Rolls-Royce

Rolls-Royce Corporation
M250-C20R

COMMERCIAL ENGINE BULLETIN (CEB)

Technical Publications Index

February 1, 2014

Rolls-Royce

COMMERCIAL ENGINE BULLETIN INDEX

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
72-4001	Engine Conversion, 250-C20R/2 to 250-C20R/1	01-31-89	1	03-01-92		
72-4002	Cancelled Prior To Publication					
72-4003	Engine, Turbine Assembly, Fourth-Stage Nozzle Increased Labyrinth Seal Clearance	12-15-88			12-01-92	
72-4004	Engine, Turbine Assembly, New Optimized Power Turbine Sump Clearances	Cancelled				
72-4006	Engine, Turbine Assembly, Fourth-Stage Nozzle Diaphragm Locating Key Welds - Modify	10-16-89	2	11-15-96		
72-4007	Engine, Turbine Assembly, First-Stage Nozzle, Modify	04-01-89	1	11-15-90		
72-4008	Engine, Turbine Assembly, Gas Producer Support, Addition Of Brazed Wear Pads	05-01-89	3	06-15-93		
72-4009	Engine, Accessory Gearbox Assembly Centrifugal Breather Gear - Improved Configuration	01-31-89	1	06-15-94		
72-4010	Engine, Engine Assembly Shipping Container-Modify	11-01-88	2	04-15-93		
72-4011	Engine, Accessory Gearbox Housing, Modify To Reduce Oil Flow For The No. 2 Bearing Squeeze Film Dampener	05-01-89				
72-4012	Cancelled Prior To Publication					
72-4013	Engine, Compressor Assembly, Front Support - Modify	06-01-89	2	12-03-12		
72-4014	Engine, Turbine Assembly, Second-Stage Turbine Wheel, Reduced Diameter Balance Piston Seal Knife	04-01-89				
72-4015	Model 250 Engine or Module Conversion Authorization	09-30-85	7	05-04-09		
72-4016	Engine, Compressor Assembly, Addition of Body-Bound Bolts To Compressor Case Half Splitline	05-01-89			07-31-90	
72-4017	Engine "Quick-Disconnect" Magnetic Drain Plugs - Install	01-31-79	8	10-18-99		
72-4018	Engine, Compressor Assembly Front Support Scavenge Oil Fitting, Modify	12-15-89				
72-4019	Engine, Compressor Assembly, Impeller, Reidentify Certain Impellers For Increased Life Limits	06-01-89	1	04-15-93		
72-4020	Engine, Gearbox Assembly, Installation of New 3 and 4 Roller Bearings	09-30-90	3	10-31-96		
72-4021	Engine, Gearbox Assembly, Spur Adapter Gearshaft, Modify 2 1/2 Bearing Guide	03-01-89	1	08-01-89		
72-4022	Cancelled Prior To Publication					
72-4023	Engine, Turbine Assembly, Internal Energy Absorption Ring (Series III, P/N 23031865), Rework and Reidentify For Series II Use	03-01-89				
72-4024	Gearbox, Oil Filter Differential Pressure Indicator Kit - Option	08-30-80	6	10-31-94		

