

1

2

3

4

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19

20

U.O.S. MANUFACTURING REFERENCE NUMBERS ARE TO BE POSITIONED SUCH THAT THEY ARE NOT ADJACENT TO THE IDENTITY MARKINGS OR ARE NOT VISIBLE ON THE FINISHED ASSEMBLY.

THIRD ANGLE PROJECTION

SOLUTION / LAYOUT REF

SLN024237 ITEM 01

GEOMETRICS

DATUM LETTER

A

B

C

CALL-OUT

A8-2

D12-2

K4-4

DASH NO.

CONFIGURATION FEATURE OR PART No.

NO. REQD

ZONE LOCATION OF

MATERIAL

R/S

HEAT TREAT

CLASSIFICATION

1

NPN21890

1

D7-2

ALL

A OR B

C

—

—

—

2

AS44803

1

M5-4

—

—

—

—

—

ALL SPECIAL PROCESSES TO SPEC 'V'

DASH 1:—

WHEN PRODUCED FROM SPEC 'A' (FORGING) IT IS A CLASS 2 FORGING.

ACCEPTANCE PROCEDURES TO SPEC 'E'.

HEAT TREATMENT IN ACCORDANCE WITH MATERIAL SPEC.

HARDNESS TEST TO SPEC 'F'.

REFER TO MATERIAL SPEC FOR HARDNESS VALUE.

WHEN PRODUCED FROM SPEC 'B' (F.W.R.)

RADIOLOGICAL EXAMINATION OF WELD IS NOT REQUIRED.

ACCEPTANCE PROCEDURES TO SPEC 'U'.

HEAT TREATMENT IN ACCORDANCE WITH MATERIAL SPEC.

HARDNESS TEST TO SPEC 'F'.

REFER TO MATERIAL SPEC FOR HARDNESS VALUE.

DASH 1 TO BE SUPPLIED IN STRESS RELIEVED CONDITION TO A PROFILE AGREED BY THE ROLLS-ROYCE CONTROLLING LABORATORY

HARD COATING:—

FLAME DEPOSIT SPEC 'G' TO SPEC 'H' ON SURFACE DESIGNATED CF (B3-3) TO A FINISHED THICKNESS OF 0.08 TO 0.25.

THIS SURFACE IS TO BE FINISHED BY GRINDING.

OVERSPRAY IS PERMISSIBLE ON SURFACE MARKED CH (C3-3).

OVERSPRAY IS PERMISSIBLE ON SURFACE MARKED CJ (E7-3) UP TO A THICKNESS OF MAX 0.05.

ABRADABLE COATING:—

AREA DESIGNATED AB TO HAVE A BOND COAT 0.08 TO 0.13 THICK OF SPEC 'J' TO SPEC 'K' OR SPEC 'L' TO SPEC 'M' FOLLOWED BY A TOP COAT OF SPEC 'N' TO SPEC 'P' TO COMPLETELY FILL THE RECESS.

OVERSPRAY IS NOT PERMISSIBLE.

CORROSION PROTECTION:—

APPLY SPEC 'R' TO SPEC 'S' ALL OVER, EXCEPT FOR HOLES AND SURFACES DESIGNATED CD (SHT 3 AND SHT 4).

PART MAY BE DIMENSIONALLY INSPECTED IN A CONSTRAINED CONDITION LOCATED ON DATUMS A AND B. ONLY DATUMS A AND B AND FACE BG (D6-2)

MAY BE USED FOR CONSTRAINT.

FREE STATE DIMENSIONS AND TOLERANCES ARE DESIGNATED TS.

TRACEABILITY TO SPEC 'D'.

