

SERVICE BULLETIN No. 319 72 4830

Version: B

Date: 8 March 2024

Reason for update: Introduction of the list of the applicable materials in the appendix.

Modification

Periodical action

One-off action

Applicable from:
« MAY 2008 »

Subject:
Module M02 (gas generator). Inspection of the oil jet support of the power turbine rear bearing assembly.

APPLICABLE ENGINE / VARIANT(S)	EFFECTIVITY CODE	MAINTENANCE LEVEL	CONDITION OF APPLICATION	EFFECT ON OPERATION
ARRIUS 2 F	2-4	1, 2, 3	Not applicable	
		4	Application upon first return to an approved Repair Center, regardless of the reason for return.	Removal of the jet holder flange (item 72-42-20-01-750)

Apply this SB in full compliance with the manufacturer's instructions.
Refer to the effectivity code above.

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

1. GENERAL

1.1. Background

1.1.1. Context

Safran Helicopter Engines was informed in 2007 of a chip event that occurred on an ARRIUS 2 B2 engine, during a ground run. This engine had 69 operating hours since new.

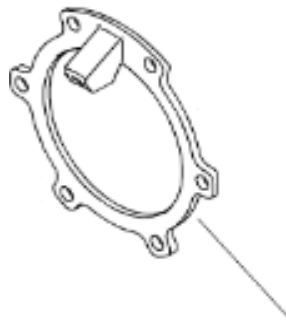
1.1.2. Analysis

The investigation done on this engine showed that the oil jet of the PT bearing was outside its housing. The loss of this jet then its interaction with the rotating parts was the source of particles that the electrical magnetic plug of module M02 detected.

The subsequent quality investigation done found that three manufacturing batches of jet holder flanges are possibly affected by a non-conformity of bonding of the oil jets.

1.1.3. Solution

For module M02 serial numbers given in the list of the [Appendix 1](#), this Service Bulletin (SB) makes sure that the oil jets of the jet holder flange of the rear bearing assembly (item 72-42-20-01-750) are correctly tightened.



72-42-20-01-750

1.2. Approval

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

1.3. Summary of updates

Version	Date	Primary cause for update
A	29-APRIL-2008	First issue

End of Section §1

“General”

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

2. PROCEDURE DONE AT THE OPERATOR'S SITE OR AT A MAINTENANCE CENTER APPROVED FOR LEVEL 1, 2

Not applicable.

End of Section §2**“Procedure done at the operator's site or at a Maintenance Center approved for Level 1, 2”**

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

3. PROCEDURE DONE AT A MAINTENANCE CENTER APPROVED FOR LEVEL 3 OR AT THE OPERATOR'S SITE BY A MAINTENANCE CENTER APPROVED FOR LEVEL 3

Not applicable.

End of Section §3

“Procedure done AT a Maintenance Center approved for Level 3 OR AT THE OPERATOR'S SITE BY a Maintenance Center approved for Level 3”

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

4. PROCEDURE DONE AT A REPAIR CENTER APPROVED FOR LEVEL 4**4.1. Manpower**

- Personnel of approved Repair Center.
- Time calculated by the Repair Center for this level of intervention.

4.2. Tools / Parts

Refer to the ARRIUS 2 Overhaul Manual.

4.3. Parts information**4.3.1. Basic information**

The list of parts is given for one engine.

4.3.2. List of parts

Refer to the ARRIUS 2 Overhaul Manual and Illustrated Parts Catalog.

4.3.3. Supply conditions

Order supplies from:

Your local Safran Helicopter Engines Support Center

or

SAFRAN HELICOPTER ENGINES

Direction Support et Service

Département Commercial

40220 TARNOS - France

4.4. Procedures

Inspection of the jet holder flange of the rear bearing assembly, refer to paragraph 4.6.

