

Rockwell service letter

No. SL-AG-78

International

P.O. BOX 3090 ALBANY, GEORGIA 31706-3090 PHONE 229/883-1440 FAX 229/439-9790

Service Letter No. SL-AG-78

Revision No. 1

30 January, 1976

COLLECTOR RING REPLACEMENT

APPROVAL: FAA DER Approved

Page 2 of 3 - Figure 1

Add: View of flange assembly to figure 1 showing area to be welded. See sheet 3 of this revision.

Page 3 of 3 - ACCOMPLISHMENT INSTRUCTIONS:

Change: **Step 4 to read:**

- 4 Assure that hole in existing flange assemblies are spot faced 0.80 inch diameter on center of bolt hole. Flange to be a minimum thickness of 0.25 inch after spot facing. Inspect flange for weld attachment (some flange assemblies appear to be welded, but are not). If not welded, add weld bead to flange assemblies in area shown in figure 1.

NOTE

See Service Information No. SI-131 for recommended weld procedures.

Step 5.b. to read:

- b. Work progressively around engine until all segments of collector ring assembly are in place. After all segments are in place and properly aligned (each segment must align with next segment within 0.040-inch), assure that clearance between 60621-21 segment and 60621-29 segment is 0.50 (± 0.10) inch (see Figure 1).

NOTE

Clearance of more than 0.60-inch is acceptable.

ADD: Step 5.c., d., e., f., and g.

- c. If clearance is less than 0.40-inch, remove 60621-29 segment and rework by cutting segment off at sleeve. Remove sufficient material from segment provide adequate clearance and reweld segment to sleeve (see Figure 1).

NOTE

See Service Information No. SI-131 for recommended weld procedures.

- d. Reinstall reworked 60621-29 segment and torque clamp bolts.
- e. Torque remaining segment clamps to 20-25 inch-pounds on beaded side, then torque non beaded side to 8-12 inch-pounds.
- f. Torque flange assembly clamps to 20-25 inch-pounds.
- g. Torque flange nuts to 20-25 inch-pounds.

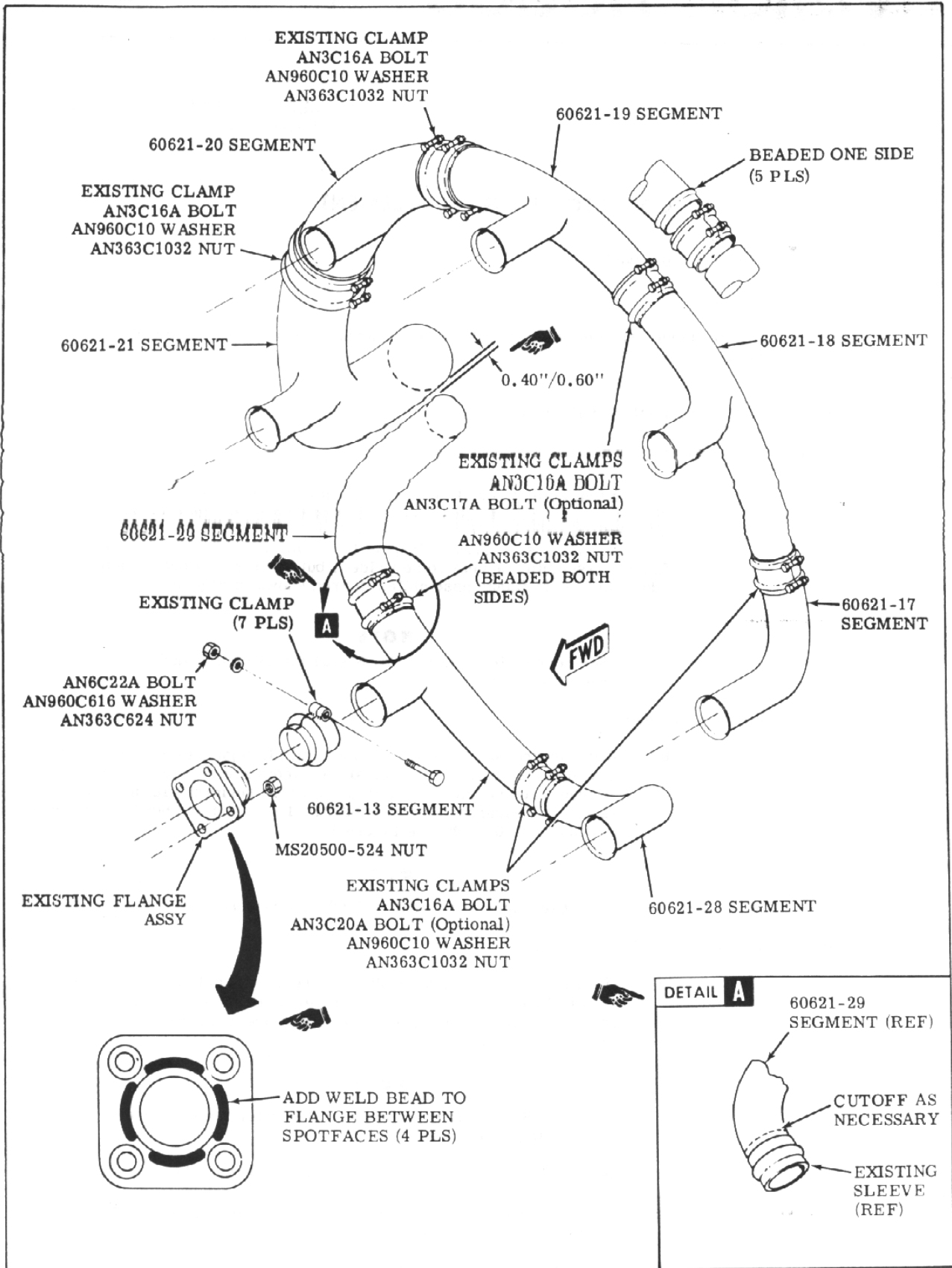


Figure 1.