



A Textron Company

ALERT SERVICE BULLETIN

206-14-131  
3 September 2014

**MODEL AFFECTED:** 206A/B and TH-67

**SUBJECT:** ENGINE, COMPRESSOR ASSEMBLY –  
INSPECTION OF FRONT SUPPORT P/N M250-  
10051, M250-10052, M250-10059, M250-10060

**HELICOPTERS AFFECTED:** Serial numbers 4 through 660 and 672 through 715  
that have been modified per BHT-206-SI-80.

Serial numbers 661 through 671, 716 through 2211,  
2212 through 4690, and 5101 through 5313.

**COMPLIANCE:** See attached Rolls-Royce Corporation ALERT  
Commercial Engine Bulletin CEB-A-1416.

**DESCRIPTION:**

The purpose of this bulletin is to achieve complete distribution of the attached vendor bulletin to the current affected model distribution list on record by Bell Helicopter Textron. As such, it is the responsibility of the owner to ensure that the most current revision of the Rolls-Royce Alert CEB-A-1416 is consulted.

**APPROVAL:**

See attached Rolls-Royce Corporation ALERT CEB-A-1416.

**CONTACT INFO:**

For any questions regarding this bulletin, please contact:

Rolls-Royce M250 Customer Support Group  
Email: [helicoptercustsupp@rolls-royce.com](mailto:helicoptercustsupp@rolls-royce.com)  
Phone: +1 (317) 230-2720 or inside North America: 1-888-255-4766



## ENGINE, COMPRESSOR ASSEMBLY - INSPECTION OF FRONT SUPPORT P/N M250-10051, M250-10052, M250-10059, M250-10060

### 1. PLANNING INFORMATION

#### A. Effectivity

##### (1) Engines

All Rolls-Royce M250<sup>®</sup> series engines or compressor modules with the affected part number front supports listed in the Table below.

##### (2) Spares - Affected

#### B. Reason

Rolls-Royce has become aware of a potential issue where the affected part number front supports could have inadequate oil flow to the number one bearing.

#### C. Description

This commercial engine bulletin provides the instructions to perform the following:

(1) For installed front supports listed in Table below perform oil flow inspection check.

(2) For non-installed front supports listed in Table below perform wire check.

**NOTE:** The front supports that are listed with a corresponding compressor serial number are as manufactured and delivered from Rolls-Royce production. The Compressor serial numbers as listed in the engine log books begin with CAC. The serial numbers in this Table were taken from the manufacturing records which only lists the last C.

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10051	JE62385	SPARE	M250-10052	JE65011	C46313
M250-10051	JE62382	SPARE	M250-10052	JE66724	C46314
M250-10051	JE62383	SPARE	M250-10052	JE66729	C46315
M250-10051	JE62376	SPARE	M250-10052	JE66750	C46317
M250-10051	JE62378	SPARE	M250-10052	JE65008	C46319
M250-10051	JE62379	SPARE	M250-10052	JE66728	C46316
M250-10051	357548	C81619	M250-10052	JE66760	C46320
M250-10051	JE62386	C81616	M250-10052	JE66755	C46318
M250-10051	JE62393	C18921	M250-10052	JE66759	C46321
M250-10051	JE65057	C81624	M250-10052	JE66725	C46322
M250-10051	JE65055	SPARE	M250-10052	JE65037	SPARE
M250-10051	JE65061	SPARE	M250-10052	JE65041	SPARE

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10051	JE65060	SPARE	M250-10052	JE66721	C46323
M250-10051	JE65086	SPARE	M250-10052	JE66735	C46325
M250-10051	JE65088	SPARE	M250-10052	JE66765	C46327
M250-10051	JE65089	SPARE	M250-10052	JE66753	C46324
M250-10051	JE65080	SPARE	M250-10052	JE63709	C46328
M250-10051	JE65084	SPARE	M250-10052	JE66762	C46326
M250-10051	JE65090	SPARE	M250-10052	JE66770	C46329
M250-10051	JE65095	SPARE	M250-10052	JE63716	C46330
M250-10051	JE65099	SPARE	M250-10052	JE66733	C46331
M250-10051	JE65101	SPARE	M250-10052	JE66785	C46332
M250-10051	JE65102	SPARE	M250-10052	JE66776	SPARE
M250-10051	JE65103	SPARE	M250-10052	JE66779	SPARE
M250-10051	JE65106	SPARE	M250-10052	JE66787	C46333
M250-10051	JE65076	SPARE	M250-10052	JE66763	SPARE
M250-10051	JE65097	SPARE	M250-10052	JE66778	SPARE
M250-10051	JE65105	SPARE	M250-10052	JE66781	SPARE
M250-10051	JE65100	SPARE	M250-10052	JE66788	C46335
M250-10051	JE65104	SPARE	M250-10052	JE66782	C46337
M250-10051	JE65098	C18925	M250-10052	JE66747	C46338
M250-10051	JE65107	C81627	M250-10052	JE66722	C46339
M250-10051	JE65115	SPARE	M250-10052	JE66783	C46336
M250-10051	JE65110	C81630	M250-10052	JE66794	C46340
M250-10051	JE65081	C18926	M250-10052	JE66772	C46334
M250-10051	JE65096	C81631	M250-10052	JE66784	C46343
M250-10051	JE65114	C81632	M250-10052	JE66803	C46342
M250-10051	JE65117	SPARE	M250-10052	JE66789	C46347
M250-10051	JE65122	SPARE	M250-10052	JE66810	C46346
M250-10051	JE65124	SPARE	M250-10052	JE66764	SPARE
M250-10051	JE65132	SPARE	M250-10052	JE66768	SPARE
M250-10051	JE65119	C81633	M250-10052	JE66775	SPARE
M250-10051	JE65128	C81634	M250-10052	JE66812	C46348
M250-10051	JE65135	C43588	M250-10052	JE66774	C46341
M250-10051	JE65123	C81635	M250-10052	JE63737	C46349
M250-10051	JE65139	C81636	M250-10052	JE66796	C46350
M250-10051	JE65121	C81637	M250-10052	JE66802	C46352

