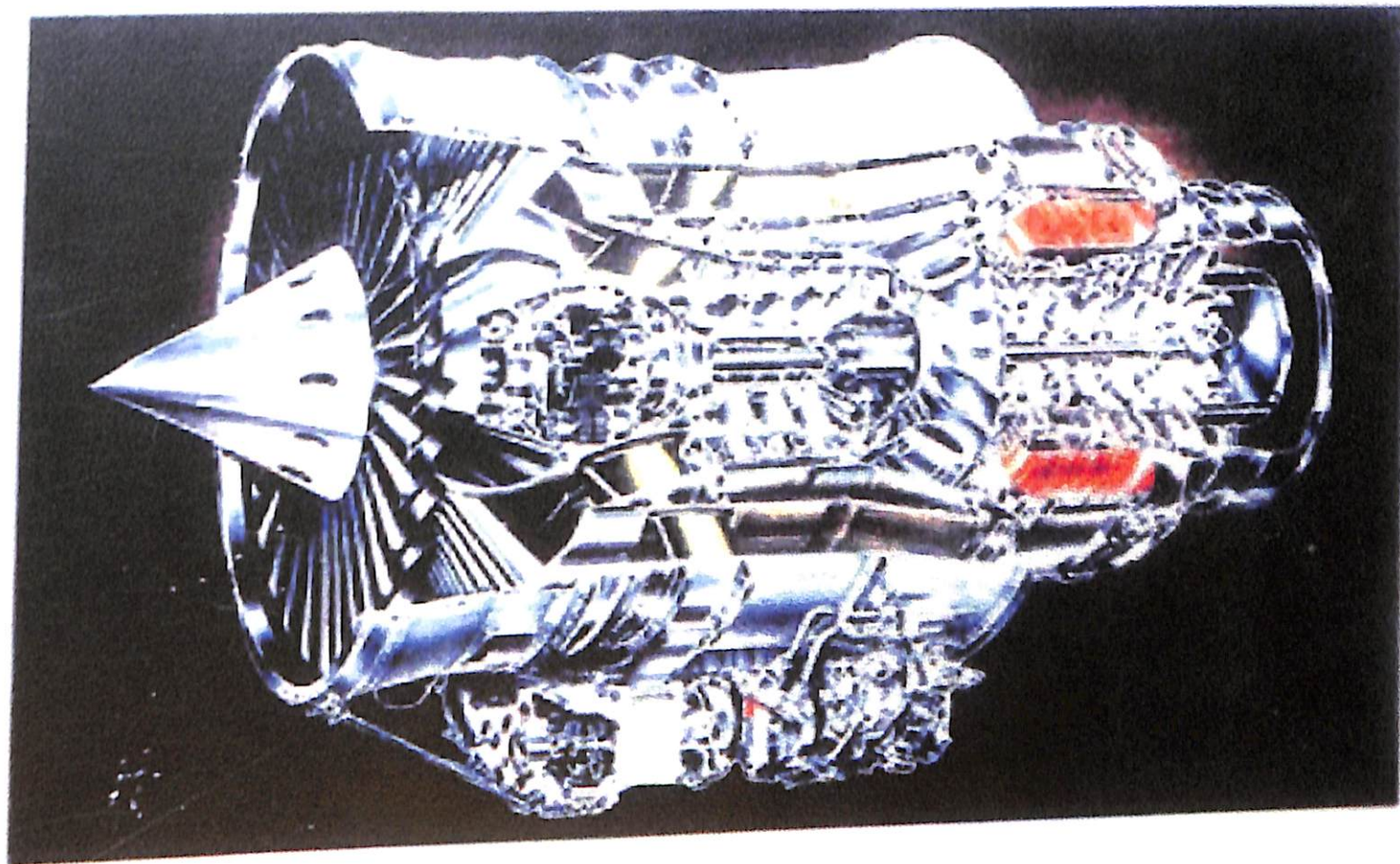
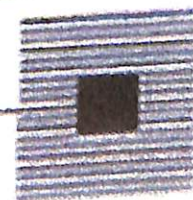


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LH



TFE731



ENGINE LOG BOOK

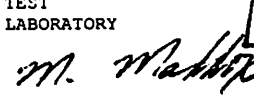
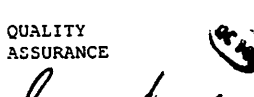
Honeywell

HONEYWELL International Inc.
Engines & Systems
111 S. 34th Street
Phoenix, Az. 85034-2892

S/N P137179

P13107-2F3

Honeywell Engine TFE731-40BR-1B
Honeywell Part Number 3062075-1
ENGINE SERIAL NUMBER P137179

SEA-LEVEL U.S. STANDARD DAY STATIC CONDITIONS				SEA-LEVEL 103.0 F STATIC CONDITIONS				
PARAMETER	REQUIRED	TEST VALUE	REQUIRED	TEST VALUE	REQUIRED	TEST VALUE	REQUIRED	TEST VALUE
NET THRUST LBS	3850.	3850.	3850.	3850.	3850.	3850.	3850.	3850.
THRUST SPECIFIC FUEL CONSUMPTION LB/HR-LB	0.446	0.433	0.446	0.433	0.469	0.458	0.469	0.458
HIGH PRESSURE TURBINE DISCHARGE TEMPERATURE, F	1528.		1528.		1693.		1693.	
ENGINE SPEED, N1, RPM	18464.		18464.		19225.		19225.	
ACCEPTANCE TEST CONDUCTED WITH AIR-OIL COOLERS INSTALLED. NO PERFORMANCE ADJUSTMENTS HAVE BEEN MADE.				SIGNATURE				DATE
N1 COMPENATOR PART NO. 3060735-4								 2/07/14
								 2/7/14

D3C-A1630 , REV.

Honeywell Engine TFE731-40BR-1B
Honeywell Part Number 3062075-1
ENGINE SERIAL NUMBER P137179

TEST DATE: 02/07/2014

AUTOMATIC PERFORMANCE RESERVE PERFORMANCE AT TAKEOFF SEA LEVEL STATIC CONDITIONS			
TEST VALUES			
POWER SETTING	AMBIENT TEMP. DEG. C/F	REQUIRED THRUST LBS	
APR	44.4/112.0	3850	
SIGNATURE		DATE	
ACCEPTANCE TEST CONDUCTED WITH AIR-OIL COOLERS INSTALLED: NO PERFORMANCE ADJUSTMENT HAS BEEN MADE.		TEST LABORATORY	
		QUALITY ASSURANCE	

07/24/12 6.77 6.77 07/24/12 03:52:42 02/07/14

ENGINE DATA

ENGINE DATA

Model No. TFE731-40BR-1B

Part Number 3062075-1

Serial No. P137179

Net Thrust - Lbs. Takeoff 3850

Maximum Continuous 3500

Specific Fuel Consumption - Lb/Hr. 0.446

High Pressure Turbine Discharge Temperature

Deg F -----

Deg C -----

Fuel - See Aircraft Flight Manual

Oil - See Aircraft Flight Manual

TOTAL ENGINE WEIGHT 873 **LBS.**

Honeywell Engine TFE731-40BR-1B
Honeywell Part Number 3062075-1
ENGINE SERIAL NUMBER P137179

[illegible]

DSC-A1630 , REV.

