

TURBINE WI DEMO (assembly)

Summary:	Turbine assembly Work Instructions
Work type:	Assembly
Role:	General Operative
Exp time:	5 hours 27 minutes
Work cell:	Hangars Nr. 17 - Nr. 29
Pre job:	C3D-WI-TURBINE-DEMO-01
Post job:	C3D-WI-TURBINE-DEMO-03
Work order:	Refer to document SRT-987 Rev. 4
Revision:	A01

PREREQUISITES**REQUIRED PARTS**

Part number	Description	Quantity
M-001	Reductor Module	1
KOR-001	Bolt	1
M-002	Forward SUMP	1
M-003-001	Compressor lower case	1
M-003-000-001	1 Stage compressor blades	1
RING_1	Compressor ring 1	1
	Compressor upper case	1
M-003-003	Compressor rotor	1
T_5	T 5 Rotor crane adaptor	1
M-004	Combustion Chamber	1
M-004-005	Fuel Nozzles	1
M-004-004	Fuel Pipeline	1
T-001	Cooling System Pipeline	1
M-005-005	LPT rotor	1
T_4	T-4	1
M-005-002-002	LPT lower case	1
M-005-000-003	3 Stage LPT blades	1
M-005-003	AFT frame	1
M-006	Outlet Nozzle Module	1
STARTER	Starter	1
RC-002	Reductor Cover (lower)	1
RC-001	Reductor Cover (upper)	1
IN-001	Inlet Nozzle Front	1
IN-002	Inlet Nozzle Rear	1
COMPRESSOR_WAY	Compressor module Way	1
WAY	LPT way	1
CC_WAY	Combustion chamber way	1

Part number	Description	Quantity
TURB_WAY	Turbine way	1
SHP_3	Turbine Way Bolt	1
T_1	T-1	1
CRANE_1	Crane 1	1
T_2	T-2	1
T_3	T-3 chain	1

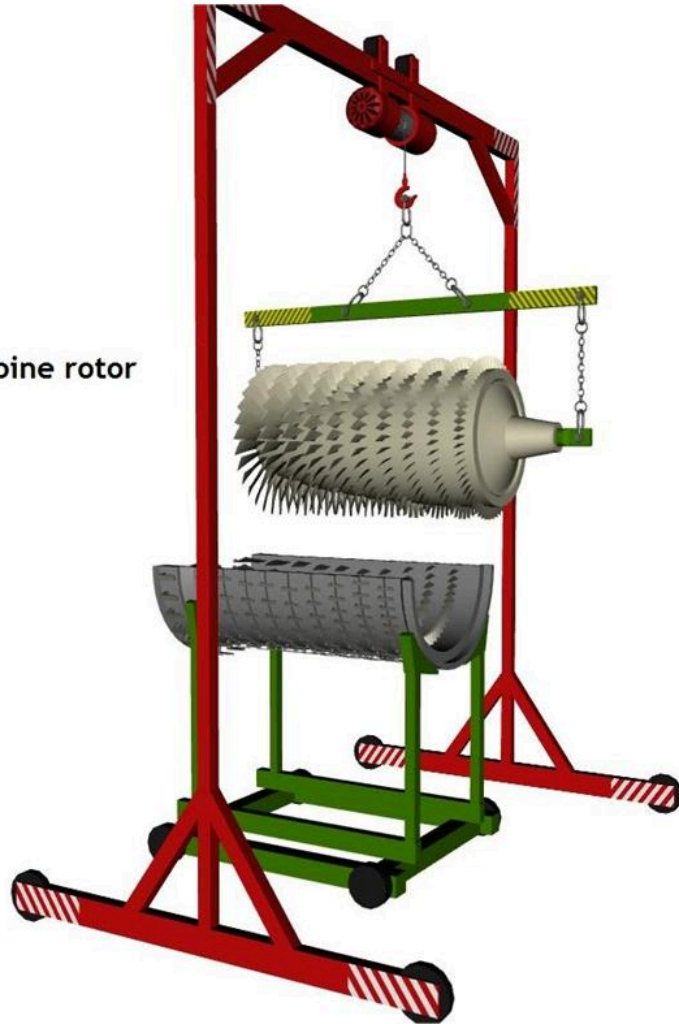
JOB

TASK 1

Bring in the [Compressor Lower Case](#) with [Compressor blades](#) on the [Compressor module Way](#).

