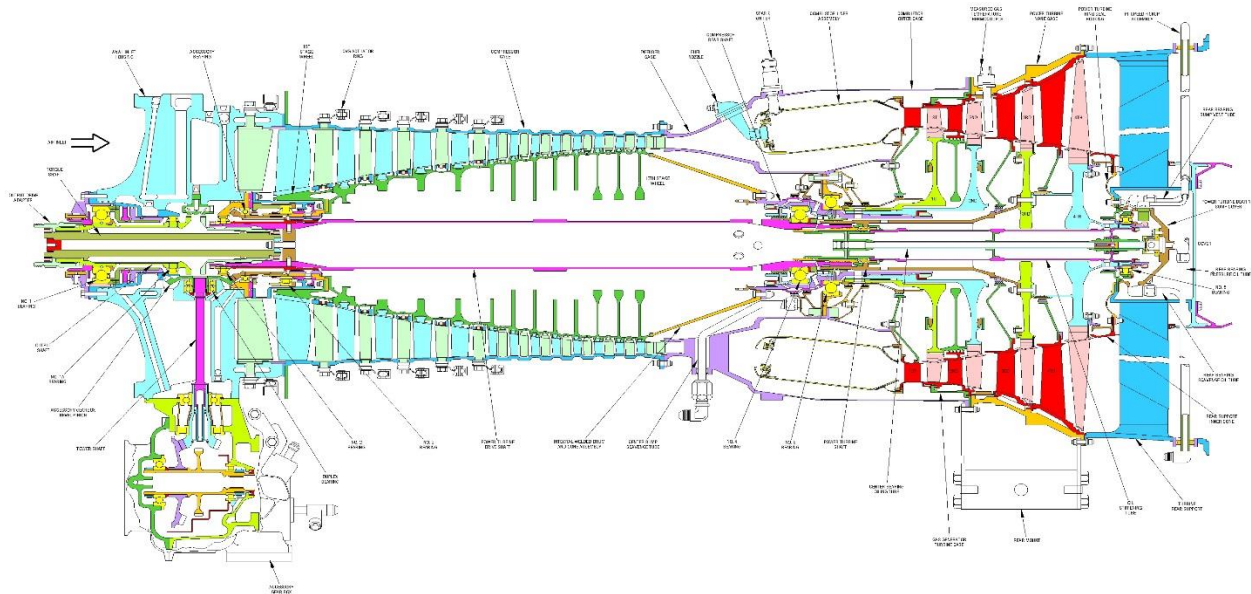


Engine Teardown Report

Prepared for:

ANR Pipeline

570-KC Engine
S/N 0072



CONTENTS

- Modifications and Bulleting Compliance
- Receiving Photos
- Shipping Photos After the Repair
- Engine Inventory
- Test Acceptance Log

Modifications and Bulleting Compliance

COMPRESSOR (N1) MODIFICATION RECORD				
Spec. No:	Rev.	Title	Status	Technician
6-IT-86	None	Replace Accessory Gearbox Drive Shaft	PCW	026
9-IT-86	None	Replace Engine Diffuser Combustor Tube Seals	CW	026
1-IT-87	None	Modify Compressor Air Inlet Bevel Gear	PCW	026
I.R.I.L. 41	#1	Replace 570 #5 Bearing with #5 571 Bearing	NCW	026
I.R.I.L. 7	#1	Bell Cranks and Stator Settings	CW	026
ISL 4	None	Bell Cranks and Stator Settings	CW	026
I.R.I.L. 1	C	Oil Pump Modification	CW	026
EA 570-C-06	D	Incorporate Threaded Combustor Location Pins in Diffuser	PCW	026
EA 570-C-10	F	Torquemeter Modification	PCW	026
EA 570-C-17	C	Output Shaft (SO) Seal Modification for Whip Pickup	PCW	026
EA 570-C-18	None	Modify SO Seal by Enlarging Air Holes	PCW	026
EA 570-C-19	C	Compressor Front Sump Sealing Modification (Add Tubes)	PCW	026
EA 570-C-25	E	4 th and 5 th Stage Bellcrank Modification	PCW	026
EA 570-C-29	C	Bellcrank Modification Stages 1 thru 3	PCW	026
EA 570-C-30	A	Honeycomb Deal and Lab Seal Hard-Face Coating Modification	PCW	026
EA 570-E-05	A	Rear Thrust Bearing (RTB) Modification	NCW	026
EA 570-E-07	D	Engine Corrosion Protection	PCW	026
EA 570-E-08	None	570 to 571 Engine Conversion	NCW	026
EA 570-E-09	None	571 Power Recovery Modification	NCW	026
EA 570-E-12	A	Dump Diffuser Modification	PCW	026
EA 570-E-13	None	C/B Bearing Scavenge Oil Vent System Configuration	N/A	026
EA 570-GP-09	A	Modify Center Bearing Key slot	PCW	026
EA 570-GP-12	D	Apply Thermal Barrier Coating to 1 st Stage GP Vane	NCW	026
EA 570-GP-13	A	Apply Thermal Barrier Coating to 1 st Stage Vane Support	NCW	026
I.R.I.L. 10	None	Accessory Gearbox, Drain Plug, Oil Leakage	CW	026
8-IT-86	None	Release of Improved Pinion Gear Bearing	PCW	026