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TPCEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10051	JE65127	C81638	M250-10052	JE66795	C46356
M250-10051	JE65094	SPARE	M250-10052	JE66824	C46357
M250-10051	JE65125	SPARE	M250-10052	JE66793	C46355
M250-10051	JE65136	SPARE	M250-10052	JE66825	C46360
M250-10051	JE65140	SPARE	M250-10052	JE66809	C46361
M250-10051	JE65126	C81642	M250-10052	JE66821	C46358
M250-10051	JE62375	C18927	M250-10052	JE66817	C46362
M250-10051	JE65063	SPARE	M250-10052	JE66791	C46359
M250-10051	JE65133	SPARE	M250-10052	JE66756	SPARE
M250-10051	JE65146	C43590	M250-10052	JE66777	SPARE
M250-10051	JE65120	C81643	M250-10052	JE66799	SPARE
M250-10051	JE65131	C43591	M250-10052	JE66806	SPARE
M250-10051	JE65138	SPARE	M250-10052	JE66816	C46364
M250-10051	JE65141	SPARE	M250-10052	JE67937	C46366
M250-10051	JE65116	C81644	M250-10052	JE63752	C46367
M250-10051	JE65118	C43589	M250-10052	JE66814	C46368
M250-10051	JE65147	SPARE	M250-10052	JE67934	C46369
M250-10051	JE65149	SPARE	M250-10052	JE66828	C46370
M250-10051	JE65150	C18929	M250-10052	JE67945	C46371
M250-10051	JE65112	C81645	M250-10052	JE67939	C46373
M250-10051	JE65108	C18930	M250-10052	JE66818	C46375
M250-10051	JE65142	C81647	M250-10052	JE67942	C46376
M250-10051	JE65143	C18931	M250-10052	JE67963	SPARE
M250-10051	JE67029	SPARE	M250-10052	JE67964	SPARE
M250-10051	JE67037	SPARE	M250-10052	JE66826	C46374
M250-10051	JE67032	C81648	M250-10052	JE66819	C46372
M250-10051	JE65148	SPARE	M250-10052	JE67959	C46377
M250-10051	JE67035	SPARE	M250-10052	JE67944	C46381
M250-10051	JE67042	SPARE	M250-10052	JE67955	C46378
M250-10051	JE62383	C81649	M250-10052	JE67940	C46379
M250-10051	JE65144	C81650	M250-10052	JE66805	C46353
M250-10051	JE65145	C81651	M250-10052	JE66807	C46351
M250-10051	JE67043	C81653	M250-10052	JE67971	C46385
M250-10051	JE65151	SPARE	M250-10052	JE67947	C46386
M250-10051	JE65153	SPARE	M250-10052	JE66758	C46388

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10051	JE67030	C81655	M250-10052	JE67969	C46389
M250-10051	JE67034	SPARE	M250-10052	JE66808	C46354
M250-10051	JE67038	SPARE	M250-10052	JE66822	C46382
M250-10051	JE67045	C81652	M250-10052	JE67936	C46380
M250-10051	JE67031	C81654	M250-10052	JE67938	SPARE
M250-10051	JE67052	C81656	M250-10052	JE67956	SPARE
M250-10051	JE67053	C81658	M250-10052	JE67957	SPARE
M250-10051	JE67064	C81657	M250-10052	JE66731	C46391
M250-10051	JE67075	C81659	M250-10052	JE67962	C46390
M250-10051	JE67033	SPARE	M250-10052	JE67952	C46383
M250-10051	JE67047	SPARE	M250-10052	JE67973	C46392
M250-10051	JE67049	SPARE	M250-10052	JE67987	C46393
M250-10051	JE67050	SPARE	M250-10052	JE67990	C46395
M250-10051	JE67055	SPARE	M250-10052	JE66811	C46394
M250-10051	JE67056	SPARE	M250-10052	JE67989	SPARE
M250-10051	JE67059	SPARE	M250-10052	JE67996	SPARE
M250-10051	JE67061	SPARE	M250-10052	JE66761	C46396
M250-10051	JE67063	SPARE	M250-10052	JE67929	C46387
M250-10051	JE67069	SPARE	M250-10052	JE67935	C46401
M250-10051	JE67077	SPARE	M250-10052	JE67951	C46398
M250-10051	JE67080	SPARE	M250-10052	JE67954	C46397
M250-10051	JE67068	C18932	M250-10052	JE67953	C46404
M250-10051	JE67054	C81660	M250-10052	JE67958	C46399
M250-10051	JE67085	C81663	M250-10052	JE67994	C46400
M250-10051	JE67090	C18933	M250-10052	JE66823	C46405
M250-10051	JE67086	C81664	M250-10052	JE66827	C46403
M250-10051	JE67078	SPARE	M250-10052	JE67992	C46402
M250-10051	JE67081	SPARE	M250-10052	JE66800	C46406
M250-10051	JE67092	C81665	M250-10052	JE67960	C46407
M250-10051	JE67083	C81666	M250-10052	JE67968	C46408
M250-10051	JE67072	C81667	M250-10052	JE67941	C46409
M250-10051	JE67104	C81668	M250-10052	JE67967	C46410
M250-10051	JE67067	SPARE	M250-10052	JE67999	C46411
M250-10051	JE67105	SPARE	M250-10052	JE67946	C46384
M250-10051	JE67114	C81669	M250-10052	JE67976	C46415

