

XI. Maintenance (Contd.)

- Wipe off the old compound and replace it with new compound frequently. Apply more pressure to speed the cutting action of the compound.
- To check the seating surfaces, remove all compound from the seat and the lap. Then, shine the seat with the same lap using the lapping method as described above. Low sections on the seating surface show up as shadow in contrast to the shiny portion.
- If shadows are present, further lapping is necessary. Only laps known to be flat can be used. It should take only a few minutes to remove the shadows.
- When lapping is complete, any lines appearing as cross-scratches can be removed by rotating the lap on its axis (which has been wiped clean of compound) on the seat.
- Thoroughly clean the lapped seat using a lintfree cloth and a cleansing fluid.

ATTENTION!

Before assembly, lap the contact surfaces of the nozzle, soft-seat disc (JM DA) and O-ring retainer to provide metal-to-metal seat tightness in the event of O-ring or Teflon seal (JM DA) failure.

Lapping O-Ring Seating Surfaces

Refer to Figure 10 and assemble the O-ring retainer to the disc holder (8) (D through J orifice) or disc (6) (K through U orifice) using the retainer lock screw(s) as follows:

1. Apply 3A lapping compound to the retainerseating surface.
2. Place the retainer on the nozzle seat (see Figure 26) and lap the retainer to the nozzle (2).
3. Once uniform contact is established, clean the nozzle (2) and O-ring retainer.
4. Repeat the procedure with 1000-grit compound.
5. Remove the retainer lock screw(s) and O-ring retainer, and thoroughly clean the O-ring retainer, retainer lock screws, and disc holder (8) or disc (6).

Reconditioning of Laps

Ring laps are reconditioned by lapping them on a flat lapping plate in a figure-eight motion (see Figure 29). To ensure the best results, recondition the ring laps after each use. Use an optical flat to check the quality of the lap.

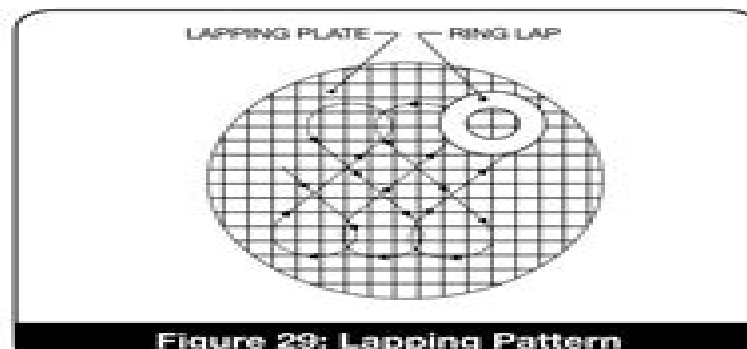


Figure 29: Lapping Pattern

Nozzle laps (see Figure 27) must be re-machined to recondition the lapping surfaces. Place the nozzle lap in a lathe between centers (see Figure 30). The surfaces marked A and B must be running concentrically.

One lapping surface is 90° and the other is 85°. The angle of each surface is marked on the lap. Machine surfaces C and D by taking light cuts at the proper angle until the lapping surfaces are reconditioned.



Figure 30: Nozzle Lap in a Lathe

Motion Retainer Manual

D Keegan



Motion Retainer Manual:

Manuals Combined: 50 + Army T-62 T-53 T-55 T-700 AVIATION GAS TURBINE ENGINE Manuals , Over 70 350 Mbs U S Army Repair Maintenance and Part Technical Manuals TMs related to U S Army helicopter and fixed wing turbine aircraft engines as well as turbine power plants generators Just a SAMPLE of the CONTENTS ENGINE AIRCRAFT TURBOSHAFT MODELS T700 GE 700 T700 GE 701 T700 GE 701C 1 485 pages TURBOPROP AIRCRAFT ENGINE 526 pages ENGINE GAS TURBINE MODEL T55 L 712 997 pages ENGINE ASSEMBLY GAS TURBINE GTCP36 150 BH GTCP36 150 BH 324 pages ENGINE AIRCRAFT GAS TURBINE T63 A 5A T63 A 700 144 pages ENGINE AIRCRAFT GAS TURBINE MODEL T63 A 720 208 pages ENGINE AIRCRAFT TURBOSHAFT T703 AD 700 T703 AD 700A T703 AD 700B 580 pages ENGINE ASSEMBLY T700 GE 701 247 pages ENGINE ASSEMBLY GAS TURBINE GTCP3645 H 214 pages ENGINE AIRCRAFT GAS TURBINE MODEL T63 A 720 208 pages GAS TURBINE ENGINE AUXILIARY POWER UNIT APU MODEL T 62 T 40 1 344 pages ENGINE ASSEMBLY T700 GE 700 243 pages SANDY ENVIRONMENT AND OR COMBAT OPERATIONS FOR T53 L 13B T53 L 13BA AND T53 L 703 ENGINES 112 pages DUAL PURPOSE MOBILE CHECK AND ADJUSTMENT GENERATOR STAND FOR T62T 2A AND T62T 2A1 AUXILIARY POWER UNITS T62T 40 1 AND T62T 2B AUXILIARY POWER UNITS 193 pages Others included POWER PLANT UTILITY GAS TURBINE ENGINE DRI LIBBY WELDING CO MODEL LPU 71 FSN 6115 937 0929 NON WINT AND 6115 134 0825 WINTERIZED POWER PLANT UTILITY MUST GAS TURBINE ENGINE DRIVEN AIRESEARCH CO MODEL NO PPU85 5 LIBBY WELDING CO MODEL NO LPU 71 AME CORP MODEL APP 1 AND HOLLINGSWORTH CO MODEL NO JHTWX10 9 NSN 6115 00 937 0929 NON WINTERIZED AND 6115 00 134 0825 WINTERIZED POWER PLANT UTILITY MUST GAS TURBINE ENGINE DRIVEN AIRESEA MODEL PPU85 5 LIBBY WELDING CO MODEL LPU 71 AMERTECH CO MODEL APP 1 AND HOLLINGSWORTH CO MODEL JHTWX10 96 NSN 6115 00 937 0929 NON WINTERIZED AND 6115 00 134 0825 WINTERIZED GENERATOR SET GAS TURBINE ENGINE DRIVEN TACTICAL SKID MTD 1 400 HZ ALTERNATING CURRENT GENERATOR SET GAS TURBINE ENGINE 45 KW AC 120 208 AND 240 4 3 PHASE 4 WIRE SKID MTD WINTERIZED AIRESEARCH MODEL GTGE 70 FSN 6115 075 1639 POWER PLANT UTILITY MUST GAS TURBINE ENGINE DRIVEN AIRESEARCH CO MOD PPU85 5 LIBBY WELDING CO MODEL LPU 71 AMERTECH CORP MODEL APP 1 AND HOLLINGSWORTH CO MODEL JHTWX 10 96 NSN 6115 00 937 0929 NONWINTERIZED AND 6115 00 134 0825 WINTERIZED POWER PLANT UTILITY GAS TURBINE ENGINE DRIVEN AMERTECH CORP MODEL APP 1 POWER PLANT UTILITY GAS TURBINE ENGINE DRIVEN LIBBY WELDING CO MODEL LPU 71 POWER UNIT UTILITY PACK GAS TURBINE ENGINE DRIVEN AIRESEARCH MODEL PPU85 5 TYPE A AVIATION UNIT AND INTERMEDIATE MAINTENANCE FOR GAS TURBINE ENGI AUXILIARY POWER UNIT APU MODEL T 62T 2B PART NO 161050 10 NSN 2835 01 092 2037 AVIATION UNIT AND INTERMEDIATE MAINTENANCE REPAIR PARTS AND SPE TOOLS LIST INCLUDING DEPOT MAINTENANCE REPAIR PARTS AND SPECIA FOR GAS TURBINE ENGINE

