

TECHNICAL MANUAL

AVIATION UNIT AND
AVIATION INTERMEDIATE
MAINTENANCE MANUAL

ENGINE, GAS TURBINE
MODEL T55-L-712
NSN 2840-01-030-4890

HEADQUARTERS, DEPARTMENT OF THE ARMY

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Technical Manual
NO. 55-2840-254-23

HEADQUARTERS
DEPARTMENT OF THE ARMY
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Aviation Unit and Aviation Intermediate Maintenance Manual
ENGINE, GAS TURBINE
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REPORTING ERRORS AND RECOMMENDING IMPROVEMENTS

You can help improve this manual. If you find any mistakes, or if you know of a way to improve these procedures, please let us know. Mail your letter or DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2 located in the back of this manual directly to: Commander, US Army Aviation and Missile Command, ATTN: AMSAM-MMC-MA-NP, Redstone Arsenal, AL 35898-5000. A reply will be furnished to you. You may also provide DA Form 2028 information to AMCOM via e-mail, fax, or the World Wide Web. Our fax number is: DSN 788-6546 or Commercial 256-842-6546. Our e-mail address is: 2028@redstone.army.mil. Instructions for sending an electronic 2028 may be found at the back of this manual immediately preceding the hard copy 2028. For the World Wide Web use: <https://amcom2028.redstone.army.mil>.

OZONE DEPLETING CHEMICAL INFORMATION

This document has been reviewed for the presence of class I ozone depleting chemicals. As of the basic through change 05, dated 30 September 1996, all references to Class I ozone depleting chemicals have been removed from this document by substitution with chemicals by the Engineering, Environment, and Logistics Oversight Office that do not cause atmospheric ozone depletion.

DISTRIBUTION STATEMENT A: Approved for public release; distribution is unlimited

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NOTE

This manual is printed in four volumes as follows:
TM 55-2840-254-23-1, consisting of Warning Pages, Table of Contents, Chapter 1, and Alphabetical Index.
TM 55-2840-254-23-2, consisting of Warning Pages, Table of Contents, Chapter 2, and Alphabetical Index.
TM 55-2840-254-23-3, consisting of Warning Pages, Table of Contents, Chapter 3 through 5 and Alphabetical Index.
TM 55-2840-254-23-4, consisting of Warning Pages, Table of Contents, Chapter 6 through 9, Appendixes A through F, Glossary, and Alphabetical Index.

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HOW TO USE THIS MANUAL

OVERVIEW

This information gives a general description of the entire manual and how to use it along with the repair parts and special tools list (TM 55-2840-254-23P). If you cannot find information, you cannot do the job. Learning how to use this manual can help. Check how the manual is put together and how its system works.

1. DESCRIPTION OF MANUAL

This manual has nine chapters and six appendixes. Each chapter is divided into sections. Each section in Chapter 1 is divided into paragraphs or tasks. Each section in Chapters 2 thru 9 is divided into tasks. The tasks tell you what you need and how to do any job. The paragraphs have specific information you will need to know. The appendixes have general information you will need to know. They list references, expendable supplies and materials etc.

A. Chapters. Chapters divide the manual into usable engine maintenance groups. They align with standard groupings shown in the MAC chart. Refer to Appendix B.

B. Sections. Sections divide the chapters into smaller groups. They have information about the components of parts for which the chapter is titled. They align with components shown in the MAC chart. Refer to Appendix B.

C. Paragraphs/Tasks. Paragraphs make up some of the sections in Chapter 1. They contain specific information about the engine. Tasks make up some of the sections in Chapter 1 and the sections in Chapters 2 thru 9. It is the tasks that have the information you need to do any job. The upper heading after the task number is the task name. It tells the job to be done in the task. The task heading at the top of each page specifies the task to be performed and the lowest maintenance level authorized to perform that task. Tasks to be accomplished by the Aviation Intermediate Maintenance level only will be reflected by the term (AVIM) at the end of the task heading. If the term (AVIM) is not at the end of the task heading, then either the Aviation Unit or Aviation Intermediate Maintenance (AVUM) or (AVIM) level can accomplish that task. All paragraphs and tasks are numbered. This helps you find what you need when you need it. USE THE INDEX TO FIND THE PARAGRAPH OR TASK YOU NEED. DO NOT USE PAGE NUMBERS. Paragraphs and tasks are numbered as follows:

(1) Two-element numbers are used as shown in the examples:

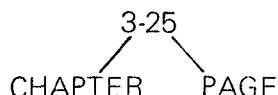


(2) The first number is the number of the chapter. The second number is the paragraph or task in that chapter. The two elements are separated by a dash.

