
SERVICE BULLETIN

Modification <input checked="" type="checkbox"/>	Recurring action <input type="checkbox"/>	One-off action <input type="checkbox"/>
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No.**292 72 2046**

ARRIEL 2 B - C - C1 - S1

Subject: Module M04 (power turbine). Increase of the power turbine bearing pressurization.**Application of modification TU 46A.**

Date on which this SB becomes effective and must systematically be complied with, according to the conditions of application.

This is the date all resources (parts, tools, documentation, etc.) required for this procedure are available.

Applicable from NOVEMBER 1999

If resources (parts, tools, documentation, etc.) are available any earlier, the SB may be applied prior to the effectivity date.

Version: B**Reason for update:****As PRE TU 46A labyrinth rings removed during repair and outside acceptance criteria cannot be modified into POST TU 46A rings, they must systematically be scrapped.**

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1. GENERAL

1.1. Purpose

To decrease the risk of oil leakage on the power turbine bearing labyrinth to prevent coking between the deflector and the power turbine disk rear face.

1.2. Reason

Coking between the deflector and the power turbine disk rear face can cause risk of non-starting or seizure after shut-down.

1.3. Description

This SB consists of expanding the section of the labyrinth ring where pressurizing air passes through.

1.4. Approval

The technical content of this document is approved under the authority of the DOA (Design Organisation Approval) ref. EASA.21J.070.

1.5. Conditions of application

The conditions of application for this SB are specified in:

- Chapter §2 for application at the operator's site or at a Maintenance Center qualified for level 1, 2.
- Chapter §3 for application at a Maintenance Center qualified for level 3.
- Chapter §4 for application at a Safran Helicopter Engines-approved Repair Center.

1.6. Definition

Not applicable.

1.7. Update history

VERSION	CAUSE FOR UPDATING
B	As PRE TU 46A labyrinth rings removed during repair and outside acceptance criteria cannot be modified into POST TU 46A rings, they must systematically be scrapped.

END of section §1

“General”

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2. APPLICATION AT THE OPERATOR'S SITE OR AT A MAINTENANCE CENTER QUALIFIED FOR LEVEL 1, 2

2.1. Required actions

Replace the PRE TU 46A module M04 with a POST TU 46A module M04 according to paragraph 2.3.

2.2. Effectivity and compliance times

ENGINE / VARIANT	EFFECTIVITY CODE	CONDITIONS OF APPLICATION FOR ENGINES IN SERVICE
ARRIEL 2 B - C - C1 - S1	2-A-3	Application upon customer request, by replacement of module M04.

2.3. Accomplishment instructions

2.3.1. Implementation

Application of this SB necessitates removing the engine.

2.3.2. Operating instructions

- 2.3.2.1. Remove the PRE TU 46A module M04: refer to the applicable ARRIEL 2 Maintenance Manual, task 72-00-54-900-801.
- 2.3.2.2. Install a POST TU 46A module M04: refer to the applicable ARRIEL 2 Maintenance Manual, task 72-00-54-900-801.

2.3.3. Reconditioning and checks

Do a ground run check: refer to the applicable ARRIEL 2 Maintenance Manual, task 05-50-00-200-801.

2.3.4. Identification

- 2.3.4.1. Update the log card of the installed module M04 and the log card of the removed module M04.
- 2.3.4.2. Record the replacement of module M04 in section "B" of the engine log book and integrate the log card of the installed module M04.
- 2.3.4.3. Record the application of this SB in section "D" of the current engine log book and in section "E" of the unique engine log book.
Note: Update the availability status, if necessary.
- 2.3.4.4. Return the removed module M04, along with its log card, to a Safran Helicopter Engines-approved Repair Center.
- 2.3.4.5. Tell Safran Helicopter Engines that module M04 has been replaced by returning the fully completed compliance certificate (Appendix 2.1 of this SB).

2.3.5. Scheduled maintenance

No modification to the scheduled maintenance.