AUXILIARY POWER UNIT APU MODEL T 62 PART NO 160150 100 NSN 2835 01 092 2037 *Operator, Organizational, Direct and General Support, and Depot Maintenance Manual* ,1973 *Information Control Problems in Manufacturing Technology 1979* U. Rembold,2014-05-19 Information Control Problems in Manufacturing Technology 1979 is a compilation of papers presented at the second IFAC IFIP Symposium held at Stuttgart Germany on October 22 24 1979 The book discusses the following topics flexible manufacturing systems research information processing in large and small systems materials handling in a manufacturing system control requirements in industrial robot use and quality assurance in automated manufacturing processes The text gives an overview of the Integrated Computer Aided Manufacturing program employed in aerospace batch manufacturing One paper then presents a research and development program of Japan pertaining to use of lasers in a flexible manufacturing system complex Another paper discusses the development and set up of two flexible and different manufacturing systems the paper also explains the appropriate information processing system that will control such complicated manufacturing processes Another paper presents the advances in computers for quality control applications that are expected through lower hardware costs and better utilization of statistical methods Mechanical engineers technical designers and students with serious interest in automatic control and computer aided systems will find this book valuable Chilton's Motor Age Flat Rate and Service Manual ,1939 Small Air-cooled Engine Service Manual, 1990-1994 ,1995 Previously published as one volume under same title **Complete Manual of Criminal Forms, Federal and State** Francis Lee Bailey, Henry B. Rothblatt, 1974 **Manuals Combined: 150+ U.S. Army Navy Air Force Marine Corps Generator Engine MEP APU Operator, Repair And Parts Manuals** , Over 36 000 total pages Just a SAMPLE of the CONTENTS by File Number and TM Number 013511 TM 5 6115 323 24P 4 GENERATOR SET GASOLINE ENGINE DRIVEN SKID MOUNTED TUBULAR FRAME 1 5 K SINGLE PHASE AC 120 240 V 28 VDC LESS ENGINE DOD MODELS MEP 015A 60 HZ NSN 6115 00 889 1446 AND DOD MODEL MEP 025A 28 VDC 6115 00 017 8236 TO 35C2 3 385 4 SL 4 07609A 07610A 013519 TM 5 6115 329 25P 1 GENERATOR SET GASOLINE ENGINE DR LESS ENGINE 0 5 KW AC 120 240 V 60 HZ 1 PHASE DOD MODEL FSN 6115 923 4469 400 HZ MODEL MEP 019A 6115 940 7862 AN DC MODEL MEP 024A 6115 940 7867 TO 35C2 3 440 14 013537 TM 5 6115 457 12 7 GENERATOR SET ENGINE DRIVEN TACTICAL SKID MTD 100 KW 3 PHASE 4 WIRE 120 240 416 V DOD MODELS MEP 007A UTILITY CLASS 50 60 HZ NSN 6115 00 133 9101 MODEL MEP 106A PRECISE CLASS 50 60 H 6115 00 133 9102 MODEL MEP 116A PRECISE CLASS 400 KW 6115 00 133 9103 INCLUDING OPTIONAL KITS MODEL MEP 007 AWF WINTERIZATION KIT FUEL BURNING 6115 00 463 9082 MEP 007AWE WINTERIZATION KIT ELECTRIC 6115 00 463 9084 MODEL MEP 007A DUMMY LOAD KIT 6115 00 463 9086 AND MODEL MEP 007AWM WHEEL 013538 TM 5 6115 457 34 12 GENERATOR SET DIESEL ENGINE DRIVEN TACTICAL SKID 100 KW 3 PHASE 4 WIRE 120 208 AND 240 416 V DOD MODELS MEP0 UTILITY CLASS 50 60 HZ NSN 6115 00 133 9101 MODEL MEP106A CLASS 50 60 HZ 6115 00 133 9102 AND MODEL MEP116A PRECISE 400 HZ 6115 00 133 9103