HOW TO USE THIS MANUAL (Continued)

D. Page Numbers. Pages are numbered by order of chapters, from front to back of manual. They are used as follows:

- (1) Two-element numbers are used as shown in the example:



- (2) The first number is the number of the chapter. The second number is the page in that chapter.

E. Initial Setup Tables. An initial setup table is the first part of every task in the manual. It lists information you will need to know before you can do the job. How to prepare the work area, what tools will be needed, and other critical information are listed when they apply. The following headings are used when they apply.

- (1) Applicable Configuration. If the task does not apply to all engine configurations, different configurations covered by the same procedure will be brought to your attention.

(2) Tool. Tools, kits, or shop sets needed to do the task are listed here. If tools from your repairman's tool kit are needed, the kit is listed. Individual tools from your shop set are listed, as needed, by name, type, and size. Tools you need that are not in the kit or set, are listed by name, type, and size. Special tools and test and support equipment are listed by a T-number. Find these items in Table 1-1.

(3) Materials. This heading lists all expendable items and support materials (things you normally use up doing a job). These are things like solvent, rags, grease, safety wire, etc. They are listed by an E-number; example: Grease (E23). Find these items in Appendix C.

(4) Parts. This heading lists all mandatory replacement parts (parts you must replace if you expose or remove them during the task). These are things like gaskets, packings, cotter pins, lockwashers, etc. They are listed by RPSTL nomenclature.

(5) Personnel Required. This heading lists the people needed to do the job. They are identified by their MOS. The heading identifies the MOS and the recommended skill level to accomplish the subject task. The assigned skill level should not be construed as the only skill level authorized to accomplish that task. The Maintenance Allocation Chart (MAC) (Ref. Appendix B) assigns maintenance functions to the authorized maintenance level without regard to the MOS skill level. When more than one of any MOS is needed, the number needed is shown in parentheses. The text will tell you when the additional MOS is needed.

(6) References. This heading lists related tasks and TM's you will need to do the job. The task steps tell you when these tasks and TM's are needed.

(7) Equipment Condition. This heading lists all the things to be done before you start the job. To help, the number of the task that tells you how to do them is given when applicable.

HOW TO USE THIS MANUAL (Continued)

NOTE

All tasks covered in this manual are off helicopter tasks. If a task is an off engine task, it will be brought to your attention under "Equipment Condition." Example: "Off Engine Task. "

(8) General Safety Instructions. Safety precautions that must be observed when you are doing the job are described under this heading. Warnings also include basic first aid instructions.

F. Locator Illustrations. When needed (for removal, installation and other procedures) a locator illustration is included on or facing initial setup pages. They show you the area of the engine to be worked on. Parts involved in the task are called out.

G. Illustration Arrows. You will find five types of arrows used. They areas shown below:



Locator arrow used to show parts that cannot be easily seen or to indicate area of engine being worked on.



Index arrow used to identify parts on artwork.



Direction arrow used to indicate position; i.e., fwd, aft.



Movement arrow used to indicate direction of movement.



