



Rolls-Royce

**Rolls-Royce Corporation
M250-C28**

**COMMERCIAL SERVICE
LETTER
(CSL)**

**Technical Publications
Index**

March 3, 2020

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2001	M250 - Authorized Maintenance Centers (AMC's), Publications, Rolls-Royce Telephone Contacts, Warranty, Training, and Unapproved Parts	Reissue 03-31-97	11	06-11-18
2002	Approved Lubricants-Engine Oil System	Cancelled		
2003	Fuels Approved For Use In 250 Series Engines	Cancelled-Ref: Ops. And Maint. Manual		
2004	250-C28 Series Engine Time Between Overhauls	Cancelled-Ref: Ops. And Maint. Manual		
2005	250-C28 Series Engine Life Limited Parts	Cancelled-Ref: Ops. And Maint. Manual		
2006	Water Washing The Compressor In Cold Weather	Cancelled (Ref. OMM)		
2007	Outer Combustion Case - Inspect Welds	Cancelled-Ref: Ops. And Maint. Manual		
A-2008	Engine N ₂ Overspeed System	10-25-78	2	09-01-94
A-2009	Precautions 250-C28B Thermal Switch/Bleed Valve System	11-09-78		
2010	DDA Model 250 Questionnaire	Cancelled		
2011	Auto-Acceleration for 250-C28B Engines	Cancelled-Ref: Ops. And Maint. Manual		
2012	Lubrication System Troubleshooting	06-07-79	7	09-14-09
2013	Cancelled Prior to Publication			
2014	250-C28B, -C28C, and -C30 Bleed Valve - Troubleshooting And Maintenance	Cancelled-Ref: Ops. And Maint. Manual		
2015	Use of Silicone Base Molybdenum Disulfide And Nickel Base Anti-Seize Compounds	07-06-79	2	02-15-80
2016	Recall of "Prist" Packaged In Cans Manufactured By Continental Can Company	Cancelled		
2017	Cancelled prior to Publication			
2018	Purchase of Detroit Diesel Allison Commercial Model 250 Engines	07-12-79		

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2019	Turbine Exhaust Collector To Gearbox Housing Retaining Nuts	Cancelled-Ref: Ops. And Maint. Manual		
2020	Model 250 Reporting	02-20-75	8	02-07-11
2021	250-C28/-C30 Installation of Discharge Air Tube Clamp, P/N 6892313, and 6892314	Cancelled		
2022	Starting Improvement Techniques With Bendix FCU On 250-C28B/-C28C, and -C30 Engines	12-15-79		
2023	Fire Extinguisher Material (Cleaning)	09-28-79	1	12-01-80
2024	250-C28B Bleed Valve System	10-12-79		
2025	Fuel Control Assembly Start-Acceleration Fuel Flow Schedule Adjuster	Cancelled-Ref: Ops. And Maint. Manual		
2026	Combustion Liner Wider Service Limits	Cancelled-Ref: Ops. And Maint. Manual		
2027	Inspection, P/N 6898966 And 6896021 Compressor Mount Assembly	Cancelled-Ref: CEB-A-72-2080		
2028	P _c Air Filter Recommended Maintenance Practices	Cancelled-Ref: Ops. And Maint. Manual		
A-2029	Engine Flameouts Due To Snow or Ice Ingestion - Warning	09-15-80	3	10-06-05
2030	250-C28 Series P/N 6898952 Second-Stage Turbine Nozzles-900 Hour Replacement	Cancelled-Ref: Ops. And Maint. Manual		
2031	Cancelled Prior to Publication.			
2032	Turbine Assembly Mounting Pad Shims - Series III And IV Engines	09-10-80		
2033	Special Inspections for Engines Operated In Volcanic Ash	06-02-80	5	01-05-07
2034	Rear Engine Mount Bearing Inspection	Cancelled-Ref: Ops. And Maint. Manual		
2035	Optimized Starting Technique	Cancelled-Ref: Ops. And Maint. Manual		
2036	250 Series III and IV Fuel Control Drive Bearing Grease Washout	09-30-80		

