

ATA AIRLINES, INC.

#1 ENGINE IGNITER PLUG REPLACEMENT (PHASE II ENGINES)

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CHECK BEING PERFORMED: Custom

ZONES: 410
A/C NUMBER:
REV. DATE: 11/14/03
FREQUENCY: 3A

W/C NUMBER: 241R7401 DATE:
W/O:
JAC CODE:

MFR P/N	DESCRIPTION	QTY
YA211-25	IGNITER PLUG	2
EU45691	WASHER	A/R
LK50396	WASHER	A/R
ASC251	DRY FILM LUBRICANT (OR EQUIVALENT.)	A/R

TOOLS	DESCRIPTION	QTY
UT1152	R.R. SOCKET WRENCH OR EQUIVALENT	1
HU28096/1	PROTRUSION GAGE	1

PANELS

413AL 416AR
415AL

REFERENCES

FIGURES 1 THRU 3

MECH INSP

| #1 ENGINE RB211-535E4 IGNITER PLUG REPLACEMENT (PHASE II ENGINES)

| NOTE: THIS WORKCARD IS ONLY EFFECTIVE TO RB211-535E4 ENGINES
| CONFIGURED WITH PRE S/B 72-C230 (PHASE II) COMBUSTORS.
| ENGINES CONFIGURED WITH PHASE II COMBUSTORS HAVE IGNITERS
| SECURED AT THE NO. 8 AND NO. 12 FUEL SPRAY NOZZLE
| ASSEMBLIES.

| 1. REPLACE #1 ENGINE IGNITER PLUGS.

| CAUTION: DO NOT ACCOMPLISH IGNITER REMOVAL AND INSTALLATION
| WORKSTEPS CONTAINED IN THIS WORKCARD ON RB211-535E4
| ENGINES CONFIGURED WITH POST S/B 72-C230 (PHASE V)
| COMBUSTORS. DAMAGE TO ENGINE COULD OCCUR.

| _____ XXXXX A. Check the Engine Serial Number and Record Below.

| Engine S/N _____

| (1) If engine serial number is 31795 or 31796, the engine
| is configured with PHASE V combustors. N/A all
| remaining worksteps with the explanation "PHASE V
| Combustors".

| (2) If engine serial number is NOT 31795 or 31796,

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W/C #: 241R7401

DATE WORK CARD COMPLETE ___/___/___

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continue with workcard accomplishment.

B. Prepare for Igniter Removal

XXXXXX

(1) For the Left Engine, open these circuit breakers on the P11 overhead circuit breaker panel and attach TAG-OUT (M-142) TAGS:

(a) 11D7 ENGINES STBY IGN L 1

(b) 11D8 ENGINES STBY IGN L 2

(c) 11L1 LEFT ENGINE IGN 1

CAUTION: OBEY THE PRECAUTIONS FOR THE KEVLAR WRAPPING WHEN YOU OPEN THE FAN COWL PANEL. IF THE PRECAUTIONS ARE NOT OBEYED, DAMAGE TO THE KEVLAR WRAPPING CAN OCCUR.

XXXXXX

(2) Open the fan cowl panels (AMM 71-11-04-2).

WARNING: OBEY THE INSTRUCTIONS IN AMM 78-31-00-2 WHEN YOU OPEN THE THRUST REVERSERS. IF YOU DO NOT OBEY THE INSTRUCTIONS INJURY TO PERSONS OR DAMAGE TO EQUIPMENT WILL OCCUR.

XXXXXX

(3) Open the thrust reversers (AMM 78-31-00-2).

XXXXXX

(4) Determine the location of the igniter plugs and mark the position below using an X or check mark.

At the NO. 8 and NO. 12 fuel spray nozzle assemblies.

Secured to individual igniter adapters separate from the fuel spray nozzle assemblies.

(a) If igniters are located at the NO. 8 and NO. 12 fuel spray nozzle assemblies (FIGURE 2) then continue with igniter replacement worksteps.

(b) If igniters are secured to individual igniter

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adapters separate from the fuel spray nozzle assemblies, the engine is configured with PHASE V combustors.

1) Accomplish engine and circuit breaker close steps only.

2) N/A all igniter plug removal, replacement, and operational check worksteps with the explanation "PHASE V Combustors".

WARNING: THE ELECTRICAL DISCHARGE FROM THE HIGH ENERGY IGNITION UNITS IS VERY DANGEROUS. THE LOW TENSION (LT) LEAD TO THE UNIT MUST BE DISCONNECTED FOR ONE MINUTE BEFORE YOU DISCONNECT THE HIGH TENSION (HT) LEAD. INJURY TO PERSONS CAN OCCUR IF THESE INSTRUCTIONS ARE NOT FOLLOWED.