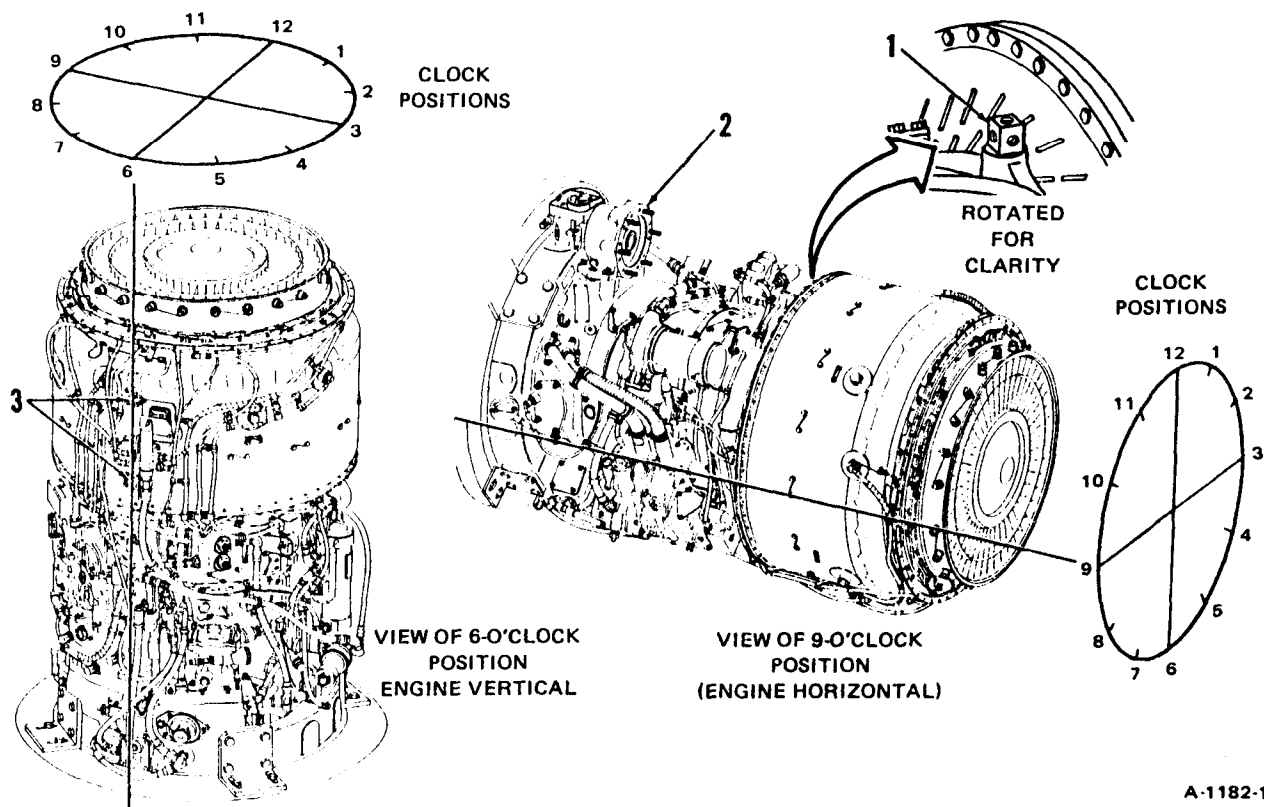
Movement arrow used to indicate direction of rotation.

H. Procedures. Step by step procedures tell you how to do the job. They are arranged in logical sequence to help you get the job done efficiently.

HOW TO USE THIS MANUAL (Continued)

I. Use of Clock Positions. Many procedures contain references to or views of clock positions. Comparing engine to face of clock is an easy way to locate specific engine areas. To help find clock positions on the engine, remember the following:

- (1) Clock position is always determined from rear of engine.
- (2) Once a clock position is determined from rear of engine, visualize that clock position along entire length of engine.
- (3) Hoist adapter (1) and starter drive assembly (2) are mounted at the 12-o'clock position.
- (4) Two fuel drain valves (3) are mounted at the 6-o'clock position.
- (5) Some procedures show engine mounted vertical in maintenance stand. This does not change the method for finding clock positions on the engine.



HOW TO USE THIS MANUAL (Continued)

J. Appendix A – References. This appendix lists all referenced publications needed to perform the maintenance procedures in this manual.

K. Appendix B – Maintenance Allocation Chart (MAC). This appendix consists of four sections as follows:

Section I – Introduction. This section is a summary of what is in the MAC.

