

Restricted

10/10/51
CE/ED

Air Force Head-Quarters

NENE INSTRUCTION NO.5

Technical Order

Application: Nene 2-VH
Engines

TORCH IGNITER BOSS - OUTER AIR CASING - SALVAGE

Introduction

1. This Instruction specifies a method of repair for stripped or damaged setscrew (CA.20137) threads in torch igniter bosses welded into numbers 3 and 8 outer air casing assemblies (BK.4270, BK.4274). If any one of the four setscrew threads in the torch igniter boss is stripped or damaged, all threads are to be repaired as described in paragraphs 2 and 3.
2. Tap threads to the next oversize required to clean up and select a KL.351 (standard, +4, +8 or +62 oversize) stud to give a .003"L to .006"L fit; modify as shown on Drawing B11313 Figure 2 attached.
3. Fit stud, holding a projection of .600" and low temperature braze into position from inside of casing. Outer face of boss must be free from braze metal.
4. On completion of repair assemble gasket (BK.1347) and torch igniter assembly (BK.8105), and secure with existing grover washer (KJ.4508) and new nut (KJ.4310), as shown on Drawing No. B11313 Figure 1 attached.

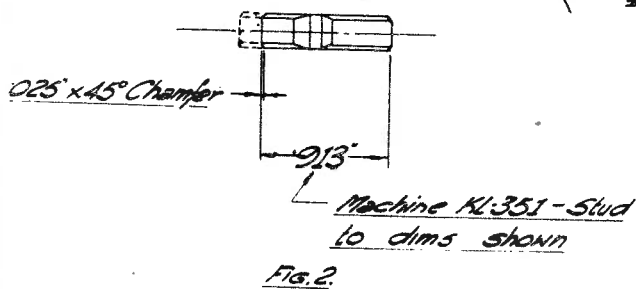
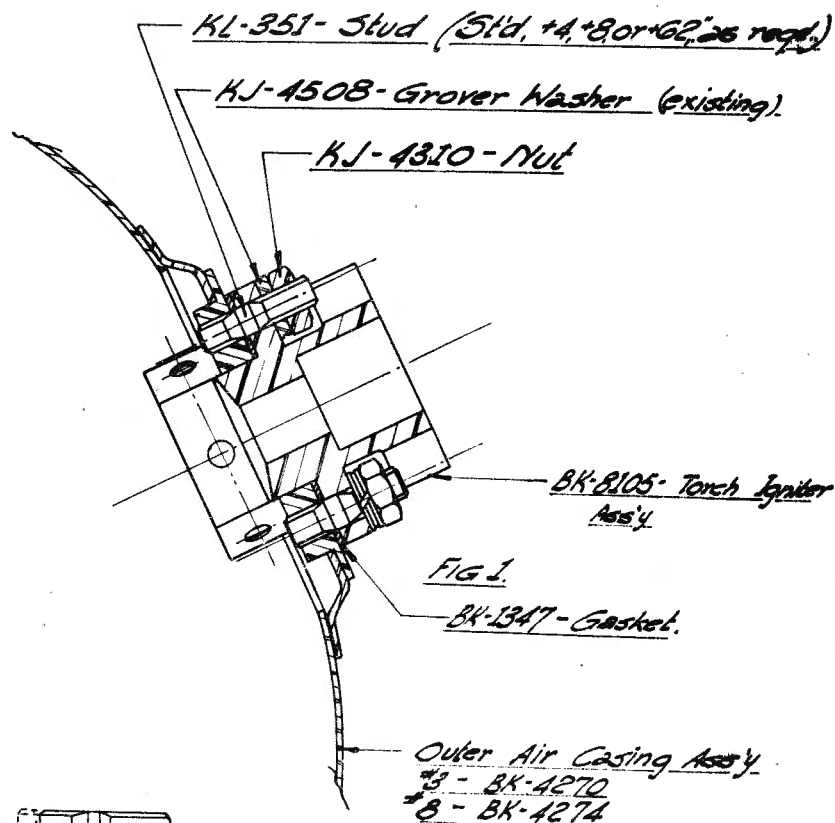
References: R.A.A.F. File 150/4/8124;
C.A.C. Salvage Scheme SL-447.

Drawing: B11313 attached.