Install [Compressor Rotor](#).

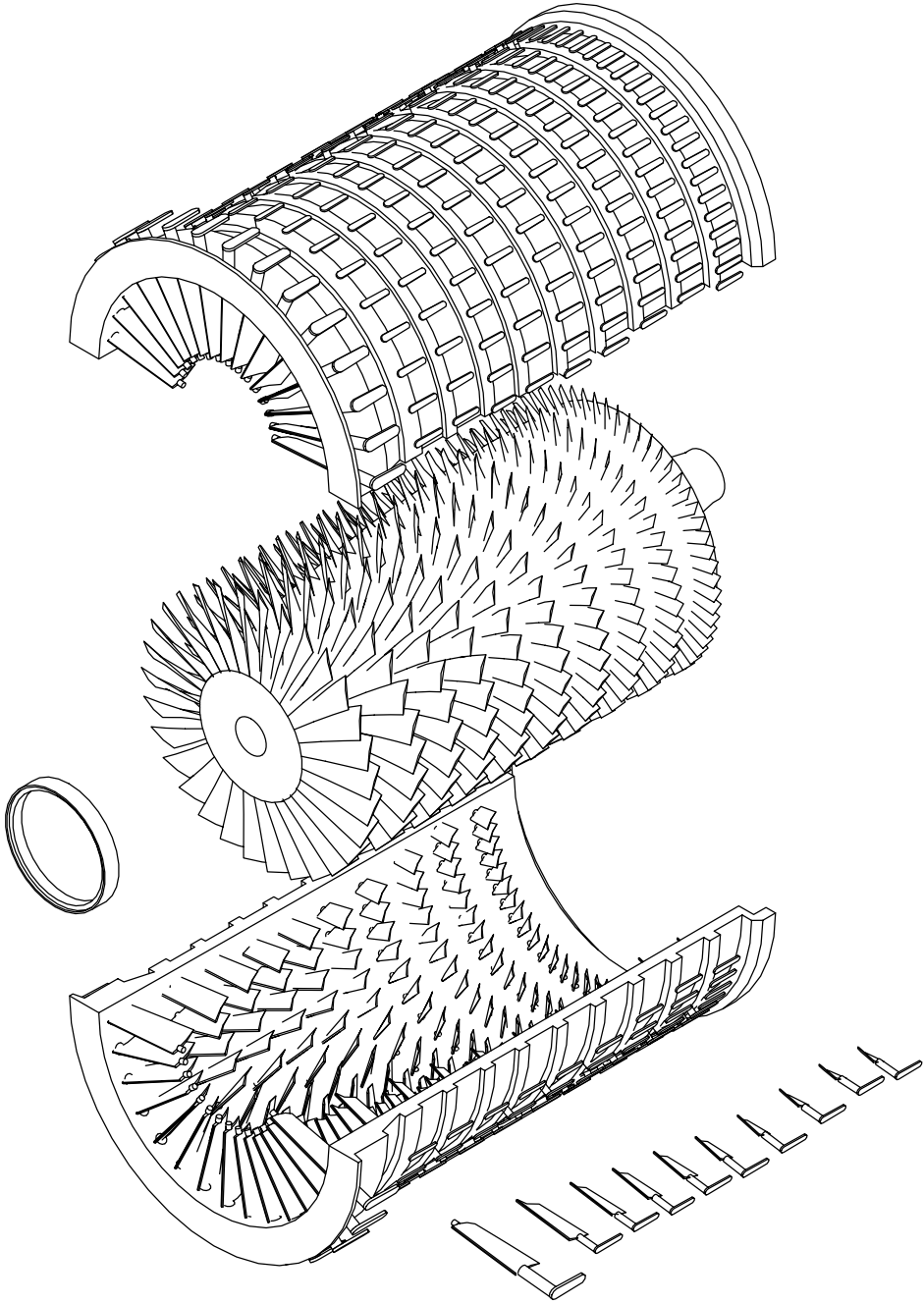
Install the turbine rotor



Remove the [T-5](#). Remove the [Crane](#).