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2037	Turbine Support And Exhaust Collector Flow Divider - Scheduled Inspection	Cancelled-Ref: Ops. And Maint. Manual		
2038	Fuel/Control System Air Leak Safety Warning	09-15-80	2	11-22-10
2039	Bendix Gas Producer Turbine Fuel Control And Power Turbine Governor "Stiff" Throttle Controls	07-30-80		
2040	Spectrographic Oil Analysis Programs (SOAP) Versus Magnetic Drain Plug Lights - Safety Warning	09-30-80	3	11-01-96
A-2041	250-C28B P _c Air Tube Assembly, Fuel Control To Governor Tee - Inspect	09-10-80		
2042	Cancelled Prior to Publication			
2043	Model 250 Series Engine Identification	Cancelled 04-07-08		
2044	Fire Shield - Horizontal And Vertical - Inspect For Cracks	Cancelled-Ref: Ops. And Maint. Manual		
2045	Cancelled Prior to Publication			
2046	DDA Model 250-C28B And -C30 Engine Improvement Program - Special Pricing on Parts	02-05-81		
2047	List of Model 250 Publications Indicating The Latest Revision as of March 30, 1982	Cancelled		
2048	Turbine "U" Ring Installation And Pressure Test	Cancelled-Ref: Ops. And Maint. Manual		
2049	Maintenance Procedures For Spur Adapter Gearshaft O-Ring P/N AS3085-018, and Turbine Maintenance	Cancelled-Ref: Ops. And Maint. Manual		
2050	Cancelled Prior to Publication			
2051	Inspection of No. 6 and 7 Bearing Oil Pressure Nozzle After Removal	Cancelled-Ref: Ops. And Maint. Manual		
2052	Cancelled Prior to Publication			
2053	Cancelled Prior to Publication			
2054	Operating Instructions For 250-C28B Anti-Ice, EAPS, And Bleed Valve Test Set P/N 23005411	06-01-83	2	08-01-88
2055	Troubleshooting Engine Smoking	08-25-82		
2056	Cancelled Prior to Publication			

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2057	Cancelled Prior to Publication			
2058	Series III And IV Compressor Bleed Valve Attachment Bolt	07-15-83		
2059	Cancelled Prior to Publication			
2060	Cancelled Prior to Publication			
A-2061	Inspect Outer Combustion Case For Cracks In Welded Areas	Cancelled		
2062	Cancelled Prior to Publication			
2063	Benefits of an External Scavenge Oil Filter	08-01-84	2	07-28-05
A-2064	Inspect Compressor Rotor and Splined Adapter	07-02-84	7	Cancelled 3/24/14
2065	TBO Extension Program, 250 Series Engines	09-14-84	3	04-30-96
2066	Model 250 Rework Parts Policy	Cancelled		
2067	Commercial Engine Bulletin Distribution	07-13-84		
A-2068	N ₁ Shafting Inspection	Cancelled 03-03-08		
2069	250-C28 Series and -C30 Series Additional Post Flight Inspection	08-22-84	1 (Alert Status Dropped)	12-14-84
2070	Returning Of CEB Compliance Sheets with 250 Engine Module to be Repaired	12-01-85	1	08-07-98
2071	Turbine Rotor Splined Locknut Torque Requirement for All Model 250-C28 and 250-C30 Engines	Cancelled		
2072	Commercial Engine Bulletin Classification	06-16-86	4	06-19-19
2073	Cancelled Prior to Publication			
2074	Model 250 Alignment Build Procedures	12-1-85	1	05-27-86
2075	Guidelines for Operation of "On Condition" Modules	04-01-88		
2076	Identification of Allison Power Parts (APP)	08-01-85	1	01-31-90
2077	Cancelled Prior to Publication			
2078	Noisy 250 Series Engine Fuel Pumps	11-26-75	4	06-08-04
2079	Field Vibration Test Procedure	10-17-86	10	06-19-19
2080	Cancelled Prior to Publication			