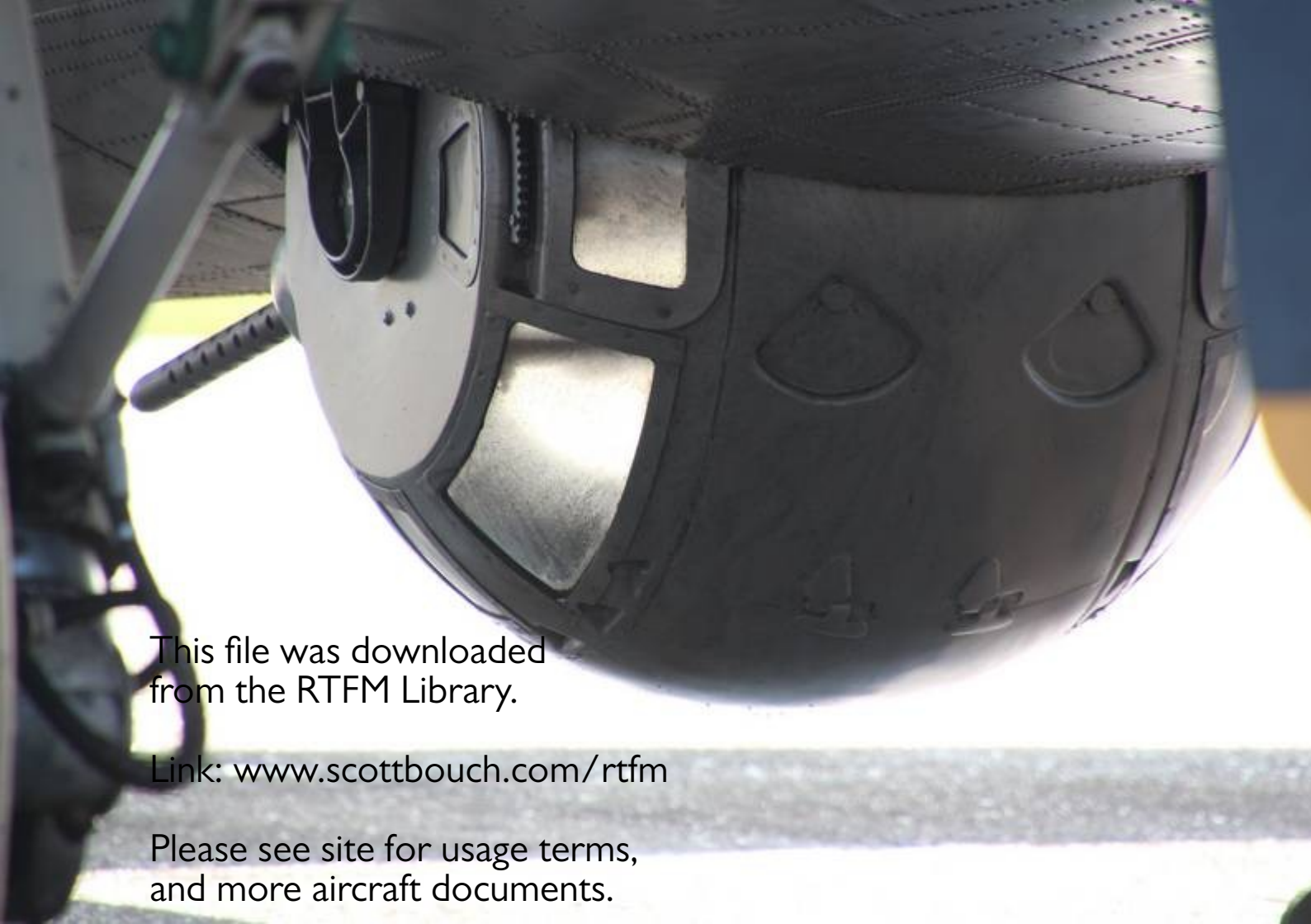
Date of Issue: 30th March, 1951.

DO NOT SCALE

ISSUE NO.	DATE	ALTERATION	D. I. L.	INITIALS	APPROVED



REFERENCE		ISSUED BY		TITLE	
		DIRECTORATE OF TECHNICAL SERVICES RAAF		TORCH IGNITER BOSS - OUTER AIR CASING - SALVAGE	
LIMITS UNLESS STATED	MATERIAL			COMPONENT OF	
DECIMALS $\pm .010$	SPEC.			MACHINE	
FRACTIONS $\pm \frac{1}{32}$	TREATMENT			ENGINE	NONE - 2VH
ANGLES $\pm \frac{1}{2}^\circ$	FINISH			TECH. ORDER	NONE INSTRUCTION 3
SURFACE FINISH	SCALE			DRAWING NO.	B-11313
AUSTRALIAN STANDARD	DRAWN	MARTIN	APPROVED		DRWG. A SIZE
ENG. DRWG. PRACTICE A.S. 621	TRACED		CHECKED		



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