Section II. This section is the MAC. The MAC assigns maintenance functions in accordance with the Three Levels of Maintenance concept for Army Aviation. The MAC has six columns, containing the following information:

Columns 1 and 2 – Functional Groups. These columns identify maintenance significant components, assemblies, subassemblies, and modules.

Column 3 – Maintenance Function. This column lists the maintenance functions to be performed on the items listed in column 2.

Column 4 – Maintenance Categories. The maintenance categories (levels) AVUM, AVIM, and DEPOT are listed with individual columns. These columns identify the maintenance level at which each maintenance function is to be performed.

Column 5 – Tools and Equipment. This column lists the reference code identifying the tool or test equipment required, as listed in Section III.

Column 6 – Remarks. Remarks identified by an alphabetical code, where applicable, are listed in Section IV and identified in column 6.

Section III – Tool and Test Equipment Requirements. This section consists of five columns, containing the following information:

Tool or Test Equipment Reference Code. This column lists the reference code listed in Column 5 – Tools and Equipment in the MAC.

Maintenance Category. This column lists the maintenance category (level) authorized to use the tool or test equipment.

Nomenclature. This column lists the nomenclature of the tools and test equipment.

National/NATO Stock Number. This column lists the stock number applicable to each tool or test equipment.

Tool Number. The tool number is listed to aid in identifying the tool or test equipment.

Section IV – Remarks. This section has two columns, containing the following information:

Reference Code. This column contains alphabetical codes or numbers in parentheses corresponding to the codes appearing in the applicable columns in the MAC.

Remarks/Notes. This column contains the actual notes cross-referenced by the reference codes to the MAC.

HOW TO USE THIS MANUAL (continued)

L. Appendix C – Expendable Supplies and Materials List. This appendix lists all expendable supplies and materials called out in the manual. The following columns are provided.

(1) Item Number. This is the E-number assigned to the expendable item. It is referred to in the detail procedures. Example: “Use cleaning solution (EI 1).”

(2) National Stock Number. This is the national stock number assigned to the item. Use it to request or requisition the item.

(3) Description. This column lists the Federal name and, if required, a description to identify the item. The last line for each item shows the part number followed by the Federal Supply Code for Manufacturer (FSCM) in parentheses, if applicable.

M. Appendix D – Wiring Diagrams. This appendix contains the engine wiring diagram. Use this appendix to help you understand the description of the engine electrical system.

N. Appendix E – Illustrated List of Manufactured Items. This appendix lists and illustrates any parts or tools you may have to make to do a job.

O. Appendix F – Abbreviations. This appendix lists abbreviations you will find in the manual.

P. Glossary. Definitions of terms you find in the manual are listed here to help you.

Q. Index. This appears at the end of the manual. It lists all subjects in the manual by alphabetical order. Items are listed as follows:

(1) Each paragraph/task number is listed with the subject it applies to:

Example:

	<u>Para./</u> <u>Task</u>	<u>Page</u>
Fuel Boost Pump Assembly		
Clean	6-10	6-42
Inspect	6-11	6-43
Install	6-13	6-48
Package	6-15	6-56
Preserve	6-14	6-55
Remove	6-9	6-39
Repair	6-12	6 44

HOW TO USE THIS MANUAL (Continued)

(2) Some tasks are listed by the job to be done. The subjects or components are listed under them.

Example:

	Para./ <u>Task</u>	<u>Page</u>
Remove		
Accessory Gear Assembly (AVIM)	5-8	5-45
Accessory Gearbox Assembly	5-1	5-3
Air Diffuser Assembly (AVIM)	2-36	2-351
Anti-Icing Air Gallery Cover.	2-14	2-51

Check over the index and see how it can work for you. It can make finding information easy.

R. Part Numbers. Part numbers are not listed in this manual except where absolutely needed for clarity. You can find the part number you need in the Repair Parts and Special Tools List (RPSTL) (TM 55-2840-264-23P) .

2. HOW TO FIND WHAT YOU NEED

A. General Information (Troubleshooting).

(1) Look at the "INDEX." Find "Symptom Index." The "INDEX" gives the paragraph number for the symptom index. Go to the Symptom Index.

