



**Rolls-Royce**

**Rolls-Royce Corporation  
M250-C18**

**COMMERCIAL SERVICE  
LETTER  
(CSL)**

**Technical Publications  
Index**

**March 3, 2020**

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1	M250 Authorized Maintenance Center (AMC's), Publications, Rolls-Royce Telephone Contacts, Warranty, Training, and Unapproved Parts	Reissue 03-31-97	11	06-11-18
2	Approved Lubricants-Engine Oil System.	Cancelled-Ref: Ops. And Maint. Manual		
3	Fuels Approved For Use In The 250-C18 Series Engines	Cancelled-Ref: Ops. And Maint. Manual		
4	Cancelled Prior to Publication.			
5	Retention of Diffuser Vent Orifice.	Cancelled		
6	Magnetic Plug Inspection Frequency.	Cancelled		
7	Power Turbine Governor Assembly Clip Inspection	Cancelled		
8	Time Between Overhauls.	Cancelled-Ref: Ops. And Maint. Manual		
9	Authorized Distributors For The 250 Series Allison Engine	Cancelled-Ref: Section V of 250 CSL-1		
10	250-C18 Series Engine Time Limited Parts.	Cancelled-Ref: Ops. And Maint. Manual		
11	Double Check Valve Cleaning.	Cancelled		
12	Dwell Time Increase At Idle Prior To Shutdown	Cancelled		
13	Interim Operating Restriction To Reduce Third-Stage Compressor Blade Stresses: Model 250-C18 And 250-C18A Engines	Cancelled		
14	Oil System Maintenance Following Engine Inactivity	Cancelled		
15	Power Turbine (N <sub>2</sub> ) Rub.	Cancelled		
16	Corrosion Control.	Cancelled		
17	Turbine Scavenge Oil Tubes.	Cancelled		
18	Field Adjustment Instructions For Start Derichment Valve	Cancelled		
19	Visual Inspection Limit - Compressor Rotor.	Cancelled		
20	Inspection And Cleaning of Power Turbine Support Scavenge Oil Strut	Cancelled		

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22	Fuel Pump Replacement Instructions.	Cancelled		
23	Model 250 Service Publications.	Cancelled		
24	Engine Oil Filter Servicing And Oil Changes	Cancelled		
25	Compound Governor Installation Instructions	Cancelled		
26	Fuel Control Deceleration Minimum Ratio Flow Stop Adjustment	Cancelled		
27	Cancelled Prior to Publication			
28	Model 250 "Blue Ribbon" Engine Program	Cancelled		
29	Cancelled Prior to Publication			
30	Inspection of Outer Combustion Case	Cancelled		
31	Gearbox Field Repair of Loose Compressor Mounting Inserts	06-17-69		
32	Re-emphasis of Model 250 Service Publications	Cancelled		
33	Model 250 Warranty	Cancelled		
34	Operating Restriction To Reduce Torquemeter Shaftgear Stress	Cancelled		
35	Helical Power Train Drive Gear Internal Spline Inspection	Cancelled		
36	Periodic Cleaning of All Magnetic Plugs	Cancelled		
37	Model 250 Compressor Mounting Shims	Cancelled		
38	"Blue Ribbon" Model 250 Engine Major Component Interchangeability	08-27-69	1	10-01-69
39	Turbine To Gearbox Assembly Interference	Cancelled		
40	Model 250 Engine Firewall Shields	09-23-69		
41	Cold Weather Starting And Operation	Cancelled		
42	Igniter Lead Clamping To The Governor To Fuel Control Tube	10-31-69		
43	Fuel Nozzle Cleaning And Inspection	Cancelled		
44	Cancelled Prior to Publication			