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
72-4025	Engine, Gearbox Assembly, Starter Generator Gearshaft, Modify Spline No-Go Gage	06-01-89				
72-4026	Engine, Accessory Gearbox Oil Filter Housing, Add Bronze Bushing To The "Oil Out" Port	07-01-89	1	04-15-93		
72-4027	Engine, Accessory Gearbox, Installation of 6000 Hz Gears For Use In Bell 206B III and 206L Helicopters	04-01-89				
72-4028	Engine, Turbine Assembly, New Gas Producer Turbine Tiebolt Spanner Nut	Cancelled				
72-4029	Engine, Tooling, Power & Accessories Gearbox Bearing Removal Puller Kit, Modify	06-01-89				
72-4030	Engine, Accessory Gearbox, Install New Pressure Oil Tube	Cancelled				
72-4031	Cancelled Prior To Publication					
72-4032	Cancelled Prior To Publication					
72-4033	Engine, Turbine Assembly, -C20R & -B17F Series Multi-Engine Configuration Conversion for use on -C20R & -B17F Series Single Engine Applications	08-31-91	2	01-19-09		
72-4034	Engine Conversion, M250-C20R/2 to M250-C20R	01-31-91	2	04-29-13		
A-72-4035	Engine, Turbine Assy., Alseal Coating of Power Turbine Inner and Outer Shafts	02-28-90	7	02-29-96	08-31-95	
72-4036	Engine, Compressor, Front Bearing Housing Assembly - Modify Housing Assembly	07-25-90	1	06-30-93		
72-4038	Engine, Accessory Gearbox, Install New Pressure Oil Tube	04-30-90	1	06-21-91	12-31-90	
72-4040	Engine, Combustion Liner, Rework	Cancelled				
A-72-4041	Engine, Turbine Assembly, Turbine Spline Adapter P/N 6898784, Replace Certain Suspect Adapters	04-30-90	1	07-15-91		
72-4042	Engine, Turbine Assembly, Authorization to Reidentify Semi-Finished 2nd Stage Nozzles	12-31-93	6	07-28-08		
A-72-4043	Engine, Turbine Assy, C20R/1, Exhaust Collector Horizontal Support Assembly Inspection	Cancelled				
72-4044	Cancelled Prior To Publication					
A-72-4045	Engine, Turbine Assembly, Multi Engine Exhaust Collector Horizontal Support Repetitive Inspection and Modification	02-28-92	2	05-31-94		
72-4046	Engine, Compressor Assembly, Improved Compressor Shroud Coating	10-15-91	1	11-15-93		
72-4047	Engine, Compressor Assembly, Addition of Puller Groove for Removal of No. 2 Bearing	07-31-92	1	12-15-94		
72-4049	Engine, Gearbox Assembly, Turbine Pressure Oil Fitting, Add Seal	12-15-92	1	01-26-01		
72-4050	Engine, Turbine Assembly, Combustion Liner Rework	09-01-91	2	06-18-98		
72-4052	Inspection of Oil Filter Inlet Tube Assembly, P/N 6876925A for Proper Engagement	11-15-91				

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
A-72-4055	Engine, Fuel, Lube and Air Assembly, Fuel Hose Assembly 23005205, Replace	07-30-92				
72-4056	Engine, Turbine Assembly, Release of New No. 8 Bearing and Retaining Plate	05-31-94				
A-72-4058	Engine, Quick Disconnect Magnetic Plugs - Inspect Locking Pins and Insert Slots for Wear	01-15-83	3	10-15-96		
A-72-4059	Engine, Gearbox, Removal of Certain Pinion Gears	10-04-95	1	11-30-95		
A-72-4060	Engine, Turbine, Inspection of First-Stage Nozzle Shield Dome Detail for HMI or Overhaul	01-15-96	2	05-12-99		
72-4063	Engine, Compressor Assembly , Compressor Rear Support, No. 2 Bearing Bore and Thrust Face, Addition of Wear Resistant Coating	04-30-98				
72-4064	Cancelled prior to publication					
A-72-4065	Engine Assembly, Turbine Pressure Lube Oil Check Valve, P/N 23062087, Verification of Proper Clamp Part Number and Position	05-30-97				
A-72-4066	Engine, Gearbox Assembly - Oil Delivery Tube - Replace	03-15-99	2	02-02-04		
72-4069	Engine, Turbine Assembly - Recoating Of Power Turbine Inner Shaft	11-22-99	2	02-22-10		
72-4070	Engine, Gearbox Assembly - Release Of New Helical Torquemeter Gearshaft Assemblies and Internal Retaining Rings (Damper)	11-05-99	3	05-03-10		
72-4071	Engine, Turbine Assembly - Release of New Engine Rear Mount Assembly	06-30-00	1	03-05-01		
A-72-4075	Engine, Turbine - Inspection Of 1st-Stage Nozzle Shield Dome	03-29-00	6	10-27-08		
A-72-4076	Engine, Turbine Assembly - Gas Producer Rotor Assembly - Replace Turbine Tie Bolt	05-09-00	2	11-03-08		
72-4077	Engine - Compressor with Improved Airflow Characteristics	06-08-00	1	10-01-07		
72-4078	Engine - Power Turbine with Improved Airflow Characteristics	06-08-00	2	06-22-09		
A-72-4079	Engine, Gearbox - Inspection For Installation Of Torquemeter Retaining (Damper) Ring	02-15-00				
A-72-4080	Engine, Turbine - One-Time Inspection For Overtemperature Damage	02-23-00				
A-72-4081	Engine, Compressor Assembly - Visual Inspection of Compressor Scroll Pressure Probe Elbow (Pressure Probe)	05-05-00	1	08-02-00		
A-72-4082	Engine, Turbine - Replacement of 2nd-Stage Nozzle Diaphragm	10-24-00	3	10-12-09		
A-72-4087	Engine, Gearbox Assembly - Inspection of Helical Torquemeter Gearshaft Assembly	10-03-01	1	01-16-02		
72-4088	Engine, Main Accessory Gearbox - Release of Rework And Reidentified Lip Seals	04-25-02				
72-4090	Engine, Compressor Assembly - Release of New No. 1 Bearing (23066679)	08-16-04	2	01-16-12		

