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SERVICE BULLETIN

AIRBORNE AUXILIARY POWER - GAS TURBINE ENGINE - REWORK AND REPAIR OF ENGINE FOR INCORPORATION OF IMPROVED COMPRESSOR CARBON SEAL AND RELATED COMPONENTS ON THE RE100 AUXILIARY POWER UNIT (APU)

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Transmittal Information

ATA Number RE100-49-8303 (Publication Number D201903000011)

Summary

The equipment changed in the revision(s) before this service bulletin may need additional changes. Refer to [Paragraph 3](#), Accomplishment Instructions.

This revision is a FULL replacement. This revision includes the changes that follow:

- [Paragraph 1.B.\(1\)](#). Changed step.
- [Paragraph 1.K.\(1\)](#). [Table 4](#). Changed revision numbers as per latest revisions.
- [Paragraph 3.B.\(3\)](#). [Table 9](#). Changed Change Number from "12" to "13" for PN 3800722-1.

The information that is identified with revision bars is listed in the Revision History section. Revision bars are not used before [Paragraph 1.A](#). The editorial changes and information that was moved, removed, or reformatted are not identified with revision bars.

Refer to [Paragraph 4.A](#) for a list of the acronyms and abbreviations used in this service bulletin.

Revision History

This service bulletin has had four revision(s) as shown in [Table 1](#).

Table 1. Revision History

| Revision Number | Revision Date |
|-----------------|---------------|
| 0 | 24 Feb 2020 |
| 1 | 1 Jul 2020 |
| 2 | 28 Aug 2020 |
| 3 | 1 Sep 2020 |
| 4 | 18 May 2022 |

Highlights

This section issues Revision 4 to Service Bulletin, ATA Number RE100-49-8303 (Publication Number D201903000011), and contains these changes:

The list of highlights tells the users about the changes that the revision makes. The list has three columns. The "Page" column shows the block of data that the revision changes and the page on which the block begins. The block can be a section, subsection, graphic, table, etc. Revision marks give the location of the change in the block. The "Description" column tells the user about the change or changes in each block. A paragraph, table, or figure reference often comes before the description. The "Effectivity" column tells the user about the part number(s) to which the block of information applies. The default value for this column is "All." "All" means that the block applies to all parts.

| Page | Description | Effectivity |
|------|---|-------------|
| 7 | Paragraph 1.B.(1) Changed step. | All |

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| Page | Description | Effectivity |
|------|--|-------------|
| 8 | Paragraph 1.K.(1) Table 4. Changed Revision Numbers as per latest revisions. | All |
| 13 | Paragraph 3.B.(3) Table 9. Changed Change Number from "12" to "13" for PN 3800722-1. | All |

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1. **Planning Information**

A. Effectivity

- (1) This service bulletin is applicable to the component(s) given in [Table 2](#).

Table 2. Applicable Component(s)

| PN | APU Model Number | Before Serial Number ¹ | Application |
|------------|------------------|-----------------------------------|--|
| 3800785-1 | RE100[CS] | P-949 | Cessna Latitude, Sovereign, Gulfstream G-150 |
| 3800722-1 | RE100[XL] | P-1088 | Citation Excel |
| 3800722-2 | RE100[XL] | P-127 | GROB G180 |
| 3800726-1 | RE100[LJ] | P-628 | Learjet 45/75 |
| 70721682-1 | RE100[BR] | P-0119 | Bell Relentless |

NOTE:

1. First Unit Production Point.

B. Concurrent Requirements

- (1) Do the service bulletin(s) given in [Table 3](#) with (or before) this service bulletin. You can do the service bulletin(s) independently.

Table 3. Concurrent Service Bulletin(s)

| Service Bulletin Number | Service Bulletin Title |
|-------------------------|--|
| RE100-49-8363 | REPLACE INLET HOUSING PN 3810880-1/-2 WITH PN 70724596-1 OR PN 70724596-2, GEARBOX HOUSING PN 3863409-6 WITH PN 70724597-1 AND GEARBOX HOUSING PN 3863409-5 WITH PN 70724597-2 ON THE RE100 AUXILIARY POWER UNIT (APU) |

C. Reason

- (1) **Problem:**
- (a) Some operators have reported a smell in the cabin during operation of the RE100 APU in the aircraft.
- (2) **Background:**
- (a) Honeywell has designed new components and uses a new seal technology that will reduce the possible leakage of oil into the bleed air system.
- (3) **Technical Validation:**
- (a) Honeywell has conducted APU and seal component validation testing that demonstrates compressor seal integrity during APU operation.

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D. Description

(1) This service bulletin gives the authorization and instructions to rework and repair the RE100 APU to incorporate the hydrodynamic carbon face seals.

E. Compliance

(1) This service bulletin is optional. The operator can make the decision if this change is necessary.

F. Approval

(1) The TSO approval was received for the changes identified in this service bulletin.

