

CHECK BEING PERFORMED: Custom

ZONES: 420  
 A/C NUMBER:  
 REV. DATE: 09/16/02  
 FREQUENCY: H1

W/C NUMBER: 543M7101  
 DATE:  
 W/O:  
 JAC CODE:



MFR P/N	DESCRIPTION	QTY
SILCOSET152	SEALANT	AR

  

TOOLS	DESCRIPTION	QTY
20M3692	STEP TOOL (-22B ENGINES ONLY)	1

## PANELS

422BL	422FL	422JL	422KL	427A	428BR	428DL
422DL5	422ER5	422KL5	428BL5	428CR5	428DR5	
422BR	422FR	422JR	422KR	428BL	428CR	428DR
422EL5	422G5	422KR5	428BR5	428DL5	422SR5	

## REFERENCES

FIGURES 1 THRU 6 MM 70-42-13 MM 70-51-00 72-03-00 MM72-34-15 M11-72-14  
 543M7101

## MECH INSP

| NOTE: THIS WORKCARD ACCOMPLISHES THE INTENT OF M SHEET M11-72-14

| \_\_\_\_\_ XXXXX 1 REMOVE ALL #3 ENGINE GAS GENERATOR FAIRINGS PER ROLLS ROYCE  
 | MM 72-03-00, PB 400.

| \_\_\_\_\_ XXXXX 2 HAND CLEAN REMOVED FAIRINGS.

| \_\_\_\_\_ XXXXX 3 ROUTE FAIRINGS REMOVED IN STEP 1 TO APPROPRIATELY RATED SHOP  
 | FOR DETAILED INSPECTION UNDER SEPARATE ATA REPAIR ORDERS.

| XXXX \_\_\_\_\_ 4 INSPECT FOR CORRECT INSTALLATION, AND RUNNING TORQUE CHECK  
 | PER ROLLS ROYCE MANUAL 70-42-13, PAGE 919, OF ALL  
 | (8) HELICOIL INSERTS (P/N AGS3708) IN FLANGE MOUNTED  
 | BRACKETS. AGS 3708 IS .3125 THREAD.

| NOTE: STEP 4 APPLICABLE TO -22B ENGINES ONLY.  
 | (N/A FOR -524 ENGINES):

| XXXX \_\_\_\_\_ 5 INSPECT FOR CORRECT INSTALLATION, AND RUNNING TORQUE CHECK  
 | PER ROLLS ROYCE STANDARD PRACTICES MANUALS 70-51-00 OF THE  
 | APPROXIMATELY 29 COLD STREAM FAIRING ATTACH BOLT ANCHOR NUTS  
 | LOCATED ON THE 03 AND 04 FLANGES. RUNNING TORQUE SHOULD BE  
 | BETWEEN 3.5 AND 30 INCH LBS.

| NOTE: STEP 5 APPLICABLE TO -524 ENGINES ONLY.  
 | (N/A FOR -22B ENGINES):

| XXXX \_\_\_\_\_ 6 INSPECT ALL (8) ATTACHING BRACKETS ON 03 AND 04 FLANGES.  
 | ENSURE BRACKETS ARE INSTALLED CORRECTLY. CHECK FOR CRACKS

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MECH: INSP:

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- | IN BEND RADII. (FIGURES 1 AND 2)
- |XXXX \_\_\_\_\_ 7 INSPECT FAIRING RUBBER SEALING STRIP ON FLANGE OF 07  
| MODULE FOR LOOSENESS, CRACKING AND TEARING.
- | NOTE: ON RB211-22B ENGINES SEALING STRIP SEGMENTS ARE REPLACED  
| PER RR ENGINE MANUAL 72-34-15, FRS 3524.
- | \_\_\_\_\_ 8 VISUALLY INSPECT #3 ENGINE CORE AREA FOR OBVIOUS DAMAGE AND  
| INCOMPLETE WORK ITEMS BEFORE INSTALLING CORE FAIRINGS.  
| (OK TO CLOSE)
- | \_\_\_\_\_ XXXXX 9 INSTALL ALL COMPRESSOR FAIRINGS LOOSELY TO ENSURE PROPER  
| ALIGNMENT, THEN TORQUE (100 IN-LB) TIGHTEN SECURING BOLTS  
| (24 EACH).
- | NOTE: STEP 9 APPLICABLE TO -524 ENGINES ONLY.  
| (N/A FOR -22B ENGINES)
- | \_\_\_\_\_ XXXXX 10 DETERMINE WHETHER SECURITY BOLTS HAVE SPRINGS. IF SPRINGS  
| ARE INSTALLED, INSERT, .060" STOP PLATES IN BRACKET UNDER TOP  
| PLATFORM PER FIGURE 3., IF POSSIBLE. (SOME BRACKETS ON 03  
| FLANGE MAY HAVE SOLID TOP AREA)
- | NOTE: STEP 10 APPLICABLE TO -22B ENGINES ONLY.  
| (N/A FOR -524 ENGINES)
- | \_\_\_\_\_ XXXXX 11 INSTALL ALL COMPRESSOR FAIRING SWITCH CLOSURE PLATES TO  
| ENSURE PROPER ALIGNMENT, THEN TORQUE (100 IN-LB) TIGHTEN  
| CLOSURE PLATE BOLTS (18 EACH).
- | NOTE: STEP 11 APPLICABLE TO -22B ENGINES ONLY.  
| (N/A FOR -524 ENGINES):
- |XXXX \_\_\_\_\_ 12 INSPECT FAIRING SEAL-TO-FAIRING INTERFACE AT 07 FLANGE PER  
| RR MM 72-03-00, PAGES 420 A, B & C. (SEE ALSO FIGURE 4).
- | NOTE: STEP 12 APPLICABLE TO -22B ENGINES ONLY.  
| (N/A FOR -524 ENGINES):
- | 13 ADJUST COMPRESSOR FAIRINGS BY METHOD A (WITH SECURITY BOLT  
| SPRINGS), OR METHOD B (WITHOUT SPRINGS)
- | NOTE: STEP 13 APPLICABLE TO -22B ENGINES ONLY.  
| (N/A FOR -524 ENGINES):