Install the [Compressor Upper Case](#).

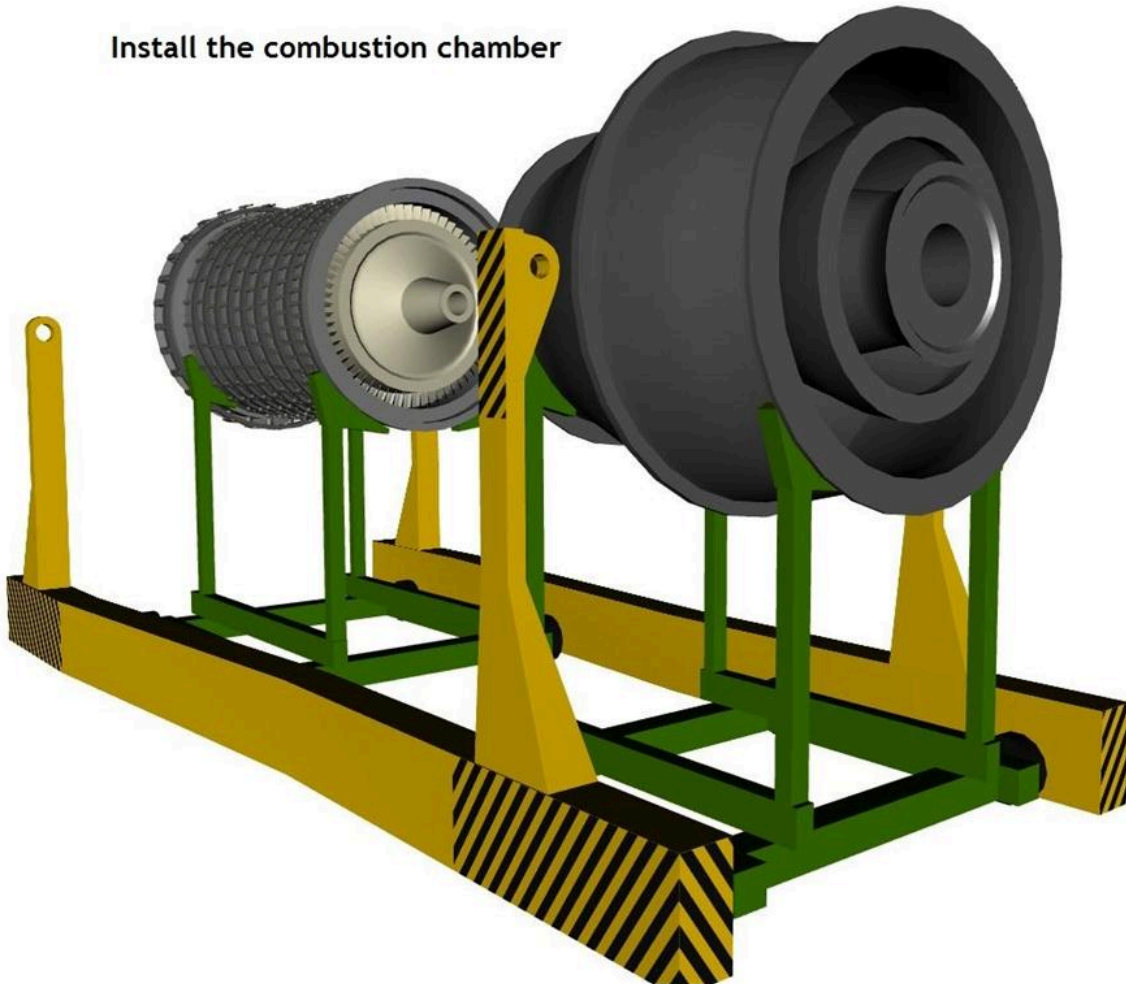
Install the [Compressor Rings](#).