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2081	Return Of Parts For Field Investigation At Allison Or Allison Authorized Maintenance Centers (AMC)	04-20-86	2	10-01-96
2082	Contamination Removal (Water Rinse) Instructions <u>Using Water Only</u>	06-23-86	11	12-20-19
2083	Publication Authorization Procedures	11-03-86	5	11-01-96
A-2084	Inspection of Turbine Splined Adapter Locknut Torque	09-10-86	1	09-29-86
2085	Alert Document Compliance	01-31-87	3	10-01-96
2086	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
A-2087	Accessory Gearbox Covers Crack	09-25-87		
2088	Longer Life Igniter Plugs	08-20-87	3	10-01-96
2089	Chafe Wrapping Of Stainless Steel Tube Assemblies	05-01-88		
2090	Warning Tags Attached to Fuel, Oil, Air Tubes, Fittings and Associated Components On 250 Series Engines	09-10-87	2	09-26-00
2091	Guidelines for Operation of Manually Activated Fuzz Burning Engine Chip Detectors	11-01-88		
2092	Model 250/225 Fuel System Operation and Maintenance Guidelines	05-11-79	2	11-01-88
A-2093	Operational Warning - Height Velocity Diagram (Not a Restriction Nor a Limitation)	Cancelled 07-18-06		
2094	Cancelled Prior to Publication			
2095	Serial Number Effectivity, Allison Commercial Engine Bulletin	05-01-88		
2096	Commercial Engine Bulletin Incorporation Philosophy	04-30-88		
2097	Installation of New Gas Producer Tiebolt Nut P/N 23039751	Cancelled		
2098	Cancelled Prior to Publication			
2099	Translation of Allison Technical Publications into Foreign Languages	11-01-88		
2100	Rolls-Royce Customer Training	08-01-88	21	05-27-15
2101	Model 250 Series III and IV No. 6 and No. 7 Bearing Power Turbine Strut Scavenge Oil Flow Check Procedure	12-01-88		

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2102	Use of Eastern European, United Kingdom, and Peoples Republic of China Specification Fuels in Rolls-Royce M250 Engines	04-01-89	7	03-26-14
A-2103	Use of Salvaged or Scrapped Parts in Allison Model 250/225 Engines	12-01-88	1	08-15-91
2104	Cancelled Prior to Publication			
2106	Seal Shelf Life (Age Control)	05-01-89	1	08-22-11
2107	Operation of Bendix Fuel Controls and Power Turbine Governors Exposed to Fire or Severe Overtemperature	04-14-89		
2108	Module Interchangeability Following Incorporation of Number 3 & 4 Roller Bearings (Gearbox Module) and/or Number 5 Labyrinth Seal (Turbine Module), and Color Coding of Oil Delivery (Piccolo) Tube and Pinion Bearing Oil Nozzle	05-15-89		
2110	Auto Accelerations or Power Decelerations in Cold Soak Environments	06-01-89		
2111	Cancelled Prior to Publication			
2112	Purolator/Facet External Scavenge Oil Filter Inspection	02-01-90	3	05-03-10
A-2113	Maintenance Warning - External Lines	11-15-90	2	07-08-19
A-2114	Compliance, 250-C28 Series Internal Energy Absorbing Ring	11-30-89		
2115	Model 250 Logbook Changes	11-15-94		
2116	N ₂ /N _R Speed Setting	03-15-92		
2117	Model 250 Engine Designations and Applications	11-30-91	5	07-13-15
2118	Model 250-Engine Mean Time Between Removal Experience and Recommendations on use of Overhauled First-Stage Turbine Nozzles	01-31-91	2	05-30-94
2119	"B" Nut Warning Placard	Cancelled		
2121	Cancelled Prior To Publication			
2122	Unapproved Hot Engine Cool Down Procedure	03-01-93	1	11-13-01
2123	Recommendations in Conjunction with Engine Oil Change	04-30-93	1	04-15-98
2124	Operation and Maintenance Manual Publications Concerning Magnetic Chip Detector Guidelines	04-30-93		
2125	Authorized Allison Repair/Overhaul Facilities for the Allison Model 250 Engine	Cancelled-Ref Ops & Maint Manual		

