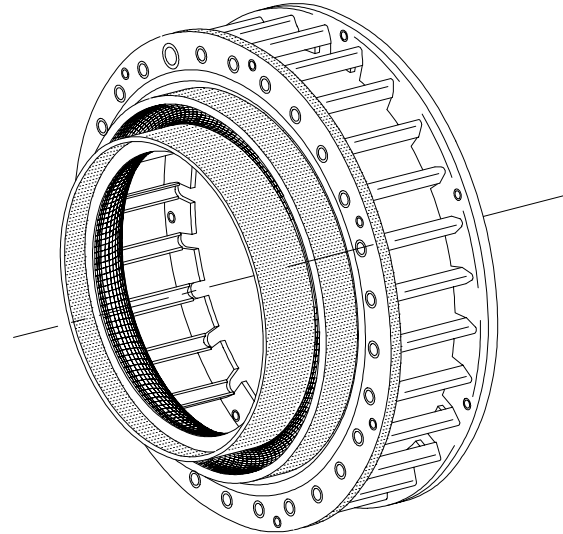


Product Repair Bulletin

P/N 3810224

IGV Housing Assembly

NHA: GTCP331 Series APU



OEM Manual Repairs

Repairs for OEM Manual 49-23-49:

Set-up to install inserts as required.
Procure/install K9005-3G/TR29006-201L insert
Procure/install 3612894-1 bushing.
Weld cracked strut(s).
Weld diameter E and/or F.
Dress welds and minor surface defects.
Fabricate/install -50 Plug for large bearing bore.
Metallize diameter B.
Metallize diameter F.
Metallize diameter G.
Metallize diameter E.

Metallize surface J.
Metallize contour.
Machine diameter B.
Machine diameter F.
Machine diameter G.
Machine diameter E.
Machine surface J.
Machine contour.
Hard anodize required dimensions.
Clean/iridite.
Apply epoxy paint.

Additional FAA Approved Repairs

Repairs for Britt Metal Major Repair 9108061:

Weld Diameter B.
Metallize surface A.
Machine surface A.
Fabricate/install -20 Strut. (28)
Fabricate/install -90 sleeve for trunnion bore.(28)
Fabricate/Install BMP3827221-1 Bearing. (1)
Converts to -7/-8/-9/-10 to -11/-12/-13/-14 per SB 49-6948.
Fabricate/Install BMP3827221-2 Bearing. (27)
Converts to -7/-8/-9/-10 to -11/-12/-13/-14 per SB 49-6948.
Fabricate/install -90 sleeve for small bearing bore.
Fabricate/install -100 flange and restore bores.
Set-up to install strut(s) as required.

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