(2) Find your symptom in the "Symptom Index." Next to the symptom is the page number of the troubleshooting procedure that will help you solve your problem. Turn to the troubleshooting procedure page.

(3) Follow the troubleshooting procedure until you find the problem. The troubleshooting procedure gives you the task number of the maintenance procedure needed to fix the engine. Turn to that task.

(4) Follow the maintenance procedure and complete all work. Check again and make sure you are right. When the job is done, recheck that the trouble has been corrected.

B. Part Numbers. To find a part number go to the RPSTL (TM 55-2840-254-23P). Find the "How To Locate Repair Parts" paragraph in the introduction. It will tell you how to find your part number.

C. Tasks. To find any task, use the "INDEX." Find the subject you want. The "INDEX" gives you the task number you want.

HOW TO USE THIS MANUAL (Continued)

3. HOW TO PREPARE FOR A TASK

Read the initial setup page carefully before starting. It tells you what you will need and what you have to know to start the job. DO NOT START A JOB UNTIL:

- You know what is needed
- You have the things you need
- You understand what to do

A. If a tool has a T-number in front of it, go to the Special Tools and Test and Support Equipment List in Table 1-1. Read down the far left-hand column to your T-number. This is the tool you need for your task.

B. If an expendable material has an E-number in front of it, go to the Expendable Supplies and Materials List in Appendix C. Read down the Item Number column to your E-number. This is the expendable you need for your task.

C. If parts are listed, they can be drawn from supply. Before you start the job, check and make sure you can get the needed parts. Part numbers are listed in TM 55-2840-254-23P.

D. Check for personnel required.

E. If preliminary procedures are listed under "Equipment Conditions," BE SURE THE LISTED JOBS ARE DONE; then do this job.

4. HOW TO DO THE JOB

Before starting, read the entire task. Familiarize yourself with the entire procedure before you begin the task. As you read, remember the following:

A. PAY ATTENTION TO WARNING, CAUTIONS AND NOTES.

B. Always follow standard maintenance practices (Chapter 1, Section XIII).

C. When values are underlined or followed by the word INSPECT, an inspector must OK the completed step.

D. Major steps and key words are printed in bold type for experienced repairers.

E. A GLOSSARY is provided. It lists the special words and terms used in this manual and gives their meaning. Use it. It may help you understand the instructions.

COMPRESSOR SECTION – MAINTENANCE INSTRUCTIONS

CHAPTER OVERVIEW

This chapter contains maintenance procedures for the compressor section. It is divided into the following sections and tasks:

<u>SECTION</u>	<u>TASK NO.</u>	<u>TITLE</u>	<u>PAGE</u>
1		INTERSTAGE AIR-BLEED ACTUATOR – MAINTENANCE PROCEDURES	
	2-1	Remove Interstate Air-Bleed Actuator	2-5
	2-2	Disassemble Interstate Air-Bleed Actuator	2-12
	2-3	Clean Interstate Air-Bleed Actuator	2-14
	2-4	Inspect Interstate Air-Bleed Actuator	2-16
	2-5	Repair Interstate Air-Bleed Actuator	2-18
	2-6	Assemble Interstate Air-Bleed Actuator	2-19
	2-7	Install Interstate Air-Bleed Actuator	2-21
	2-8	Adjust Interstate Air-Bleed Actuator	2-28
II		COMPRESSOR BLEED BAND – MAINTENANCE PROCEDURES	
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	2-10	Clean Compressor Bleed Band	2-44
	2-11	Inspect Compressor Bleed Band	2-45
	2-12	Repair Compressor Bleed Band	2-46
	2-13	Install Compressor Bleed Band	2-47
III		ANTI-ICING AIR GALLERY COVER – MAINTENANCE PROCEDURES	
	2-14	Remove Anti-Icing Air Gallery Cover	2-51
	2-15	Clean Anti-Icing Air Gallery Cover	2-55
	2-16	Inspect Anti-Icing Air Gallery Cover	2-58
	2-17	Repair Anti-Icing Air Gallery Cover	2-60
	2-18	Install Anti-Icing Air Gallery Cover	2-62
IV		COMPRESSOR HOUSING – MAINTENANCE PROCEDURES	
	2-19	Remove Upper Compressor Housing	2-71
	2-20	Remove Lower Compressor Housing	2-104
	2-21	Clean Compressor Housing	2-144
	2-22	Inspect Compressor Housing	2-146
	2-23	Repair Compressor Housing	2-147
	2-24	Install Upper Compressor Housing	2-149
	2-25	Install Lower Compressor Housing	2-178