REFER TO PROCESS CONTROL DOCUMENT FOR IDENTIFICATION OF PROCESS CONTROL FEATURES

MARK THE FOLLOWING PER SPEC 'T1' AND 'W1':

"MFR AND CAGE/NOAGE CODE"

"SER" AND SERIAL NUMBER

"PNR AND PART NUMBER"

"ASSY"

BASIC SECTION

SHOWING EXTENT OF ABRADABLE COATING AFTER MACHINING

ANGLES ARE IN DEGREES AND DECIMAL PARTS OF A DEGREE

MACHINE ALL OVER —WHERE MARKED—

UNLESS OTHERWISE SPECIFIED:—

ALL DIMENSIONS IN MILLIMETRES —WHEN—

TOLERANCE ON DIMENSIONS ±0.30

TOLERANCE ON ANGLES ±2°

SURFACE TEXTURE VALUES IN MICROMETRES —WHEN—

SURFACE TEXTURE TO BE 3.2

SHEET-ITEM-REMOVE-CURVE-AND-OR-EDGE

SHEET-ITEM-BREAK SHARP EDGES 0.30 ± 0.20 ± 0.08 ± 0.00

SIMILAR PART REFERENCE

NEW PART — SIMILAR TO FWS6083

ENGINE TRENT XWB (FIRST USAGE)

ENGINE SECTION 3391

SPECIALIST APPROVALS

NONE

DATE FEB 2010

CHECKED NEIL ROBSON

LAB APPROVAL L.FRAMPTON

APPROVED C.GARNER

DRAWN QUEST/GOPINATH

SITE DERBY

SECURITY CLASSIFICATION

NOT APPLICABLE

PART NAME

CASE, ASSY, STAGE 1

PLM

DRAWING NUMBER

FW71169

ORIGINAL SCALE

S:1 U.O.S. SHEET 1 OF 4 SHEETS

THIS DRAWING PRODUCED BY CAD AND MUST NOT BE ALTERED BY ANY OTHER MEANS

PARTS MADE CAN ONLY GO TO FINISHED PART STORES AGAINST A LETTERED DRAWING 'ISSUE STATUS'

ISSUE STATUS

ISSUE/CHANGES

DATE

AUTHORITY

1

ALL

M

FOR MANUFACTURING ACCEPTANCE ASSESSMENT

DEC 2009

SLN024237 /CDG/031

2

ALL

M

FOR MANUFACTURING ACCEPTANCE ASSESSMENT

JAN 2010

SLN024237 /CDG/110

P

ALL

F

FINAL ISSUE

FEB 2010

SLN024237

R

SHTS 2-4

SEE ALTERATION ORDER

SEP 2015

14749 TEW

T

SHTS 1-4

SEE ALTERATION ORDER

JUN 2017

22509 TEW

W

F16

RRES

90003-21

—

V

C4

RRP

50000

—

U

E4

MSRR

9994

—

T

F15

RRES

90003-12

—

S

H3

RPS

666/1

—

R

H2

MSRR

9140

—

P

H3

RPS

427 APP 26

—

N

H2

MSRR

9507/54

—

M

H5

RPS

300

—

L

H4

MSRR

9507/101

—

K

H3

RPS

392

—

J

H1

MSRR

9507/5

—

H

F4

RPS

643

—

G

F3

YCE

MSRR 9507/69

—

F

D3,E3

JES

161

—

E

D4

MSRR

9951

—

D

K3

RRES

90005-6

—

C

B4

ROSG

3E

—

B

B3,D3

EBL

MSRR 6506

—

A

B3,C3

EAK

MSRR 6503

—

WELDS

TYPE

INSPECTION AND GROUP IDENTITY

RADIOLOGICAL EXAMINATION

YES

NO

NON DESTRUCTIVE TEST INSPECTION

YES

NO

SEE NOTES

SEE NOTES

N.O.T. ASSEMBLY

SEE CHART

(B4)

HEAT TREAT

ASSEMBLY DEFINED ITEMS

SEE NOTES

IDENTITY

MANF. REF. No.