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46	Interim Repair For Diffuser Vent Tube Orifice	Cancelled		
47	Cancelled Prior to Publication			
48	Compressor To Gearbox Assembly Interference	Cancelled		
49	P <sub>c</sub> Filter-Bonded Lubricant On Threads	Cancelled		
50	Cold Weather Starting, Operation, And Maintenance	Cancelled		
51	Alternate Compressor Bleed Valve Installation Instructions	Cancelled		
52	Maintenance Procedures To Prevent Entry of Foreign Metal Into The Oil System	Cancelled		
53	Fuel Control Operational Check	Cancelled		
54	Field Procedure For Checking Fuel Control Max N <sub>1</sub> Setting	Cancelled		
55	250-C18B And 250-C18C Engines-Publications And Serial Numbers	07-01-70		
56	Cancelled Prior to Publication			
57	Throttle Shaft Binding	02-24-71		
58	Troubleshooting The Bendix Start Derich System On Fuel Controls On 250-C18 And B15G Series Engines	06-28-71	1	07-06-79
59	Cleaning Of Bendix Model DP-D3 (P/L 2524463-1 thru -3) Fuel Control Air Components	08-27-71	2	01-21-72
60	Improved Cold Weather Starting-Bendix Model DP-D3 Fuel Control P/N 6871119	08-31-71	1	10-11-71
61	Dual Element Fuel Pump Drive Shaft Inspection	11-16-72	4	09-01-94
62	O-Ring Added Between Oil Filter Element And Standpipe	Cancelled-Ref: Illustrated Parts Catalog		
63	Cleaning Of The AL-L3 Power Turbine Governor Air Circuit Bleed	Cancelled-Ref: Ops. And Maint. Manual		
64	AVGAS Mixture Using 100/130 Aviation Gasoline With Commercial Jet A Turbine Fuel For Cold Weather Operation	Cancelled-Ref: Ops. and Maint. Manual		
65	Compressor Salt Water Contamination Removal	Cancelled-Ref: Ops. And Maint. Manual		

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67	Maintenance Action-Engine Operation Beyond Limits of 107°C Oil Temperature	Cancelled-Ref: Ops. And Maint. Manual		
68	Water Washing The Compressor In Cold Weather	Cancelled-Ref: Ops. And Maint. Manual		
69	Contamination Removal (Water Rinse) Instructions <u>Using Water Only</u>	Cancelled-Ref: Ops. And Maint. Manual		
70	Starter Generator And Generator Gearshaft Mating Spline Wear	Cancelled-Ref: Ops. And Maint. Manual		
71	Required 250-C18 Field Inspections	10-01-73		
72	Single Element Fuel Pump Shouldered Drive Shaft Inspection	Cancelled-Ref: Ops. And Maint. Manual		
73	Model 250 Engine Log Books	Cancelled 03-24-08		
74	250 Series Engines-Cost Effect of Modular Overhaul	Cancelled-Ref: Ops. And Maint. Manual		
75	Bleed Valve Cleaning	Cancelled-Ref: Ops. And Maint. Manual		
76	Model 250 Reporting	02-20-75	8	02-07-11
77	Use of Unapproved Parts, Engines, Major Modules, or Piece Parts That May Have Been in Long Term Storage in Rolls-Royce Commercial Engines	07-10-75	7	02-12-02
78	Cancelled Prior to Publication			
79	Noisy 250 Series Engine Fuel Pumps	11-26-75	4	06-08-04
80	Replacement Interval of Fuel Inlet Filter Strainer In Bendix Fuel Control	Cancelled-Ref: Ops. And Maint. Manual		
81	Model 250 Bendix Fuel System Certified Installation Kits	01-30-76	3	06-01-79
82	250 Compressor Erosion Inspection	Cancelled-Ref: Ops. And Maint. Manual		
83	Cancelled Prior to Publication			

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85	Cancelled Prior to Publication			
86	Field Cleaning Procedure Relative To Carbon Caused Turbine N <sub>2</sub> Lock-up On All Series I And Series II Model 250 Engines	Cancelled-Ref: Ops. And Maint. Manual		
87	Cancelled Prior to Publication			
88	Power Turbine Outer Coupling Nut Inspection	10-27-76	5	07-22-94
89	DDA Model 250 Customer Questionnaire	Cancelled		
90	Oil Foaming And Oil Pressure Fluctuations	03-09-78		
91	Gearbox, Wet Spline Starter-Generator Gearshaft (Customer Option)	03-31-78		
92	Cancelled Prior to Publication			
93	Inspection of <u>FACET</u> Low Pressure Filter Element (DDA P/N 6895177; Kit P/N 6895028)	Cancelled		
94	Cancelled Prior to Publication			
95	Cancelled Prior to Publication			
96	Part Number 6856754 and 6871444 Fourth Stage Compressor Wheel Retirement For Excessive Hardness	03-15-79		
97	Turbine to Compressor Coupling	Cancelled-Ref: Ops. And Maint. Manual		
98	Air Purge Of Low Pressure (LP) Fuel Filter For Single Element Fuel Pumps On Boost Pump Equipped Aircraft	Cancelled-Ref: Ops. And Maint. Manual		
99	Lubrication System Troubleshooting	06-07-79	7	09-14-09
100	Use of Silicone Base Molybdenum Disulfide And Nickel Base Anti-Seize Compounds	07-06-79	2	02-15-80
101	Recall of "PRIST" Packaged In Cans Manufactured By Continental Can Company	Cancelled		
102	Cancelled Prior to Publication			
103	Purchase Of Detroit Diesel Allison Commercial Model 250 Engines	07-12-79		
104	Fuel Pump Filter By-Pass Valve - Periodic Operational Check	Cancelled-Ref: Ops. And Maint. Manual		

