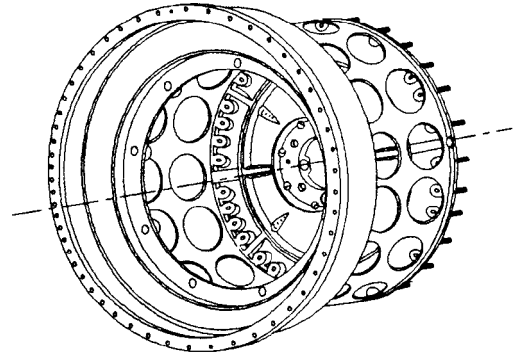


Product Repair Bulletin

P/N 3810259

Inlet Housing Assembly

NHA: GTC331 Series APU



OEM Manual Repairs

Repairs for OEM Manual 49-23-49:

Set-up to install studs as required.
 Procure/install SFC250SUM11 stud.
 Weld/dress cracks/broken welds.
 Weld repair sealing contact area dim.Y
 Metallize diameter B.
 Metallize diameter H.
 Metallize diameter K.

Metallize diameter N.
 Machine diameter B.
 Machine diameter H.
 Machine diameter K.
 Machine diameter N.
 Clean/iridite.
 Apply epoxy paint.

Repairs for Service Bulletins:

Machine aft pilot.
 Converts -1 to -3 per S/B 49-5491

Additional FAA Approved Repairs

Repairs for Britt Metal Major Repair 9104021:

Metallize surface J.	Machine surface J.
Metallize surface M.	Machine surface M.
Metallize surface F.	Machine surface F.
Metallize diameter AA.	Machine diameter AA.
Weld/bore monopole hole(s).	

Repairs for Britt Metal Major Repair 9111271:

Fabricate/install -105 Cylinder.	Restore dim. Y by metallizing.
Fabricate/install -110 Cylinder.	Metallize damage areas on cylinder.
Fabricate/install -125 Cylinder.	Metallize surface A.
Fabricate/Install	Metallize surface T.
-111 (Casting) End Plate.	Machine/hand finish cylinder.
-112 (Forging) End Plate	Machine dim. Y.
Radiographic inspect.	Machine surface A.
Restore dim. Y by forming.	Machine surface T.

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