



Rolls-Royce

ADVANCED RELEASE

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

Reason: Revised inspection procedure.

Component: Compressor Front Bearing Housing

Remarks: Contact Rolls-Royce

72-30-11-200-801

Jul 31/23



COMPRESSOR FRONT BEARING HOUSING INSPECTION/CHECK

TASK 72-30-11-200-801

1. Do the Inspection of the Compressor Front Bearing Housing

A. General

This task gives you the procedure to do the inspection of the compressor front bearing housing.

B. Materials

None

C. Consumable Materials

None

D. Expendable Parts

None

E. Special Tools and Equipment

None

F. References

- (1) TASK 70-21-01-200-801, Do the Inspection of the Part with the Type I Fluorescent Penetrant Inspection, Method A, SPM.

G. Procedure

SUBTASK 72-30-11-220-001

REF. FIG. 801/TASK 72-30-11-990-801

- (1) Do the inspection of the compressor front bearing housing.

- (a) Do the inspection of the compressor front bearing housing to the limits that follow:

ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
Compressor front bearing housing			
- Cracks	None permitted.	Not repairable.	Replace the compressor front bearing housing.
- Damaged threads	None permitted.	Not repairable.	Replace the compressor front bearing housing.
- Dents or nicks	Maximum of 0.040 in. (1.02 mm) in length and 0.010 in. (0.25 mm) in depth.	Not repairable.	Replace the compressor front bearing housing.
- High metal	None permitted.	Not repairable.	Replace the compressor front bearing housing.
- Scratches	Maximum of 0.200 in. (5.08 mm) in length and 0.010 in. (0.25 mm) in depth.	Not repairable.	Replace the compressor front bearing housing.

Locating pin

EFFECTIVITY: ALL



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ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
- Bent	None permitted.	Not repairable.	Replace the compressor front bearing housing.
O-ring grooves			
- Nicks, dents or scratches	None permitted.	Not repairable.	Replace the compressor front bearing housing.
Oil passages			
- Clean and free of coked oil and contamination	None permitted.	Not repairable.	Replace the compressor front bearing housing.
SURFACE A			
- Nicks, dents or scratches	None permitted.	Not repairable.	Replace the compressor front bearing housing.

SUBTASK 72-30-11-230-001

(2) Do the fluorescent penetrant inspection, method A, sensitivity level 3.

(a) Do the fluorescent penetrant inspection, method A, sensitivity level 3 (Ref. TASK 70-21-01-200-801), of the compressor front bearing housing to the limits that follow:

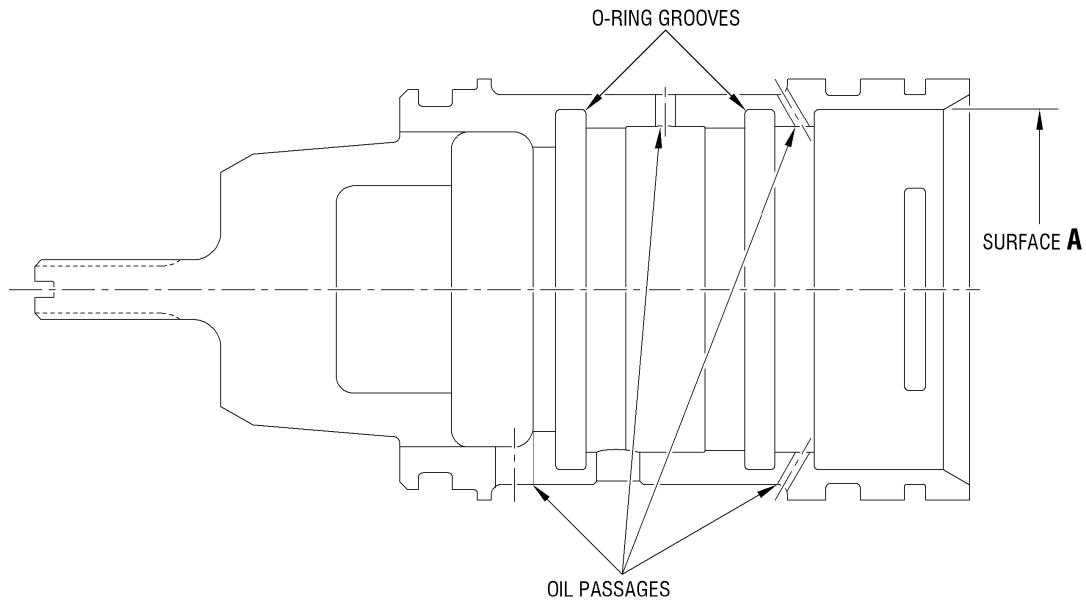
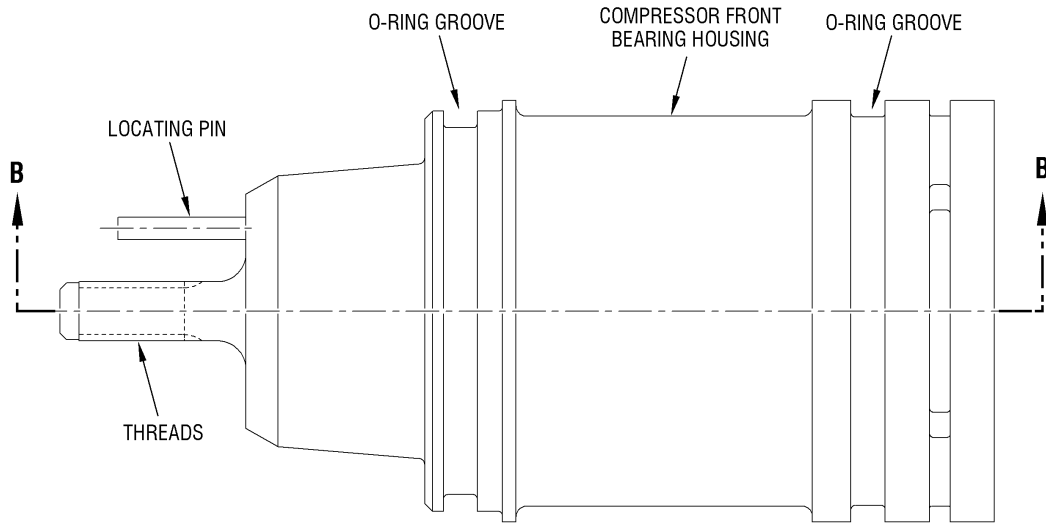
ITEM	SERVICEABLE LIMITS	REPAIR LIMITS	ACTION NECESSARY
Compressor front bearing housing			
- Linear indications	None permitted.	Not repairable.	Replace the compressor front bearing housing.
- Non-linear indications	None permitted.	Not repairable.	Replace the compressor front bearing housing.

EFFECTIVITY: ALL

INSPECTION/CHECK- 801

72-30-11

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SECTION B-B

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Compressor Front Bearing Housing - Inspection/Check
FIG. 801/TASK 72-30-11-990-801

EFFECTIVITY: ALL