INCLUDING OPTIONAL KITS DOD MODELS MEP007AWF WINTERIZATION KIT FUEL BURNING 6115 00 463 9082
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AND MODEL MEP007A MOUNTING KIT 6 013540 TM 5 6115 458 24P 9 GENERATOR SET DIESEL ENGINE DRIVEN
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005AWE WINTERIZATION KIT ELECTRIC 6115 00 463 908 MODEL MEP 005ALM LOAD BANK KIT 6115 00 463 9088
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BURNING 6115 00 407 8314 DOD MODEL MEP006AWE WINTERIZATION KIT ELECTRIC 6115 00 455 7693 DOD M
MEP006ALM LOAD BANK KIT 6115 00 407 8322 DOD MODEL MEP006 013550 TM 5 6115 545 34 12 INTERMEDIATE
FIELD DIRECT AND GENERAL SUPPORT AND DEPOT MAINTENANCE MANUAL FOR GENERATOR SET DIESEL ENGINE
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8240 400 DOD MODEL MEP 022A 6115 00 017 8241 TO 35C2 3 424 24 020611 LO 5 6115 457 12 GENERATOR SET DIESEL ENGINE DRIVEN SKID MTD 100 KW 3 PHASE 120 208 AND 240 416 V DOD MODELS MEP 007A UTILITY CLASS 50 NSN 6115 00 133 9101 MODEL MEP 106A PRECISE CLASS 50 60 H 6115 00 133 9102 AND MODEL MEP 116A PRECISE CLASS 400 HZ 6115 00 133 9103 020612 LO 5 6115 458 12 GENERATOR SET DIESEL ENGINE DRIVEN SKID MTD 200 KW 3 PHASE 4 WIRE 120 208 416 VOLTS DOD MODELS MEP 009A UTILITY CLASS 50 60 HERTZ NSN 6115 00 133 9104 MEP 108A PRECISE CLASS 50 HERTZ 6115 00 935 8729 LO 07536A 12 020614 LO 5 6115 465 12 GENERATOR SET DIESEL ENGINE DRIVEN TACTICAL SKID MOUNTED 30 3 PHASE 4 WIRE 120 206 AND 240 416 V DOD MODEL MEP 055A UT CLASS 50 60 HZ NSN 6115 00 118 1240 MODEL MEP 104A PRECI CLASS 50 60 HZ 6115 00 118 1247 AND MODEL 114A PRECISE CLA 400 HZ 6115 00 118 1248 025150 TM 5 6115 271 14 12 GENERATOR SET GASOLINE ENGINE DRIVEN S MTD TUBULAR FRAME 3 KW 3 PHASE AC 120 208 AND 120 240 V 2 DC LESS ENGINE DOD MODEL MEP 016A 60 HZ NSN 6115 00 017 823 MODEL MEP 016C 60 HZ 6115 00 143 3311 MODEL MEP 021A 400 HZ 6115 00 017 8238 MODEL MEP 021C 400 HZ 6115 01 