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

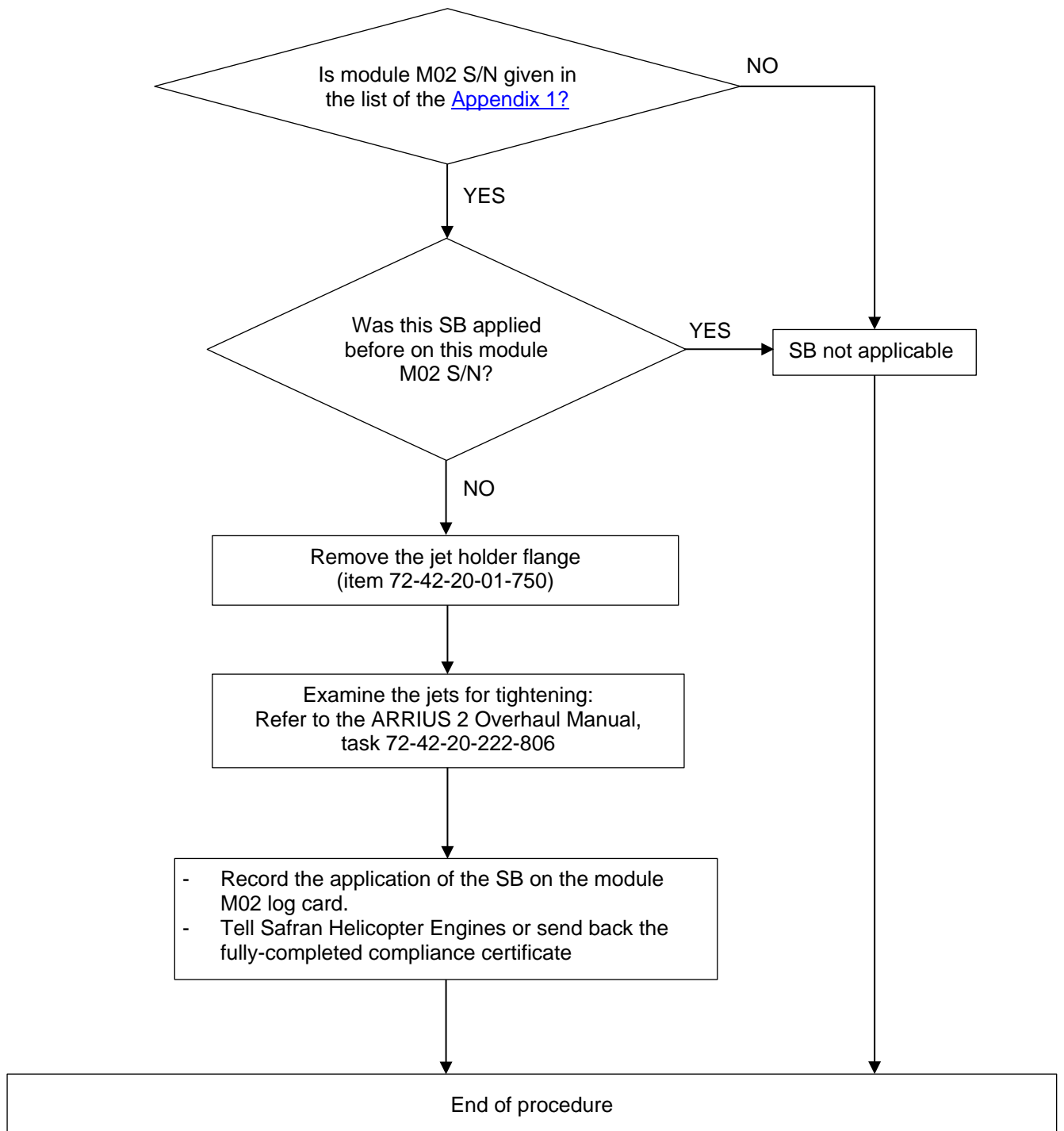
§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

4.5. Block diagram for this SB



SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

4.6. Instructions on how to do the procedure**4.6.1. Implementation**

Systematic application upon first return of module M02 S/Ns given in the list of the [Appendix 1](#).

4.6.2. Operating instructions

If necessary, use force to disassemble the module M02 to get access to the jet flange.

- 4.6.2.1. Remove the jet holder flange (item 72-42-20-01-750): Refer to the ARRIUS 2 Overhaul Manual.
- 4.6.2.2. Examine the jets for tightening: Refer to the ARRIUS 2 Overhaul Manual, task 72-42-20-222-806.

4.6.3. Reconditioning and checks

Refer to the ARRIUS 2 Overhaul Manual.

4.6.4. Identification

Refer to the Guides U441 and U015 for instructions on how to record the engine log book and the log cards.

- 4.6.4.1. Record the application of this SB on the log card of the module M02.
- 4.6.4.2. Send back the fully-completed compliance certificate, links to the digital document

EngineLife Customer Portal: [Certificate 5.1 SB 319 72 4830 EN B](#) or

**4.7. Weight and balance**

Not applicable.

End of Section §4**“Procedure done at a Repair Center approved for Level 4”**

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

§2. LEVEL 1, 2

§3. LEVEL 3

§4. LEVEL 4

§5. CERTIFICATES

5.1- Compliance certificate of SB No. 319 72 4830 - LEVEL 4

Important :

Fill in the compliance certificate after application of the instructions given in this SB.

Mail or email it to:

SAFRAN HELICOPTER ENGINES
 Equipe Administration Base installée / Fleet Data Administrator Team, BP 25
 40220 TARNOS - France
 Email: data-fleet.fr.she@safrangroup.com

Equipment information					
Customer				Aircraft S/N:	
	S/N	P/N	TSN*	CSN HP*	CSN PT*
Engine					
Modified module M02					

* TSN = Time Since New
 CSN = Cycles Since New

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

Date [DD/MMMM (letters)/YYYY]	
Comments	

SERVICE BULLETIN No. 319 72 4830

Appendix 1

VARIANT	S/N MODULE									
	205	1227	1228	1229	1233	1236	1259	1263	1270	1271
	1272	1277	1292	1312	1316	1317	1318	1320	1323	1327
ARRIUS 2 F	1328	1334	5502	5504	5507	5514	5516	5518	5522	5524
	5528	5529	5530	5531	5534	5535	5537	5539	5541	5542
	5546	5551	5553							

SERVICE BULLETIN No. 319 72 4830

§1. GENERAL

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SAFRAN HELICOPTER ENGINES
 Equipe Administration Base installée / Fleet Data Administrator Team, BP 25
 40220 TARNOS - France
 Email: data-fleet.fr.she@safrangroup.com

Equipment information					
Customer				Aircraft S/N:	
	S/N	P/N	TSN*	CSN HP*	CSN PT*
Engine					
Modified module M02					

* TSN = Time Since New
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