G. Manpower

(1) No additional man hours are necessary when this service bulletin is done at the time of heavy repair or access to the parts.

H. Weight and Balance

(1) None.

I. Electrical Load Data

(1) Not applicable.

J. Software Accomplishment Summary

(1) Not applicable.

K. References

(1) Publications.

(a) The Honeywell publication(s) used to do this service bulletin is/are given in [Table 4](#).

Table 4. Honeywell Publication(s)

| Outline PN | Component Maintenance Manual | | Illustrated Parts Catalog | |
|---------------|------------------------------|----------|---------------------------|----------|
| | ATA Number | Revision | ATA Number | Revision |
| 3800785-1 | 49-24-65 | 5 | 49-24-63 | 7 |
| 3800722-1, -2 | 49-25-87 | 5 | 49-25-83 | 6 |
| 3800726-1 | 49-25-93 | 5 | 49-25-89 | 6 |
| 70721682-1 | 49-27-63 | 1 | 49-27-62 | 1 |

NOTE: Unless specified differently, you can use subsequent revisions.

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(2) Service Bulletin Reference(s).

(a) The service bulletin(s) given in [Table 5](#) is/are referenced in this Service Bulletin.

Table 5. Service Bulletin Reference(s)

| Service Bulletin Number | Service Bulletin Title |
|-------------------------|--|
| 70722359-49-8304 | Balance Repair of Compressor Rotor, PN 70722359-1 |
| 3822523-49-8305 | Balance Repair of Compressor Rotor, PN 3822523-003 |
| 70722360-49-8306 | Balance Repair of Turbine Rotor, PN 70722360-1 |
| 3842340-49-8307 | Balance Repair of Turbine Rotor, PN 3842340-2 |

L. Other Publications Affected

(1) The same as the publication(s) given in [Paragraph 1.K.\(1\)](#).

M. Interchangeability or Intermixability of Parts

(1) Not applicable.

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2. **Material Information**

A. Material - Price and Availability

- (1) The part(s) necessary for this service bulletin will be available at the time of service bulletin release. Refer to [Paragraph 2.B.](#) and [Paragraph 2.C.](#) for details.
- (2) No modification kit is available for this service bulletin.

B. Industry Support Information

- (1) Information on price and availability of parts will be supplied by a Honeywell authorized APU service center or a Honeywell Engines facility. For a complete listing of Honeywell authorized service centers, visit our website at <https://aerospace.honeywell.com> or call our Honeywell at Telephone: 800-601-3099 (Toll Free U.S.A./Canada), 602-365-3099 (International Direct).
- (2) The warranty/program data is listed in [Table 6.](#)

Table 6. Warranty/Program Data

| Term | Yes | No |
|--|-----|----|
| Commercial Warranty (Standard new engine warranty) | | X |
| Spare Part Warranty (Standard new spare part warranty) | | X |
| Special Extended Warranty Program Number (Extension of either standard commercial warranty or spare part warranty may apply) | | X |
| Special Program Number 4 (Programs in which special pricing and/or special conditions may apply) | X | |
| Special Pricing Notice Number (Reduction from catalog list pricing, i.e. "P" condition may apply) | | X |
| MSP | X | |

- (3) This service bulletin and those referenced in [Table 5](#) require "fixed process certification". The service centers listed below have received the necessary approvals to perform these service bulletins:

Honeywell Phoenix Repair & Overhaul
Shipping & Receiving
1944 E Sky Harbor Circle North
Phoenix, AZ 85034
Telephone: 800-601-3099 (USA)
Telephone: 602-365-3099 (International)

Gulfstream Aerospace Corporation
Service Center
1 Product Support Road
Savannah, GA 31408
Telephone: 912-965-3000 (U.S.A.)

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Turbine Engine Specialist, Inc
 3804 Falcon Way West
 Hgr 18S Meacham Field
 International Airport Fort Worth, TX 76106
 Telephone: 817-625-6100

C. Material Necessary for Each Engine

- (1) Refer to [Table 7](#) for material to be purchased and to [Table 8](#) for the Instructions/Disposition Codes.

NOTE: The illustrated parts catalogs and spare parts bulletins dated later than the original issue date of this service bulletin can introduce different parts. Refer to these documents before you order parts.

NOTE: The parts usually discarded when you access the area, referred to in this service bulletin, are not included.