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TPCEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10051	JE67097	C81670	M250-10052	JE67988	C46412
M250-10051	JE67046	C18936	M250-10052	JE67991	C46414
M250-10051	JE65094	C18937	M250-10052	JE67948	C46413
M250-10051	JE67057	C81671	M250-10052	JE67998	C46416
M250-10051	JE67082	C18934	M250-10052	JE67979	C46417
M250-10051	JE67123	C43592	M250-10052	JE68007	C46418
M250-10051	JE67095	C18935	M250-10052	JE67997	C46420
M250-10051	JE67108	C18938	M250-10052	JE68002	C46423
M250-10051	JE67112	C81672	M250-10052	JE68005	SPARE
M250-10051	JE67121	C81673	M250-10052	JE68630	SPARE
M250-10051	JE67058	C81662	M250-10052	JE67982	C46426
M250-10051	JE67120	C43593	M250-10052	JE68006	C46421
M250-10051	JE67065	C81661	M250-10052	JE68011	C46425
M250-10051	JE67109	SPARE	M250-10052	JE68026	C46427
M250-10051	JE68829	SPARE	M250-10052	JE67986	C46424
M250-10051	JE67126	C81674	M250-10052	JE67993	C46429
M250-10051	JE67128	C81675	M250-10052	JE68001	C46431
M250-10051	JE67125	C81676	M250-10052	JE68023	C46430
M250-10051	JE67113	C81677	M250-10052	JE67931	C46419
M250-10051	JE67111	C81678	M250-10052	JE67978	C46422
M250-10051	JE68845	SPARE	M250-10052	JE68024	C46432
M250-10051	JE68846	SPARE	M250-10052	JE67961	C46428
M250-10051	JE67127	C81679	M250-10052	JE68013	C46433
M250-10051	JE67107	C81680	M250-10052	JE68016	C46434
M250-10051	JE67119	C81681	M250-10052	JE68022	C46435
M250-10051	JE68844	C43594	M250-10052	JE68000	C46439
M250-10051	JE68832	C81682	M250-10052	JE68003	C46438
M250-10051	JE68843	C81683	M250-10052	JE68009	C46436
M250-10051	JE67122	SPARE	M250-10052	JE68020	C46437
M250-10051	JE67066	SPARE	M250-10052	JE68004	C46441
M250-10051	JE67071	SPARE	M250-10052	JE67950	C46445
M250-10051	JE68854	SPARE	M250-10052	JE67985	C46443
M250-10051	JE68863	SPARE	M250-10052	JE67970	C46446
M250-10051	JE68862	SPARE	M250-10052	JE67983	C46447
M250-10051	JE68871	SPARE	M250-10052	JE67949	C46448

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

EXPORT CONTROLLED

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	GX107503	C45926	M250-10052	JE68638	C46449
M250-10052	GX107523	C46004	M250-10052	JE68015	C46440
M250-10052	JE61955	C46010	M250-10052	JE68633	C46450
M250-10052	GX107518	C46013	M250-10052	JE68012	C46442
M250-10052	GX107520	C46012	M250-10052	JE67995	C46452
M250-10052	GX107515	C46015	M250-10052	JE67933	C46444
M250-10052	JE61959	C46011	M250-10052	JE67972	C46453
M250-10052	GX107522	C46016	M250-10052	JE68027	C46451
M250-10052	GX107521	C46014	M250-10052	JE66790	SPARE
M250-10052	GX107517	C46057	M250-10052	JE66804	SPARE
M250-10052	JE61971	C46079	M250-10052	JE67932	C46455
M250-10052	JE61964	C46080	M250-10052	JE67977	C46454
M250-10052	JE61963	C46083	M250-10052	JE66792	C46458
M250-10052	JE61973	C46091	M250-10052	JE67984	C46456
M250-10052	JE61969	C46092	M250-10052	JE66773	C46459
M250-10052	JE63630	C46093	M250-10052	JE68025	C46461
M250-10052	JE61968	C46094	M250-10052	JE68640	SPARE
M250-10052	JE63621	C46106	M250-10052	JE68641	SPARE
M250-10052	JE61980	C46107	M250-10052	JE68658	C46464
M250-10052	JE63624	SPARE	M250-10052	JE68664	C46463
M250-10052	JE63650	SPARE	M250-10052	JE68010	C46465
M250-10052	JE63616	SPARE	M250-10052	JE68634	C46462
M250-10052	JE63620	C46112	M250-10052	JE68659	C46467
M250-10052	JE63627	C46114	M250-10052	JE67974	C46466
M250-10052	JE63619	C46113	M250-10052	JE68660	C46468
M250-10052	JE63628	C46115	M250-10052	JE66801	C46460
M250-10052	JE61982	C46120	M250-10052	JE68657	C46457
M250-10052	JE63611	C46116	M250-10052	JE68642	C46470
M250-10052	JE63612	C46111	M250-10052	JE68661	C46472
M250-10052	JE63613	C46124	M250-10052	JE66797	C46473
M250-10052	JE63610	C46117	M250-10052	JE68636	C46474
M250-10052	JE63618	C46125	M250-10052	JE68019	SPARE
M250-10052	JE61975	C46119	M250-10052	JE68632	SPARE
M250-10052	JE63635	C46118	M250-10052	JE68680	SPARE
M250-10052	JE63625	SPARE	M250-10052	JE68018	C46476