XXXXX C. Remove LH Igniter Plug. (FIGURE 1 and 2)

(1) Disconnect the applicable LT connector and wait one minute before you continue the procedure.

(2) Disconnect the HT lead from the igniter plug.

NOTE: The right igniter plug is for the number 1 unit and the left igniter plug is for the number 2 unit.

(3) Remove the igniter using the socket wrench.

(a) Keep the spacer washers for installation.

(4) Put dust caps on the igniter plug hole, the connector and the plug.

XXXXX D. Remove RH Igniter Plug. (FIGURE 1 and 2)

(1) Disconnect the applicable LT connector and wait one minute before you continue the procedure.

(2) Disconnect the HT lead from the igniter plug.

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NOTE: The right igniter plug is for the number 1 unit and the left igniter plug is for the number 2 unit.

(3) Remove the igniter using the socket wrench.

(a) Keep the spacer washers for installation.

(4) Put dust caps on the igniter plug hole, the connector and the plug.

E. Install New Igniter Plugs

XXXXX

(1) Remove the dust caps from the igniter plug hole, the connector and the plug.

XXXXX

(2) Do the following steps to make a check of the immersion depth for each igniter plug:

(a) PHASE II COMBUSTORS;

1) Set stop A on the protrusion gage (FIGURE 3).

a) Release the lock screws on stop A and B.

b) Pull out the distance piece from the body and turn the distance piece 90 degrees to put it on the end face of the body.

c) Use the igniter plug to set the protrusion gage.

d) Make sure stop B touches the distance piece and stop A touches stop B.

e) Tighten stop A.

f) Turn the distance piece 90 degrees and push it into the body.

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- 2) Install the protrusion gage on the engine (FIGURE 3).
 - a) Turn the probe indicator notch to face forward and install the protrusion gage on the engine at the igniter plug hole.
 - b) Make sure the body of the protrusion gage is fully seated on the plug mounted flange.
- 3) Set stop B on the protrusion gage.

CAUTION: BE CAREFUL NOT TO DAMAGE THE COMBUSTION LINER COATING WHEN YOU USE THE PROTRUSION GAGE.

- a) Pull out and turn the distance piece 90 degrees to put it on the end face of the body.
 - b) Turn the probe indicator notch to the aft.
 - c) Pull out the probe until the conditions that follow have occurred:
 - 1 The probe foot touches the combustion liner;
 - 2 The distance piece touches the gage body;
 - 3 Stop B touches the distance piece.
 - d) Tighten stop B on the protrusion gage.
- 4) Turn the distance piece 90 degrees and push it into the body.
 - 5) Turn the probe indicator notch to face forward and remove the protrusion gage

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from the engine.

- 6) Get the correct number of spacer washers to equal gap Y.

_____ XXXXX

- (3) Do the following steps to install the left igniter plug:

- (a) Put lubricant on the threads of the igniter plug.

- (b) Utilizing results from the immersion check, install the spacer washers on the igniter plug.

- (c) Install the igniter plug.

- 1) PHASE II COMBUSTORS;

- a) Install the igniter plug into the boss on the fuel spray nozzle.

- 1 Tighten the igniter plug to 200 pound-inches (22.6 Newton meters) reference AMM 70-51-00-2.

- (d) Connect the HT igniter lead to the igniter plug, and tighten to 140-150 pound-inches (15.8 - 16.9 Newton meters), so the igniter lead elbow does not turn.

- 1) Install lockwire on the connector.

_____ XXXXX

- (4) Do the following steps to install the right igniter plug:

- (a) Put lubricant on the threads of the igniter plug.

- (b) Utilizing results from the immersion check, install the spacer washers on the igniter plug.

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(c) Install the igniter plug.

1) PHASE II COMBUSTORS;

a) Install the igniter plug into the boss on the fuel spray nozzle.

1 Tighten the igniter plug to 200 pound-inches (22.6 Newton meters) reference AMM 70-51-00-2.

(d) Connect the HT igniter lead to the igniter plug, and tighten to 140-150 pound-inches (15.8 - 16.9 Newton meters), so the igniter lead elbow does not turn.

1) Install lockwire on the connector.

|_____ XXXXX F. Connect the applicable LT connector to the igniter unit, reference AMM 70-50-00-2.