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107	Cancelled Prior To Publication			
108	Special Inspections For Engines Operated In Volcanic Ash	06-02-80	5	01-05-07
109	Compressor Case-Sealing of Cracked Plastic Liner	Cancelled-Ref: Ops. And Maint. Manual		
110	Sundstrand Grease Part Number Change	08-18-80		
111	Compressor Water Rinse On Engines With Water-Alcohol Augmentation System Installed	07-30-80		
112	Fuel/Control System Air Leak Safety Warning	09-15-80	2	11-22-10
113	Bendix Gas Producer Fuel Control And Power Turbine Governors, "Stiff" Throttle Controls	07-30-80		
114	Flight In Turbulence - Safety Warning	09-30-80		
115	Spectrographic Oil Analysis Programs (SOAP) Versus Magnetic Drain Plugs - Safety Warning	09-30-80	3	11-01-96
116	Cancelled Prior to Publication			
117	Cancelled Prior to Publication			
118	Model 250 Series Engine Identification	Cancelled 04-07-08		
119	Turbine "U" Ring Installation And Pressure Test	Cancelled-Ref: Ops. And Maint. Manual		
120	List of Model 250 Publications Indicating The Latest Revision As of March 30, 1982	Cancelled-Ref: Ops. And Maint. Manual		
121	Cancelled Prior to Publication.			
122	Inspection of The No. 6 And No. 7 Bearing Pressure Oil Nozzle After Removal	Cancelled-Ref: Ops. and Maint. Manual		
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131	Commercial Engine Bulletin Distribution	07-13-84		
132	Commercial Engine Bulletin Classification	06-16-86	4	06-19-19
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134	Model 250 Turbine Alignment Build Procedures	12-01-85	1	05-27-86
135	Guidelines For Operation of "On Condition" Modules	04-01-88		
136	Identification of Allison Power Parts	08-01-85	1	01-31-90
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138	Field Vibration Test Procedure	10-17-86	10	06-19-19
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140	Return of Parts for Field Investigation at Allison or Allison Authorized Maintenance Centers (AMC)	04-20-86	2	10-01-96
141	Contamination Removal (Water Rinse) Instructions Using Water Only	06-23-86	11	12-20-19
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145	Chafe Wrapping Of Stainless Steel Tube Assemblies	05-01-88		
146	Warning Tags Attached to Fuel Oil, Air Tubes, Fittings and Associated Components On 250 Series Engines	09-10-87	2	09-26-00
147	Guidelines for Operation of Manually Activated Fuzz Burning Engine Chip Detectors	11-01-88		
148	Warning-Use of Proper Compressor Scroll to P <sub>c</sub> Filter Tube Assemblies	05-01-88		
149	Model 250 System - Operation and Maintenance Guidelines	05-11-79	2	11-01-88
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164	Operation of Bendix Fuel Controls and Power Turbine Governors Exposed to Fire or Severe Overtemperature	04-14-89		
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170	Allison Auto Reignition Control System	12-31-89		
171	Model 250 Logbook Changes	11-15-94		
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173	Model 250 Engine Designations and Applications	11-30-91	5	07-13-15
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181	Authorized Allison Repair/Overhaul Facilities for the Allison Model 250 Engine	Cancelled - Ref Ops & Maint Manual		
183	Change in Commercial Engine Bulletin Index Format	06-15-93		
185	Cancelled Prior to Publication			
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187	Allison Model 250 Engine Customer Support and Service Parts Telephone Numbers	Cancelled 02-01-02		
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189	Use of Rolls-Royce Military Surplus Parts in Commercial Engines	01-27-95	5 Reissue	04-23-02
190	Troubleshooting Guide for Bendix Fuel Control Systems Used on Helicopters	06-30-97		
191	Recommended Use of Airframe Accessory Filter for Remote Area Fueling	09-15-97		
193	Identification of A New Fuel Pump Vendor	11-01-95	1	06-30-97
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204	Commercial Operation of Military T63 Engines	04-30-98	2	10-12-09
205	Hot Corrosion - Sulfidation	02-10-00	1	05-25-04
206	Inconel Bellows Incorporation in all 250 Allied Signal (Bendix) Fuel Controls	02-27-98		
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212	Alternate Consumable Materials List	04-19-00	3	09-17-12
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214	Manufacturing Tooling Marks On Tubing Assemblies	04-11-00	1	04-27-09
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A-218	Honeywell Extension Of Inconel Bellows Special Pricing	12-20-00		
219	Second Stage Nozzle Special Pricing Policy	Cancelled 03-15-10		
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