TASK 2

Attach the [Combustion Chamber](#), using [Combustion Chamber Way](#).

Install the combustion chamber



TASK 3

Place assembled modules in the [Turbine Way](#).

Bring in the [LPT Lower Case](#) with [LPT Blades](#) on the [LPT Way](#).

Bring in the [Low Pressure Turbine rotor](#), using the [Crane](#) and [T-4](#).

Install the [LPT Rotor](#) on the [LPT Lower Case](#) with [LPT Blades](#).

Remove the [T-4](#). Remove the [Crane](#).

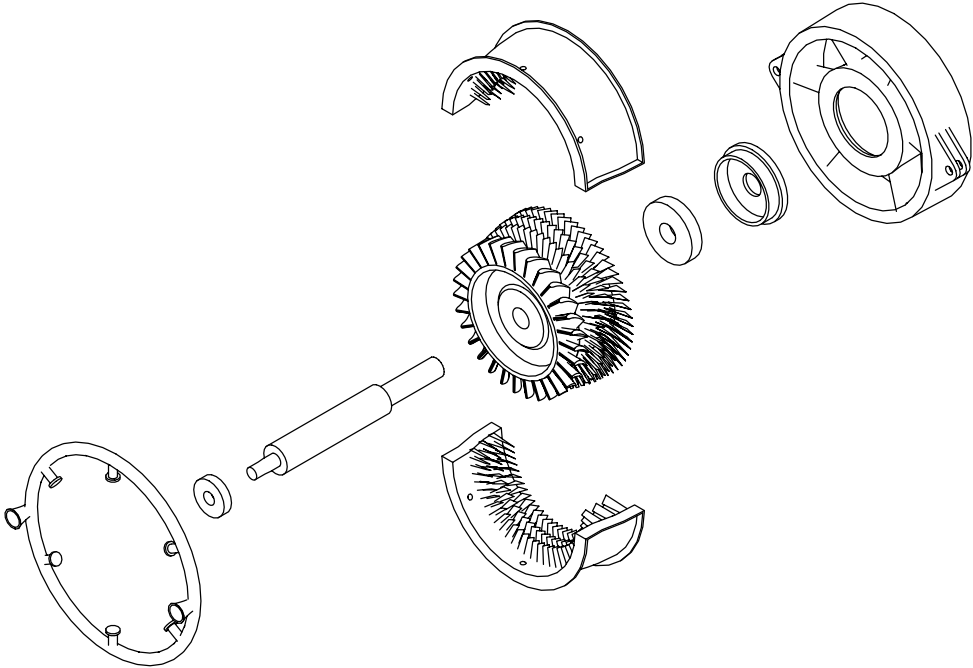
Install the [LPT Upper Case](#).

Move the [LPT Way](#) and attach the [Low pressure turbine](#) to the assembly.

Bring in the [AFT Frame](#), using the [Crane](#) and the [Chain T-3](#).

Install the [AFT Frame](#) using the [Turbine Way Bolts](#).

