



**Rolls-Royce**

# **ADVANCED RELEASE**

TO: Holders of RR300 Series Operations and Maintenance Manual, Publication CSP 21009.

Reason: To revise power turbine rotor assembly life limits.

Added part number to Life Limits table.

Component: 3rd-stage Wheel

Remarks: Contact Rolls-Royce

**05-12-00-800-801**





## TIME LIMITS/MAINTENANCE CHECKS SYSTEM DESCRIPTION SECTION

TASK 05-12-00-800-801

1. RR300 SERIES LIFE LIMITS

A. Compressor Rotor

**CAUTION:** DO NOT TOUCH TITANIUM PARTS WITH BARE HANDS. WEAR CLEAN, LINT FREE, WHITE COTTON GLOVES OR USE PROTECTIVE ANTI-PERSPIRANT HAND CREAM. THE PARTS MUST BE KEPT IN A PROTECTIVE MATERIAL. IF YOU TOUCH TITANIUM PARTS WITH BARE HANDS CORROSION TO THE PART CAN OCCUR.

Nomenclature	Part No.	Description	Maximum Operating Hours	Maximum Cycles
Impeller	RR30000332	Original	10000	15000

B. Gas Producer Turbine Rotor Assembly

**CAUTION:** DO NOT INSTALL A TURBINE WHEEL WITH PERMITTED WHEEL RIM CRACKS IN A PREVENTATIVE MAINTENANCE INTERVAL (PMI) REPAIR. PERMITTED WHEEL RIM CRACKS IN A TURBINE WHEEL CAN ONLY BE USED DURING A TIME CONTINUED REPAIR. ENGINE MALFUNCTION CAN OCCUR.

**CAUTION:** DO NOT INSTALL FIRST AND SECOND STAGE TURBINE WHEELS WHICH HAVE INDICATIONS THAT THE BLADE TIPS HAVE RUBBED OTHER PARTS. IF COMPRESSOR COMPONENTS FAIL THEY CAN ENTER THE AIRFLOW OF THE ENGINE AND CAUSE THE TIPS OF THE FIRST AND SECOND STAGE TURBINE BLADES TO RUB THE SECOND STAGE TURBINE NOZZLE RING. STRESS IN THE BLADES AND FATIGUE FAILURE CAN OCCUR. FIRST AND SECOND STAGE TURBINE WHEELS MUST BE REMOVED FROM SERVICE IF THE TIP OF ONE BLADE HAS A RUB INDICATION.

Nomenclature	Part No.	Description	Maximum Operating Hours	Maximum Cycles
1st-stage Wheel	RR30000235	Original	2025	3000
1st-stage Wheel	RR30000465	New Coating (Alt)	2025	3000
1st-stage Wheel	RR30000481	New Coating (Alt)	2025	3000
2nd-stage Wheel	RR30000237	Original	2025	3000
2nd-stage Wheel	RR30000482	Subsequent release	2025	3000
Gas Producer Turbine Tie-Bolt	23068265	Original	----	3000
2nd-stage Turbine R Nozzle Diaphragm	23084419	Original	2025	3000
2nd-stage Turbine Nozzle Diaphragm	M250-10550	Subsequent release	2025	3000

EFFECTIVITY: ALL



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A. Power Turbine Rotor Assembly

**CAUTION:** DO NOT INSTALL A TURBINE WHEEL WITH PERMITTED WHEEL RIM CRACKS IN A PREVENTATIVE MAINTENANCE INTERVAL (PMI) REPAIR. PERMITTED WHEEL RIM CRACKS IN A TURBINE WHEEL CAN ONLY BE USED DURING A TIME CONTINUED REPAIR. ENGINE MALFUNCTION CAN OCCUR.

Nomenclature	Part No.	Description	Maximum Operating Hours	Maximum Cycles
3rd-stage Wheel	RR30000236	Original	4050	6000
3rd-stage Wheel	RR30000509	Improved Low Cycle Fatigue	4050	6000
4th-stage Wheel	RR30000240	Original	4050	6000
4th-stage Wheel	RR30000494	New	4050	6000

EFFECTIVITY: ALL

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