COMPRESSOR CASE MODIFICATION RECORD

Spec. No.	Rev.	Title	Status	Technician
EA 570-C-09	G	Incorporate Improved 6 th thru 12 th Stage Vanes	PCW	033
EA 570-C-26	B	Aluminum Polyester Metallize for Titanium Blades	PCW	033
EA 570-E-07	D	Engine Corrosion Protection	NCW	033

COMPRESSOR ROTOR MODIFICATION RECORD

Spec. No.	Rev.	Title	Status	Technician
IEB 3-IT-00	1	Compressor Rotor Assembly Field Measurements	PCW	033
IEB 2-IT-00	None	Replacement of 2 nd & 3 rd Stage Compressor Blades	PCW	033
EA 570-C-05	C	Incorporate Locked #4 Bearing	PCW	033
EA 570-C-24	C	Compressor Rotor Drum Modification	PCW	033
EA 570-E-05	A	Rear Thrust Bearing (RTB) Modification	NCW	033
EA 570-E-07	D	Engine Corrosion Protection	NCW	033
EA 570-C-21	None	Turbine Drive Shaft Locking Bar Assembly Inspection and Repair	PCW	033
IRIL 38	None	Alert: Remove and Return of the Second and Third Stage Compressor Blades	PCW	033
IRIL 40	1	Release of 2 nd and 3 rd Stage Blades	PCW	033
IRIL 58	None	Remove the Second-Stage Compressor Balance Lug P/N:6887539	CW	033

GAS GENERATOR TURBINE ROTOR MODIFICATION RECORD

Spec. No:	Rev.	Title	Status	Technician
EA 570-GP-04	None	Incorporate Improved 1 st and 2 nd Stage Turbine Blades	PCW	015
EA 570-E-05	A	Rear Thrust Bearing (RTB) Modification	NCW	015
EA 570-E-08	None	570 to 571 Conversion	NCW	015
EA 570-E-09	None	571 Power Recovery Modification	NA	015

POWER TURBINE MODIFICATION RECORD

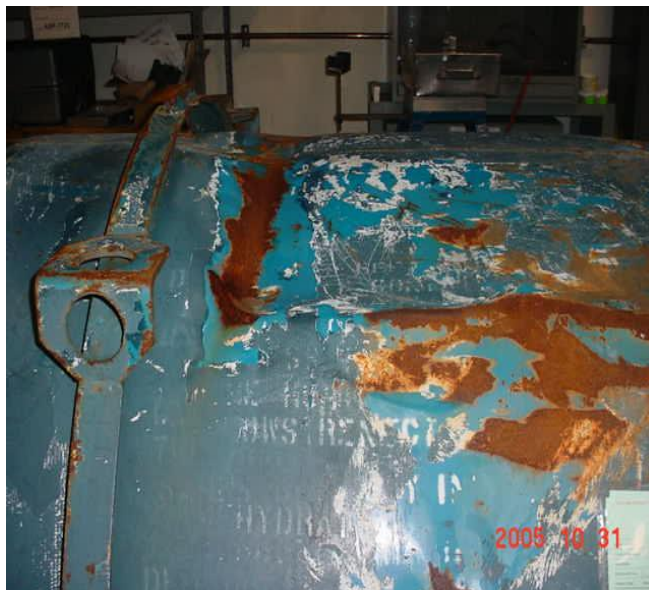
Spec. No:	Rev.	Title	Status	Technician
EA 570-E-05	A	Rear Thrust Bearing (RTB) Modification	NCW	061
EA 570-E-07	D	Engine Corrosion Protection	CW	061
EA 570-E-08	None	570 to 571 Engine Conversion	NCW	061
EA 570-PT-06	B	Modify Vane Case for 571 Configuration	NCW	061
3-IT-95	None	Power Turbine High Temperature Packings	CW	061

