



Rolls-Royce

ADVANCED RELEASE

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

Reason: Revised inspection procedure.

Component: Compressor Front Support Assembly

Remarks: Contact Rolls-Royce

72-30-10-200-801

Jul 31/23



COMPRESSOR FRONT SUPPORT ASSEMBLY INSPECTION/CHECK

TASK 72-30-10-200-801

1. Do the Inspection of the Compressor Front Support Assembly

A. General

This task gives you the procedure to do the inspection of the compressor front support assembly.

B. Materials

None

C. Consumable Materials

None

D. Expendable Parts

None

E. Special Tools and Equipment

None

F. References

(1) TASK 70-33-03-300-801, Blend the Part, SPM.

G. Procedure

SUBTASK 72-30-10-220-001

REF. FIG. 801/TASK 72-30-10-990-801

(1) Do the visual inspection of the compressor front support assembly (support).

(a) Do the visual inspection of the support when it is removed to the limits that follow:

ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
Cracks or linear indications	None permitted.	There is no limit to the quantity.	Replace the support.
Flow path area (non-strut)			
- Nicks or dents	Maximum diameter of 0.040 in. (1.02 mm) with a maximum depth of 0.020 in. (0.51 mm).	There is no limit to the quantity.	Replace the support.
- Scratches	Maximum length of 0.100 in. (2.54 mm) with a maximum depth of 0.020 in. (0.51 mm).	There is no limit to the quantity.	Replace the support.
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending (Ref. TASK 70-33-03-300-801).

Strut flow path area

EFFECTIVITY: ALL



ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
- Nicks or dents	Maximum diameter of 0.040 in. (1.02 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.
- Scratches	Maximum length of 0.100 in. (2.54 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending (Ref. TASK 70-33-03-300-801).
Bearing bore (non-O-ring surfaces)			
- Nicks or dents	Maximum diameter of 0.025 in. (0.64 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.
- Scratches	Maximum length of 0.200 in. (5.08 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending (Ref. TASK 70-33-03-300-801).
- Wear from No. 1 bearing pin	Maximum axial (fore and aft) width of 0.100 in. (2.54 mm).	There is no limit to the quantity.	Replace the support.
Bearing bore (O-ring surfaces)			
- Nicks or dents	None permitted.	There is no limit to the quantity.	Replace the support.
- Scratches	None permitted.	There is no limit to the quantity.	Replace the support.
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending. Keep the circumferential sequence of the surface texture. Do not make axial scratches (Ref. TASK 70-33-03-300-801).
Fore and aft flanges			
- Nicks or dents	Maximum diameter of 0.040 in. (1.02 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.

EFFECTIVITY: ALL

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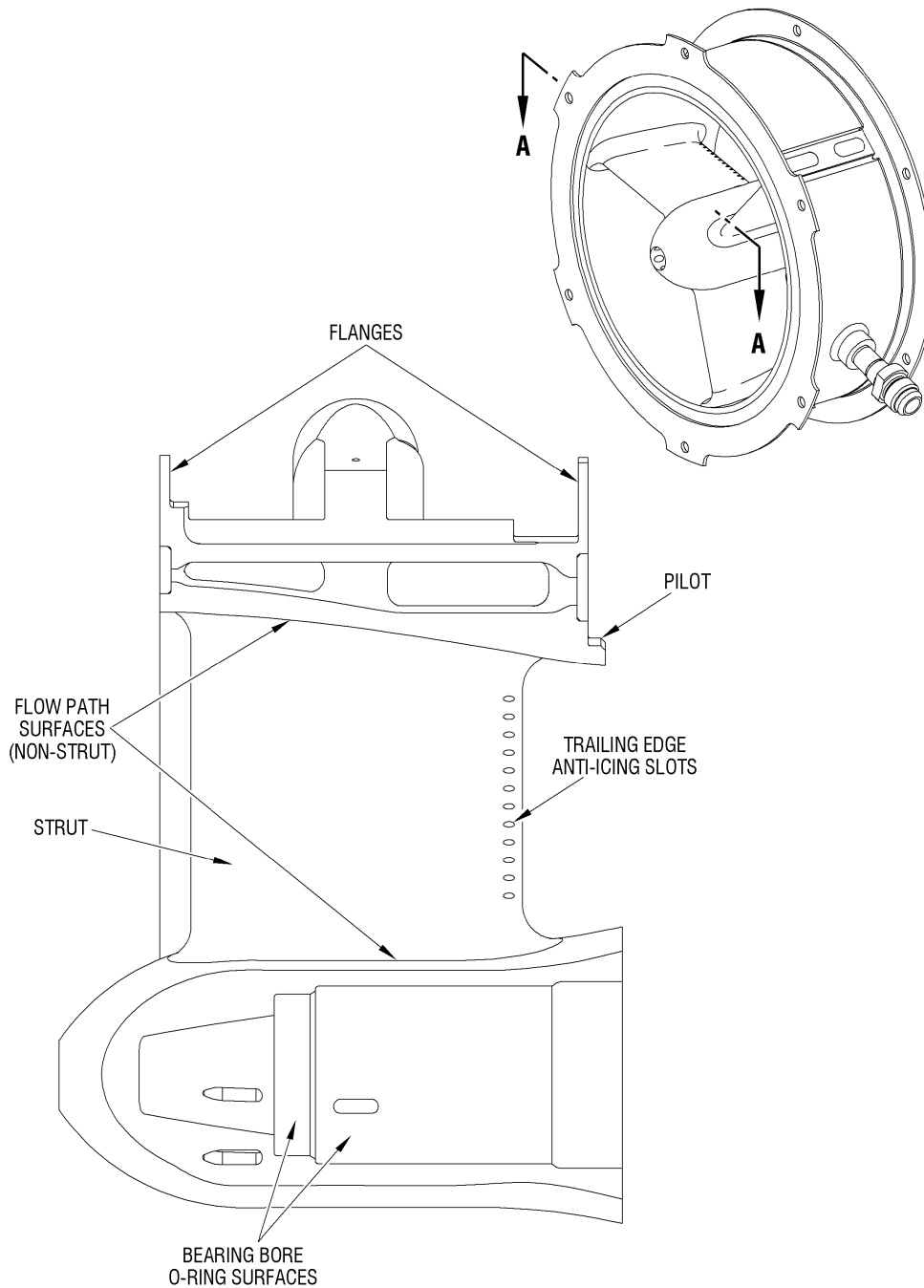
ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
- Scratches	Maximum length of 0.200 in. (5.08 mm) with a maximum depth of 0.010 in. (0.25 mm).	There is no limit to the quantity.	Replace the support.
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending (Ref. TASK 70-33-03-300-801).
Pilot			
- High metal	None permitted.	There is no limit to the quantity.	Remove the high metal by blending (Ref. TASK 70-33-03-300-801).
Threaded fittings			
- Damaged threads	None permitted.	There is no limit to the quantity.	Replace the support.
- Axial scratches on seal surface	None permitted.	There is no limit to the quantity.	Replace the support.
Strut trailing edge anti-icing slot			
- Blockage	None permitted.	There is no limit to the quantity.	Replace the support.

EFFECTIVITY: ALL

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SECTION A-A

Compressor Front Support - Inspection/Check
FIG. 801/TASK 72-30-10-990-801

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EFFECTIVITY: ALL

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