

ALERT SERVICE BULLETIN
Bell Helicopter **TEXTRON**

A Subsidiary of Textron Inc.

NO. 206L-04-128

DATE May 17, 2004

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DATE

REV

MODEL AFFECTED: 206L1

SUBJECT: ENGINE, TURBINE ASSEMBLY – THIRD STAGE
TURBINE WHEEL REPLACEMENT, SPECIFIC SERIAL
NUMBERS

HELICOPTERS AFFECTED: All model 206L1 helicopters equipped with 250-C28
engine.

COMPLIANCE: In accordance with Rolls-Royce Corporation ALERT
Commercial Engine Bulletin CEB-A-72-2202 dated May
6, 2004.

DESCRIPTION:

Rolls Royce has determined that a number of P/N 6899383 third stage turbine wheels were sold with a blue print variance that affects their high cycle fatigue life.

Rolls-Royce Corporation has released the ALERT Commercial Engine Bulletin (CEB-A-72-2202) that provides a list of affected third stage wheel serial numbers, and provides the replacement procedure.

This Bell Helicopter Alert Service Bulletin is being sent to all Bell Helicopter operators of record who may be affected by the release of Rolls-Royce ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004. This Bell Helicopter Alert Service Bulletin will not be revised in the event of subsequent changes to the Rolls-Royce ALERT Commercial Engine Bulletin

APPROVAL:

The engineering aspects of this bulletin are Transport Canada approved.

MANPOWER:

Refer to Rolls-Royce Corporation ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004.

WARRANTY:

Rolls Royce has committed to providing financial consideration for engine removal/installation labor, shipping charges and wheel replacement as necessary in compliance with CEB-A-72-2202. Please contact your Rolls Royce Approved Maintenance Center (AMC) for full details.

MATERIAL:

Refer to Rolls-Royce Corporation ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004.

SPECIAL TOOLS:

Not applicable.

WEIGHT AND BALANCE:

Not affected.

ELECTRICAL LOAD DATA:

Not affected.

REFERENCES:

Refer to Rolls-Royce Corporation ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004.

PUBLICATIONS AFFECTED:

Refer to Rolls-Royce Corporation ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004.

ACCOMPLISHMENT INSTRUCTIONS:

1. Comply with Rolls-Royce Corporation ALERT Commercial Engine Bulletin CEB-A-72-2202 dated May 6, 2004.



ENGINE, TURBINE ASSEMBLY – THIRD-STAGE TURBINE WHEEL REPLACEMENT – SPECIFIC SERIAL NUMBERS

1. PLANNING INFORMATION

A. Effectivity

(1) Engines

All Rolls-Royce Model 250–C28 series engines are affected by this bulletin.

(2) The affected turbine wheels are listed below. They might have been sold as a spare or in a new production engine.

P/N	Serial	P/N	Serial	P/N	Serial
6899383	HX91922	6899383	X523239	6899383	X523287
6899383	HX91923	6899383	X523243	6899383	X523288
6899383	HX91925	6899383	X523266	6899383	X523289
6899383	HX91926	6899383	X523244	6899383	X523290
6899383	HX91928	6899383	X523246	6899383	X523291
6899383	HX91929	6899383	X523249	6899383	X523292
6899383	HX91930	6899383	X523250	6899383	X523293
6899383	HX91932	6899383	X523253	6899383	X523294
6899383	HX91934	6899383	X523255	6899383	X523295
6899383	HX91936	6899383	X523257	6899383	X523296
6899383	HX91937	6899383	X523263	6899383	X523297
6899383	HX91939	6899383	X523264	6899383	X523298
6899383	HX91940	6899383	X523265	6899383	X523300
6899383	HX91976	6899383	X523251	6899383	X523305
6899383	HX91977	6899383	X523260	6899383	X523309
6899383	X523241	6899383	X523261	6899383	X523313
6899383	X523242	6899383	X523262	6899383	X523315
6899383	HX91960	6899383	X523268	6899383	X523317
6899383	HX91962	6899383	X523269	6899383	X523319
6899383	HX91966	6899383	X523270	6899383	X523320
6899383	HX91979	6899383	X523271	6899383	X523277
6899383	HX91980	6899383	X523273	6899383	X523278
6899383	X523236	6899383	X523276	6899383	X523281
6899383	X523237	6899383	X523284	6899383	X523283
6899383	X523238				

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B. Reason

A number of third-stage turbine wheels (6899383) were sold with a blue print variance that affects their high cycle fatigue life.