2.4. Material information

2.4.1. Basic information

The parts list required for the application of this SB is for one engine.

2.4.2. List of parts

POST TU 46A module M04.

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2.4.3. Supply conditions

Order supplies as needed from:
 Your local Safran Helicopter Engines Support Center
 or
 SAFRAN HELICOPTER ENGINES
 Direction Support et Service
 Département Commercial
 40220 TARNOS - France

2.5. Manpower

- Personnel: 1 mechanic.
- Time required: 4 man hours (removal and installation of module M04).

2.6. Tooling and/or products

- Mechanic's standard tooling.
- Tooling for removal and installation of module M04.

2.7. Weight and balance

Not applicable.

2.8. Publication references

Document	Engine	Reference
Maintenance Manual (MM)	ARRIEL 2 B	X 292 M5 450 2
	ARRIEL 2 C	X 292 M1 450 2
	ARRIEL 2 C1	X 292 N4 450 2
	ARRIEL 2 S1	X 292 L0 301 2
Spare Parts Catalog (SPC)	ARRIEL 2 B	X 292 M5 700 2
	ARRIEL 2 C	X 292 M1 700 2
	ARRIEL 2 C1	X 292 N4 700 2
	ARRIEL 2 S1	X 292 L0 700 2

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Objet : Attestation de remplacement du module M04 par application du SB n° 292 72 2046 (TU 46A).

Subject: Compliance certificate for replacement of module M04 through application of SB No. 292 72 2046 (TU 46A).

Important / Important notice:

Après application des instructions spécifiées dans ce SB, veuillez compléter la présente attestation et la retourner par courrier ou courriel à :

After application of the instructions specified in this SB, please mail or email the fully-completed certificate to:

SAFRAN HELICOPTER ENGINES
Equipe Administration Base installée / Fleet Data Administrator Team, BP 25
40220 TARNOS - France

Email: data-fleet.fr.she@safrangroup.com

Information concernant le matériel / Equipment information						
Utilisateur Customer				N° Appareil Aircraft S/N		
	N/S - S/N	Réf. - P/N	TSN*	TSO*	CSN*	CSO*
Moteur Engine						
Module M04 déposé AVANT TU 46A Removed PRE TU 46A module M04						
Module M04 posé APRES TU 46A Installed POST TU 46A module M04						

* **TSN = Time Since New** (Heures depuis neuf)
CSN = Cycles Since New (Cycles depuis neuf)

TSO = Time Since Overhaul (Heures depuis RG)
CSO = Cycles Since Overhaul (Cycles depuis RG)

Opération faite par / Work done by:

Je certifie que le module M04 identifié ci-dessus a été installé selon les directives de ce SB.

I certify that the above-mentioned module M04 has been installed according to the directives given in this SB.

Date [JJ/MMMM (en lettre)/AAAA ou/or DD/MMMM (letter)/YYYY]	Nom / Name	Fonction / Job title

Signature :

ANNEXE 2.1 / APPENDIX 2.1

END of section §2

“Application at the operator’s site or at a Maintenance Center qualified for level 1, 2”

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3. APPLICATION AT A MAINTENANCE CENTER QUALIFIED FOR LEVEL 3

Refer to the paragraphs that apply to Maintenance Centers, given in chapter 2.

END of section §3

“Application at a Maintenance Center qualified for level 3”

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4. APPLICATION AT A SAFRAN HELICOPTER ENGINES-APPROVED REPAIR CENTER

4.1. Required actions

Replace the PRE TU 46A labyrinth ring with a POST TU 46A labyrinth ring according to paragraph 4.3.

4.2. Effectivity and compliance times

ENGINE / VARIANT	EFFECTIVITY CODE	CONDITIONS OF APPLICATION FOR ENGINES IN SERVICE
ARRIEL 2 B - C - C1 - S1	2-A-3	Application upon first return to an approved Repair Center, if the repair/overhaul being done gives access to the power turbine bearing (ITEM 72-54-20-01 was removed).