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MECH: INSP:

| \_\_\_\_\_ XXXXX A ADJUST COMPRESSOR FAIRINGS WITH SECURITY BOLT SPRINGS  
| USING METHOD A.

| NOTE: N/A STEP 13A IF STEP 13B IS USED.

- | 1 SEE FIGURE 5. USING AN APPROPRIATE DEPTH MICROMETER  
| MEASURE DEPTH FROM "A" TO "C" ("C" IS TOP OF STOP PLATE  
| REF. FIG 3 -IF STOP PLATE NOT INSTALLED, "C" IS TOP OF  
| MOUNTING BRACKET). RECORD DIMENSION ON A PIECE OF TAPE  
| ADJACENT TO THE SECURITY BOLT HOLE.
- | 2 REPEAT THIS MEASURING ON ALL COMPRESSOR FAIRINGS.
- | 3 REMOVE ALL COMPRESSOR FAIRINGS. REMOVE STOP PLATES  
| IF INSTALLED.
- | 4 AT EACH SECURITY BOLT HOLE, MEASURE DISTANCE FROM  
| "A" TO "B" (FIG 5) (ADD .050" IF STOP PLATE WAS INSTALLED)  
| AND SUBTRACT THIS TOTAL FROM THE "A" TO "C" DISTANCE.  
| THE RESULT IS THE THICKNESS OF ADJUSTING BUTTON REQUIRED.  
| (SEE EXAMPLE IN FIGURE 5)

| NOTE: MAXIMUM ALLOWABLE CLEARANCE IS .010". FOR  
| DISTANCE GREATER THAN .010" INSERT AN APPROPRIATE  
| ADJUSTMENT BUTTON. AVAILABLE BUTTON SIZES SHOWN  
| IN (FIG. 5).

- | 5 TO KEEP BUTTON IN PLACE DURING INSTALLATION OF FAIRING  
| USE SILCOSET152.
- | 6 INSTALL SPRING, SPRING COVER (WITH LARGE OPENING  
| TOWARD SPRING) AND BOLT THREADED THRU SPRING COVER.
- | 7 INSTALL ALL COMPRESSOR FAIRINGS WITH CLOSURE PLATES/  
| HOLD DOWN BOLTS LOOSE.
- | 8 TIGHTEN/TORQUE THE 18 CLOSURE BOLTS (100 IN-LB), AND  
| THE 8 SECURITY BOLTS (170 IN-LB).

| \_\_\_\_\_ XXXXX B ADJUST COMPRESSOR FAIRINGS WITHOUT SECURITY BOLT SPRINGS  
| USING METHOD B.

| NOTE: N/A STEP 13B IF STEP 13A IS USED.

- | 1 SEE FIGURE 6. INSURE THAT ADJUSTABLE SPACER IS  
| BACKED ALL THE WAY OUT AGAINST THE SOLE PLATE.

INSPECT #3 ENGINE CORE AREA AND CORE PANELS

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| 2 INSURE THE LOCKING NUT IS BACKED OUT TO ALLOW  
| ENOUGH ADJUSTMENT.

| 3 INSTALL FAIRING ON ENGINE. THE FAIRING ATTACH  
| BOLT SHOULD BE BACKED INTO THE INTERNAL THREADS  
| TO HOLD IT OUT OF THE WAY.

| 4 TURN ADJUSTING SPACER BY HAND UNTIL IT TOUCHES  
| THE BRACKET.

| 5 INSTALL THE ATTACH BOLT AND TORQUE TIGHT.

| 6 TIGHTEN THE ADJUSTABLE SPACER LOCK NUT USING  
| TOOL 20M3692.

|XXXX \_\_\_\_\_ 14 INSPECT FOR PROPER SECURITY AND FAIRING MIS-MATCH.

|XXXX \_\_\_\_\_ 15 VISUALLY INSPECT #3 ENGINE CORE AREA FOR OBVIOUS DAMAGE  
| AND INCOMPLETE WORK ITEMS. (FINAL INSPECTION).

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