WARNING: OBEY THE INSTRUCTIONS IN 78-31-00-2 WHEN YOU OPEN THE THRUST REVERSERS. IF YOU DO NOT OBEY THE INSTRUCTIONS INJURY TO PERSONS OR DAMAGE TO EQUIPMENT WILL OCCUR.

|_____ XXXXX G. Close the thrust reversers, reference AMM 78-31-00-2.

CAUTION: OBEY THE PRECAUTIONS FOR THE KEVLAR WRAPPING WHEN YOU OPEN THE FAN COWL PANEL. IF THE PRECAUTIONS ARE NOT OBEYED, DAMAGE TO THE KEVLAR WRAPPING CAN OCCUR.

|_____ XXXXX H. Close the fan cowl panels reference AMM 71-11-04-2.

|_____ XXXXX I. For the left engine, remove the TAG-OUT (M-142) tags and close the following circuit breakers on the P11 overhead circuit breaker panel:

(1) 11D7 ENGINES STBY IGN L 1

(2) 11D8 ENGINES STBY IGN L 2

#1 ENGINE IGNITER PLUG REPLACEMENT (PHASE II ENGINES)

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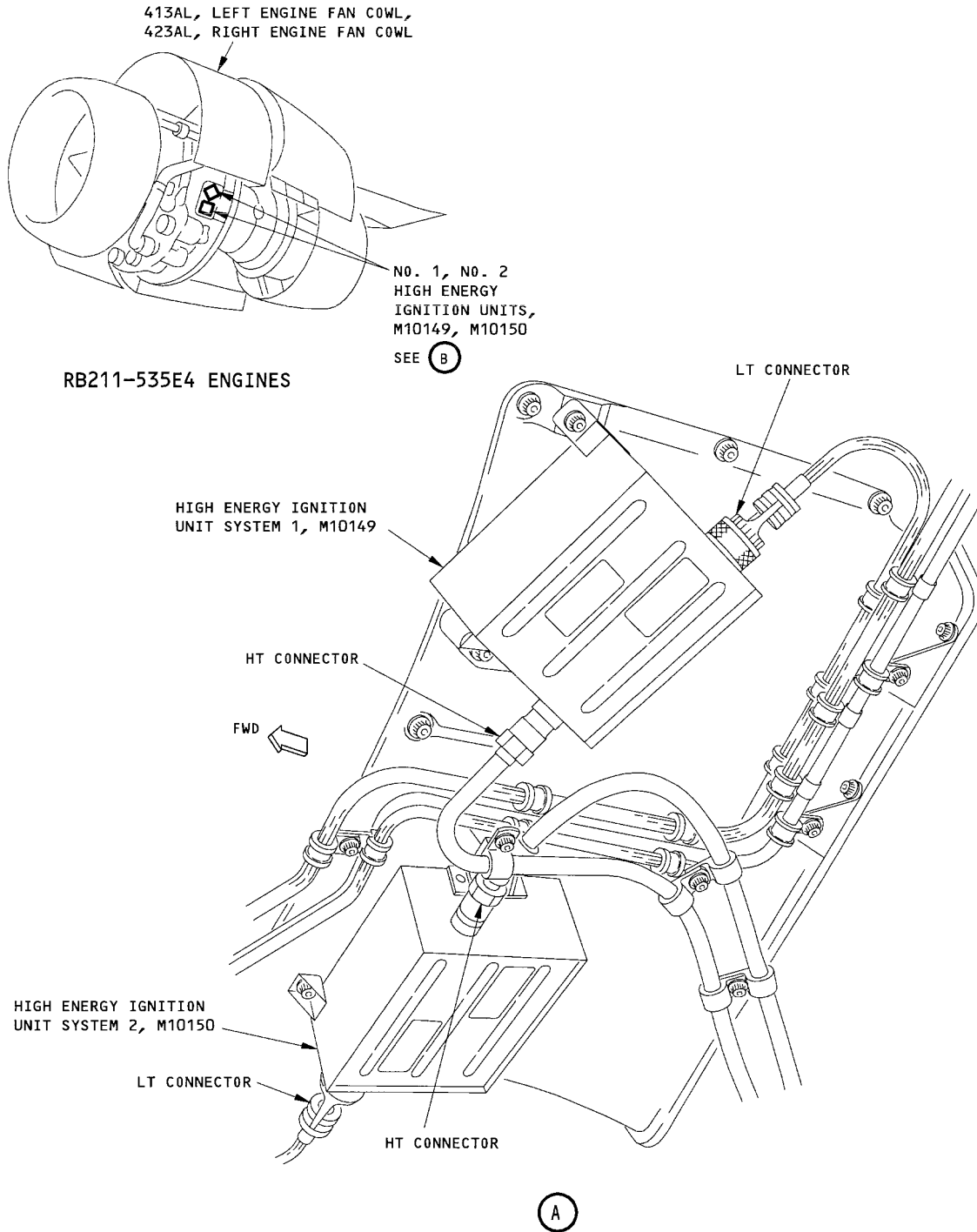
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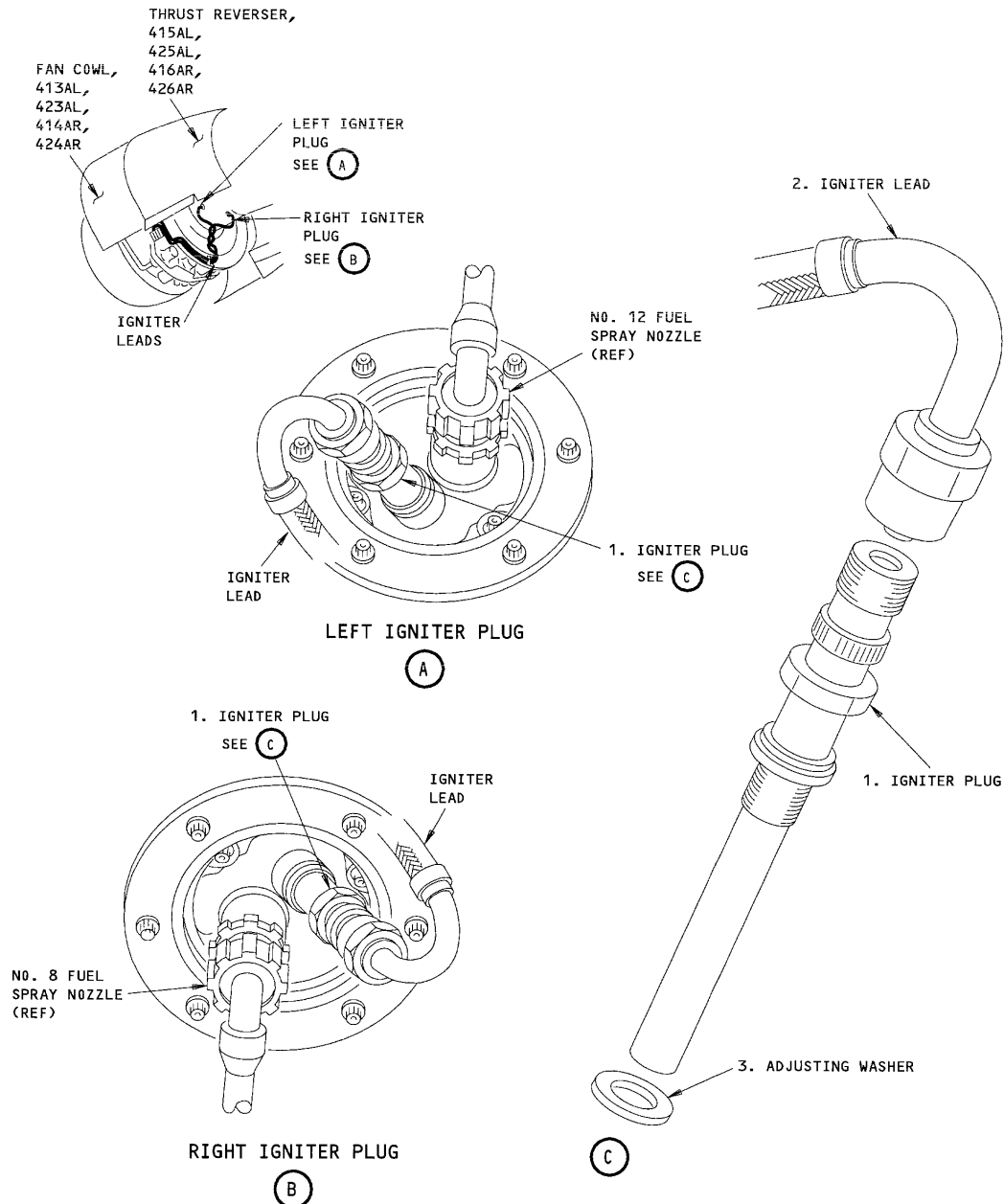
| (3) 11L1 LEFT ENGINE IGN 1

|_____ XXXXX J. Do the ignition system audible test procedure outlined
| in AMM 74-00-00-5.