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TPCEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE63626	C46129	M250-10052	JE68639	C46479
M250-10052	JE63651	SPARE	M250-10052	JE68631	C46475
M250-10052	JE63658	SPARE	M250-10052	JE68662	C46477
M250-10052	JE63663	SPARE	M250-10052	JE68672	C46480
M250-10052	JE63668	SPARE	M250-10052	JE67943	C46481
M250-10052	JE63636	C46142	M250-10052	JE68021	C46482
M250-10052	JE63661	C46143	M250-10052	JE68017	C46483
M250-10052	JE63681	C46144	M250-10052	JE68666	C46484
M250-10052	JE63684	C46147	M250-10052	JE68683	C46485
M250-10052	JE63654	SPARE	M250-10052	JE68665	C46486
M250-10052	JE63682	C46149	M250-10052	JE68656	C46487
M250-10052	JE63652	SPARE	M250-10052	JE68669	C46488
M250-10052	JE63685	C46150	M250-10052	JE68708	C46491
M250-10052	JE63676	C46148	M250-10052	JE68684	C46489
M250-10052	JE63660	SPARE	M250-10052	JE68685	C46492
M250-10052	JE63662	SPARE	M250-10052	JE68682	C46493
M250-10052	JE63664	SPARE	M250-10052	JE68663	C46495
M250-10052	JE63667	SPARE	M250-10052	JE68667	C46494
M250-10052	JE63669	SPARE	M250-10052	JE68671	C46496
M250-10052	JE63670	SPARE	M250-10052	JE68678	C46497
M250-10052	JE63700	SPARE	M250-10052	JE68687	C46501
M250-10052	JE63702	SPARE	M250-10052	JE68695	SPARE
M250-10052	JE63691	C46151	M250-10052	JE68696	C46513
M250-10052	JE63657	C46152	M250-10052	JE68723	C46520
M250-10052	JE63688	C46153	M250-10052	JE69063	C46524
M250-10052	JE63683	C46154	M250-10052	JE69084	SPARE
M250-10052	JE63607	SPARE	M250-10059	GX107534	SPARE
M250-10052	JE63609	SPARE	M250-10059	GX107538	SPARE
M250-10052	JE63633	SPARE	M250-10059	GX107537	SPARE
M250-10052	JE63639	SPARE	M250-10059	GX107539	C92398
M250-10052	JE63641	SPARE	M250-10059	JE61990	C92399
M250-10052	JE63645	SPARE	M250-10059	JE61988	C98570
M250-10052	JE63648	SPARE	M250-10059	JE62010	C92400
M250-10052	JE63665	C46155	M250-10059	JE61997	C92401
M250-10052	JE63693	SPARE	M250-10059	JE61998	C92402

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101



# ALERT

## Rolls-Royce

EXPORT CONTROLLED

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE63694	SPARE	M250-10059	JE61989	C92403
M250-10052	JE63697	SPARE	M250-10059	JE61985	C92404
M250-10052	JE63701	SPARE	M250-10059	JE62000	C92406
M250-10052	JE63672	C46156	M250-10059	JE61995	C92405
M250-10052	JE63692	C46158	M250-10059	GX107536	C98574
M250-10052	JE63647	C46157	M250-10059	JE61996	C98575
M250-10052	JE63671	C46160	M250-10059	JE66668	C98576
M250-10052	JE63687	C46166	M250-10059	JE66667	C98577
M250-10052	JE63708	C46163	M250-10059	JE66669	C92409
M250-10052	JE63717	C46162	M250-10059	JE66666	C98578
M250-10052	JE63707	C46164	M250-10059	JE66670	C98579
M250-10052	JE63715	C46167	M250-10059	JE62011	C92411
M250-10052	JE63699	C46159	M250-10059	JE66665	C92410
M250-10052	JE63720	C46161	M250-10059	JE62001	C98580
M250-10052	JE63726	C46165	M250-10059	JE66673	C98581
M250-10052	JE63614	C46173	M250-10059	JE66675	C92412
M250-10052	JE63705	C46172	M250-10059	JE66674	SPARE
M250-10052	JE63690	C46174	M250-10059	JE66664	C98582
M250-10052	JE63713	C46169	M250-10059	JE66679	C98583
M250-10052	JE63719	C46170	M250-10059	JE66672	C98584
M250-10052	JE63721	C46169	M250-10059	JE66678	C92413
M250-10052	JE63677	C46175	M250-10059	JE66680	C92414
M250-10052	JE63711	C46168	M250-10059	JE66688	C92415
M250-10052	JE63638	C46176	M250-10059	JE66690	C98585
M250-10052	JE63714	C46177	M250-10059	JE66686	C98586
M250-10052	JE63722	SPARE	M250-10059	JE66748	C98587
M250-10052	JE63695	C46182	M250-10059	JE66691	C98588
M250-10052	JE63739	C46183	M250-10059	JE66682	C92417
M250-10052	JE63679	C46178	M250-10059	JE66657	C92416
M250-10052	JE63673	C46185	M250-10059	JE66662	C92418
M250-10052	JE63704	C46187	M250-10059	JE66695	C92419
M250-10052	JE63728	C46186	M250-10059	JE66683	C98589
M250-10052	JE61970	C46188	M250-10059	JE66698	SPARE
M250-10052	JE63680	C46189	M250-10059	GX107534	C98590
M250-10052	JE63712	C46190	M250-10059	JE66661	C92420

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series            CEB-A-1416  
M250-C20R Series        CEB-A-72-4104  
M250-C30 Series         CEB-A-72-3297  
M250-C40B                CEB-A-72-5066  
M250-C47 Series         CEB-A-72-6079  
M250-B17 Series         TPCEB-A-1353  
M250-B17F Series        TP CEB-A-72-2101