Honeywell Engine TFE731-40BR-1B
Honeywell Part Number 3062075-1
ENGINE SERIAL NUMBER P137179

TEST DATE: 02/07/2014

AUTOMATIC PERFORMANCE RESERVE PERFORMANCE AT TAKEOFF SEA LEVEL STATIC CONDITIONS			
TEST VALUES			
POWER SETTING	AMBIENT TEMP. DEG. C/F	REQUIRED THRUST LBS	
		THRUST LBS	
		N2 RPM (MAX VALUE 31,200)	N1 RPM (MAX VALUE 19,611)
APR	44.4/112.0	3850	3850.
			30671.
			19377.
ACCEPTANCE TEST CONDUCTED WITH AIR-OIL COOLERS INSTALLED: NO PERFORMANCE ADJUSTMENT HAS BEEN MADE.		SIGNATURE	DATE
		TEST LABORATORY	2/07/14
		QUALITY ASSURANCE	2/2/14

07/24/12 6.77 6.77 07/24/12 03:52:42 02/07/14

CONFIGURATION REPORT

Unison Industries
7575 Baymeadows Way, Jacksonville, FL 32256 USA
Phone: 904-739-4201 Facsimile: 904-739-4006

CERTIFICATE FOR SEALED RADIOACTIVE SOURCE

Model number: 9060280-1 (Honeywell P/N 3061186-1)
Serial number: J13460385
Radionuclide: ⁸⁵Kr
Description: Beta radiation source
Gas mixture containing ⁸⁵Kr in sealed glass/metal envelope
ISO Classification: ISO/99/C11111
Estimated content activity: 215.4 kBq (107.7 kBq/spark gap)
Radiation output:
Quantity measured: Air kerma rate at 0.1 m from the source
Results: < 0.002 µGy/hr (minimum level detectable by dose rate meter used)
Test for freedom from surface contamination: N/A, inert gas
Test for freedom from leakage:
Method: ISO 9978 Hot-liquid bubble test (See 6.2.2)
Results: Passed Date: 12/10/2013 (mm/dd/yyyy)

This certificate and the information contained herein complies with the requirements of ISO 2919

