

Restricted

Air Force Head-Quarters

NENE INSTRUCTION NO. 13

Technical Order

EXPANSION CHAMBERS - OUTLET ELBOW
BOLTS - TIGHTENING PROCEDURE

Introduction

1. To ensure that the spherical sealing ring is properly bedded, and that undue tightness of the nuts, which would cause fracture of the flange during hot running conditions, is prevented, the following procedure is to be adopted.

Instruction

2. Tighten the nuts to a torque of 35 in. lb. The nuts must then be released, relieving the bolts of tension. Again tighten the nuts to finger tightness only. Increase the tension by a further constellation, then insert split pin and lock.

3. This instruction cancels and supersedes D.T.S. Special Instruction Nene No./26.

Reference : File R.A.A.F. 150/4/8818, C.A.C. Turbine
Engineering Bulletin No. 19.

Date of Issue : 11th August, 1954.

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