



24834 Avenue Rockefeller
Phone: (818) 291-0338
Email: info@hyetechllc.com

IFCA-C-003
Valencia, CA 91355
Fax: (818) 291-0339
Web: www.hyetechllc.com

6875248HT Compressor Scroll Discharge Insert

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

Subject: Removal, cleaning, inspection/rework/repair, and installation procedures for 6875248HT – Scroll Discharge Insert.

Compliance: Any time the insert is beyond serviceable limit.

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

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.

1.0 REMOVAL

- 1.1 Remove the compressor assembly in accordance with the manufacturer's instructions.
- 1.2 Disassemble compressor assembly in accordance with the manufacturer's instructions.
- 1.3 Do not remove insert unless necessary. If necessary, refer to repair section.

2.0 CLEANING

- 2.1 Spray part with petroleum solvent, P-D-680, Type 2 dry cleaning petroleum solvent or equivalent, and a soft bristle brush.

3.0 INSPECTION

- 3.1 Inspect and repair or replace the insert per Table 1:

Table 1

Condition	Service Limit	Repair Limit	Corrective Action
Wear in ID air tube inserts (visual)	2.240 in. max ID in area of greatest wear. Max wear for groove depth 0.005 in. (See fig. 1). Chrome plating must be present (100% coverage).	See corrective action.	Replace insert if serviceable limits are exceeded. For out-of-round limits, refer to figure 1.

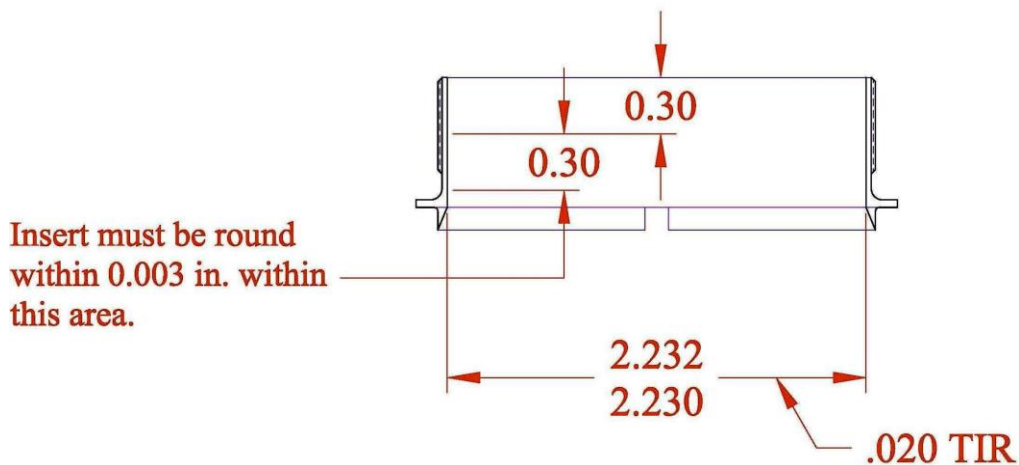


Figure 1

4.0 REPAIR

- 4.1 Use a punch to straighten flange to disengage it from the slot in the scroll. Using 6872272 wrench or equivalent, remove the insert from the diffuser scroll.

5.0 INSTALLATION

5.1

Clean the threads per section 2.0. Apply a thin uniform coat of sealing compound, Plastiseal "F", Epoxylite 814 or equivalent, to the mating surfaces of the diffuser scroll & insert. Use sufficient sealant to fill cavities. Install the new insert in the diffuser scroll using 6872272 wrench or equivalent. Tighten the insert to 40 to 50 ft lb above running torque. Using a round punch, depress the insert flange into the slot in the diffuser scroll. The installed insert must be round within the limits shown Fig. 1.