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2127	Change in Commercial Engine Bulletin Index Format	06-15-93		
2128	Increased Impeller Life Limits for Model 250-C28/C30 Engines	08-31-93		
A-2131	Inspection, Rework and Overhaul of Parts Manufactured by Anyone Other Than Allison and/or Allison Approved Vendors and Suppliers	02-15-94	1	11-30-94
2132	Handling of Fluorocarbon Elastomer Preformed Packings and/or Seals	02-01-95		
2133	Model 250 Power By The Hour®/Fleet Hour Agreement Program	09-30-94	6	Cancelled 02-22-08
2134	Allison Model 250 Engine Customer Support and Service Parts Telephone Numbers	Cancelled 02-01-02		
2135	Use of Rolls-Royce Military Surplus Parts in Commercial Engines	01-27-95	5 Reissue	04-23-02
2136	Troubleshooting Guide for Bendix Fuel Control Systems Used on Helicopters	06-30-97		
2138	Identification of A New Fuel Pump Vendor	11-01-95	1	06-30-97
2139	Model 250 Publications Procurement Policy	02-15-96	3	03-03-08
2140	Letterhead, Model 250 Commercial Engine Bulletins, Commercial Service Letters and Installation Bulletins	11-15-95		
2141	Manufacturing Origin Request Procedure	02-20-96	3	07-23-04
2142	Rolls-Royce Part or Assembly Modification	07-31-96	2	05-22-02
2143	No-Go Gages for Spline Inspection	11-15-97	Cancelled	02-10-14
2145	Disposition of Old Engine and Module Data Plate	10-15-97	3	02-24-16
2146	Return of Model 250 Field Parts for Investigation at Rolls-Royce	06-30-97	4	04-06-15
2147	Cancelled Prior to Publication			
2148	Release of New Oil Delivery Tube (Piccolo)	09-02-97		
2149	Commercial Engine Bulletin, CECO Fuel Pump Spline Inspection	09-02-97		
2150	Use of High Thermal Stability (HTS) or Third Generation Oils	09-15-97	2	02-13-12
2151	Recommended Use of Airframe Accessory Filter for Remote Area Fueling	09-15-97		

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2152	Hot Corrosion - Sulfidation	02-10-00	1	05-25-04
2153	Inconel Bellows Incorporation in All 250 AlliedSignal (Bendix) Fuel Controls	02-27-98		
2154	Pilot Warning - Practice Autorotations With Certain Allied Signal (Bendix) Fuel Controls	05-30-97	1	02-15-98
2155	Lifting Patches On -C28, -C30, -C40 And -C47 Compressor Assemblies (Scroll)	01-15-98	2	09-19-11
2156	Release of New Gearbox Vent Tube	07-07-98		
2157	Release of New Number One Bearing Housing	01-04-99	1	03-24-14
2158	OEM Engine Warranty	04-15-99	1	07-08-16
A-2161	Model 250 Engine Cautions For Changes In Engine Noise	09-15-99		
2162	Alternate Consumable Materials List	04-19-00	3	09-17-12
2163	Rolls-Royce Model 250/Aviall Parts And Technical Publications Distribution	Cancelled 01-25-02		
2164	Manufacturing Tooling Marks On Tubing Assemblies	04-11-00	1	04-27-09
2165	Model 250 Lip Seals	09-07-00	3	05-16-14
2166	Engine - New Publications Prices	08-01-00	1 Reissue	08-24-00
A-2167	Honeywell Extension Of Inconel Bellows Special Pricing	12-20-00		
2168	Special Pricing for 1st-stage Nozzle Shield	Cancelled 07-18-06		
2169	Black Oxide Removed From Specified Gears	04-05-01	1	04-08-03
2170	Use Of AN503-8-8 Screws In Honeywell Products	04-25-01		
2171	Operations In Methane Laden Atmosphere	09-19-01		
2172	Handling Instructions For Bare Metal Parts	09-19-01	1 Reissue	10-19-01
2173	Shipment Of Fuel System Components	11-15-01		
2174	Rolls-Royce Model 250 Engine Customer Support And Service Telephone Numbers	Cancelled 03-20-08		
2175	Fuel System Contamination	04-23-02	2	07-20-09
2176	Overhaul Manual MPI Requirements	01-13-03	1 Reissue	01-22-03