# ALERT

## Rolls-Royce

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE63725	C46191	M250-10059	JE66696	C98591
M250-10052	JE63735	C46192	M250-10059	JE66693	C98592
M250-10052	JE64957	C46193	M250-10059	JE66700	C98593
M250-10052	JE64956	C46195	M250-10059	JE66684	C98594
M250-10052	JE63733	C46194	M250-10059	JE67229	C98595
M250-10052	JE63748	C46196	M250-10059	JE66701	C92421
M250-10052	JE63655	C46198	M250-10059	JE66660	C98596
M250-10052	JE63753	C46197	M250-10059	JE67230	C92422
M250-10052	JE63723	C46201	M250-10059	JE66703	C98598
M250-10052	JE63634	C46199	M250-10059	JE66655	C92423
M250-10052	JE63674	C46181	M250-10059	JE67231	C98599
M250-10052	JE63740	C46171	M250-10059	JE66692	C98601
M250-10052	JE63710	C46204	M250-10059	JE67235	C98600
M250-10052	JE64965	C46205	M250-10059	JE67233	C92424
M250-10052	JE63749	C46202	M250-10059	JE66681	C92426
M250-10052	JE64975	C46179	M250-10059	JE66699	C92425
M250-10052	JE64972	C46208	M250-10059	JE66689	SPARE
M250-10052	JE64977	C46207	M250-10060	GX107573	C81317
M250-10052	JE64958	C46209	M250-10060	JE62040	C28418
M250-10052	JE64995	C46210	M250-10060	JE62037	C28420
M250-10052	JE63742	SPARE	M250-10060	JE62023	C81322
M250-10052	JE64969	SPARE	M250-10060	JE62028	C28419
M250-10052	JE64985	SPARE	M250-10060	JE62033	C28422
M250-10052	JE64966	C46211	M250-10060	JE62030	SPARE
M250-10052	JE64961	C46206	M250-10060	JE62041	C28426
M250-10052	JE63732	SPARE	M250-10060	JE62020	C28428
M250-10052	JE63706	C46184	M250-10060	JE62017	C28425
M250-10052	JE63745	C29147	M250-10060	JE62043	C81329
M250-10052	JE64955	C46212	M250-10060	JE64755	C28432
M250-10052	JE64963	C46215	M250-10060	JE64754	C81330
M250-10052	JE64984	C46214	M250-10060	JE64761	C81331
M250-10052	JE63747	C46218	M250-10060	JE62042	C28435
M250-10052	JE64962	C46219	M250-10060	JE64764	C81333
M250-10052	JE64954	SPARE	M250-10060	JE64759	C81334
M250-10052	JE64973	SPARE	M250-10060	JE62015	C28438

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

EXPORT CONTROLLED

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE63689	SPARE	M250-10060	JE62016	C81335
M250-10052	JE64988	C46213	M250-10060	JE64765	C81336
M250-10052	JE63724	C46228	M250-10060	JE64771	SPARE
M250-10052	JE63637	SPARE	M250-10060	JE64788	SPARE
M250-10052	JE63703	C46227	M250-10060	JE64795	C28443
M250-10052	JE64981	SPARE	M250-10060	JE64792	C28442
M250-10052	JE64991	C46231	M250-10060	JE64802	C28444
M250-10052	JE63606	C46232	M250-10060	JE64807	SPARE
M250-10052	JE64994	C46229	M250-10060	JE64808	SPARE
M250-10052	JE63730	C46233	M250-10060	JE64804	SPARE
M250-10052	JE64987	C46235	M250-10060	JE64811	SPARE
M250-10052	JE64970	C46236	M250-10060	JE64805	C28446
M250-10052	JE64983	C46234	M250-10060	JE64824	C28448
M250-10052	JE65006	C46237	M250-10060	JE64806	C81340
M250-10052	JE65007	C46238	M250-10060	JE64810	C28447
M250-10052	JE64979	C46241	M250-10060	JE64826	C28449
M250-10052	JE65014	C46243	M250-10060	JE64813	SPARE
M250-10052	JE65009	C46240	M250-10060	JE64819	SPARE
M250-10052	JE64996	C46242	M250-10060	JE64825	C28450
M250-10052	JE65017	C46244	M250-10060	JE64828	SPARE
M250-10052	JE65015	C46245	M250-10060	JE64822	C28451
M250-10052	JE65016	C46246	M250-10060	JE64829	C28452
M250-10052	JE65013	C46255	M250-10060	JE64820	C81341
M250-10052	JE65018	C46247	M250-10060	JE64827	C28453
M250-10052	JE64976	C46248	M250-10060	JE64812	C81342
M250-10052	JE64982	C46249	M250-10060	JE64798	C81344
M250-10052	JE65010	C46250	M250-10060	JE64799	C81343
M250-10052	JE65019	C46251	M250-10060	JE64801	C81345
M250-10052	JE64989	C46253	M250-10060	JE64791	SPARE
M250-10052	JE64990	SPARE	M250-10060	JE64793	SPARE
M250-10052	JE65002	C46254	M250-10060	JE64797	SPARE
M250-10052	JE65020	C46258	M250-10060	JE64814	SPARE
M250-10052	JE64978	C46259	M250-10060	JE64816	SPARE
M250-10052	JE63746	C46260	M250-10060	JE64823	SPARE
M250-10052	JE65043	C46261	M250-10060	JE64830	SPARE