SEE SPEC 'W'

MARKINGS

ASSEMBLY

SEE NOTE

(G16)

CAGE CODE

K0 680

SCREW THREADS

NONE

SURFACE TEXTURE

RRES 90036

DRAWING PRACTICE AND TOLERANCE INTERPRETATION

JES 160

GENERAL SPECIFICATIONS

ROLLS-ROYCE

ROLLS-ROYCE

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PO BOX 31

DERBY

DE24 8BJ

ENGLAND

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SECURITY CLASSIFICATION

NOT APPLICABLE

PART NAME

CASE, ASSY, STAGE 1

PLM

DRAWING NUMBER

FW71169

ORIGINAL SCALE

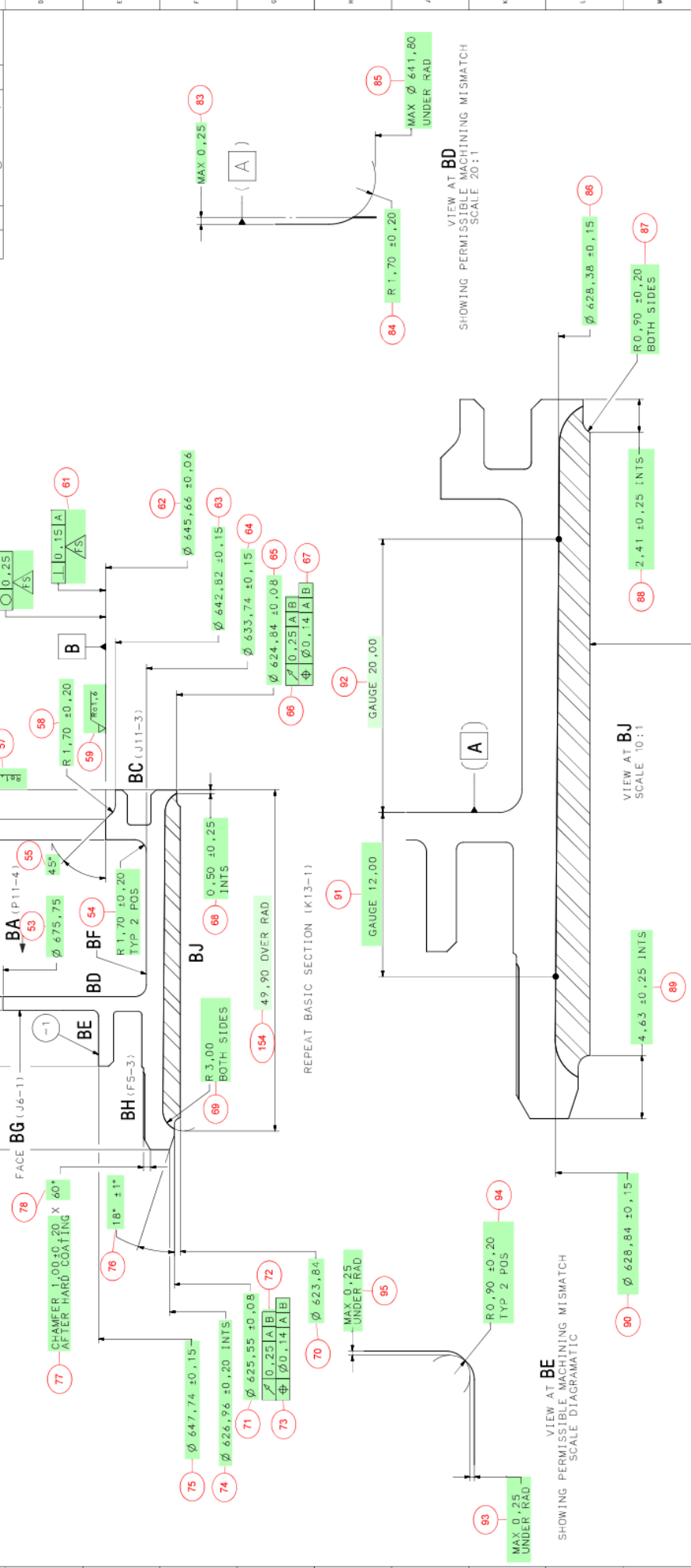
S:1 U.O.S. SHEET 1 OF 4 SHEETS


DESIGNATION LETTERS ORIGINATING ON THIS SHEET IS AB

TCEng Item No.: FW71169 / TCEng Item Rev.: T / TCEng Status: Released



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1	ALL	M	FOR MANUFACTURING ACCEPTANCE ASSESSMENT	DEC 2009	SLND2437	DATE	ISSUE/CHANGES	ZONE	A
2	ALL	M	FOR MANUFACTURING ACCEPTANCE ASSESSMENT	JAN 2010	SLND2437	DATE	ISSUE/CHANGES	ZONE	B
P	ALL	F	FINAL ISSUE	FEB 2010	SLND2437	DATE	ISSUE/CHANGES	ZONE	C
R	VAR	SEE ALTERATION ORDER	SEP 2015	14749 TEN	DATE	ISSUE/CHANGES	ZONE		
T	N/A	SHEET UNDEFFECTED BY ALTERATION REQUEST	JUN 2017	22509 TEN	DATE	ISSUE/CHANGES	ZONE		