175 7321 MODEL MEP 026A DC HZ 6115 00 017 8239 MODEL MEP 026C 28 V DC 6115 01 175 7320 TO 35C2 3 386 1 TM 05926A 14 NAVFAC P 8 6 025151 TM 5 6115 271 24P 3 GENERATOR SET GASOLINE ENGINE DRIVEN SKID MOUNTED TUBULA FRAME 3 KW 3 PHASE AC 120 208 AND 120 240 VOLTS 28 VDC LE ENGINE DOD MODEL MEP 016A 60 HERTZ NSN 6115 00 017 8237 MEP 021A 400 HERTZ 6115 00 017 8238 MEP 026A 28 VDC HERTZ 6115 00 017 8239 MEP 016C 60 HERTZ 6115 01 143 3311 MEP 400 HERTZ 6115 01 175 7321 MEP 026C 28 VDC HERTZ 6115 01 175 7320 TO 35C2 3 386 4 SL 4 05926A 032507 TM 5 6115 275 14 10 GENERATOR SET GASOLINE ENGINE DRIVEN SKID MOUNTED TUBULAR FRAME 10 KW AC 120 208V PHASE AND 120 240V SINGLE PHASE LESS ENGINE DOD MODELS MEP HZ NSN 6115 00 889 1447 AND MEP 023A 400 HZ 6115 00 926 08 NAVFAC P 8 615 14 TO 35C2 3 452 1 THIS ITEM IS INCLUDED ON EM 0086 EM 0088 D MEP 018A UTILITY CLASS 60 HZ NSN 6115 00 889 1447 AND MEP 0 PRECISE CLASS 400 HZ 6115 00 926 0843 NAVFAC P8 615 24P TO 35C2 3 452 4 THIS ITEM IS INCLUDED ON EM 0086 EM 0088 1 PHASE 3 WIRE 3 PHASE 4 WIRE 120 120 240 AND 120 208 V DOD MODEL MEP 002A UTILITY CLASS 60 HZ NSN 6115 00 465 1044 NAVFAC P 8 622 12 TO 35C2 3 456 1 TM 05682C 12 032640 TM 5 6115 585 12 12 GENERATOR SET DIESEL ENGINE DRIVEN TACTICAL SKID MTD 10 KW 1 PHASE 2 WIRE 1 PHASE 3 WIRE AND 3 PHASE 4 WIRE 120 120 240 AND 120 208 V DOD MODEL MEP 003A UTILITY CLASS 60 HZ NSN 6115 00 465 1030 AND MODEL MEP 112A UTILITY CLASS 400 HZ 6115 00 465 1027 NAVFAC P 8 623 12 TO 35C2 3 455 1 TM 05684C 05685B 12 032781 TM 5 6115 584 34 8 GENERATOR SET DIESEL ENGINE DRIVEN TAC SKID MOUNTED 5 KW 1 PHASE 2 WIRE 1 PHASE 3 WIRE 3 PHASE 120 120 240 AND 120 208 V DOD MODEL MEP 002A UTILITY CLASS NSN 6115 00 465 1044 NAVFAC P 8 622 34 TO 35C2 3 456 2 TM 0568C 34 032936 TM 5 6115 329 14 4 GENERATOR SET GASOLINE ENGINE DRIVEN 0 5 KW LESS ENGINE DOD MODEL MEP 014 UTILITY CLASS 60 HZ NSN 6115 00 923 4469 DOD MODEL MEP 01 UTILITY CLASS 400

