

ALERT SERVICE BULLETIN

430-15-55
3 November 2015

MODEL AFFECTED: 430

SUBJECT: ENGINE, TURBINE ASSEMBLY - INSPECTION OF
3RD STAGE TURBINE WHEELS 6898663

HELICOPTERS AFFECTED: Serial number 49001 and subsequent.

COMPLIANCE: See attached Rolls-Royce Corporation ALERT
Commercial Engine Bulletin (CEB) A-72-5065 Revision
2.

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.

APPROVAL:

See attached Rolls-Royce Corporation ALERT CEB A-72-5065 Revision 2.

CONTACT INFO:

For any questions regarding this bulletin, please contact:

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

Rolls-Royce Corporation
450 South Meridian Street
Indianapolis, IN 46225-1103 USA
Mail Code MC-S2-08
Phone: 317-230-3774
Fax: 317-230-6084
email: indy.pubs.services@rolls-royce.com



Rolls-Royce

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

October 14, 2015

TO: Recipients of M250[®]-C30, -C40B, and -C47B Commercial Engine Bulletins

SUBJECT: ENGINE, TURBINE ASSEMBLY - INSPECTION OF 3RD STAGE
 TURBINE WHEELS 6898663

This letter transmits Revision 2 to the subject commercial engine bulletins:

<u>Model</u>	<u>Bulletin Number</u>
M250-C30 Series	CEB-A-72-3296
M250-C40B	CEB-A-72-5065
M250-C47B	CEB-A-72-6078

This is a complete revision. Replace the Revision 1 issue with this Revision 2.

Revision 2 updates the Planning Information section.

The following list includes the original issue date and all revisions to this bulletin:

Original issue	June 27, 2014
Revision 1	May 26, 2015
Revision 2	October 14, 2015

CUSTOMER SUPPORT
ROLLS-ROYCE



ENGINE, TURBINE ASSEMBLY - INSPECTION OF 3RD STAGE TURBINE WHEELS 6898663

1. PLANNING INFORMATION

A. Effectivity

(1) Engines

All Rolls-Royce M250[®]-C47B and C30S engines and turbine modules are affected by this bulletin.

Any 6898663 3rd-stage Turbine Wheel or 23064627 Turbine Module that has operated in either a M250-C47B or C30S engine.

M250-C47M and C40B engines and turbine modules are affected by this bulletin.

(2) Spares - Affected

B. Reason

Rolls-Royce has redesigned the 3rd-stage Turbine Wheel to limit the variation in shroud slot position. This change is to provide increased margin to the operational speed range.

C. Description

This Commercial Engine Bulletin (CEB) provides the requirement to replace all 3rd-stage Turbine Wheels 6898663 with a new 23092511 3rd-stage Turbine Wheel or a 23064627 Power Turbine Rotor Assembly that has been inspected in compliance with this CEB.

D. Approval

Technical aspects are FAA approved.

E. Compliance

Compliance Code 2, and 3 for For C47B engines. To be complied with per the below table: or when the turbine assembly is at an authorized repair/overhaul facility for any reason, which ever occurs first.

For wheels which have accumulated the below hours as of June 1, 2018	Comply No Later than
800-2000 hours	June 1,2018
2000-3200 hours	November 1, 2018
3200 hours or more	April 1, 2019
0-800 hours	June 1, 2019

Compliance Code 4 for C30S engines. To be complied with when the turbine assembly is at an authorized repair/overhaul facility and the turbine assembly is disassembled for any reason.

Compliance Code 7 for C40B and C47M engines. To be complied per customer option. Part obsolescence can require compliance with this CEB even though the CEB originally stated compliance as a customer option for these models.