Bruce D. Markert

Bruce D. Markert Radiation Safety Officer

Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
1	3070685-11	VALVE, PRESSURE LIM	U	18899	1			1.0
2	3070580-4	BODY, VALVE - PCD LIMITER	C					1.0
2	3070581-1	BELLOWS REGULATING,PCD LIMITER	R	131070005889				1.0
2	3070583-1	RETAINER,SPRING	B					1.0
2	3070586-1	SLEEVE SPACER	B					1.0
2	3070587-1	STRAP RETAINER	-					1.0
2	3070596-1	SEAT VALVE,BALL	C					1.0
2	3070872-1	SPRING, HELICAL, COMPRESSION	-					1.0
2	3070878-1	SPRING,HELICAL COMP	B					1.0
2	S21025-3	PLATE,IDENTIFICATION	A					1.0
2	3070584-1	LUG RETAINER,SPRING	B					1.0
1	394476-2	VALVE OUTL,FLOW DIVIDER	B	3723	1			1.0
1	3060150-3	SEAL, SEGMENTED		13-169020-00200				1.0
1	3070816-14	SENSOR, P2T2		1316901724314				1.0
1	3060116-1	COUPLING SFT RIGID			P4575791			1.0
1	3060155-6	FAN ROTOR ASSEMBLY	F	13-162246-00731	P4810083			1.0
2	3060154-3	FAN BLADE			13-181879-48C			12.0
2	3060154-3	FAN BLADE			13-181879-47C			12.0
2	3060154-3	FAN BLADE			13-181879-35C			1.0
2	3060154-3	FAN BLADE			13-181879-34C			5.0
2	3060287-2	DISK, FAN	F	13-162246-00731	131034289			1.0
3	3900358-111	DISK, FAN, ULTRASONIC SHAPE	A	13-162246-00731				1.0
1	3060156-2	SPINNER ENG INL		13-5060-00130	13-5060-267			1.0
1	3060270-3	HOUSING, SEAL NO. 3			13-162545-000			1.0
1	3060272-3	GEAR HLCL SUN	E	13-1034-39349	P4571238			1.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
2	3060272-751	GEAR HELICAL SUN	C	13-1034-39349	5018252817			1.0
3	9-8925	6.00 CBS600 AMS6255BAR STOCK						5.8
1	3060709-4	COOLER FUEL OIL	D	3747	2			1.0
1	3060720-5	TANK, OIL, ENGINE		14-5040-80001				1.0
1	3060735-4	COMPENSATOR		98/309700388				1.0
1	3060757-3	HARNESS, WIRING		13-150262-34903				1.0
1	3061186-1	IGNITION UNIT		J13460385				1.0
1	3071870-3	SHAFT SHOULDERED			13-169019-673			1.0
1	3072653-1	HOUSING, TOWER SHAFT			13-100159-323			1.0
1	3074672-2	SEAL AIR OIL			13-162313-062			1.0
1	70060003-1	PUMP, FUEL - MOTIVE FLOW		13-30003-00089				1.0
1	3060022-930	PLANET GEAR ASSEMBLY		LA049396				1.0
2	3060121-8	CARRIER, PLANETARY REDUCTION GEAR		1216224301181	13-3300-317			1.0
2	3060129-7	PLANETARY GEARSHAFT	A	13P62074				1.0
3	3060255-1	BEARING, ROLLER PLANET-FWD		13-162255-21320				1.0
3	3060256-1	BEARING, ROLLER PLANET-AFT		13-162255-26555				1.0
3	3060273-2	GEAR HELICAL PLANETARY	E	13-1034-38364	P4387006			1.0
4	3060273-751	GEAR HELICAL PLANETARY	D	13-1034-38364	LN131034115			1.0
5	9-8915	3.00 CBS600 AMS-6255 BAR STOCK						5.0
2	3060129-7	PLANETARY GEARSHAFT	A	14P64228				1.0
3	3060255-1	BEARING, ROLLER PLANET-FWD		13-162255-21339				1.0
3	3060256-1	BEARING, ROLLER PLANET-AFT		13-162255-29661				1.0
3	3060273-2	GEAR HELICAL PLANETARY	E	13-1034-39952	P4615081			1.0
4	3060273-751	GEAR HELICAL PLANETARY	D	13-1034-39952	LN131034277			1.0
5	9-8915	3.00 CBS600 AMS-6255 BAR STOCK						5.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
2	3060129-7	PLANETARY GEARSHAFT	A	14P64229				1.0
3	3060255-1	BEARING, ROLLER PLANET-FWD		13-162255-21340				1.0
3	3060256-1	BEARING, ROLLER PLANET-AFT		13-162255-29671				1.0
3	3060273-2	GEAR HELICAL PLANETARY	E	13-1034-39957	P4615081			1.0
4	3060273-751	GEAR HELICAL PLANETARY	D	13-1034-39957	LN131034277			1.0
5	9-8915	3.00 CBS600 AMS-6255 BAR STOCK						5.0
2	3060129-7	PLANETARY GEARSHAFT	A	14P64230				1.0
3	3060255-1	BEARING, ROLLER PLANET-FWD		13-162255-21343				1.0
3	3060256-1	BEARING, ROLLER PLANET-AFT		13-162255-29673				1.0
3	3060273-2	GEAR HELICAL PLANETARY	E	13-1034-39959	P4615081			1.0
4	3060273-751	GEAR HELICAL PLANETARY	D	13-1034-39959	LN131034277			1.0
5	9-8915	3.00 CBS600 AMS-6255 BAR STOCK						5.0
2	3060129-7	PLANETARY GEARSHAFT	A	14P64231				1.0
3	3060255-1	BEARING, ROLLER PLANET-FWD		13-162255-28173				1.0
3	3060256-1	BEARING, ROLLER PLANET-AFT		13-162255-29678				1.0
3	3060273-2	GEAR HELICAL PLANETARY	E	13-1034-39969	P4615081			1.0
4	3060273-751	GEAR HELICAL PLANETARY	D	13-1034-39969	LN131034277			1.0
5	9-8915	3.00 CBS600 AMS-6255 BAR STOCK						5.0
2	3060212-1	BEARING, BALL-LP-THRUST		13-162255-33023				1.0
2	3000005-64	WASHER SPRING TNSN			13-151587-101			1.0
1	3060022-980	BYPASS DUCT ASSEMBLY		LA049392				1.0
2	109696-6-1	VALVE, SOLENOID-CONTROLLER	K	14189				1.0
2	3060769-1	VALVE, OIL REDUCTION		13-182215-12202				1.0
2	160554-5	COOLER, OIL, SURGACE - OUTLINE	J	3691	1			1.0
3	MFG3-6706	CORE AY		13100253				1.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
4	R2722-150	.003XMASTER 4047F AMS4185			4910703486			1.0
2	160554-6	COOLER, OIL, SURFACE - OUTLINE	K	3736	2			1.0
3	MFG3-6706	CORE AY		13100256				1.0
2	3061300-8	DUCT, BYPASS - LOWER		13-181898-01048	13-181898-024			1.0
2	3061300-7	DUCT, BYPASS - UPPER		13-181898-01015	13-181898-024			1.0
2	160552-4	COOLER, OIL, SURFACE - OUTLINE	M	2278				1.0
3	157024-7	CORE ASSEMBLY, OIL COOLER	R	13100002				1.0
1	3060188-7	SHAFT AND HOUSING ASSY, FAN SUPPORT	N	LA049393				1.0
2	3061510-1	BEARING, ROLLER		13-162111-19834				1.0
2	3075657-1	RUNNER ASSY SEAL NO1		13-162397-03940				1.0
2	3060130-1	WASHER SPRING TNSN			12-192298-734			1.0
2	3060162-4	HOUSING ASSEMBLY, FAN SUPPORT			13-3300-298			1.0
2	3060180-2	SHAFT FAN	B	1216205002342	P4425693			1.0
3	3060180-901	MACHINED FORGING SHA		1216205002342	5017178480			1.0
2	3060257-1	BEARING BALL NO2		13-162111-08687				1.0
2	3060277-4	GEAR HELICAL RING	A	1215611408533	P4571600			1.0
3	3060277-751	GEAR HELICAL RING	B	1215611408533	LN131034081			1.0
4	3900214-115	FORGING GEAR RING	D	1215611408533				1.0
2	3060457-1	SEAL, HYDRODYNAMIC CARBON, NO. 1		14-152826-46981				1.0
1	3060022-925	POWER SECTION ASSEMB		LA049391				1.0
2	3060601-2	GEAR, EXCITER			13-163248-001			1.0
2	3060714-5	SENSOR, SPEED (N1 MONOPOLE)		14910300006				1.0
2	3060718-4	LEAD, N1 MONOPOLE		13-150262-34938				1.0
2	3060722-11	LEAD IGNITER		S13360003				1.0
2	3060722-12	LEAD IGNITER		S13320009				1.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
2	158465-6	VALVE OIL TEMP CONT	L	14058	1			1.0
2	3071740-1	NUT RND SLOTTED			13-162313-106			1.0
2	3060022-907	PLENUM ASSEMBLY		LA049399				1.0
3	3060584-1	RETAINER VANE HPT			13-108737-004			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00636	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00637	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00646	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00647	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00649	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00650	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00651	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00652	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00653	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00654	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00655	13-163498-006			1.0
3	3060540-2	NOZZLE FUEL INJ		13-163498-00656	13-163498-006			1.0
3	3060318-8	DIFFUSER, CENTRIFUGAL COMPRESSOR, HP			14-3300-008			1.0
3	3060534-4	CASE, COMBUSTION CHAMBER		13-3300-02955	13-3300-349			1.0
4	MS20605R3W2	MS20605R3W2 Per NASM20605 RIVET			010006246650			80.0
4	MS20470AD6-6	RIVET, SOLID, UNIVERSAL HEAD			010004909875			1.0
4	MS21062-3	NUT PLATE			010007113195			2.0
4	MS21076-3	NUT PLATE			010007751050			38.0
4	3060545-2	BOLT, D HEAD			010008088619			40.0
4	3072443-935	SUPPORT						1.0
4	VZOREK 28	SAMPLE TH3.18 INCO 718			6004248082			1.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
4	3060534-937	BOSS			010008322389			3.0
4	3060534-977	CLIP			010008010470			1.0
4	3060534-979	GUSSET, Find Number 10/MBP			010006542385			2.0
4	3072443-927	MACHINED BOSS			010008432019			1.0
4	3060534-907.51	WELDED SUBASSY			6004443780			1.0
4	3060534-991.51	WELDED FLANGE			6004443791			1.0
3	3060573-2	LINER, OUTER TRANSITION		13-3300-02935	13-3300-326			1.0
4	4662098	PLASMA POWDER METCO 81VF-NS				0001720065		150.0
4	3060573-01	SUB ASSY			6003857575			1.0
4	3060573-902	FLANGE			6004377006			1.0
4	3060573-903	LINER			6004413050			1.0
3	3060579-1	SWIRL RING, COOLING AIR, BLADE			13-3300-297			1.0
3	3060766-1	CHAMBER, COMBUSTION		13-3300-03523	13-3300-333			1.0
4	3060766-914	OUTER PANEL	W					1.0
4	3060766-916	INNER SUB ASSY	P					1.0
4	3073026-1	IGNITER GROMMET			010008426677			2.0
4	3075542-2	NOZZLE GROMMET			010008309673			12.0
4	4662081	PLASMA POWDER AMDRY 964				0001908289		0.2
4	4665696	PLASMA POWDER AMDRY 204 NS-1				0001929369		0.5
2	3060022-912	TURBINE/REAR MOUNT ASSY		LA049394				1.0
3	3070344-2	ROTOR SEAL			13-162313-147			1.0
3	3071383-2	SEAL AIR OIL		13-150211-00270	13-150211-015			1.0
3	358750-2	BEARING, ROLLER		13-162111-13244				1.0
3	3060626-8	TURBINE ROTOR ASSY - LP, THIRD STAGE	H	12-156103-00868	P4777421			1.0
4	3060671-2	DISK, ROTOR - LP TURBINE, STAGE 3		12-156103-00868	13-169025-378			1.0