POWER TURBINE ROTOR MODIFICATION RECORD

Spec. No:	Rev.	Title	Status	Technician
EA 570-E-05	A	Rear Thrust Bearing (RTB) Modification	NCW	015
EA 570-E-07	D	Engine Corrosion Protection	PCW	015
EA 570-E-08	None	570 to 571 Engine Conversion	NCW	015

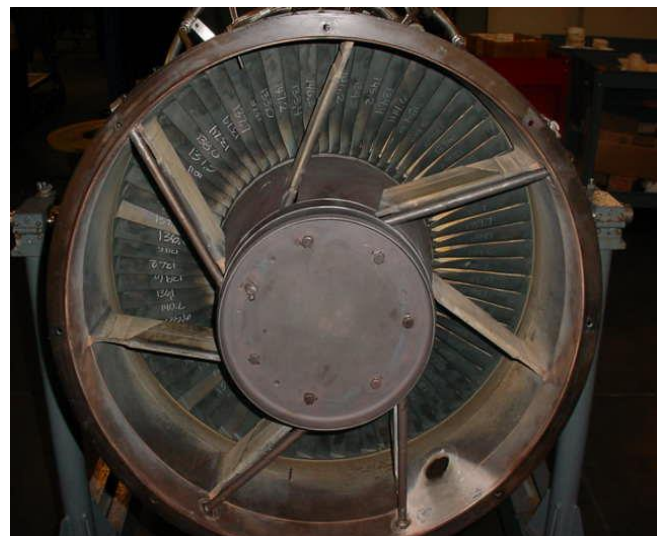
Actual Compliance Codes: PCW—Previously Complied With, CW—Complied with during this visit,
NCW—Not complied with, NA—Not applicable to this engine configuration

Receiving Photos





Shipping Photos after the Repair



Engine Inventory

COMPRESSOR INVENTORY RECORD					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23002341	NE10085	T/M Connector	23002341	NE10085	Reused
23031619	DN10229	T/M Assembly	23031619	DN10229	Reused
23006988	DN10229	T/M Shaft Assembly	23006988	DN10229	Reused
23066970	JJ00001	#1 Bearing	23066970	JJ00121	New
6895725	JJ00001	#1a Bearing	6895725	JJ00006	New
6892032	GG0332	#2 Bearing	23065408	NWE04-1585	New
23052297	FF02108	#1 Accessory Bearing	23052297	AF03107	New
6886706	NWETC01-018	#5 Bearing	6886706	C01034	New
23030405	CX46235	Inlet Housing	23030405	CX46235	Reused
23004668	XX10141	Accessory G/B Assembly	23004668	XX10141	Reused
23002287	X4	G/P Vane Case	23002287	X4	Reused
23066051	MH10440	Combustion Liner	23066051	MH10440	Reused
23037276 23060521	Various	1 st Stage Turbine Vanes	23037276-36 23037276-5	Various	RU/SV/OH
23001172 23005142 23060542	Various	2 nd Stage Turbine Vanes	23060542-11 23001172-9 23001178-1	Various	Reused / New
Not Legible	NSN	Diffuser	Not Legible	NSN	Reused
23037478	AG68786	#1 Fuel Nozzle	23037478	AG68786	Reused
23037478	AG68778	#2 Fuel Nozzle	23037478	AG68778	Reused
23037478	AG68770	#3 Fuel Nozzle	23037478	AG68770	Reused
23037478	AG68771	#4 Fuel Nozzle	23037478	AG68771	Reused
23037478	AG68776	#5 Fuel Nozzle	23037478	AG68776	Reused
23037478	AG68775	#6 Fuel Nozzle	23037478	AG68775	Reused
23037478	AG68777	#7 Fuel Nozzle	23037487	AG68777	Reused
23037478	AG68774	#8 Fuel Nozzle	23037478	AG68774	Reused
23037478	AG68784	#9 Fuel Nozzle	23037478	AG68784	Reused
23037478	AG68779	#10 Fuel Nozzle	23037478	AG68779	Reused
23037478	AG68783	#11 Fuel Nozzle	23037478	AG68783	Reused