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
72-4091	Engine, Gearbox Assembly - Replacemant of Breather Gear Seal	02-07-05				
A-72-4093	Engine, Turbine Assembly - Power Turbine Outer Shaft	10-09-06	3	01-19-09		
72-4094	Engine, Turbine - Inspection of Sump Assembly, Oil - Gasifier Turbine Bearing Support	02-19-07	1	07-12-07		
A-72-4095	Engine, Turbine Assembly - Steady-State Operation Avoidance Limit	12-22-06	3	01-19-09		
72-4097	Engine, Turbine Assembly - Replacement of Turbine Gas Producer Forward Labyrinth Seal	09-13-10	1	08-15-11		
72-4098	Engine, Turbine Section - Inspection of Rolls-Royce M250-C20, C20B, or C20R/2 3rd-Stage (23065818) & 4th-Stage (23055944) Enhanced Power Turbine Wheels	11-29-10	2	08-20-12		
72-4099	Engine, Compressor Assembly - Inspection & Replacement of Metco 52C Coated Cases	11-29-10	1	12-05-11		
72-4101	Gearbox - Spare Accessory Drive Gear (Vacuum/Hydraulic Pump) Removal	02-01-80	7	12-03-12		

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
73-4001	Engine, Fuel and Control, Allied/Bendix Fuel Control - Incorporation of Damped Metering Valve Assembly	08-1-88			08-31-89	
73-4002	Engine, Fuel and Control, Electrical System - Modify to Eliminate Interference	10-31-89	1	01-31-91		
73-4003	Engine, Fuel and Control, Bendix Power Turbine Governor, - Incorporation of Governor Body Access Window	08-1-88				
73-4004	Cancelled Prior To Publication					
73-4005	Engine, Fuel and Control, Allied/Bendix Fuel Control Models DP-N2 and DP-P2 Increase Minimum Flow Setting	01-31-89				
73-4006	Engine, Fuel and Control - Fuel Pump, Machine Fuel Pump Gear Housing	07-01-88	1	12-17-07		
73-4007	Cancelled Prior to Publication					
A-73-4008	Engine, Fuel and Control, Inspection of Certain Bendix Fuel Control Bellows Assemblies	08-01-88	2	09-01-94	10-01-88 07-01-89	
73-4009	Cancelled Prior To Publication					
73-4010	Engine, Fuel and Control, Allied/Bendix Fuel Control, Model DP-N2 - Incorporation of Two Position Maximum Flow Stop	03-01-89	1	09-30-91		
73-4011	Cancelled Prior To Publication					
A-73-4012	Engine Control System, Bendix Power Turbine Governor, Inspect P_y Port Casting Area	04-01-89	3	04-15-92		
73-4013	Cancelled Prior to Publication					
73-4014	Engine, Fuel and Control, Fuel Control Damped Metering Valve with Increased Clearance	03-31-90	1	03-29-91		
A-73-4015	Engine, Fuel and Control Bendix P.T. Governor Removal of P_y Accumulator	04-15-92				
73-4016	Aviall Recall of Certain Bendix Power Turbine Governors	03-15-90	1	10-15-91	01-01-92	
73-4017	Engine, Fuel and Control, Fuel Control Unit Improved Response	07-01-90				
73-4018	Engine, Fuel and Control, Incorporation of Suction Fuel Pump on Certain C20R/2 Engines, Add	10-20-92				
A-73-4019	Engine, Fuel and Control, Fuel Control Assembly Improved Throttle Return Spring - Add	04-15-91	2	02-15-92	04-01-93	
73-4021	Cancelled Prior to Publication					
73-4022	Engine, Fuel and Control, Replacement of Throttle Balance Spring and Maximum Fuel Flow Quadrant	07-01-91	1	12-15-91		
A-73-4024	Bendix Main Fuel Controls, Verification of Maximum Fuel Flow Setting	09-15-91	1	02-15-92	01-01-92	
A-73-4025	Engine, Fuel and Control, Disarm N_2 (Electronic) Overspeed Control System - Multi-Engine Aircraft	03-15-92	2	11-15-93	06-30-92	