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Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
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 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
4	3075307-1	SEAL ROTOR LPT 3STG		12-169025-00437	13-169025-832			1.0
4	3061823-2	BLADE, TURBINE, ROTOR, LPT, STAGE 3			HG-4006			30.0
4	3061823-2	BLADE, TURBINE, ROTOR, LPT, STAGE 3			HG-4015			10.0
4	3061823-2	BLADE, TURBINE, ROTOR, LPT, STAGE 3			HG-3354			16.0
3	3060653-7	NOZZLE TURB LP 2STG			13-3300-317			1.0
3	3060655-6	NOZZLE ASSY LPT 3STG			13-3300-319			1.0
3	3060662-1	PIN, RETAINER RING			13-3300-312			1.0
3	3060674-3	SHAFT AND SEAL AY LPT			P4763737			1.0
3	3060694-8	DUCT, TRANSITION, TURBINE INTERSTAGE		13-3300-02415	13-3300-303			1.0
4	3060694-921	FLANGE			010007849017			1.0
4	3060694-964	PIN			010006387441			6.0
4	3075293-1	BOLT ENG MOUNT AFT			010006387441			19.0
4	4662081	PLASMA POWDER AMDRY 964				0001781837		0.2
4	4665696	PLASMA POWDER AMDRY 204 NS-1				0001781836		0.4
4	3060694-927	FLANGE TX T.OWEN			010007734919			1.0
4	3060694-901	SUB ASSY		13-3300-02415				1.0
5	3060694-923	FLANGE			010008328243			1.0
5	3060694-925	FLANGE			010008094156			1.0
5	3060694-933	CONE			010008222779			1.0
4	3060694-920	FWD FLANGE						1.0
4	3060694-951	PAD			010006376613			1.0
4	3060694-961	MACHINED PAD			010008021092			4.0
3	3060763-3	HARNESS ITT		1316901740688				1.0
3	3074108-2	SEAL AIR ROTTUR2STG		12-169025-00245	13-169025-692			1.0
3	3074743-1	SHAFT TIE			13-156138-A4W			1.0

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Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
3	3074767-1	SEAL ROTATING			13-162313-102			1.0
3	3000005-5	WASHER SPRING			11-162298-725			1.0
3	3075443-4	BEARING HOUSING, REAR - NO. 6		13-3300-03384	13-3300-354			1.0
4	423-603-9011	INSERT, SCREW THREAD,-KEY LOCKED (THIN W			010008212033			11.0
4	3072889-5	PIN ALIGNMENT			010006950805			1.0
4	3074809-955	PLUG			010006497551			1.0
4	3075443-111	HOUSING BEARING			010008677861			1.0
4	3075443-902	SUB ASSY						1.0
4	3075443-931	STIFFENER			010008048877			1.0
4	4665708	PLASMA POWDER METCO 307 NS			010007771570			0.2
3	3061497-10	RING, RETAINING SHROUD			08-29914-004			1.0
3	3060610-5	TURBINE ROTOR ASSY - LP, FIRST STAGE	-	12-156103-01098	P4723683			1.0
4	3060612-1	BLADE, TURBINE ROTOR, LPT - STAGE 1			HM-3350			50.0
4	3060612-1	BLADE, TURBINE ROTOR, LPT - STAGE 1			HM-3315			5.0
4	3060612-1	BLADE, TURBINE ROTOR, LPT - STAGE 1			HM-3316			9.0
4	3060625-1	DISK, ROTOR - LP TURBINE, 1ST STAGE		12-156103-01098	13-169025-536			1.0
3	3060608-5	TURBINE ROTOR ASSY - LP, SECOND STAGE	-	12-156103-00173	P4295105			1.0
4	3075424-2	BLADE, TURNINE ROTOR 2DN STAGE LP			HM-4154(ECWM)			1.0
4	3075424-2	BLADE, TURNINE ROTOR 2DN STAGE LP			HM-3052			2.0
4	3075424-2	BLADE, TURNINE ROTOR 2DN STAGE LP			HM-3129			23.0
4	3075424-2	BLADE, TURNINE ROTOR 2DN STAGE LP			HM-3106			5.0
4	3075424-2	BLADE, TURNINE ROTOR 2DN STAGE LP			HM-3128			21.0
4	3060611-1	DISK, TURBINE ROTOR - LOW PRESSURE, STG		12-156103-00173	12-169025-767			1.0
3	3060666-11	NOZZLE ASSY, LPT, STAGE 1		13-3300-02264	13-3300-331			1.0
4	NAS1398C5-4	"RIVET, BLIND, PROTRUDING HEAD, LOCKED S			010008390849			9.0

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ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
4	3060679-1	DEFLECTOR FORWARD			010008377847			1.0
4	3060680-1	DEFLECTOR-AFT			010008431760			1.0
4	3060693-1	SUPPORT, STATIONARY SEAL, AIR		13-3300-02250				1.0
5	3060693-111	SUPPORT-INVEST CSTG			010008141909			1.0
4	3073765-12	SEAL, AIR, STATIONARY		13-3300-03415				1.0
5	3073765	SEAL			6004508584			1.0
4	3001797-13	BUSHING TURB NOZ			010008509620			9.0
4	3001797-6	BUSHING TURB NOZ			010008378403			9.0
4	NAS1198-5-7	RIVET			010008432008			9.0
4	NAS1398C5-2	*RIVET, BLIND, PROTRUDING HEAD, LOCKED S			010008371282			15.0
4	3060651-10	NOZZLE TURBINE LP, STAGE 1	-	13-3300-02264				1.0
5	3060651-115	NOZZLE			010007472440			1.0
3	3073718-3	SUPPORT, BEARING HOUSING, REAR - NO. 6		13-3300-01999	13-3300-255			1.0
4	MS20605R3W2	MS20605R3W2 Per NASM20605 RIVET			010006246650			24.0
4	MS20501-1032	NUT			010007581898			12.0
4	3075384-902	SUB ASSEMBLY FIND #3 AND #4						1.0
4	3073718-113	SUPPORT, BEARING HOUSING, REAR - NO. 6 -			010007918017			1.0
2	3060022-913	LPT1 SHROUD ASSEMBLY		LA049395				1.0
3	3061494-1	HPT SHROUD SEGMENT			13-150285-020			12.0
3	3061495-2	CASE HP TURBINE	B	13-156113-18890				1.0
4	3061495-903	CASE		13-156113-18890	010008881118			1.0
2	3060022-950	FRONT FRAME ASSEMBLY	CA	LA049398				1.0
3	3060163-5	VANE ASSEMBLY, FAN STATOR	-	14P63991	P4787479			1.0
3	3060435-1	HOUSING, FAN INLET			13-3300-261			1.0
3	3060421-3	FRAME ASSY, FRONT - 9 STRUT MACHINING		13-101376-00050	13-3300-320			1.0

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 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
4	423-603-9031	INSERT, SCREW THREAD, -KEY LOCKED (THIN			0100084226689			28.0
4	682-557-2109	STUD KEY LKD			010008522475			4.0
4	682-557-2109	STUD KEY LKD			010008522475			84.0
4	682-557-2111	STUD KEY LKD			010008619935			77.0
4	3060189-1	PIN			010007959301			5.0
4	3060207-12	BUSHING			010006669415			4.0
4	3060207-12	BUSHING			010006669415			4.0
4	3060207-13	BUSHING			01007209145			4.0
4	3060207-13	BUSHING			01007209145			2.0
4	3060207-14	BUSHING			010006597356			2.0
4	3060207-15	BUSHING			010007630065			8.0
4	3060207-2	BUSHING			010005066364			3.0
4	3060207-2	BUSHING			010005066364			2.0
4	3060207-4	BUSHING			010007102395			2.0
4	3060416-1	PLUG FRONT FRAME			010003824413			2.0
4	682-557-2211	STUD KEY LKD			010008535080			11.0
4	682-557-2211	STUD KEY LKD			010008535080			18.0
4	423-603-9022	INSERT, SCREW THREAD, -KEY LOCKED (THIN			010007692336			4.0
4	682-5504-2401	STUD, KEY LOCKED - WEIGHT - REDUCED, INC			010008378277			16.0
4	682-5504-2401	STUD, KEY LOCKED - WEIGHT - REDUCED, INC			010008378277			18.0
4	3060420-111	FRAME, FRONT - 9 STRUT CASTING		13-101376-00050	010008515767			1.0
2	3060300-17	COMPRESSOR ASSEMBLY	AC	14P07008				1.0
3	3071824-5	RETAINER BRG HP RTR			13-169006-216			1.0
3	3075016-1	BEARING BALL THR RTR	J	13-151725-06989		0001972012		1.0
3	3075633-2	SEAL RUNNER ASSY NO5		13-162397-07435				1.0