COMPRESSOR INVENTORY RECORD (Cont.)					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23037478	AG68781	#12 Fuel Nozzle	23037478	AG68781	Reused
23037478	AG68782	#13 Fuel Nozzle	23037478	AG68782	Reused
23037478	AG68780	#14 Fuel Nozzle	23037478	AG68780	Reused
23037478	AG68787	#15 Fuel Nozzle	23037478	AG68787	Reused
23037478	AG68773	#16 Fuel Nozzle	23037478	AG68773	Reused
Not Received	---	Gas Valve	Not Received	---	---
6896632	186	MOOG (Servo) Valve	6896632	186	Reused
23002328	10100	Press/Scavenge Pump	23050624	10054	Overhauled
6886673	75	C.V.G. R/H Actuator	6886673	0472	Serviceable
6886673	0285	C.V.G. L/H Actuator	6886673	0174	Serviceable
6893592	0521	Vibration Pickup Forward	6893592	0521	Reused
6893592	0675	Vibration Pickup Rear	6893592	2018	Overhauled
Not Received	---	Vibration Pickup Harness	Not Received	---	---
6890194	NDV156	Ejector Shutoff Valve	6890194	NDV156	Reused
23005353	0050	C.I.T. Sensor	23005353	0050	Reused
6896633	FM12545	C.V.G. Filter	6896633	FM12545	Reused
6895733	180105	Speed Pickup N1	6895733	180105	Reused
6896332	B0201 / NSN	Spark Igniters	68896332	B0201 / NSN	Reused

COMPRESSOR ROTOR INVENTORY RECORD					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23008857	DN10748	PT Drive Shaft	23008857	DN10748	Reused
23054531	MM10146	Rotor Drum	23054531	MM10146	Reused
23038306	DU10350	Rear Shaft	23038306	DU10350	Reused
6896615	CG10117	1 st Stage Wheel	6896615	CG10117	Reused
23066971	JJ00055	#3 Bearing	23066971	JJ00046	New
23066970	JJ00039	#4 Bearing	23066970	JJ00126	New
23005066	NSN	Front Shaft	23005066	NSN	Overhauled
23004656	NSN	Inlet Housing Labyrinth Seal (Rotating – Inner)	23004656	NSN	Reused
6886582	NSN	Front Center Bearing Labyrinth Seal (Rotating – Inner)	6886582	NSN	Reused
23005067	NSN	Drive Shaft Seal (Rotating – Outer)	23005067	NSN	Reused

COMPRESSOR ROTOR INVENTORY RECORD					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23006996	CX470996	Front I/S Seal (Rotating – Outer)	23006996	CX47096	Reused
23002343	NSN	Front I/S Seal (Rotating – Inner)	23002343	NSN	Reused
6892017	NSN	Rear I/S Seal (Rotating – Inner)	6892017	NSN	Reused

GAS GENERATOR TURBINE ROTOR INVENTORY RECORD					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23037495	10259	GP Turbine Rotor Balance Assembly	23037495	10259	Reused
23037294	WY10094	1 st Stage Wheel	23037294	WY10094	Reused
23037298	NSN	1 st Stage Wheel and Blade Assembly	23037298	NSN	Reused
23037299	NSN	1 st Stage Blades	23037299	NSN	RU / SV
6896624	WY10468	2 nd Stage Wheel	6896624	WY10468	Reused
23037494	NSN	2 nd Stage Wheel and Blade Assembly	23037494	NSN	Reused
23050663	NSN	2 nd Stage Blades	23050663	NSN	RU / SV
23054570	MW10488	1-2 Spacer	23054570	MW10488	Reused
23037295	007	Front Labyrinth Seal	23037295	007	Reused