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TPCEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE65042	C46262	M250-10060	JE64831	SPARE
M250-10052	JE64992	C46263	M250-10060	JE64833	SPARE
M250-10052	JE65026	C46265	M250-10060	JE64834	SPARE
M250-10052	JE65032	C46266	M250-10060	JE64815	SPARE
M250-10052	JE65035	C46267	M250-10060	JE64817	SPARE
M250-10052	JE63744	C46270	M250-10060	JE64835	SPARE
M250-10052	JE65039	C46271	M250-10060	JE64847	SPARE
M250-10052	JE65031	C46272	M250-10060	JE64848	SPARE
M250-10052	JE65012	C46268	M250-10060	JE64850	SPARE
M250-10052	JE65050	SPARE	M250-10060	JE64790	C28454
M250-10052	JE65021	C46273	M250-10060	JE64841	C81348
M250-10052	JE65004	C46269	M250-10060	JE64842	C81349
M250-10052	JE65040	C46275	M250-10060	JE64768	SPARE
M250-10052	JE65047	C46274	M250-10060	JE64849	C28455
M250-10052	JE65027	C46276	M250-10060	JE64853	SPARE
M250-10052	JE64993	C46277	M250-10060	JE67129	SPARE
M250-10052	JE65029	C46278	M250-10060	JE67134	SPARE
M250-10052	JE65003	C46280	M250-10060	JE64846	C81352
M250-10052	JE63686	SPARE	M250-10060	JE67132	C81351
M250-10052	JE63731	SPARE	M250-10060	JE64844	SPARE
M250-10052	JE64980	SPARE	M250-10060	JE64845	SPARE
M250-10052	JE65005	SPARE	M250-10060	JE64840	C81353
M250-10052	JE65023	SPARE	M250-10060	JE64838	C81350
M250-10052	JE65030	C46281	M250-10060	JE64800	SPARE
M250-10052	JE65033	SPARE	M250-10060	JE67136	SPARE
M250-10052	JE65034	SPARE	M250-10060	JE67157	C28457
M250-10052	JE65046	SPARE	M250-10060	JE67130	C28456
M250-10052	JE65048	SPARE	M250-10060	JE67131	C81357
M250-10052	JE65049	SPARE	M250-10060	JE64794	C28458
M250-10052	JE65051	SPARE	M250-10060	JE67137	C81358
M250-10052	JE65052	SPARE	M250-10060	JE67148	C28459
M250-10052	JE66704	SPARE	M250-10060	JE67140	SPARE
M250-10052	JE66706	SPARE	M250-10060	JE67141	SPARE
M250-10052	JE66707	SPARE	M250-10060	JE67142	SPARE
M250-10052	JE66708	SPARE	M250-10060	JE67155	SPARE

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

EXPORT CONTROLLED

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE66714	C46282	M250-10060	JE67161	C28460
M250-10052	JE63675	C46279	M250-10060	JE67154	C28461
M250-10052	JE66705	C46285	M250-10060	JE67149	C28462
M250-10052	JE66716	C46283	M250-10060	JE67166	SPARE
M250-10052	JE66718	C46284	M250-10060	JE67169	SPARE
M250-10052	JE65038	C46286	M250-10060	JE67173	C28463
M250-10052	JE66710	SPARE	M250-10060	JE67162	C28466
M250-10052	JE66713	C46287	M250-10060	JE67158	C28469
M250-10052	JE65024	C46288	M250-10060	JE67188	C28474
M250-10052	JE66711	C46290	M250-10060	JE67163	C28465
M250-10052	JE65036	C46289	M250-10060	JE67174	C28464
M250-10052	JE66720	C46292	M250-10060	JE67186	C28473
M250-10052	JE66732	C46291	M250-10060	JE67133	C28467
M250-10052	JE66719	C46293	M250-10060	JE67150	C81359
M250-10052	JE66712	C46294	M250-10060	JE64851	C81356
M250-10052	JE66715	C46295	M250-10060	JE67146	C81360
M250-10052	JE66723	C46296	M250-10060	JE67160	C81361
M250-10052	JE66736	SPARE	M250-10060	JE67167	C28470
M250-10052	JE66737	SPARE	M250-10060	JE67185	C28471
M250-10052	JE66730	SPARE	M250-10060	JE64803	C28472
M250-10052	JE66734	SPARE	M250-10060	JE67156	C28478
M250-10052	JE66717	C46298	M250-10060	JE67187	C28475
M250-10052	JE66744	C46299	M250-10060	JE67165	C28477
M250-10052	JE66745	C46300	M250-10060	JE64832	C81346
M250-10052	JE66742	C46301	M250-10060	JE67147	C28476
M250-10052	JE66749	C46302	M250-10060	JE64839	C81347
M250-10052	JE65022	C46304	M250-10060	JE64852	C81362
M250-10052	JE66709	C46303	M250-10060	JE67135	C81363
M250-10052	JE66751	C46305	M250-10060	JE67143	C28480
M250-10052	JE66746	SPARE	M250-10060	JE67144	C28481
M250-10052	JE66754	SPARE	M250-10060	JE67138	C28479
M250-10052	JE66738	C46306	M250-10060	JE67171	C28482
M250-10052	JE66739	C46307	M250-10060	JE64837	C81354
M250-10052	JE66741	C46308	M250-10060	JE67170	C28483
M250-10052	JE66743	C46309	M250-10060	JE64787	C28484

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TPCEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

### COMMERCIAL ENGINE BULLETIN

PART	SERIAL	Compressor Serial Number	PART	SERIAL	Compressor Serial Number
M250-10052	JE65044	C46310	M250-10060	JE67139	C81364
M250-10052	JE66757	C46311	M250-10060	JE67168	C81365
M250-10052	JE66752	C46312	M250-10060	JE67175	C81366
			M250-10060	JE67184	C81367

D. Approval

Technical aspects are FAA approved.