This SB must be applied with strict conformity to the manufacturer's conditions of application as defined by the effectivity code given in the above table.

4.3. Accomplishment instructions

4.3.1. Implementation

Application at a Safran Helicopter Engines-approved Repair Center.

4.3.2. Operating instructions

The removed and out-of-tolerance criteria PRE TU 46A labyrinth rings must systematically be scrapped.
Refer to the ARRIEL 2 Overhaul Manual.

4.3.3. Reconditioning and checks

Refer to the ARRIEL 2 Overhaul Manual.

4.3.4. Identification

4.3.4.1. Record the application of the SB on the module M04 log card.

Note: Update the availability status, if necessary.

4.3.4.2. Tell Safran Helicopter Engines that this SB has been applied by returning the fully completed compliance certificate (Appendix 4.1).

4.3.5. Scheduled maintenance

No modification to the scheduled maintenance.

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4.4. Material information

4.4.1. Basic information

The parts list required for the application of this SB is for one engine.

4.4.2. List of parts

New Part Number	Key	Qty	Description / Item	Old Part Number	Key	Qty
ARRIEL 2 B - C - C1 - S1						
0 292 81 742 0	A	1	Labyrinth ring / 72-54-20-01-200	0 292 81 727 0	C	1

Key

A	Part incorporated by the modification
C	Part deleted by the modification

4.4.3. Supply conditions

Order supplies as needed from:

Your local Safran Helicopter Engines Support Center

or

SAFRAN HELICOPTER ENGINES

Direction Support et Service

Département Commercial

40220 TARNOS - France

4.5. Manpower

- Personnel of approved Repair Center.
- Time determined by the Repair Center as being appropriate for this level of intervention.

4.6. Tooling and/or products

Refer to the ARRIEL 2 Overhaul Manual.

4.7. Weight and balance

Not applicable.

4.8. Publication references

Document	Engine	Reference
Overhaul Manual (OM)	ARRIEL 2	X 292 R1 500 2
Illustrated Parts Catalog (IPC)	ARRIEL 2 B	X 292 M5 600 2
	ARRIEL 2 C	X 292 M1 600 2
	ARRIEL 2 C1	X 292 N4 600 2
	ARRIEL 2 S1	X 292 L0 600 2

SERVICE BULLETIN

Objet : Attestation d'application du SB n° 292 72 2046 (TU 46A).

Subject: SB No. 292 72 2046 compliance certificate (TU 46A).

Important / Important notice:

Après application des instructions spécifiées dans ce SB, veuillez compléter la présente attestation et la retourner par courrier ou courriel à :

After application of the instructions specified in this SB please mail or email the fully-completed certificate to:

**SAFRAN HELICOPTER ENGINES,
Equipe Administration Base installée / Fleet Data Administrator Team, BP 25
40220 TARNOS - France**

Email : data-fleet.fr.she@safrangroup.com

Information concernant le matériel / Equipment information						
Utilisateur Customer				N° Appareil Aircraft S/N		
	N/S - S/N	Réf. - P/N	TSN*	TSO*	CSN*	CSO*
Moteur Engine						
Module M04 modifié Modified module M04						
Bague labyrinthe AVANT TU 46A PRE TU 46A labyrinth ring						
Bague labyrinthe APRES TU 46A POST TU 46A labyrinth ring						

* **TSN = Time Since New** (Heures depuis neuf)
CSN = Cycles Since New (Cycles depuis neuf)

TSO = Time Since Overhaul (Heures depuis RG)
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Opération faite par / Work done by:

Je certifie que le module M04 identifié ci-dessus a été modifié selon les directives de ce SB.

I certify that the above-mentioned module M04 has been modified according to the directives given in this SB.

Date [JJ/MMMM (en lettre)/AAAA ou/or DD/MMMM (letter)/YYYY]	Nom / Name	Fonction / Job title

Signature :

ANNEXE 4.1 / APPENDIX 4.1

END of section §4

“Application at a Safran Helicopter Engines-approved Repair Center”