



6876872HT – Compressor Rear Bearing Seal

For Warranty & Model Eligibility, Please visit us at www.hyetechllc.com

Subject: Removal, cleaning, inspection/rework/repair, and installation procedures for 6876872HT – Rotating Labyrinth Seal.

Compliance: Any time the compressor rotor is disassembled.

Notes: Refer to OEM’s published engine operation data.

Technical aspects are FAA approved

Standard shop practices may be substituted for materials and procedures referenced herein provided they have been demonstrated as effective and safe for use with these parts or their OEM and other FAA approved equivalents.

1.0 REMOVAL

- 1.1 Remove the compressor assembly in accordance with the manufacturer’s instructions.
- 1.2 Disassemble compressor rotor assembly in accordance with the manufacturer’s instructions.
- 1.3 Remove rotating labyrinth seal using 6795590 puller or equivalent.

2.1 CLEANING

- 2.2 Wash with petroleum solvent, P-D-680, Type 2 dry cleaning petroleum solvent or equivalent, and a soft bristle brush.

3.1 INSPECTION

- 3.2 Inspect and repair or replace the seal per Table 1:



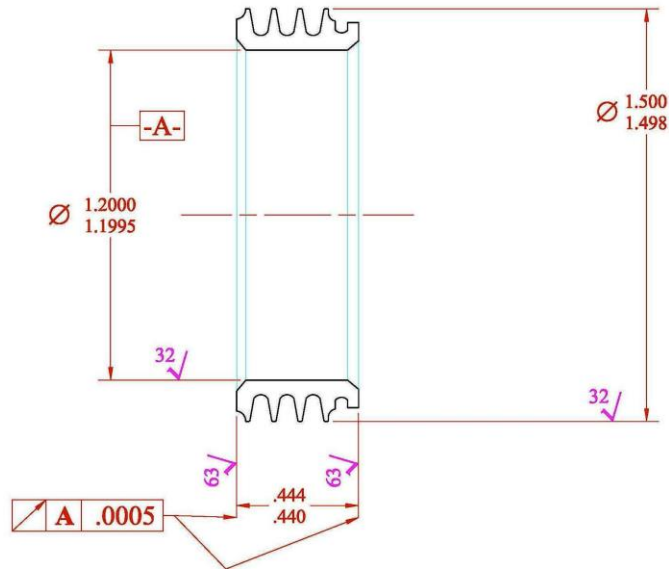
24834 Avenue Rockefeller
 Phone: (818) 291-0338
 Email: info@hyetechllc.com

IFCA-C-002

Valencia, CA 91355
 Fax: (818) 291-0339
 Web: www.hyetechllc.com

Table 1

Condition	Service Limit	Repair Limit	Corrective Action
Cracks (Visual)	None permitted.	No Repair.	Replace seal
Nicks, dents, and scratches. (Visual)	Minor nicks, dents, and scratches on tapered faced of seal knives less than 0.002 in. deep.	Local areas up to 0.25 in. total length and 0.010 in. max depth on each knife after blending. Clean up of individual damage areas may exceed max depth limit as long as equivalent total area is not exceeded.	Blend with a fine file or grind with a fine stone (FED-SS-S-736, Type 1). Final polish is a radial direction with abrasive paper (No. 320 grit) to remove blending marks.
Pickup, rough or rolled edges on seal knives (Visual)	None permitted.	Not Applicable.	Blend with a fine file or grind with a fine stone (FED-SS-S-736, Type 1). Final polish is a radial direction with abrasive paper (No. 320 grit) to remove blending marks.
Seal knives min dia.	1.4965 in. min dia. Plus blend area of the item stated above on each knife. Refer to Figure 1.	No Repair	Replace seal.
End Surfaces	Both end surfaces must be square to the axis within .0005 in. max total. Refer to Figure 1.	No Repair	Replace Seal

Figure 1


4.0 REPAIR

4.1 None

5.0 INSTALLATION

5.1 Assemble compressor rotor in accordance with the manufacturer's instructions until acceptable rotor run-out is accomplished.

Heat the rotating seal to 500° F max for no longer than 25 minutes. Install rotating labyrinth seal on the impeller shaft using 6798803 drift or equivalent.