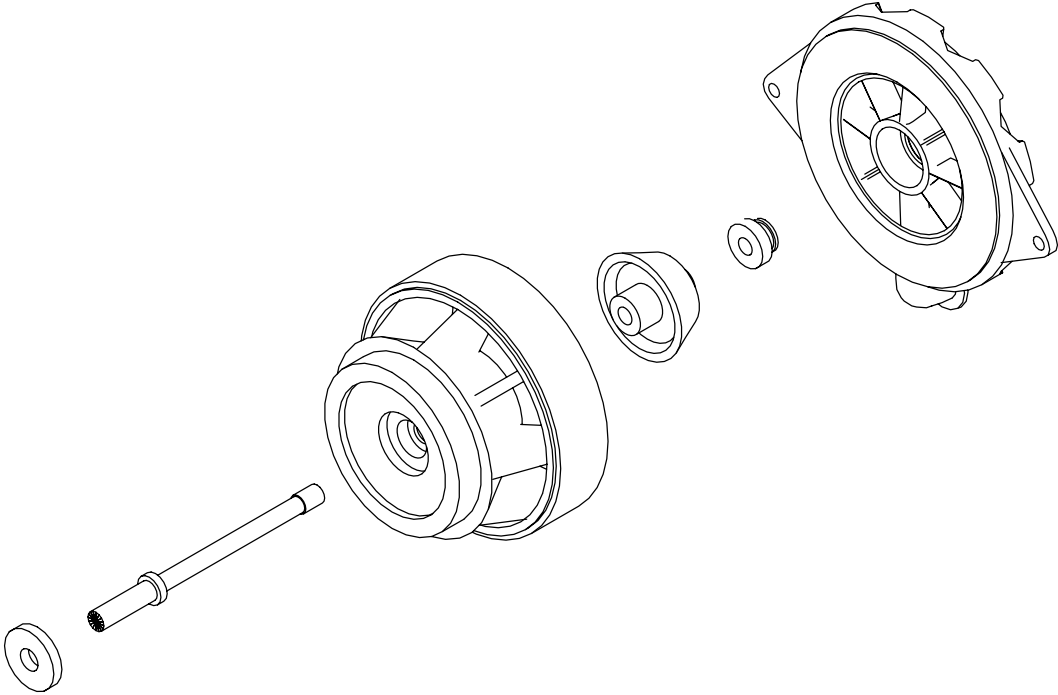
Remove the T-3 and the Crane. Remove the LPT Way.



TASK 4

Bring in the [Forward SUMP Assembly](#), using the [Crane](#) and [T-2](#).

Attach the **Forward SUMP** to the turbine assembly using Turbine Way **Bolts**.



Remove [T-2](#) and the [Crane](#). Remove the [Combustion Chamber Way](#). Remove the [Compressor Way](#).

TASK 5

Install the [Outlet Nozzle Module](#).

Install the [Inlet Nozzle Rear](#).

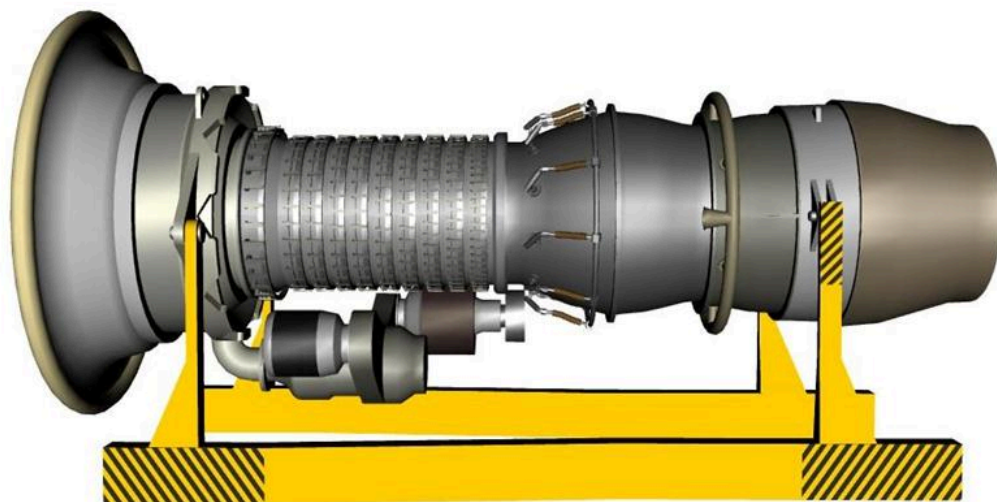
Install the [Inlet Nozzle Front](#).

TASK 6

Install the [Cooling System Pipeline](#).

Install [Fuel Pipeline](#) together with preinstalled [Fuel Nozzles](#).

Install the fuel system



Install the [STARTER](#).

TASK 7

Bring in the [Reductor Module](#), using the [Crane](#) and [T-1](#)

Attach the [Reductor Module](#).

Install 10 [bolts](#).

Remove [T-1](#) and the [Crane](#).

Install the [Lower Reductor Cover](#).

Install the [Upper Reductor Cover](#).

Assembled Engine turbine