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BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
3	3075639-2	SEAL RUNNER ASSY NO4		13-162397-08705				1.0
3	358751-1	BEARING, ROLLER		13-162111-20340				1.0
3	358752-3	BEARING, BALL		13-151725-04994				1.0
3	358759-1	BEARING, ROLLER CYLINDRICAL-HP ROTOR		14-162255-00507				1.0
3	3060316-4	CASE HP IMPELLER			13-3300-339			1.0
3	3060366-3	SHAFT SHOULDERED	-	14P64041	P4574637			1.0
4	3060366-751	SHAFT SHOULDER			5018673608			1.0
3	3060371-1	COMPRESSOR, ROTOR, CENTRIFUGAL	J	13-182449-09499	141034014			1.0
4	3900232-111	FORGING, IMPELLER	B	13-182449-09499				1.0
3	3060382-1	SPACER SLEEVE			13-5060-324			1.0
3	3060436-1	SEAL, HYDRODYNAMIC CARBON, NO. 5		13-152826-44575				1.0
3	3060437-1	SEAL, HYDRODYNAMIC CARBON, NO. 4		13-152826-47016				1.0
3	3060502-2	COUPLING, SHAFT HP TURBINE	E	13-1034-40066	131034289			1.0
4	3060502-751	COUPLING SFT HP TURB	D					1.0
4	3073609-5	RING SEAL METAL	K					1.0
4	3060502-915	PIN	-					2.0
3	3060514-1	SEAL PLATE, HPT	J	13-182449-09483	131034304			1.0
4	3060514-751	SEAL PLATE HPT	E	13-182449-09483				1.0
5	3900219-111	FORGING, ROTATING	B					1.0
3	3060555-5	HPT ROTOR ASSEMBLY	H	12-156111-00067	P4775842			1.0
4	3060556-1	BLADE, TURBINE ROTOR, HP			HM-4011			56.0
4	3060841-1	DISK, TURBINE ROTOR - HP	J	12-156111-00067	131034295			1.0
5	3900246-111	FORGING, DISK, HPT		12-156111-00067				1.0
3	3060698-1	SEAL, AIR, ROTATING	F	13-162246-00052	131034341			1.0
4	3060698-761	SEAL AIR ROTATING		13-162246-00052				1.0

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BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
5	3900222-111	FORGING ROTATING	A	13-162246-00052				1.0
3	3060804-1	GEARSHAFT, BEVEL	B	14P63805	P4606762			1.0
4	3060804-751	MACHINED BLANK			LN131034219			1.0
3	3060805-1	GEAR, BEVEL, ACCESSORY DRIVE			P4674811			1.0
3	3070024-1	SCOOP, OIL			13-107281-005			1.0
3	3070027-1	TUBE TRANSFER			09-162806-001			1.0
3	3070151-4	TIE SHAFT NUT			13-5040-392			1.0
3	3070369-2	SUPPORT ASSY			13-156138-DRG			1.0
3	3070490-1	SCOOP OIL			14-5060-003			1.0
3	3071463-1	CARRIER ASSEMBLY, ROLLER BEARING - HP CO			13-3300-296			1.0
3	3071863-1	RETAINER BRG			12-169006-666			1.0
3	3071866-3	CARRIER BEARING			13-162313-122			1.0
3	3060599-3	COUPLING, REAR SEAL - HP SHAFT	H	13-1034-40495	131034336			1.0
2	3061704-2	NOZZLE, ASSEMBLY, H.P. TURBINE	A	14P07007				1.0
3	3060581-1	SEAL CARR HP TURB			14-182271-002			1.0
3	3061496-2	HP NOZZLE RETAINING RING			12-182382-745			1.0
2	3061704-902	A-4 NOZZLE ASSEMBLY		LA049400				1.0
3	3060840-5	NOZZLE SEGMENT, HP, COOLED			12-1082-158			1.0
3	3060840-5	NOZZLE SEGMENT, HP, COOLED			12-1082-107			1.0
3	3060840-5	NOZZLE SEGMENT, HP, COOLED			12-1082-102			1.0
3	3060840-6	NOZZLE SEGMENT, HP, COOLED			13-1082-344			4.0
3	3060840-6	NOZZLE SEGMENT, HP, COOLED			13-1082-340			4.0
3	3060840-6	NOZZLE SEGMENT, HP, COOLED			13-1082-318			1.0
3	3060840-6	NOZZLE SEGMENT, HP, COOLED			13-1082-273			1.0
3	3060840-6	NOZZLE SEGMENT, HP, COOLED			13-1082-311			2.0

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BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
2	3060022-971	LPC STACK		LA049397				1.0
3	978812-7-1	VALVE OUTL MODULATING & SHUTOFF PNEUMATIG		14832	1			1.0
3	3060334-1	SEAL			13-3300-330			1.0
3	3070279-17	COMPRESSOR STATOR ASSEMBLY, THIRD STAGE AF	14P63900		P4775843			1.0
4	3060348-4	VANE, COMPRESSOR STATOR - STAGE 3			13-3500-071			2.0
4	3060348-4	VANE, COMPRESSOR STATOR - STAGE 3			13-3500-151			10.0
4	3060348-4	VANE, COMPRESSOR STATOR - STAGE 3			13-3500-108			28.0
4	3060348-5	VANE, COMPRESSOR STATOR - STAGE 3			13-3500-049			1.0
4	3060348-6	VANE STATOR LPC-3			13-3500-120			18.0
4	3072464-6	RING RTNR VANE 3STG			13-108737-003			1.0
3	3070280-9	COMPRESSOR STATOR ASSY, 2ND STAGE - LOW M	14P63905		P4775844			1.0
4	3060347-4	VANE STATOR LPC-2			L13-3500-149			55.0
4	3060347-5	VANE STATOR LPC-2			12-3500-085			1.0
4	3060347-6	VANE STATOR LPC-2			0707641079			5.0
4	3072482-2	RING RETAINING			12-156138-A4F			1.0
4	3072485-1	STOP, VANE, STATOR - COMPRESSOR, SECOND			13-163248-001			1.0
3	3070281-12	COMPRESSURE STATOR ASSY, 1ST STAGE LOW P V	14P64035		P4783531			1.0
4	3060346-4	VANE, COMPRESSOR STATOR - STAGE 1			13-3500-150			2.0
4	3060346-4	VANE, COMPRESSOR STATOR - STAGE 1			13-3500-150			25.0
4	3060346-4	VANE, COMPRESSOR STATOR - STAGE 1			13-3500-189			19.0
4	3060346-5	VANE, COMPRESSOR STATOR - STAGE 1			13-3500-117			1.0
4	3072481-2	RING VANE RETAINER, FIRST STAGE CMPSR			12-108737-005			1.0
4	3072484-1	STOP STATOR VANE			1316230168			1.0
3	3070289-9	SHROUD LPC-2			12-182127-003			1.0
3	3070292-9	SHROUD, COMPRESSOR WHEEL, THIRD STAGE			12-182127-005			1.0