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2178	Position Statement on Use of Red Dye Contaminated Fuel	02-27-03		
2179	Goodrich Pump and Engine Control Systems, Inc. (GPECS) AOG Hotline	08-26-04	1 Reissue	09-17-04
2181	250 Engine Wash Procedures	05-27-04		
2182	Cancellation Notice - Cancellation of AMC-OIL's and AMC-IL's	05-13-04		
2183	Power Turbine Rotor Clamping	05-10-04		
2184	Inspection for Engine Damage Following Failure of Non-Rolls-Royce Provided Engine Hardware	05-26-04	1	06-23-04
2186	Model 250 E-Pubs Technical Publications	Cancelled 03-20-08		
2187	Suspect Repairs	10-31-05		
2188	Oil Filter Cap	10-12-07		
2189	M250 Engine Warranty Guidelines	11-15-06	2	07-27-16
2190	Maintenance of Turbine Oil Check Valve	02-07-07	1	09-07-09
2191	Quick Disconnect Magnetic Plug Installation	02-07-07	1	11-17-15
2192	Alternate Method of Compliance (AMOC) to Airworthiness Directive (AD) 2005-20-11	03-07-07		
2193	No. 3 and No. 4 Bearing Configuration	08-01-07		
2197	Rolls-Royce use of Self Adhesive Labels on Certain Parts	06-30-08		
2198	Model 250 Series IV (250-C30P) Engine Upgrades for Eurocopter BO105LS and Bell Helicopter B206L-1 Longranger Applications, and Cessation of Model 250 Series III (250-C28B/C) Service Parts Manufacturing in 2011	09-25-09		
2199	Jet A-1 Fuel System Icing Inhibitor (FSII) Notice	07-26-10		
2200	Rolls-Royce M250® Power Turbine Governor Assembly Replacement Reminder	03-21-11	1	11-11-16
2201	Helicopter Wreckage in Brazil	08-06-12		
A-2202	No. 2 Bearing Installation Information	03-04-13	1	03-24-14
A-2203	Enhanced Awareness of Outer Combustion Cracks (OCC)	03-04-13		

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2206	Engine Control System- Identification Plate change	08-24-15		
2207	Outer Combustion Case Leak TEC Inspection Video	10-19-16	s	
2208	Release of B-Nut Tool (23083893) and Definition	10-24-16		
2209	Electronic Availability of Commercial Service Letter	02-14-17	1	09-14-18
2210	Engine Assembly- Parts Multilation Manual	10-17-17		
2211	First Stage Turbine Wheel Failure Followed By Inflight Power Loss Due to Over-Temperature Engine Operation	12-05-17		
A-2212	Enhanced Awareness of Loose or Broken Split Line Bolts/ Studs	02-09-18		
2213	Engine Preservation and Stroage	04-24-19		
2215	Engine- Radiosotopes	11-07-19		
2216	Oil Pressure Regulating Valve Adjustment	12-12-19		