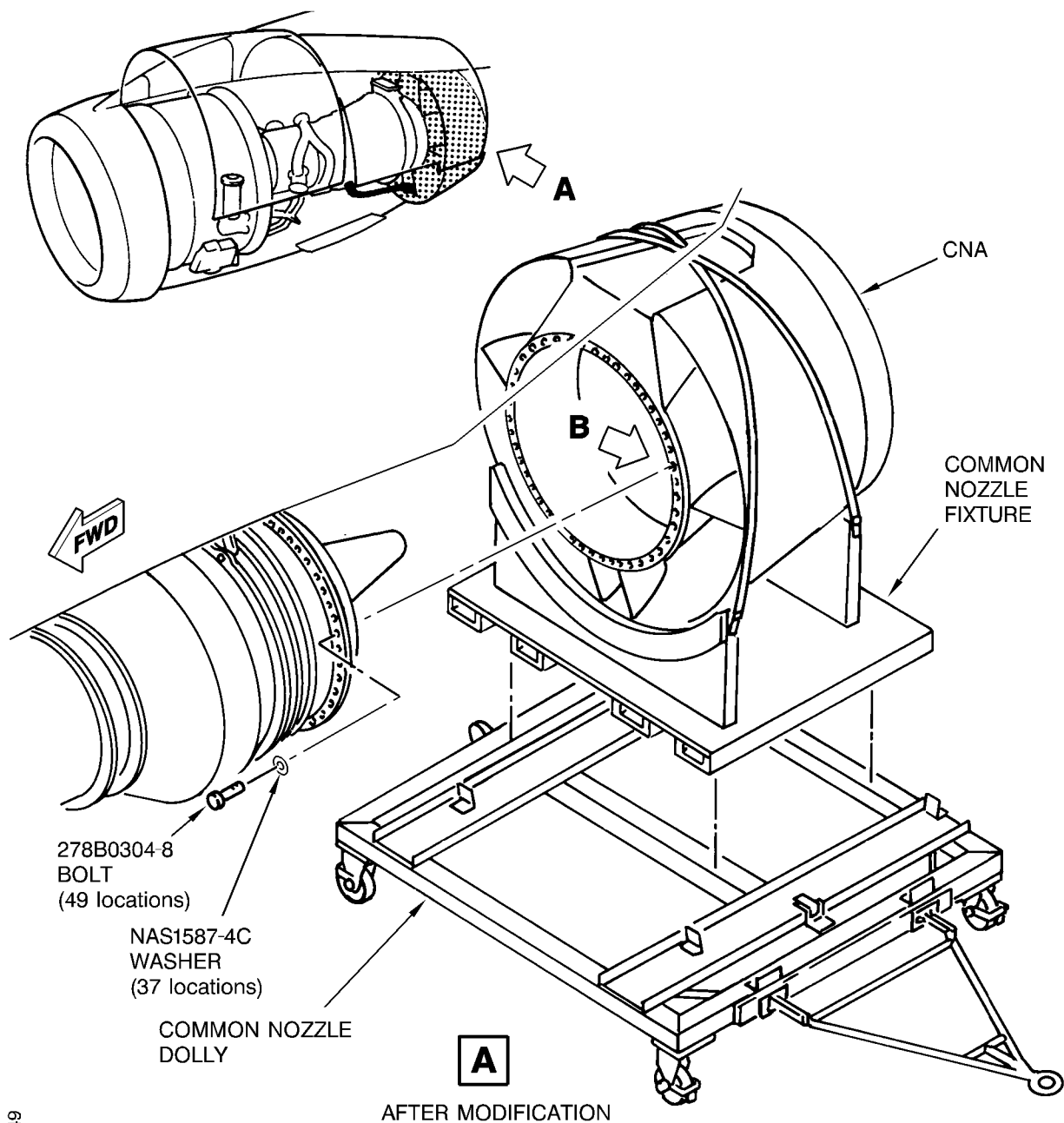
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CNA Installation - Before Modification  
Figure 2 (Sheet 1)