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
A-73-4026	Bendix Main Fuel Controls Used on Model 250 Series Engines - Application of NYE Synthetic Oil 608 to Beryllium Copper PC Bellows Assembly	Cancelled				
73-4027	Engine, Fuel and Control, Release of New Fuel Control With Stronger Bypass Valve Cover Retaining Screws, Modify	02-15-93	1	12-07-93		
73-4028	Cancelled Prior to Publication					
A-73-4029	Engine, Fuel and Control, Fuel Control Bellows - Replace	11-18-93	4	10-09-01		
73-4030	Engine, Fuel and Control, CECO Fuel Pump and Filter Assy, Change in Impending By-pass Valve Cracking Pressure - Rework	04-15-94				
73-4031	Engine, Fuel and Control, Release of New Investment Cast Cover Assy	08-30-94	4	03-12-98		
73-4032	Engine, Fuel and Control, Rework of Gover-nor Throttle Shaft to Add Lubrication Chan-nel to Lubricate the Throttle Shaft	08-30-94	2	10-31-96		
73-4033	Engine, Fuel and Control, Rework of Fuel Control Throttle Shaft to Add Lubrication Channel to Lubricate the Throttle Shaft	08-30-94	1	10-31-97		
73-4034	Engine, Fuel and Control, Removal of N2 Overspeed System from 250-C20R Series Engines and B17F/1 Series Engines in Multi-Engine Installations	03-10-99	1	06-16-08		
73-4035	Engine, Fuel & Control, Release of New Design Shaft Seal for CECO Model 263 and 264 Fuel Pump	07-31-96				
73-4036	Engine, Fuel and Control - Fuel Control Drive Bearings - Replace	04-10-97	4	05-17-10		
73-4037	Engine, Fuel, Lube, and Air System, Fuel Pump to Fuel Control Tube Assembly, Replace	06-17-96				
73-4038	Engine, Fuel and Control, Power Turbine Governor Drive Bearings - Replace	07-15-97	1	05-08-98		
73-4039	Engine, Fuel and Control, Fuel Control Stop Nut - Rework	08-31-97	2	10-13-99		
A-73-4040	Engine, Fuel and Control - CECO Engine Driven Fuel Pump - Internal Spline Inspection	08-21-97				
73-4041	Engine, Fuel and Control - Certain Honey-well Fuel Control Units and Power Turbine Governors - Inspection of Cam Follower Lever	05-30-98	2	06-28-00		
73-4042	Engine, Fuel and Control - CECO MFP-263 Fuel Pump - Replace	04-30-98				
73-4044	Engine, Fuel and Control - AlliedSignal (Bendix) Main Fuel Control - Incorporate One Piece Bypass Valve Sleeve	01-08-99	1	09-28-99		
A-73-4045	Engine, Fuel and Control - Honeywell Fuel Control Unit and Power Turbine Governor - Internal Spring Replacement	10-05-98	3	08-13-04		
73-4046	Engine, Fuel and Control - Honeywell Model DP-N2 Main Fuel Control - Inspection and Replacement of Fuel Control Throttle Lever	08-01-01				