C. Description

This commercial engine bulletin provides a list of affected third-stage turbine wheel serial numbers and provides the replacement procedure.

D. Approval

Technical aspects are FAA approved.

E. Compliance

Compliance Code 2: To be complied with as follows:

- (1) All engines with an affected wheel and less than 250 hours on the wheel must have the wheel replaced before 300 hours are exceeded.
- (2) All engines with an affected wheel and more than 250 hours on the wheel must have the wheel replaced within the next 50 hours.

F. Interchangeability – Not affected

G. Material Availability

New P/N	Nomenclature	Qty
6899383	Third-Stage Turbine Wheel	1

H. Tooling – Not applicable

I. Weight and Balance – Not affected

J. Electrical Load Data – Not affected

K. References

- (1) 16W2 Operation and Maintenance Manual, Turboshaft Model 250-C28 (OMM).
- (2) 16W3 Overhaul Manual, Turboshaft Model 250-C28 (O/H).
- (3) 16W4 Illustrated Parts Catalog, Turboshaft Model 250-C28 (IPC).

L. Other Publications Affected – None

M. Prerequisites – None

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2. ACCOMPLISHMENT INSTRUCTIONS

NOTE: Comply with the appropriate procedures in the referenced Operation and Maintenance Manual, Overhaul Manual and Illustrated Parts Catalog.

- A. Remove the engine or turbine and send it to a Rolls-Royce Model 250 FIRST (Full-service Integrated Rolls-Royce support Team) network facility. (Ref. OMM).
- (1) Remove third-stage turbine wheel (6899383) (Ref. O/H).
- (2) Install new third-stage turbine wheel (6899383) (Ref. O/H).
- (a) Please contact your Rolls-Royce Model 250 FIRST network facility for financial considerations provided by Rolls-Royce. Pro-rated, special pricing will be provided for new replacement wheels installed via a Rolls-Royce Model 250 FIRST network facility.
- B. Install the engine or turbine (Ref. OMM).
- C. Record compliance with this bulletin in the applicable section of the engine logbook, Turbine Assembly (pink pages), AD Note Compliance and CEB Modification Record, Part III, as applicable with the following:

250-C28 Series

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- D. If you have an affected wheel, please complete and FAX the attached form at the end of this bulletin to Model 250 Customer Support as soon as you receive this bulletin.
- E. Please contact Rolls-Royce using the numbers below for instructions regarding the return of the affected third-stage turbine wheels. All returned parts must have a Field Parts Return Form and corresponding control number.

Phone: 317-230-2720

FAX: 317-230-3381

Toll Free: 1-888-255-4766

Email: model250custsupp@rolls-royce.com

3. MATERIAL INFORMATION

A. Configuration Chart

NEW P/N	QTY/ ENG	NAME	OLD P/N	QTY/ ENG	INSTRUCTIONS/ DISPOSITION
6899383	1	Wheel ,Turbine 3rd-Stage	6899383	1	1,2

INSTRUCTIONS/DISPOSITION NOTES

1. New item.
2. Return removed item.

CUSTOMER SUPPORT
ROLLS-ROYCE

May 6, 2004

250-C28 Series

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CEB-A-72-2202 Reporting Form

Instructions: If you have an affected wheel, please fill out the requested information listed below. Make a copy of this page to fax or fax this page to Model 250 Customer Support at 1-317-230-3381.

Operator: _____

Address: _____

Contact: _____ Ph No: _____

Fax No.: _____ E-mail _____

Turbine Wheel S/N: _____ Engine S/N: _____

Turbine Wheel TIS: _____ Cycles: _____

Date wheel installed: _____

ATT: MODEL 250 CUSTOMER SUPPORT
1-317-230-3381

Date Received _____

(For Rolls-Royce Model 250 CS office use)