E. Compliance

Compliance Code 2 for affected supports installed on engines with 200 flight hours or less; One time inspection to be complied within 50 flight hours after receipt of this bulletin.

Front Supports with greater than 200 flight hours; One time inspection to be complied within 150 flight hours after receipt of this bulletin.

Compliance Code 1 for non-installed spare front supports. To be complied with prior to assembly into a compressor.

F. Interchangeability - Not affected

G. Material Availability

NEW P/N	NAME	QTY/ENG
M250-10051	Support Assembly, Compressor Front	1
M250-10052	Support Assembly, Compressor Front	1
M250-10059	Support Assembly, Compressor Front	1
M250-10060	Support Assembly, Compressor Front	1

H. Tooling - Not affected

I. Weight and Balance - Not affected

J. Electrical Load Data - Not affected

K. References

- (1) 10W4 Illustrated Parts Catalog, Turboshaft Models M250-C20, -C20B, -C20C, -C20F, -C20J, -C20S, -C20W (IPC).
- (2) 10W2 Operation and Maintenance Manual, Turboshaft Models M250-C20, -C20B, -C20F, -C20J, -C20S, -C20W (OMM).
- (3) CSP 23007 Illustrated Parts Catalog, Turboshaft Models M250-C20R, -C20R/1, -C20R/2, -C20R/4 (IPC).
- (4) CSP 21007 Operation and Maintenance, Turboshaft Models M250-C20R, -C20R/1, -C20R/2, -C20R/4 (OMM).
- (5) 14W2 Operation and Maintenance Manual, Turboshaft Models 250-C30, -C30S, -C30G, -C30G/2, -C30P, -C30M (OMM).

July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

# ALERT

## Rolls-Royce

EXPORT CONTROLLED

### COMMERCIAL ENGINE BULLETIN

- (6) 14W2RU Operation and Maintenance Manual, Turboshaft Models 250-C30U, -C30R/1 (OMM).
- (7) CSP 21003 Operation and Maintenance Manual, Turboshaft Model M250-C30R/3 (OMM).
- (8) CSP 21006 Operation and Maintenance Manual, Turboshaft Model M250-C30R/3M (OMM).
- (9) 14W4 Illustrated Parts Catalog, Turboshaft Models 250-C30, -C30P, -C30M, -C30S, -C30G, -C30G/2 (IPC).
- (10) CSP 21001 Operation and Maintenance Manual, Turboshaft Model M250-C47B (OMM).
- (11) CSP 21000 Operation and Maintenance Manual, Turboshaft Model M250-C40B (OMM).
- (12) CSP 21004 Operation and Maintenance Manual, Turboshaft Model M250-C47M (OMM).
- (13) CSP 23001 Illustrated Parts Catalog, Turboshaft Models M250-C40B, -C47B, -C47M (IPC).
- (14) 14W4RU Illustrated Parts Catalog, Turboshaft Models M250-C30U, -C30R, -C30R/1 (IPC).
- (15) 11W4, Illustrated Parts Catalog, Turboprop Models M250-B17 Series (IPC).
- (16) 11W2, Operation and Maintenance Manual, Turboprop Models M250-B17 Series (OMM).
- (17) CSP23008, Illustrated Parts Catalog, Turboprop Models M250-B17F Series (IPC).
- (18) CSP21008, Operation and Maintenance Manual, Turboprop Models M250-B17F Series (OMM).

L. Other Publications Affected - None

M. Prerequisites - None

## 2. ACCOMPLISHMENT INSTRUCTIONS

**NOTE:** Although Rolls-Royce recommends front supports to be tested on the engine if possible, it is acceptable to remove the front support to perform the wire test as described below. Caution should be exercised to prevent any damage to the No. 1 bearing and seal while removing and re-installing the front support.

- A. For installed front supports, verify oil flow from front support scavenge port.
- (1) Oil Flow check to be accomplished with cold (ambient) oil.
  - (2) Disconnect the scavenge oil tube from the bottom of the Compressor Front Support (Ref OMM).
  - (3) Use suitable container's to catch the oil.
  - (4) With the ignition disarmed, engage the starter and catch the oil using the first container to minimize oil spillage. When engine N1 speed reaches 15%, insert the empty second container and begin oil sample collection. (Limit N1 speed to 15-18% by interrupting the starter current.) Motor the engine at 15-18% N1 for 15 seconds and collect oil. Stop motoring engine, but continue to collect oil during coast down until engine rotation stops. It is not necessary to collect minor drips.
  - (5) Carefully remove the container, avoiding any loss of the oil sample. Pour the oil sample into a baby bottle or any other container that provides measurement in cubic centimeters (cc) or in fluid ounces (U.S.).
  - (6) Record the amount of oil collected.
  - (7) Re-install scavenge oil tube to front support (Ref OMM).

July 29, 2014

Revision 1

August 22, 2014

M250-C20 Series

M250-C20R Series

M250-C30 Series

M250-C40B

M250-C47 Series

M250-B17 Series

M250-B17F Series

CEB-A-1416

CEB-A-72-4104

CEB-A-72-3297

CEB-A-72-5066

CEB-A-72-6079

TPCEB-A-1353

TP CEB-A-72-2101

# ALERT

## Rolls-Royce

### COMMERCIAL ENGINE BULLETIN

- B. The minimum acceptable amount of oil is 20cc. If the minimum amount of oil cannot be obtained, contact Rolls-Royce Helicopter Customer Support for further instructions.
- C. For spare front supports, shelf stock, or front supports not installed, verify the oil passage is free of obstruction. See Figure 1.
  - (1) Use 0.015-0.020 in. wire and insert through oil pressure port in the bullet.
  - (2) Insert wire all the way through until it is visible in the oil pressure inlet elbow on the front support.
  - (3) Front supports which do not pass this inspection are considered rejected.
- D. Contact Rolls-Royce customer support for any failed inspections of front supports at [helicoptercustsupp@Rolls-Royce.com](mailto:helicoptercustsupp@Rolls-Royce.com).
- E. Record compliance with this commercial engine bulletin in the applicable section of the engine logbook, engine assembly (white pages), compressor assembly (blue pages), Part III, Modification Record as applicable with the following:

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101

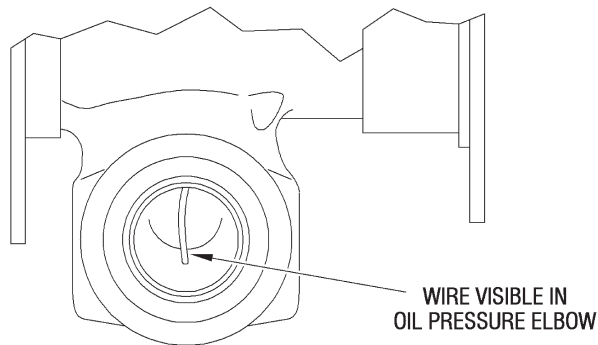
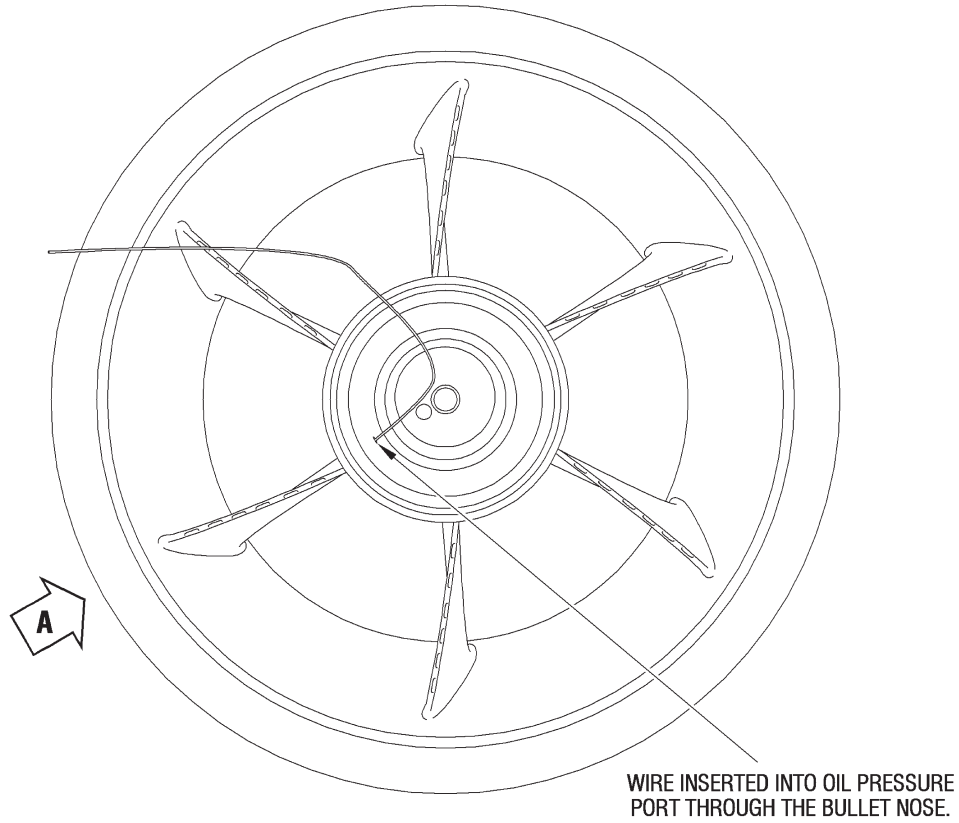
July 29, 2014  
 Revision 1  
 August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101



# ALERT

Rolls-Royce  
COMMERCIAL ENGINE BULLETIN



VIEW A

APC030XA

Figure 1  
Oil Passage Obstruction Check

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series  
M250-C20R Series  
M250-C30 Series  
M250-C40B  
M250-C47 Series  
M250-B17 Series  
M250-B17F Series

CEB-A-1416  
CEB-A-72-4104  
CEB-A-72-3297  
CEB-A-72-5066  
CEB-A-72-6079  
TPCEB-A-1353  
TP CEB-A-72-2101

3. MATERIAL INFORMATION

A. Configuration Chart

NEW P/N	QTY/ ENG	NAME	OLD P/N	QTY/ ENG	INSTRUCTIONS/ DISPOSITION
M250-10051	1	Support Assembly, Compressor Front	M250-10051	1	1, 2
M250-10052	1	Support Assembly, Compressor Front	M250-10052	1	1, 2
M250-10059	1	Support Assembly, Compressor Front	M250-10059	1	1, 2
M250-10060	1	Support Assembly, Compressor Front	M250-10060	1	1, 2

INSTRUCTIONS/DISPOSITION NOTES

1. New or inspected item.
2. Inspected item.

CUSTOMER SUPPORT  
ROLLS-ROYCE

July 29, 2014  
Revision 1  
August 22, 2014

M250-C20 Series	CEB-A-1416
M250-C20R Series	CEB-A-72-4104
M250-C30 Series	CEB-A-72-3297
M250-C40B	CEB-A-72-5066
M250-C47 Series	CEB-A-72-6079
M250-B17 Series	TP CEB-A-1353
M250-B17F Series	TP CEB-A-72-2101