*****END OF WORKCARD*****

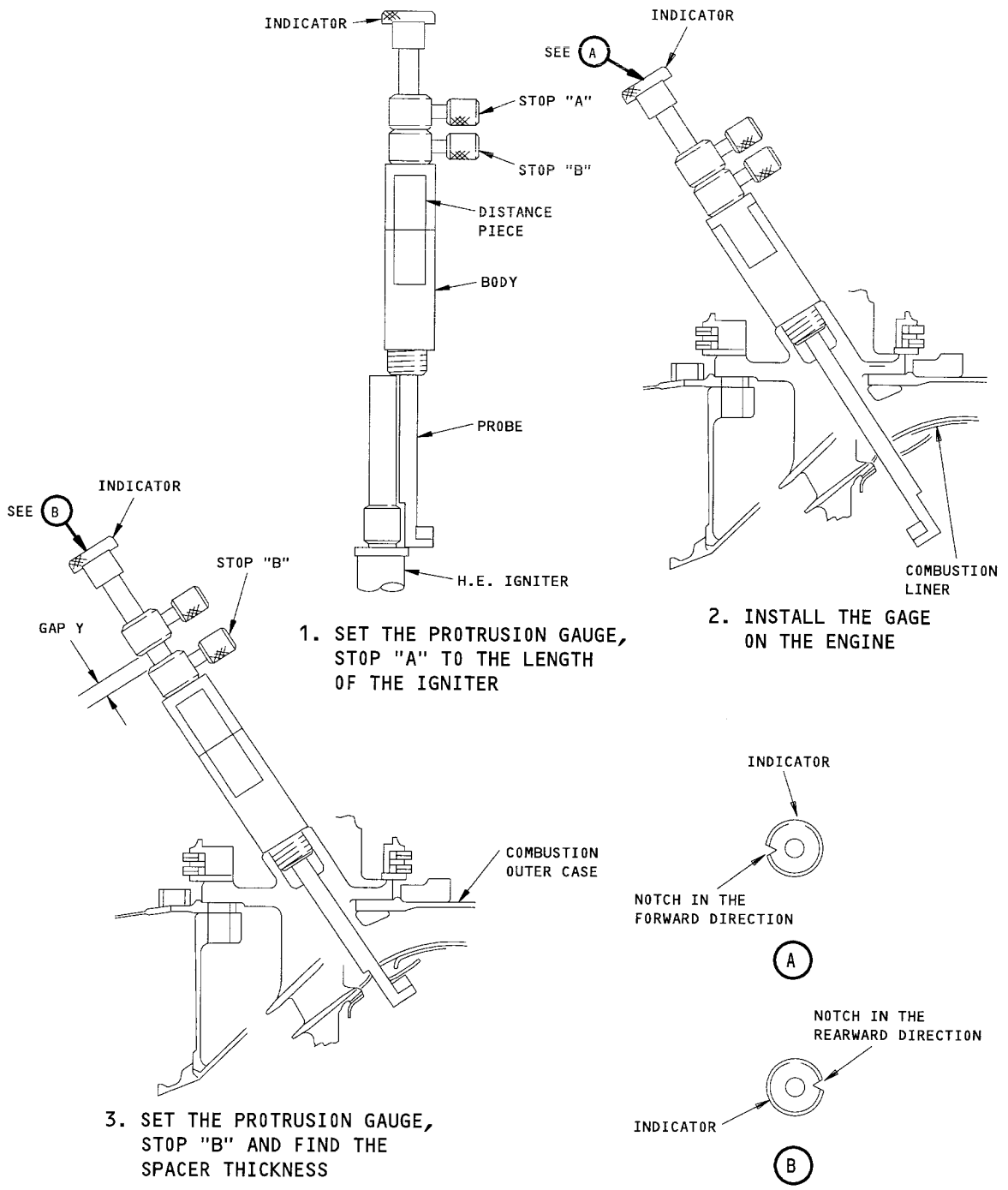


Igniter Unit Disconnect Points



Igniter Plug Installation

50836



1. SET THE PROTRUSION GAUGE, STOP "A" TO THE LENGTH OF THE IGNITER

2. INSTALL THE GAGE ON THE ENGINE

3. SET THE PROTRUSION GAUGE, STOP "B" AND FIND THE SPACER THICKNESS

GAP Y = THE THICKNESS OF SPACERS THAT ARE NECESSARY

Igniter Plug Immersion Check