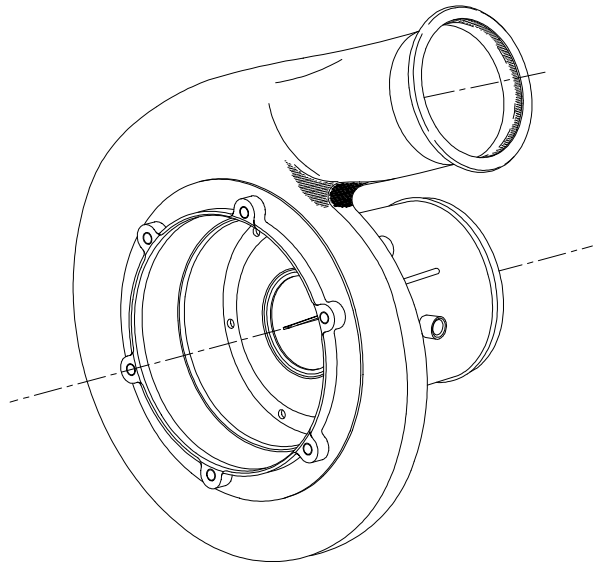


Product Repair Bulletin

P/N 204477

Turbine Scroll Assembly

NHA: 204815 Turbine Driven
Centrifugal Compressor



OEM Manual Repairs

Repairs for OEM Manual 21-20-8:
No manual repairs currently available.

Additional FAA Approved Repairs

Repairs for Britt Metal Major Repair 9107261:

- Straighten inlet flange.
- Straighten outlet flange.
- Straighten mounting flange.
- Straighten scroll deformation.
- Procure 340-510-9009 inlet flange.
- Fabricate -10 outlet flange.
- Fabricate -20 mounting flange.
- Fabricate -30 boss.
- Install inlet flange.
- Install outlet flange.
- Install mounting flange.
- Install boss.
- Weld\dress cracks\damage.
- Pressure check.
- Braze cracks.
- Install patch(s).
- Metallize diameter A.
- Metallize diameter C.
- Metallize diameter D.
- Metallize surface B.
- Metallize surface E.
- Machine diameter A.
- Machine diameter C.
- Machine diameter D.
- Machine surface B.
- Machine surface E.

Product Repair Bulletin

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Turbine Scroll Assembly

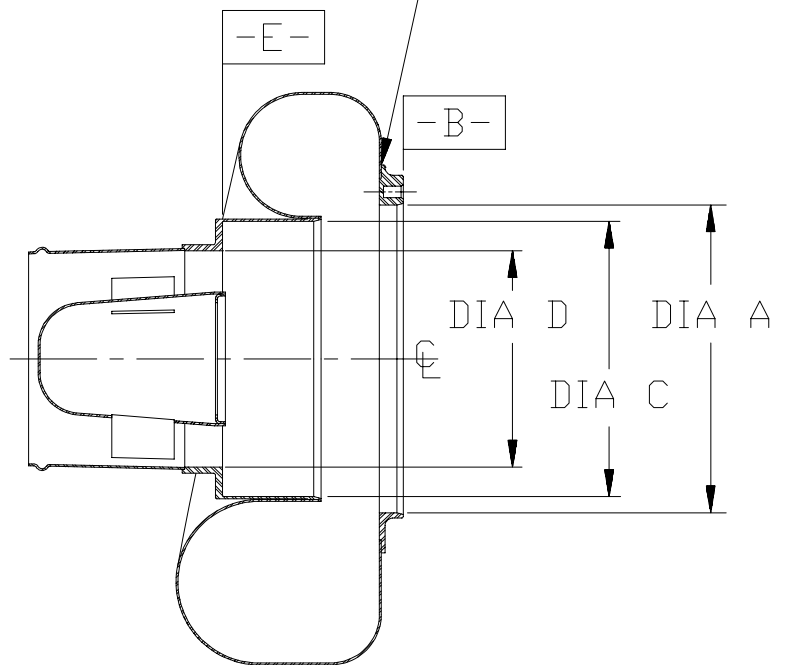
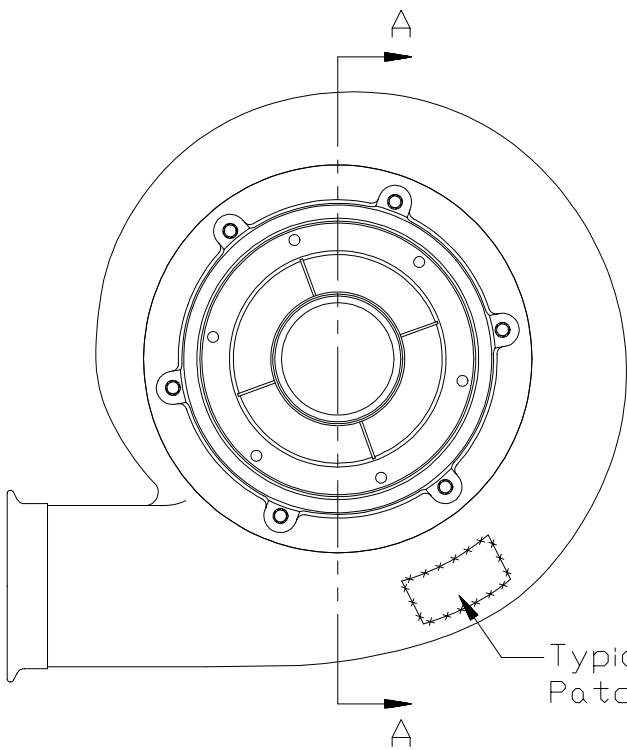
INLET FLANGE
P/N 340-510-9009

-20 MOUNTING FLANGE

-30 BOSS

-10 OUTLET FLANGE

Typical
Crack Location



SECTION A-A