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BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
3	3071740-1	NUT RND SLOTTED			13-162313-106			1.0
3	3072417-12	COMPRESSOR ROTOR ASSY, AXIAL, TURBINE EN	AK	13-162045-00675	P4434615			1.0
4	3060343-1	BLADE CPRSR RTR 3STG			13-3500-161			39.0
4	3060374-1	DISK, AXIAL COMPRESSOR, TURBINE ENGINE -	J	13-162045-00675	131034205			1.0
5	3060374-111	DISK, AXIAL COMPRESSOR, TURBINE ENGINE -		13-162045-00675				1.0
4	3072404-4	SHROUD, AXIAL COMPRESSOR, TURBINE ENGINE			131034210			1.0
3	3074744-1	TIE ROD, THREADED ENDS	P	13P62787				1.0
4	9-8934	1.375 718 EMS55476 BAR STOCK			5018814423			36.0
3	3075351-12	COMPRESSOR ROTOR ASSY, AXIAL - STAGE 4	AA	13-162053-54865	P4723410			1.0
4	3060344-1	BLADE LPC-4			13-3500-183			6.0
4	3060344-1	BLADE LPC-4			13-3500-183			30.0
4	3060344-1	BLADE LPC-4			13-3500-179			6.0
4	3072405-4	SHROUD, AXIAL COMPRESSOR, TURBINE ENGINE			13103 4306			1.0
4	3074803-5	SHAFT, SHOULDERED, LOW PRESSURE COMPRESSW		13P62092	P4478167			1.0
5	3074803-753	SHAFT SHLDR LP CPRSR			5018673240			1.0
4	3075326-5	DISK, AXIAL COMPRESSOR, - STAGE 4	AB	13-162053-54865	131034263			1.0
5	3075324-111	FORGING	B	13-162053-54865				1.0
3	3060361-5	CASE AND VANE ASSY STAGE 4		13-3300-03352	13-3300-320			1.0
4	MS20427F3-4	MS20427F3-4 PER NASM20427 RIVT			010006470633			6.0
4	MS21070-3	NUT, SELFLOCKING			010008340338			3.0
4	3075466-2	PIN STATOR LPC 4STG			010008195648			1.0
4	3060361-927	SHROUD						1.0
4	3060361-933	RING			010007922153			1.0
4	3060361-933	RING			010007922153			1.0
4	3060361-999	SEALING WRAP/MBP						1.0

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4	3060361-999	SEALING WRAP/MBP						1.0
4	3073797-2	VANE, LP COMPRESSOR, STAGE 4			6004530830			84.0
4	VZOREK 134	SAMPLE TH1,6 CRES 17-4PH			6004478443			1.0
4	VZOREK 134	SAMPLE TH1,6 CRES 17-4PH			6004478443			1.0
3	3071873-6	SHROUD LPC 1STG			13-182127-005			1.0
3	3070440-24	COMPRESSOR ROTOR ASSY 1ST STAGE	AV	13-162045-00712	P4776377			1.0
4	3060314-3	SHAFT, SHOULDERED, LP COMPRESSOR - FWD	G	13P62644	P4502606			1.0
5	3060314-751	SHAFT SHLDR LP CPRSR			LN131034271			1.0
4	3060341-1	BLADE LPC-1			13-3500-134			31.0
4	3060345-1	LPC RETAINER RING			13-169015-001			1.0
4	3060372-1	DISK, AXIAL COMPRESSOR, TURBINE ENGINE -	H	13-162045-00712	131034249			1.0
5	3060372-111	DISK, AXIAL COMPRESSOR, TURBINE ENGINE -	G	13-162045-00712				1.0
3	3075841-3	COMPRESSOR ROTOR ASSY - STG 2	-	13-162045-00273	P4774746			1.0
4	3075839-1	DISK, LPC ROTOR-STG 2	E	13-162045-00273	131034105			1.0
5	3060373-111	DISK, AXIAL COMPRESSOR, TURBINE ENGINE -	F	13-162045-00273				1.0
4	3075840-3	BLADE, COMPRESSOR ROTOR - STAGE 2			12-3500-225			39.0
4	3072403-6	SHROUD, AXIAL COMPRESSOR			141034015			1.0
1	3070800-47	FUEL CONTROL ASSY MAIN TURBINE ENGINE	CL	20397	6			1.0
2	2683881	VALVE ASSEMBLY METERING (MTCHD)	C	163194-3288		0001838359		1.0
2	3070643-4	VALVE ASSEMBLY BODY & HSG	U	163194-3116				1.0
2	3070690-8	BODY FUEL CONTROL	AW	162260-CF4207				1.0
2	3070973-2	SET VALVE,MTCHD-RELIEF	K	10128-13-0107				1.0
2	3074127-2	SERVO PRESS REG VALVE SET,MATCHED	K	150529-1599				1.0
2	3074131-2	VALVE ASSEMBLY ROTARY-MATCHED SET	R	126102500064				1.0
2	3074253-3	FLYWEIGHT ASSY GOVERNOR	G	GOV6004645859				1.0

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 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
3	3073852-4	SET FLYWEIGHT,GOV,MTCHD	H	12107006273				1.0
2	2690663	VALVE ASSEMBLY,METERING	A	MS6004673320				1.0
3	3074139-3	BELLOWS SENSOR,COMPRESSOR DISCHAR	T	1315076800096				1.0
3	3074276-3	FILTER PLATE VALVE	D	5513				1.0
2	2690665	CONTROL ASSEMBLY,SERVO VALVE	A	HS6004668681				1.0
3	2687608	BELLOWS REGULATING,SERVO VALVE	A	13107010227		0001958220		1.0
3	3070521-5	TORQUE MOTOR	AG	D9004S				1.0
2	2691329	LEVER ASSEMBLY,POWER	B	PLA6004668676				1.0
3	3074110-1	RESISTOR VAR,LIN,PRECISION	K	1316280100192				1.0
3	442580-2	SOLENOID AND VALVE,INSTALLATION OF		SVEBA10567				1.0
3	442581-2	SOLENOID AND VALVE		SVEBB10561				1.0
2	441886-ISS6	FUEL CONTROL,MAIN,TURBINE ENGINE,INSTL O	06	20397				1.0
1	2118882-8001	TFE-731 DIGITAL ELECTRONIC ENGINE CONTRO	BD	103-BP0061				1.0
2	2118883-11	TFE-731 DIGITAL ELECTRONIC ENGINE CONTRO	AL	104-ZZ1343				1.0
3	4241318-13	MODULE ASSY	AA	1342-00957				1.0
4	4241319-13	SUB, FADEC SUBASSEMBLY	P	1342-00956				1.0
5	4242010-905	SUB, DEEC :	M	1338-00953				1.0
5	4241325-909	SUB FADEC	AM	1340-00935				1.0
3	4242225-803	Q-XDCR ASSY	E	1337-00931				1.0
4	4242710-2	CIRCUIT CARD ASSEMBLY EMI/FLEX	N	1337-00931				1.0
3	4241309-11	CIRCUIT CARD ASSEMBLY, POWER SUPPLY	BH	1340-00934				1.0
1	3062075-904	GEARBOX ASSEMBLY		LA049401				1.0
2	3070639-1	SHAFT, SHOULDER			11-169019-910			1.0
2	895349-1	COUPLING RGD SP			13-169006-137			1.0
2	3060760-4	FUEL PUMP		3534				1.0