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
73-4047	Engine, Fuel Control - Release of New Bypass Retention Plate	04-20-01	1	11-15-02		
73-4050	Engine, Fuel and Control - Honeywell (Bendix/AlliedSignal) Main Fuel Control Units - One Time Inspection of Screws	04-06-01	1	05-13-02		
73-4051	Engine, Fuel and Control - Honeywell (Bendix/AlliedSignal) Power Turbine Governor - Tee Filter Inspection	06-13-01				
73-4052	Engine, Control System - One Time Inspection For Proper Components	10-15-01	1	11-28-01		
73-4053	Engine, Fuel And Control - Honeywell Main Fuel Control Unit - Modification of Model DP-N2 Governor And Gas Turbine Fuel Control Parts List Number (2549032) To Add Ball Bearing Flyweights In Drive Body Assembly	07-29-02				
73-4054	Engine, Fuel and Control - Power Turbine Governor Increased Durability Design	04-23-03				
73-4055	Engine, Fuel and Control - Goodrich Engine Driven Fuel Pump Improved Drive Shaft Durability	04-07-04	1	03-31-08		
A-73-4056	Engine, Fuel Delivery - Release of New Fuel Nozzle	09-04-03	1	08-30-04		
73-4057	Engine, Fuel and Control - Power Turbine Governor Increased Reliability	04-21-08	2	02-04-09		
73-4059	Engine, Fuel and Control - Honeywell Main Fuel Controls - Verification of Fuel Flow Calibration	05-18-09				
73-4062	Engine - Fuel Nozzle Spray Tip/Inner Air Shroud Replacement	09-09-13	1	01-13-14		
73-4063	Engine, Fuel & Control - Honeywell Main Fuel Controls - Replacement of the Bypass Valve Sleeve	04-09-12	1	08-20-12		
73-4064	Engine Fuel and Control - Power Turbine Governor Drive Bearing Replacement	01-20-14				

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
74-4001	Engine, Electrical - Start Counter Assembly - Removal/Installation	01-15-99	1	03-17-99		
74-4002	Engine, Accessory - Conversion Of -C20R Auto Relight Kit To -C20B/J Kit	10-06-00				

CEB No.	Subject	Date Published	Revision Number	Date Revised	Compliance Requirement	Compliance Completed
75-4002	Engine, Compressor Bleed Valve, Introduction of New Bleed Valve Assembly	08-01-89	2	07-15-91		
75-4003	Engine, Compressor Bleed Valve, Reduced Diameter Vent Hole	07-30-89				
75-4005	Engine, Air System, Bleed Valve, Improved Valve Stem Bushing, Install	10-15-90	2	04-15-93		
75-4006	Engine, Fuel, Lube and Air System Assembly, Removal of Hardware for Pc Filter Tube and Anti-Icing Tube, Remove	04-30-91				
75-4007	Engine, Compressor Bleed Valve, Release of New Bleed Valve Which Incorporates Refined Calibration Limits	01-10-97	1	06-15-98		
75-4008	Engine - Bleed Valve Modification for Use With Increased Airflow Characteristics Compressor	06-08-00				

IB No.	Subject	Date Published	Revision Number	Date Revised
4001	Three Cubic Inch Accumulator Installation for 250-C20 or 250-C20R Series, Bendix Fuel System	08-04-72	4	03-01-89
4002	High Force Check Valve and Six Cubic Inch Accumulator for 250-C20 Series or 250-C20R Series Bendix Fuel System	10-15-71	5	11-01-89
4003	Installation of Auto-Reignition Control Kit on 250-C20R/2 Series Engines	09-29-89	2	04-30-98
4004	Engine, Fuel and Control, Installation of Cover on Power Turbine Governor or Fuel Control Unit Vent Screen	02-15-91	1	09-15-97
4005	Cancelled Prior to Publication			
4006	Gearbox Assembly, Spare Accessory Drive Installation - Add	02-15-80	4	08-31-97
4007	Anti-Ice Tubing Installation For Instrumentation on Kamov KA-226	08-31-01		