Table 7. Operator-Purchased Material

| New PN | Keyword/ Nomenclature | Old PN | Qty | Unit Price ^{1 2} | Instructions/ Disposition Codes |
|------------|-----------------------------------|------------------------|-----|---------------------------|---------------------------------|
| 70722359-1 | Compressor Rotor, Centrifugal | 3822523-003 | 1 | | C |
| 70722360-1 | Turbine Rotor, Gas Turbine Engine | 3842340-2 | 1 | | D |
| 70722361-1 | Shaft, Compressor | 3822535-1 | 1 | | F |
| 70722432-1 | Seal Set, Generator, Matched | 3861042-2 3863504-1 | 1 | | F |
| 70722248-1 | Seal Set, Compressor, Matched | 3822532-1 3827433-1 | 1 | | F |
| 70722450-1 | Bearing, Roller, Cylindrical | 3822520-1 | 1 | | F |
| 70722483-2 | Retainer, Seal | 3863384-1 | 1 | | F |
| 70722484-1 | Nut, Plain, Round | 3861043-1 | 1 | | F |

NOTES:

1. Pricing information current at the release of the service bulletin. The latest information for price and availability can be obtained from the Honeywell Product Catalog at <https://aerospace.honeywell.com>.
2. Additional discounts may apply; prior to evaluating incorporation of this service bulletin, it is recommended to request a quote through <https://aerospace.honeywell.com>.

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Table 8. Instructions/Disposition Codes

| Disposition Code | Description |
|------------------|---|
| C | If removed part is serviceable, it must be reworked. Refer to SB 3822523-49-8305. If the part must be replaced with a new part, PN 70722359-1 is preferred. If PN 70722359-1 is not available, it is acceptable to install PN 3822523-003. NOTE: You must perform SB 3822523-49-8305. |
| D | If removed part is serviceable, it must be reworked. Refer to SB 3842340-49-8307. If the part must be replaced with a new part, PN 70722360-1 is preferred. If PN 70722360-1 is not available, it is acceptable to install PN 3842340-2. NOTE: You must perform SB 3842340-49-8307. |
| F | Discard removed part and replace with new part. |

(2) No materials supplied by operator.

D. Material Necessary for Each Spare

(1) Not applicable.

E. Reidentified Parts

(1) Not applicable.

F. Tooling - Price and Availability

(1) Not applicable.

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3. Accomplishment Instructions

A. General Information

WARNING: BEFORE YOU USE A MATERIAL, REFER TO THE MANUFACTURERS' SAFETY DATA SHEETS. SOME MATERIALS CAN BE DANGEROUS.

CAUTION: DO NOT USE MATERIALS THAT ARE NOT EQUIVALENT TO HONEYWELL-SPECIFIED MATERIALS. MATERIALS THAT ARE NOT EQUIVALENT CAN CAUSE DAMAGE TO THE EQUIPMENT AND CAN MAKE THE WARRANTY NOT APPLICABLE.

CAUTION: DO NOT HIT OR LET THE UNIT FALL DURING THESE PROCEDURES. THIS UNIT CONTAINS AN ASSEMBLY THAT CAN BE DAMAGED FROM INCORRECT USE.

CAUTION: DO THESE PROCEDURES IN A CLEAN ENVIRONMENT TO PREVENT DAMAGE TO MECHANICAL COMPONENTS.

- (1) Obey the precautions.
- (2) The manual(s) given in [Paragraph 1.K.](#) of this service bulletin contain the disassembly, cleaning, check, assembly, and test instructions. These manuals must be used to complete this service bulletin.

B. Rework and Repair of RE100 APU to incorporate improved carbon seal system.

- (1) Disassemble the APU as necessary. Refer to the manual given in [Paragraph 1.K.\(1\)](#).
 - (a) Replace the parts listed in [Table 7](#).
- (2) Assemble the APU. Refer to the manual given in [Paragraph 1.K.\(1\)](#).
- (3) Make a record of the service bulletin number and/or revision number in the engine log book. Put the change/series number on the APU identification plate adjacent to the MOD RECORD. Refer to [Table 9](#) for the applicable change/series number data.

Table 9. Change Number Data

| PN | Model Number | Change Number |
|------------|--------------|---------------|
| 3800785-1 | RE100[CS] | 11 |
| 3800722-1 | RE100[XL] | 13 |
| 3800722-2 | RE100[XL] | 2 |
| 3800726-1 | RE100[LJ] | 13 |
| 70721682-1 | RE100[BR] | 3 |

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4. Appendix

A. Appendix A, Acronyms and Abbreviations

(1) Refer to [Table 10](#) for a list of the acronyms and abbreviations used in this service bulletin.

Table 10. Acronyms and Abbreviations

| Term | Full Term |
|-------------|---|
| APU | Auxiliary Power Unit |
| ATA | Air Transport Association |
| CAGE | Commercial and Government Entity |
| CD-ROM | Compact Disc Read Only Memory |
| CFR | Code of Federal Regulations |
| ECCN | Export Control Classification Number |
| FAA | Federal Aviation Administration |
| HCS | Hazard Communication Standard |
| MOD | Modification |
| MSP | Manufacturer's Suggested Price |
| ODA | Organization Designation Authorization |
| OSHA | Occupational Safety and Health Administration |
| PMA | Parts Manufacturer Approval |
| PN | Part Number |
| Qty | Quantity |
| SFAR | Special Federal Aviation Regulation |
| TSO | Technical Standard Order |