Subject to U.S. Export Regulations

07/21/2014

Page 16 of 17

Configuration Report

Honeywell

Material Number 3062075-1 Serial Number P137179
 Material Desc ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B
 Mfg. Revision A

ESS - Engines - Phoenix
 Honeywell International Inc
 111 South 34th Street
 PHOENIX AZ 85072
 USA

BOM	Material	Material Description	Rev	Serial Number	Lot Number	Batch	Ref.Des	Quantity
2	3060800-1	SUPPORT ASSEMBLY			13-169019-939			1.0
2	3060801-1	MOUNT ASSY ACCESSORY			13-169019-795			1.0
2	3070093-16	GEARBOX, TRANSFER	BP	14P64232				1.0
3	358753-2	BEARING, BALL, THRUST		12-162255-10452				1.0
3	358754-2	BEARING, ROLLER		12-162111-05179				1.0
3	358755-1	BEARING, ROLLER		13-162111-14550				1.0
3	358756-1	BEARING, ROLLER		.13-162111-17142				1.0
3	3060828-2	HOUSING GRBX XFR			13-5060-329			1.0
3	3070212-3	GEARSHAFT, BEVEL TRANSFER GEARBOX			P4680517			1.0
3	3070219-2	GEARSHAFT, BEVEL, TRANSFER GEARBOX			P4606761			1.0
3	3070722-8	TRANSDUCER		13910300241				1.0
3	358757-1	BEARING BALL		13-151725-03571				1.0
2	3070201-2	SHAFT STRAIGHT			P4478907			1.0
2	3060785-3	PUMP - LUBE WITH REGULATOR & SCAV		1316225400143				1.0
2	3060827-4	GEARBOX ASSEMBLY ACCESSORY DRIVE		S-4241	1			1.0

Subject to U.S. Export Regulations

07/21/2014

Page 17 of 17

SERVICE RECORD

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

Page 2 of 2

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
09-Mar-2022	0	0	3222.5	3222						

No. Task No./Position

Description

1 761330A

NO. 1 ENGINE - DOWNLOAD ENGINE (DEEC) COMPUTER ECTM

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


CURT TAUNTON

Certificate #:

A&P 3788607

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
27-Mar-2022	0	0	3252.7	3259						

No. Task No./Position

Description

1 057130

NO. 1 ENGINE - 500 TO 650 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

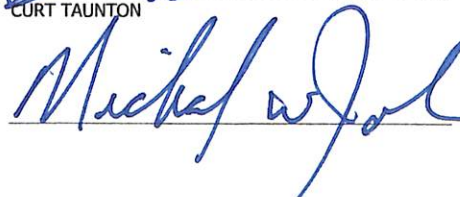
Work Performed By:


CURT TAUNTON

Certificate #:

A&P 3788607

Work Inspected By:


Michael W. Jones

Certificate #:

AP 3481311

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

Page 1 of 1

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
18-Jan-2022	0	0	3125.3	3131						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


CURT TAUNTON

Certificate #:

A&P 3788607

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

Page 1 of 1

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
05-Feb-2022	0	0	3166.6	3173						

No.	Task No./Position	Description
1	761330A	NO. 1 ENGINE - DOWNLOAD ENGINE (DEEC) COMPUTER ECTM

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


CURT TAUNTON

Certificate #:

A&P 3788607

Work Inspected By:

Certificate #:

SERVICE RECORD ENTRY

Georgia Crown		Work Order: 365961		Date: 26/October/2021	
Serial Number: 496	Tail Number: N877W	Model: Learjet 75	ACTT: 3,052.2		LNDS: 3,035
Engine Position: 1	Engine S/N: P-137179		Engine TSN: 3,019.1		Engine Cycles: 3,007

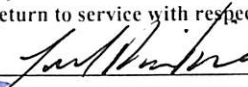
- Complied with **500 to 850** Hour Inspection in accordance with Honeywell TFE731-40 Light Maintenance Manual 72-00-00.
 - Inspect tailpipe/LPT 3 rotor assembly.
 - Inspect inlet/fan area.
 - Visually inspect electrical wires and connections.
 - Visually inspect plumbing lines and connections.
- Complied with **1500 to 1650** Hour Inspection in accordance with Honeywell TFE731-40 Light Maintenance Manual 72-00-00.
 - Perform carbon seal health check.
 - Inspect 5 o'clock ignitor plug and lead.
 - Inspect 7 o'clock ignitor plug and lead.
- Accomplished required operational and leak checks in accordance with Honeywell TFE731-40 Light Maintenance Manual.

All maintenance performed on this aircraft/engine was performed in accordance with current regulations of the Federal Aviation Administration and is approved for return to service with respect to the work performed.

Details are on file under W/O# 365961.

Date: 26/October/2021

Signed: Jonah Richie




for

StandardAero CRS No., GW4R221M Augusta, GA 30906

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
21-Sep-2021	0	0	2966.2	2956						
No.	Task No./Position	Description								

1 TFE731-72-5256 R01 (D201506000058 R01)

NO. 1 ENGINE - BYPASS SECTION - IDENTIFY AND REPLACE SPECIFIC FAN DISKS, PN 3060287-2, WITH SUSPECT SHOT PEENED ROLLED EDGES ON TFE731-20 AND -40 ENGINE MODELS, SERVICE BULLETIN NOT APPLICABLE - NA BY SERIAL NUMBER

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:

MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

Page 2 of 2

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
30-Sep-2021	0	0	2979.6	2969						
No.	Task No./Position	Description								

1 057110

NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:

MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:

SERVICE RECORD ENTRY

StandardAero
Bush Field Airport
1550 Hangar Road
Augusta GA 30906-9684

FAA Repair Station No: GW4R221M
Telephone (706) 771-5600
Fax (706) 793-0469

CUSTOMER NAME: GEORGIA CROWN	Work Order Number: 362786	Date: 19/APR/2021
ENGINE serial Number: P-137179	ENGINE Time: 2762.0	ENGINE CYCLES: 2746

Performed logbook research and found that at this time, this engine qualifies for the first use of a 3500/7000 hour MPI/CZI interval in accordance with Honeywell maintenance manual 72-03-06 Rev. 13, TR 5-18. For subsequent use of the 3500 Hr MPI/7000 Hr CZI interval, the service bulletins in the final paragraph of temporary revision 5-18 will have to be complied with at the first event.