POWER TURBINE INVENTORY RECORD					
Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23002539	BF10150	P/T Vane Case	23002539	BF10150	Reused
23005905	#6	Rear Support Assy.	23005905	#6	Reused
Not Disassembled	---	3 rd Stage Vane	6894914	Various	Reused
Not Disassembled	---	4 th Stage Vane	6896259	Various	Reused
NVPN	FF588X9	Thermocouple Terminal Assy.	6895741	FF588X9	Reused
NVPN	NSN	Thermocouple Harness	6896608	NSN	Reused
23051525	FF0H141	#1 Thermocouple	23051525	FF0H141	Reused
23051525	FF2549G	#2 Thermocouple	23051525	FF2549G	Reused
23051525	FF2532G	#3 Thermocouple	23051525	FF2532G	Reused
23051525	FF1169B	#4 Thermocouple	23051525	FF1169B	Reused
23051525	FF0H111	#5 Thermocouple	23051525	FF0H111	Reused
23051525	FF2538G	#6 Thermocouple	23051525	FF2538G	Reused
23051525	FF0H103	#7 Thermocouple	23051525	FF0H103	Reused

POWER TURBINE INVENTORY RECORD (Cont.)

Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
23051525	FF2541G	#8 Thermocouple	23051525	FF2541G	Reused
23051525	FF2534G	#9 Thermocouple	23051525	FF2534G	Reused
6898345	NR202	Speed Pickup Term.	6898345	NR202	Reused
NVPN	NSN	Speed Pickup/Tube	23002452	OK0199	Overhauled
6886707	NSN	Turbine Retain, Bolt	6886707	NSN	Reused
23033460	NSN	Center Oil Stiffening Tube	23033460	NSN	Reused
Not Disassembled	---	Center Oil Tube	Not Disassembled	---	Reused
Not Disassembled	---	P/T Ring Housing Seal	6886552	NSN	Reused
570179	NAC19245	P/T Bearing Cover & Sump Assy.	570179	NAC19245	Reused
NVPN	NVSN	Exit Diffuser Inner Body	23003787	NSN	Overhauled
Not Disassembled	---	P/T Rear Seal (Outer)	23050689	9501450-1	Reused
NVPN	NVSN	Rear Support Inner Cone	6887325	NSN	Overhauled
Not Received	---	Rear Cone	Not received	---	---
23001440	NSN	P/T Bearing Support and Seal Assy.	23001440	NSN	Overhauled
Not disassembled	---	3 rd Stage Seal Support (Outer)	6886504	NSN	Reused
6886561	NU1915	#6 Bearing	6886561	GG0158	New

POWER TURBINE ROTOR INVENTORY RECORD

Removed Component		Nomenclature	Installed Component		Disposition
Part Number	Serial Number		Part Number	Serial Number	
6886510	KK10204	3 rd Stage Wheel	6886510	KK10204	Reused
6894918	NSN	3 rd Stage Wheel & Blade	6894918	NSN	RU / SV
23002315	KK10156	4 th Stage Wheel	23002315	KK10156	Reused
23002313	NSN	4 th Stage Wheel & Blade	23002313	NSN	RU / SV
23005583	0010298	Rotor Shaft	23005583	0010298	Reused
6886521	8	4 th Stage Seal Support (Outer)	6886521	8	Reused
6887392	NSN	4 th Stage Rear Seal (Inner) (Non RTB Only)	6887392	NSN	Reused
NA	---	4 th Blade Retainer & Plate Retainer (RTB)	NA	---	Non RTB
6886512	10103	3 rd to 4 th Stage Seal (Inner)	6886512	10103	Reused
6886835	NSN	Rear Support Sump Seal	6886835	NSN	Overhauled

Disposition Codes:

RU = Reused | **SV** = Serviceable | **OH** = Overhauled | **NVPN** = No Visible Part Number | **NVSN** = No Visible Serial Number |
NA = Not Applicable

[illegible]