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PLM

SECURITY CLASSIFICATION

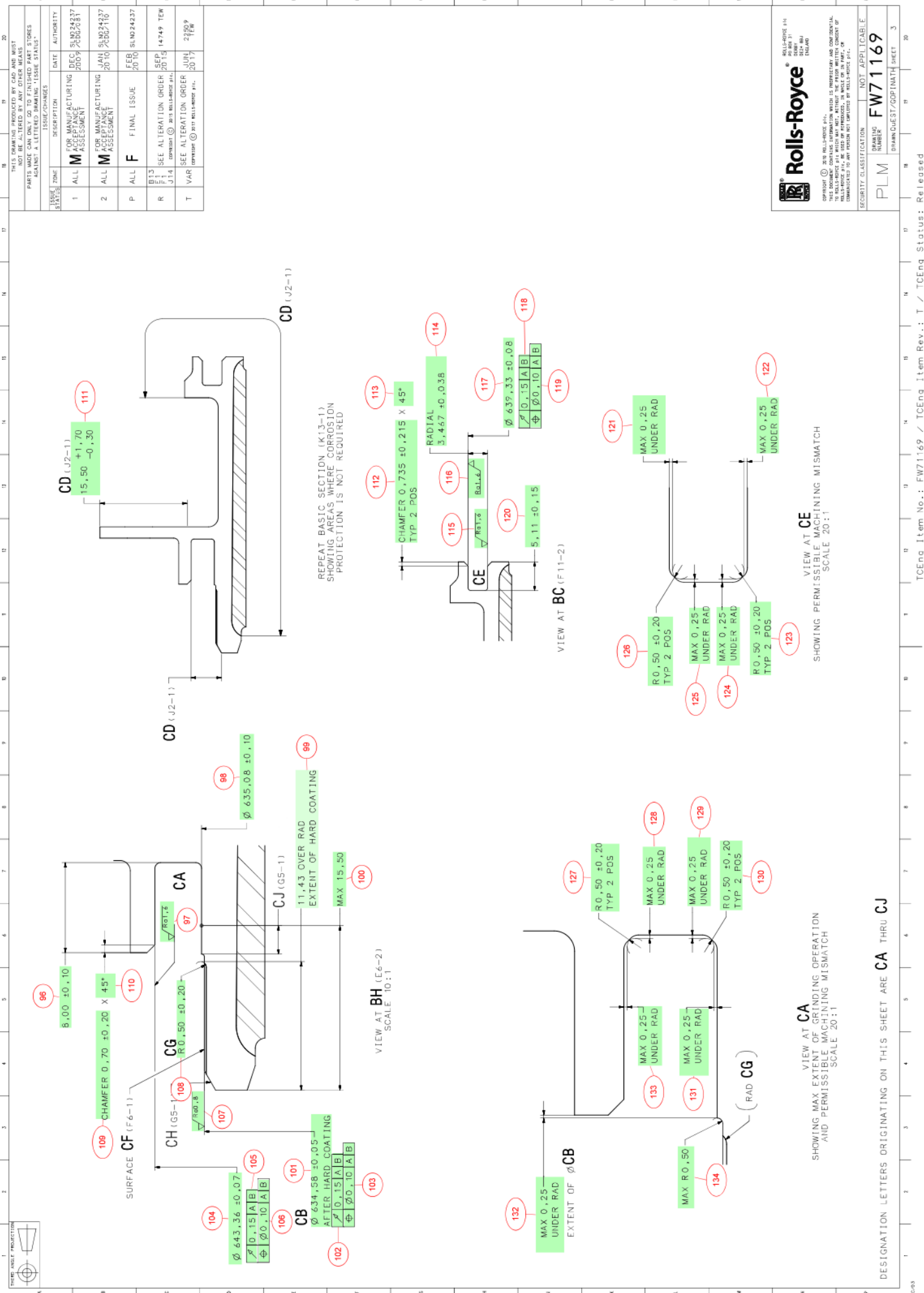
DRAWING NUMBER

FW71169

NOT APPLICABLE

2

TCEng Item No.: FW71169 / TCEng Item Rev.: T / TCEng Status: Released





CD (J2-1)

$\phi 13,00$
+1,50
-0,50

MIN 2,50
ALL AROUND

HOLE DE

DIAGRAMMATIC VIEW → DF
TYP 55 POSITIONS

156 45° ± 5°

A

DE

$\phi 5,75 \pm 0,15$
($\phi 5,60$ H14)

$\phi \phi 0,40$ A B C

$\phi 6,30 \pm 0,20$

SECTION DA
TYP 55 HOLES
EQUALLY SPACED

1 HOLE
ON P.C.D.
 $\phi 662,00$

138

DA
DB

DB

DA

DC

DC

55 HOLES AND
5 SPOT FACES
ON P.C.D.
 $\phi 664,00$

135

136

3,270°

26,180°

137

144

R 0,20 ± 0,10

A

$\phi 6,00 \pm 0,20$

$\phi \phi 0,50$ A B C

145

146

0,40 ± 0,20

157

SECTION DC
TYP 5 EQUALLY
SPACED SPOT FACES

$\sqrt{Ra} 1,6$

1 HOLE

$\phi 4,001 \pm 0,009$

($\phi 4,00$ J8)

$\phi \phi 0,12$ A B

147

A

148

90° ± 5°

150

149

C

$\phi 4,90 \pm 0,20$

151

SECTION DB
(DASH 2 OMITTED FOR CLARITY)

-2

(0,002 TO 0,032
INTERFERENCE ON
DIAMETER)


152

REPEAT SECTION DB

DESIGNATION LETTERS ORIGINATING ON THIS SHEET ARE DA THRU DF

VIEW → BA (D9-2)
SHOWING FLANGE ONLY
(LOOKING FORWARDS)
SCALE 1:1

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ISSUE STATUS	ZONE	DESCRIPTION	DATE	AUTHORITY
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2	ALL	M FOR MANUFACTURING ACCEPTANCE ASSESSMENT	JAN 2010	SLN024237 /CDG/110
P	ALL	F FINAL ISSUE	FEB 2010	SLN024237
R	B2	SEE ALTERATION ORDER	SEP 2015	14749 TEW
T	N/A	SHEET UNAFFECTED BY ALTERATION REQUEST	JUN 2017	22809 TEW
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SECURITY CLASSIFICATION		NOT APPLICABLE
DRAWING NUMBER		FW71169
DRAWN QUEST/GOPINATH		SHEET 4