<u>SECTION</u>	<u>TASK NO.</u>	<u>TITLE</u>	<u>PAGE</u>
V		STATOR VANE ASSEMBLIES – MAINTENANCE PROCEDURES	
	2-26	Remove Stator Vane Assemblies	2-219
	2-27	Clean Stator Vane Assemblies	2-228
	2-28	Inspect Stator Vane Assemblies	2-230
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VI		COMPRESSOR ROTOR BLADES – MAINTENANCE PROCEDURES	
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	2-32	Clean Compressor Rotor Blades	2-278
	2-33	Inspect Compressor Rotor Blades	2-281
	2-34	Repair Compressor Rotor Blades	2-312
	2-35	Install Compressor Rotor Blades	2-317
VII		AIR DIFFUSER ASSEMBLY – MAINTENANCE PROCEDURES	
	2-36	Remove Air Diffuser Assembly (AVIM)	2-351
	2-37	Clean Air Diffuser Assembly (AVIM)	2-361
	2-38	Inspect Air Diffuser Assembly (AVIM)	2-363
	2-39	Repair Air Diffuser Assembly (AVIM)	2-371
	2-40	Repair Air Diffuser Assembly	2-375
	2-41	Install Air Diffuser Assembly (AVIM)	2-383
VIII		NO. 2 BEARING PACKAGE – MAINTENANCE PROCEDURES	
	2-42	Remove No. 2 Bearing Package (AVIM)	2-395
	2-43	Disassemble No. 2 Bearing Package (AVIM)	2-402
	2-44	Clean No. 2 Bearing Package (AVIM)	2-411
	2-45	Inspect No. 2 Bearing Package (AVIM)	2-414
	2-46	Assemble No. 2 Bearing Package (AVIM)	2-417
	2-47	Install No. 2 Bearing Package (AVIM)	2-427
IX		OUTPUT SHAFT SEAL AND HOUSING ASSEMBLY – MAINTENANCE PROCEDURES	
	2-48	Remove Output Shaft Seal and Housing Assembly	2-431
	2-49	Clean Output Shaft Seal and Housing Assembly	2-436
	2-50	Inspect Output Shaft Seal and Housing Assembly	2-437
	2-51	Repair Output Shaft Seal and Housing Assembly	2-438
	2-52	Install Output Shaft Seal and Housing Assembly	2-447

<u>SECTION</u>	<u>TASK NO.</u>	<u>TITLE</u>	<u>PAGE</u>
X		INLET HOUSING COVER ASSEMBLY – MAINTENANCE PROCEDURES	
	2-53	Remove Inlet Housing Cover Assembly (AVIM)	2-455
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	2-55	Inspect Inlet Housing Cover Assembly (AVIM)	2-459
	2-56	Repair Inlet Housing Cover Assembly (AVIM)	2-460
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XI		OUTPUT SHAFT SUPPORT HOUSING – MAINTENANCE PROCEDURES	
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	2-59	Disassemble Output Shaft Support Housing (AVIM)	2-470
	2-60	Clean Output Shaft Support Housing (AVIM)	2-478
	2-61	Inspect Output Shaft Support Housing (AVIM)	2-481
	2-62	Assemble Output Shaft Support Housing (AVIM)	2-484
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Section I. INTERSTAGE AIR-BLEED ACTUATOR - MAINTENANCE PROCEDURES