June 27, 2014
Revision 2
October 14, 2015

M250-C30 Series	CEB-A-72-3296
M250-C40B	CEB-A-72-5065
M250-C47B	CEB -A-72-6078

ALERT

Rolls-Royce

EXPORT CONTROLLED

COMMERCIAL ENGINE BULLETIN

F. Interchangeability - Note: Affected

- (1) 23092511 to be used on C47B and C30S turbine.
- (2) Install inspected 3rd-stage power turbine wheel with life limited log card annotated with CEB 72-6078, 72-5065 or 72-3296 as applicable.
- (3) Install power turbine rotor assembly with 3rd-stage wheel life limited log card annotated with CEB 72-6078, 72-5065 or 72-3296 as applicable.

G. Material Availability

NEW P/N	NAME	QTY/ENG
23092511	3RD-STAGE TURBINE WHEEL	1

H. Tooling - Not affected

I. Weight and Balance - Not affected

J. Electrical Load Data - Not affected

K. References

- (1) Advance Engineering Memorandum (AEM) CW500020538722.
NOTE: The document above is referenced for the internal use of Rolls-Royce only.
- (2) 14W2 Operation and Maintenance Manual, Turboshaft Models 250-C30, -C30S, -C30G, -C30G/2, -C30P, -C30M (OMM).
- (3) 14W3 Overhaul Manual, Turboshaft Models 250-C30, -C30P, -C30M, -C30S, -C30G, -C30G/2, -C30U (O/H).
- (4) 14W4 Illustrated Parts Catalog, Turboshaft Models 250-C30, -C30P, -C30M, -C30S, -C30G, -C30G/2 (IPC).
- (5) CSP 21001 Operation and Maintenance Manual, Turboshaft Model 250-C47B (OMM).
- (6) CSP 23001 Illustrated Parts Catalog, Turboshaft Models 250-C40B, -C47B, -C47M (IPC).
- (7) CSP 22001 Overhaul Manual, Turboshaft Models 250-C40B, -C47, -C30R/3, (O/H).
- (8) CSP 21000 Operation and Maintenance Manual, Turboshaft M250-C40B (OMM).
- (9) CSP21004 Operation and Maintenance Manual, Turboshaft M250-C47M (OMM).

L. Other Publications Affected - None

M. Prerequisites - None

2. ACCOMPLISHMENT INSTRUCTIONS

- A. Install new 3rd-stage power turbine wheel part number 23092511, or
- B. Install power turbine rotor assembly with 3rd-stage wheel life limited log card annotated with CEB 72-6078, 72-5065 or 72-3296 as applicable.

NOTE:

- A. Non installed 3rd-stage Turbine Wheels can be sent to a Rolls-Royce FIRST Network Facility for inspection and re-identification if found acceptable.

June 27, 2014
Revision 2
October 14, 2015

M250-C30 Series	CEB-A-72-3296
M250-C40B	CEB-A-72-5065
M250-C47B	CEB -A-72-6078

ALERT

Rolls-Royce

COMMERCIAL ENGINE BULLETIN

- B. Power Turbine Rotor assemblies can also be sent to Rolls-Royce FIRST Network Facility for inspection. Those assemblies which have been inspected and found acceptable will be returned with the 3rd-stage Turbine Wheel life limited log card annotated with “CEB 72-6078, 72-5065, or 72-3296 acceptable” as applicable.
- C. Record compliance with the CEB in the Engine Log Book Turbine section as applicable.

3. MATERIAL INFORMATION

A. Configuration Chart

<u>New P/N</u>	<u>Qty</u>	<u>Nomenclature</u>	<u>Old P/N</u>	<u>Qty</u>	<u>Instructions/ Disposition</u>
23092511	1	Wheel, Turbine 3rd-stage	6898663	1	1, 2, 3

INSTRUCTIONS/DISPOSITION NOTES

- 1. New Item.
- 2. Scrap rejected wheel.
- 3. Inspect at approved facility.

CUSTOMER SUPPORT
ROLLS-ROYCE

June 27, 2014
Revision 2
October 14, 2015

M250-C30 Series	CEB-A-72-3296
M250-C40B	CEB-A-72-5065
M250-C47B	CEB -A-72-6078

