

## Product Repair Bulletin

P/N 738712

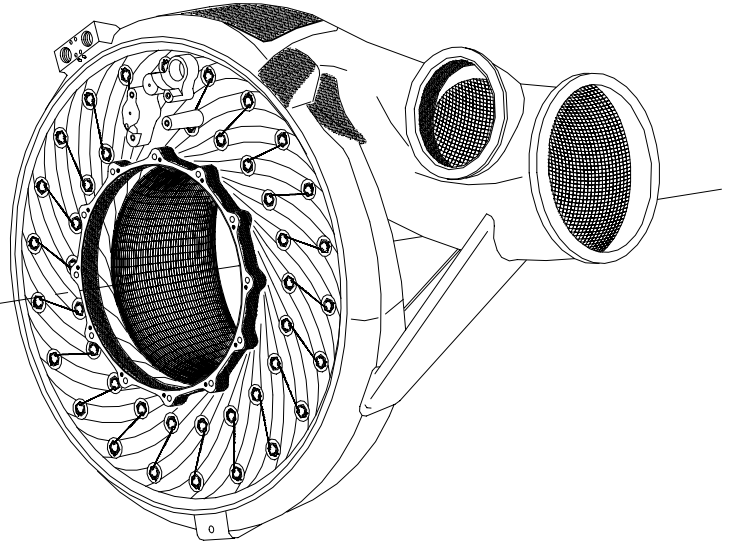
### Load Compressor Diffuser Housing

NHA: ST6L APU

### OEM Manual Repairs

#### Repairs for OEM Manual 49-51-02:

- Procure/install MS20426A3-4 rivet.(2)
- Procure/install MS20426A3-5 rivet.(10)
- Procure/install MS21047L3 nut.(6)
- Procure/install MS21209F1-15 insert.(3)
- Procure/install MS21209F4-15 insert.(12)
- Procure NAS1005-5A bolt.(43/42)
- Procure 757541-1 locking stud.(1/2)
- Procure/install MS21209F0815 insert.
- Fabricate/install AMS3345 anti-chafing rubber pad.
- Install bolts/studs and secure with safety wire.



### Additional Air Carrier Approved Repairs

- Weld internal diffuser ring vanes.
- Weld external diffuser ring vanes.

### Additional FAA Approved Repairs

#### Repairs for Britt Metal Major Repair 9104113:

- |                   |                                   |
|-------------------|-----------------------------------|
| Metallize scroll. | Machine throat.                   |
| Metallize throat. | Apply primer to containment ring. |
| Machine scroll.   | Iridite.                          |

#### Repairs for Britt Metal Major Repair 9107151:

- |   |  |
|---|--|
| Weld/dress cracks.                              | Fabricate/Install -310 Containment Ring.   |
| Plug/weld repair mounting bolt hole.(44)        | Fabricate/Install -320 Support.            |
| Metallize surface Y.                            | Fabricate/install patch(s).                |
| Metallize diameter B.                           | Fabricate diffuser ring alignment pins.(2) |
| Procure/Install MS124737 mount bolthole insert. | Set-up to restore mounting bolt holes.     |
| Fabricate/Install -25 Spacer.                   | Install diffuser ring alignment pins.(2)   |
| Fabricate/Install -15 External Diffuser Ring.   | Machine surface Y.                         |
| Fabricate/Install -42 Internal Diffuser Ring.   | Machine diameter B.                        |
| Fabricate/Install -62 Inlet.                    | Machine internal diffuser ring vanes.      |
| Fabricate/Install -75 Inner Throat.             | Machine external diffuser ring vanes.      |
| Fabricate/Install -110 Outer Deflector.         | Chromic acid anodize diffuser rings.       |
| Fabricate/Install -230 Flange.                  | Precipitation Heat Treat.                  |
| Fabricate/Install -261 Inner Deflector.         | Pressure test.                             |
|   | Boroscope inspect interior welds.          |

## Product Repair Bulletin

P/N 738712

### Load Compressor Diffuser Housing

