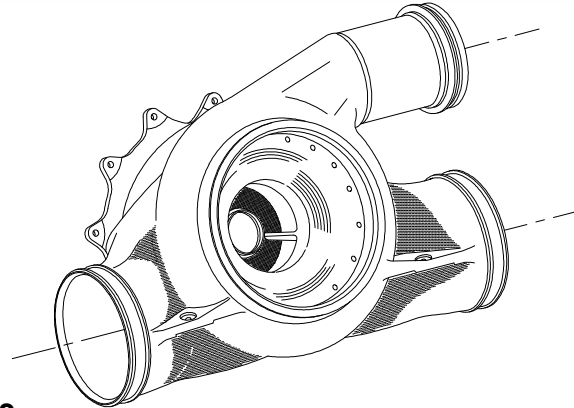




Product Repair Bulletin

P/N 737101
Turbine Housing

NHA: 719238 Air Cycle Machine
Boeing 747



OEM Manual Repairs

Repairs for OEM Manual 21-51-03:

Weld repair cracks in small webs.
Metallize contour.
Machine contour.
Machine sleeve mounting face.
Not required if -70 Wear Insert B is installed.
Fabricate/install -60 wear insert A
(fan shroud side).
Not required if S/B 21-155 is accomplished.

Fabricate/install -70 wear insert B
(contour side).
Clean and iridite.
Non destructive penetrant inspect.
Pressure test.
Procure/install 3591-3CN285 insert.
Procure/install 3591-4CN375 insert.
Apply dry film lube (-70 wear insert).

Repair for Service Bulletin 21-155:

Machine fan shaft shroud bore per S/B 21-155.
Converts 737101-2/-3/-4/-5 to 737101-6.

Additional FAA Approved Repairs

Repairs for Britt Metal Major Repair 9107262:

Weld cracked inlet/outlet/bypass ducts.
Weld cracks in fan shaft shroud/forward webbed mounting flange.
Fabricate/install -50 Plug (fan shaft shroud).
Metallize surface B dimensions. Machine surface B dimensions.
Metallize surface D dimensions. Machine surface D dimensions.
Metallize surface Z dimensions. Machine surface Z dimensions.
Metallize diameter E dimensions. Machine diameter E dimensions.
Metallize diameter F dimensions Machine diameter F dimensions

Repairs for Britt Metal Major Repair 0208151:

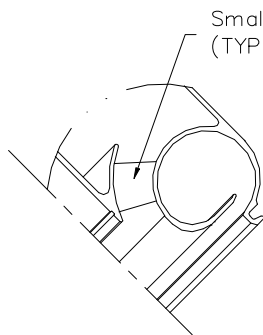
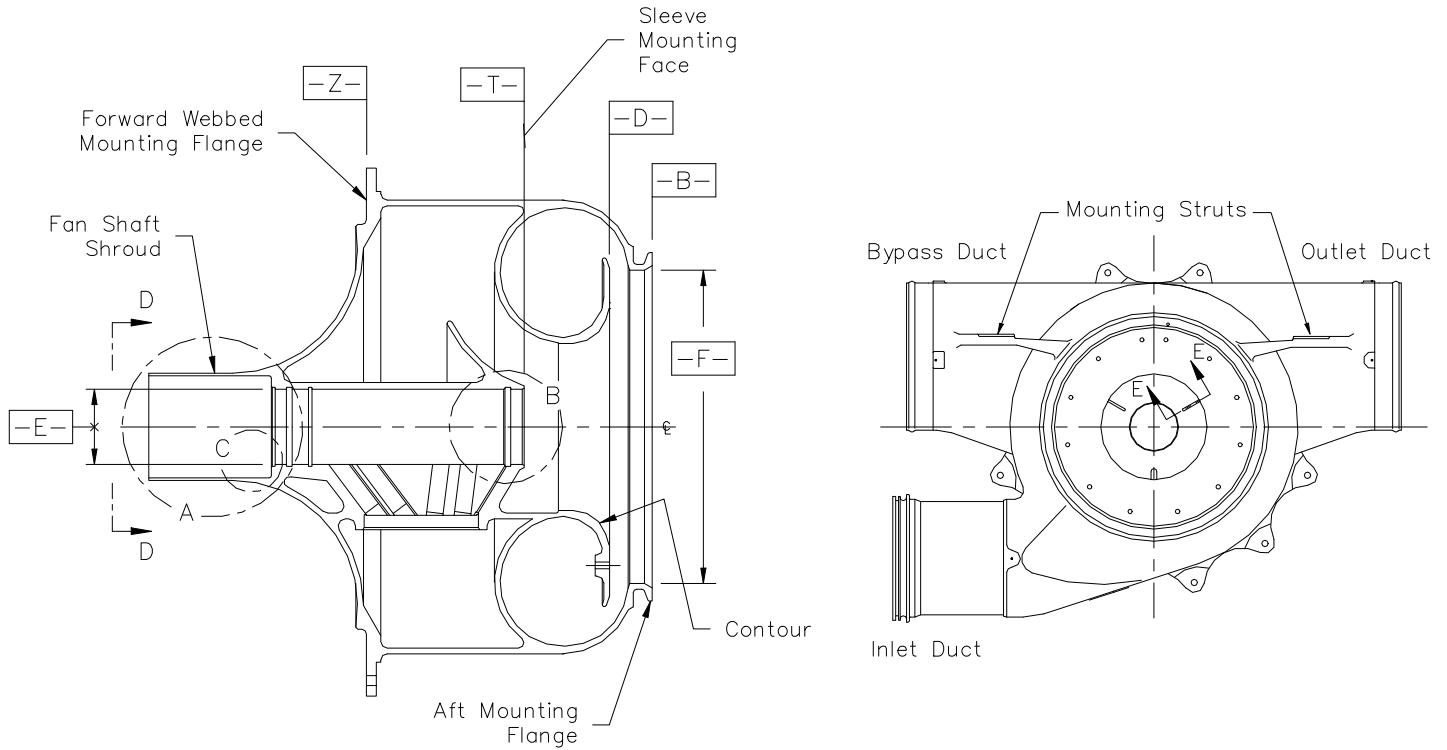
Weld repair aft mounting flange.
Weld repair mounting struts.
Weld repair threaded holes on Surface D.

Repairs for Britt Metal Major Repair 0503091:

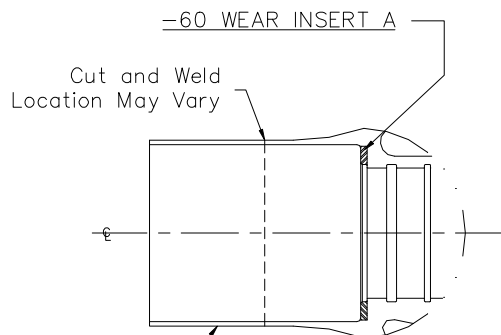
Metallize surface below -60 wear insert.
Finish machine and install new wear insert.

Product Repair Bulletin

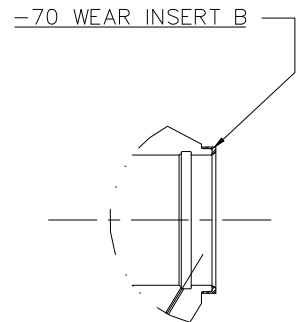
P/N 737101
Turbine Housing



Section E-E



Detail A



Detail B