2-1 REMOVE INTERSTAGE AIR-BLEED ACTUATOR-MAINTENANCE PROCEDURES
P/N 2-200-071-54 INSTALLED

2-1

INITIAL SETUP**Applicable Configurations:**

All

Tools:Powerplant Mechanic's Tool Kit,
NSN 5180-00-323-4944**Materials:**

None

Personnel Required:

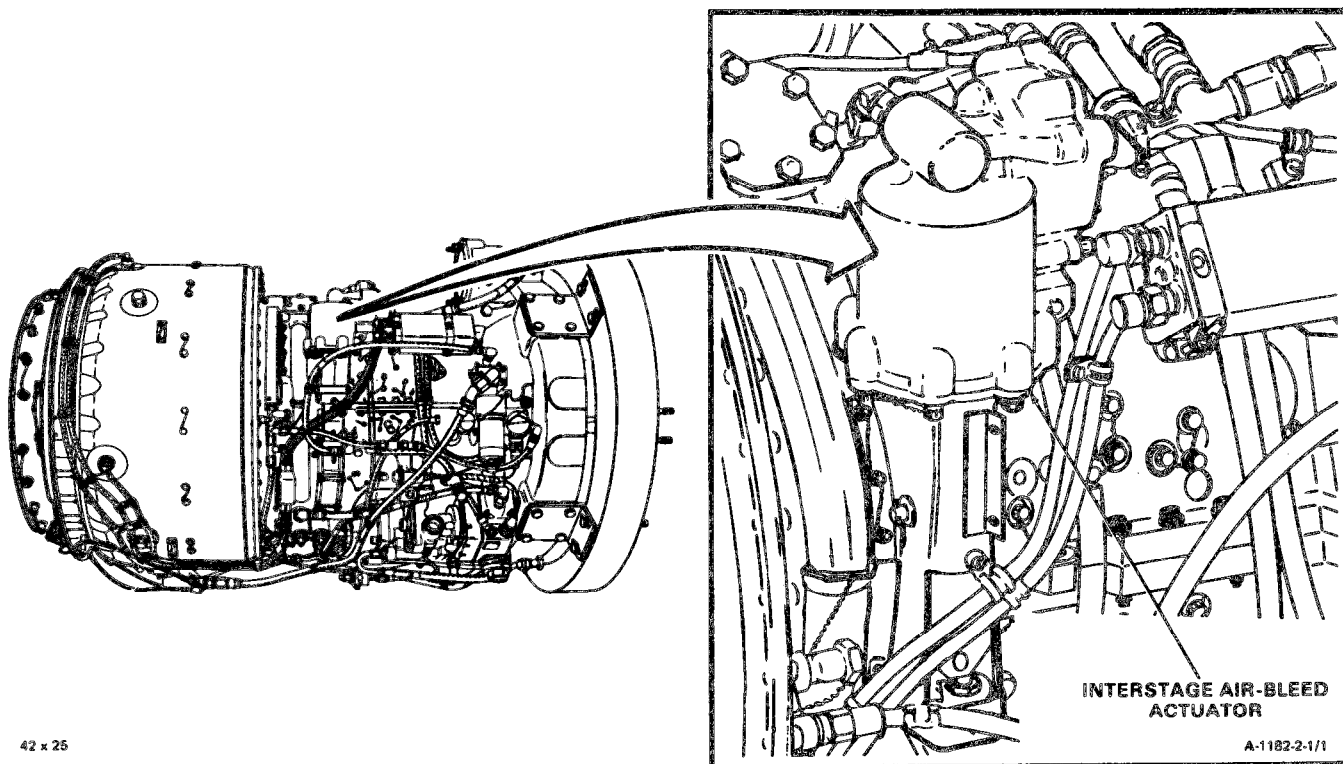
68B10 Aircraft Powerplant Repairer

Equipment Condition:

Oil Cooler Assembly Removed (Task 8-5)

General Safety Instructions:**WARNING**

The ignition exciter stores very high and possibly fatal voltage. Use extreme care when working around ignition exciter. Serious injury could result if exciter is accidentally grounded. Do not probe inside of putpit receptacles with fingers or metal object. Discharge exciter only with insulated screwdriver. In case of shock or injury, get medical attention



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