HZ 6115 00 940 7862 AND DOD MODEL MEP 024 UTILITY CLASS 28 VDC 6115 00 940 7867 TO 35C2 3 440 1 033374 TM 5 6115 332 14 10 GENERATOR SET TAC GASOLINE ENGINE AIR COOLED 5 KW AC 120 240 V SINGLE PHASE V 3 PHASE SKID MOUNTED TUBULAR FRAME LESS ENGINE MILITARY DOD MODEL MEP 017A UTILITY 60 HZ NSN 6115 00 017 8240 AND MODEL MEP 022A UTILITY 400 HZ 6115 00 017 8241 NAVFAC P 8 614 14 TO 35C2 3 424 1 033750 TM 5 6115 585 34 9 GENERATOR SET DIESEL ENGINE DRIVEN TAC SKID MOUNTED 10 KW 1 PHASE 2 WIRE 1 PHASE 3 WIRE 3 PHASE 4 WIRE 120 120 240 AND 120 208 VOLTS DOD MODEL MEP 003A UT CLASS 60 HZ NSN 6115 00 465 1030 NAVFAC P 8 623 12 TO 35C2 3 455 2 TM 05684C 05685B 34 034072 TM 5 6115 585 24P 5 GENERATOR SET DIESEL ENGINE DRIVEN TA SKID MTD 10 KW 1 PHASE 2 WIRE 1 PHASE 3 WIRE 3 PHASE 4 W 120 120 240 AND 120 208 V DOD MODELS 003A UTILITY CLASS 60 NSN 6115 00 465 1030 AND MODEL MEP 112A UTILITY CLASS 400 6115 00 465 1027 NAVFAC P 8 623 24P TO 35C2 3 455 4 SL 4 05684C 06585B 040180 TM 5 6115 584 12 HR HAND RECEIPT MANUAL COVERING END ITEM COMPONENTS OF END ITEM C BASIC ISSUE ITEMS BII AND ADDITIONAL AUTHORIZATION LIST AAL GENERATOR SET DIESEL ENGINE DRIVEN TACTICAL SKID MTD 5 KW 1 WIRE 1 PH 3 WIRE 3 PH 4 WIRE 120 120 240 AND 120 208 V D MEP 002A UTILITY CLASS 60 HZ NSN 6115 00 465 1044 040833 TM 5 6115 458 12 HR HAND RECEIPT MANUAL COVERING THE END ITEM COMPONENTS OF END ITE BASIC ISSUE ITEMS BII AND ADDITIONAL AUTHORIZATION LIST AA GENERATOR SET DIESEL ENGINE DRIVEN TACTICAL SKID MOUNTED 20 3 PHASE 4 WIRE 120 208 AND 240 416 V DOD MODEL MEP 009A UT CLASS 50 60 HZ NSN 6115 00 133 9104 AND DOD MODEL MEP 108A PRECISE CLASS 50 60 HZ 6115 00 935 8729 040843 TM 5 6115 593 34 GENERATOR SET DIESEL ENGINE DRIVEN TAC SKID MTD 500 KW 3 PHASE 4 WIRE 120 208 AND 240 416 VOLTS DOD MODEL MEP 029A CLASS UTILITY 50 60 HZ NSN 6115 01 030 DOD MODEL MEP 029B CLASS UTILITY 50 60 HZ 6115 01 318 6302 INCLUDING OPTIONAL KITS DOD MODEL MEP 029AHK HOUSING KIT 6115 01 070 7550 DOD MODEL MEP 029ACM AUTOMATIC CONTROL MO 6115 01 275 7912 DOD MODEL MEP 029ARC REMOTE CONTROL MODULE 6110 01 070 7553 DOD MODEL MEP 029ACC REMOTE CONTROL CABLE 6110 01 087 4127 NAVFAC P 8 041070 TM 5 6115 593 12 GENERATOR SET ENGINE DRIVEN TACTICAL SKID MTD 500 KW 3 PHASE 4 WIRE 120 240 416 VOLTS DOD MODEL MEP 029A CLASS UTILITY HERTZ 50 60 NSN 6115 01 030 6085 MEP 029B UTILITY 50 60 6115 01 318 INCLUDING OPTIONAL KTS DOD MODELS MEP 029AHK NOMENCLATURE HOUS 6115 01 070 7550 MEP 029ACM AUTOMATIC CONTROL MODULE 6115 01 275 7912 MEP 029ARC REMOTE CONTROL MODULE 6110 01 070 7553 MEP 029ACC REMOTE CONTROL CABLE 6110 01 087 4127 TO 35C2 3 463 1 041338 LO 55 1730 229 12 POWER UNIT AVIATION MULTI OUTPUT GTED ELECTRICAL HYDRAULIC PNEUMATIC AGPU WHEEL MOUNTED SELF PROPELLED TOWABLE DOD MODEL MEP 360A CLASS PRECISE HERTZ 400 NSN 1730 01 144 1897 042791 TM 5 6115 457 12 HR HAND RECEIPT MANUAL COVERING THE BASIC ISSUE ITEMS BII FOR GE SET DIESEL ENGINE DRIVEN TACTICAL SKID MTD 100 KW 3 PHASE 120 208 AND 240 416 V DOD MODELS

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AGPU WHEEL MOUNTED SELF PROPELLED TOWABLE AC 400HZ 3PH 0 8 PF 115 200V 30 KW DC 28 VDC 700 AMPS
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118 1245 DOD MODEL MEP 113A 6115 00 118 1244 069954 TM 9 6115 465 24P 2 GENERATOR SET DIESEL ENGINE
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AW WINTERIZATION KIT ELECTRIC 6115 00 463 9085 MEP 002 ALM L BANK KIT 6115 00 463 9088 MEP 005 AWM
WHEEL MOUNTING KIT 6115 00 463 9094 TO 35C2 3 070096 TM 9 6115 464 24P 1 GENERATOR S DIESEL ENGINE
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