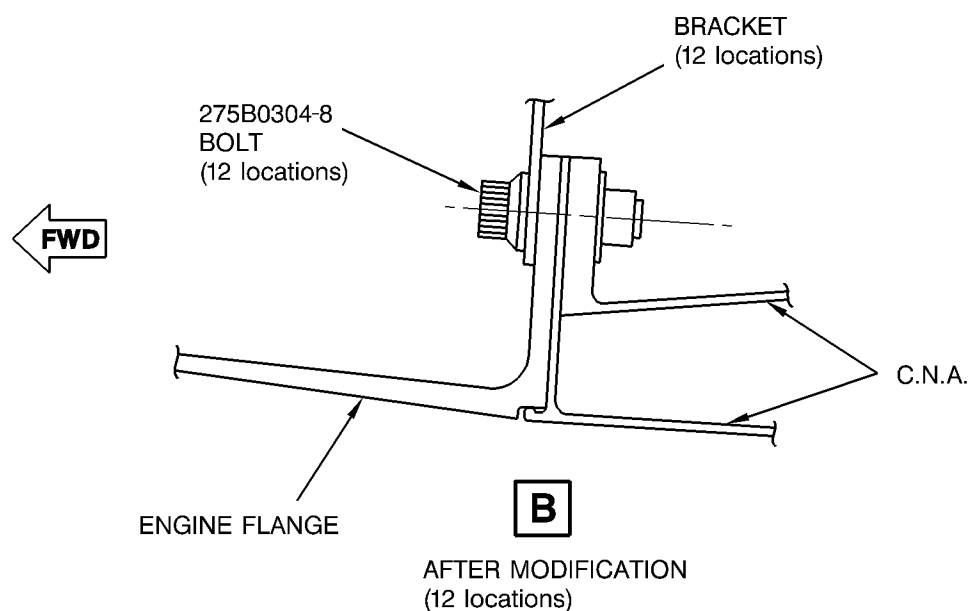
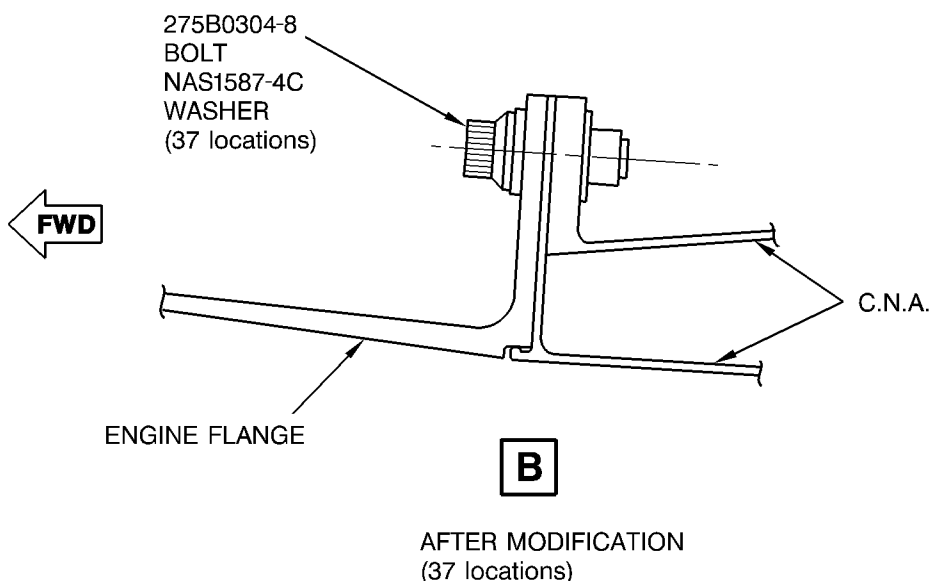


CNA Installation - Before Modification  
Figure 2 (Sheet 2)



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CNA Installation - After Modification  
Figure 3 (Sheet 1)



CNA Installation - Before Modification  
Figure 3 (Sheet 2)