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Positioning Plug

For Model Eligibility, Please visit us at www.hyetechllc.com

Subject: Removal, cleaning, inspection, and installation procedures for 23009573HT – Turbine Nozzle Shield Positioning Plug.

Compliance: Any time it is necessary.

Notes: Refer to OEM's published for data engine operation.

Technical aspects are FAA approved

Standard shop practices may be substituted for materials and procedures referenced herein provided they have been demonstrated as effective and safe for use with these parts or their OEM and other FAA approved equivalents.

1.1 REMOVAL

1.2 Remove the turbine assembly in accordance with the manufacturer's instructions.

1.3 Disassemble turbine assembly in accordance with the manufacturer's instructions.

1.4 Remove lock-wire and remove the positioning plug.

2.1 CLEANING

2.2 Clean in alkaline liquid bath or soft grit blast.

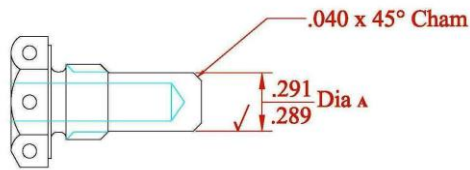
2.1.1 Soak the part of 30 – 60 minutes in an alkaline bath at approximately 200° F. The bath shall contain 20 ounces alkaline rust remover (MIL-D-26549 or equivalent) per gallon of water. Rinse in a high pressure water spray followed by an overflowing dip rinse in 170°F (approx) water.

3.1 INSPECTION

3.2 Inspect and repair or replace the plug per Table 1:

Table 1

Condition	Service Limit	Repair Limit	Corrective Action
Any visual damage (thread damage or fretting). (Visual)	0.010 in. max surface fretting wear (Dia. A)	No repair.	Replace part.



4.1 REPAIR

4.2 None

5.1 INSTALLATION

5.2 Install the first-stage turbine nozzle shield. Apply anti-seize compound, Never Seez High temperature lubricant or equivalent, to the threads and install the two positioning plugs. Tighten plugs to 100 to 150 in lb and secure with lock-wire, MS20995C20 or equivalent.