Date: 19/APR/2021 Signed: Jay Shealy AG 27
StandardAero, CRS# GW4R221M, Augusta, Ga 30906 For

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
24-May-2021	0	0	2801	2797						

No. Task No./Position

Description

1 057110

NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
15-Feb-2021	0	0	2652.6	2642						

No. Task No./Position Description

1 057110 NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
19-Feb-2021	0	0	2658.1	2646						

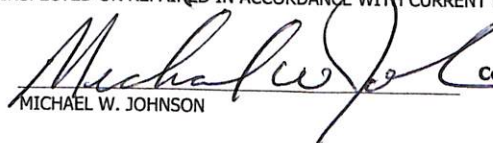
No. Task No./Position Description

1 057130 NO. 1 ENGINE - 500 TO 650 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

2 057150 NO. 1 ENGINE - 1000 TO 1300 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:

01/13/2021 08:06

Page 2 of 2

Customer: 137139

Started: 01/12/2021 15:28

Last Updated: 01/12/2021 15:29

A/C Reg: N959SE

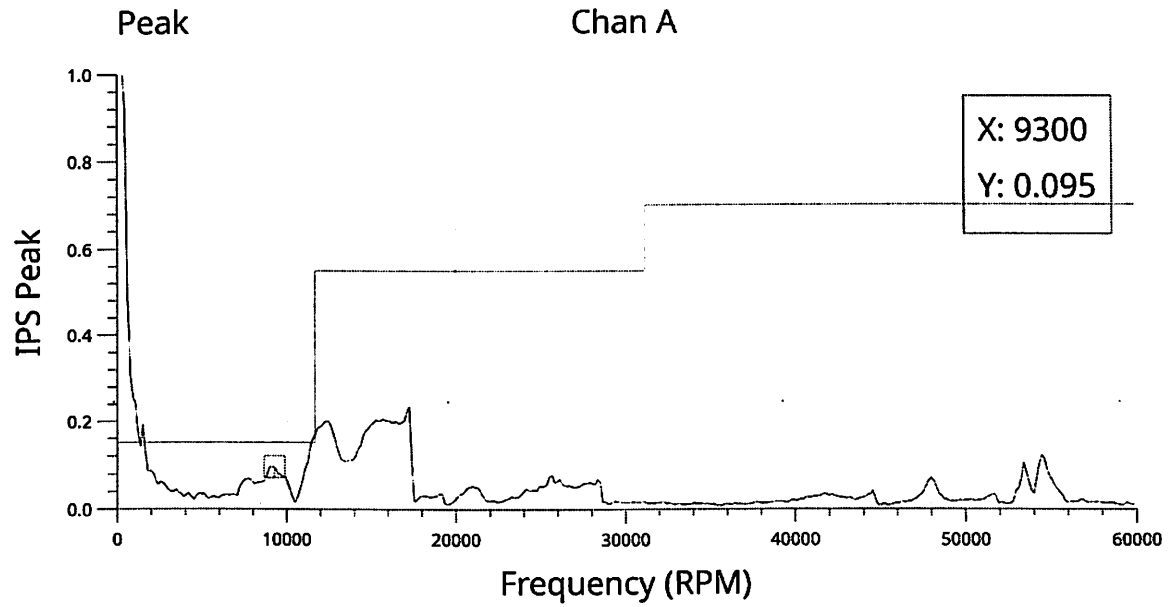
Condition: ACCEL

Speeds:

Job Status: Incomplete

A/C Total TM: 0.0

Engine: 137139



SERVICE RECORD ENTRY

Georgia Crown		Work Order: 360266		Date: 27/October/2020	
Serial Number: 496	Tail Number: N877W	Model: Learjet 45	ACTT: 2,598.3	LNDS: 2,845	
Engine Position: 1	Engine S/N: P-137179	Engine TSN: 2,565.2	Engine Cycles: 2,526		

- Disassembled Engine as necessary to perform the following;
 - Accomplished fan blade weight check for positioning and fan balance.
 - Reassembled engine using new consumables.
- Dynamically balanced fan assembly to .08 IPS. IAW Honeywell TFE 731-40 LMM 72-06-12 Rev 13.
- Accomplished engine run, performed vibration survey with all parameters within allowable limits, leak and ops check are satisfactory. All work done in accordance Honeywell TFE731-40 Light Maintenance Manual 72-06-12 Rev 13.

All maintenance performed on this aircraft/engine was performed in accordance with current regulations of the Federal Aviation Administration and is approved for return to service with respect to the work performed.

Details are on file under W/O# 360266.

Date: 27/October/2020

Signed: Jonah Richie

for

StandardAero CRS No., GW4R221M Augusta, GA 30906

SERVICE RECORD ENTRY

StandardAero

Bush Field Airport
1550 Hangar Road
Augusta GA 30906-9684

FAA Repair Station No: GW4R221M
Telephone (706) 771-5600
Fax (706) 793-0469

CUSTOMER NAME: GEORGIA CROWN	Work Order Number: 361305	Date: 13/JAN/2021
ENGINE serial Number: P-137179	ENGINE Time: 2609.3	ENGINE CYCLES: 2590

Troubleshoot engine for vibration. Removed spinner, fan blades, and fan disk. Removed paint from disk and blade dovetails and repainted. Dressed minor blade leading edge roughness. Weighed and mapped blades for balance.

Reinstalled disk, blades, and spinner. Performed vibration survey and found all acceptable. Work accomplished in accordance with 731-40 LMM 72-03-06 Rev. 13.

This aircraft or component has been inspected and work described above found airworthy for return to service. Details are on file under WO#: 361305.

Date: 13/JAN/2021

Signed: Jay Shealy

AG
27

For

StandardAero, CRS# GW4R221M, Augusta, Ga 30906

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

Page 2 of 2

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
31-Aug-2020	0	0	2510.4	2465						

No.	Task No./Position	Description
1	761330A	NO. 1 ENGINE - DOWNLOAD ENGINE (DEEC) COMPUTER ECTM

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:

MICHAEL W. JOHNSON

Certificate #: AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
14-Sep-2020	0	0	2522.7	2486						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:

MICHAEL W. JOHNSON

Certificate #: AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
04-May-2020	0	0	2373.2	2306						

No. Task No./Position

Description

1 057110

NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:

MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

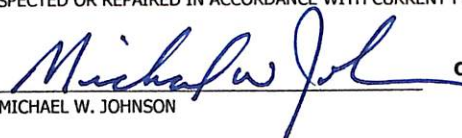
Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
20-Nov-2019	0	0	2231.8	2167						

No.	Task No./Position	Description
1	057140	NO. 1 ENGINE - 500 TO 850 HOUR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND
APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

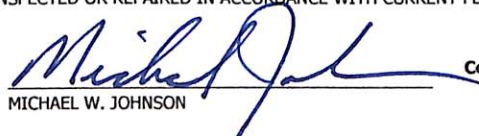
Work Order #: _____

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
10-Oct-2019	0	0	2199.9	2128						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS

CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND
APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #: AP3481311

Work Inspected By:

Certificate #: _____

SERIAL NUMBER

PAGE

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

PX-3107-51

ENGINE ☐
MODULE ☐
SERIAL NUMBER _____

SERVICE RECORD

PAGE _____

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

DATE

SERVICE RECORD ENTRY

Georgia Crown		Work Order: 351119		Date: 06/June/2019	
Serial Number: 496	Tail Number: N877W	Model: Learjet 45	ACTT: 2,075.5	LNDS: 1,989	
Engine Position: 1	Engine S/N: P-137179	Engine TSN: 2,042.3	Engine Cycles: 1,961		

- Disassembled Engine as necessary to perform the following;
 - Accomplished fan blade weight check for positioning and fan balance.
 - Reassembled engine using **new** consumables.
- Dynamically balanced fan assembly to .098 IPS. IAW Honeywell TFE 731-40 LMM 72-03-06 Rev 13
- Accomplished engine run, performed vibration survey with all parameters within allowable limits, leak and ops check are satisfactory. All work done in accordance Honeywell TFE731-40 Light Maintenance Manual 72-03-06.

All maintenance performed on this aircraft/engine was performed in accordance with current regulations of the Federal Aviation Administration and is approved for return to service with respect to the work performed.

Details are on file under W/O# 351119.

Date: 06/June/2019 Signed: Thomas Styczynski   for

StandardAero CRS No., GW4R221M Augusta, GA 30906

THIS CERTIFIES THAT THE TYPE OF INSPECTION LISTED AND SIGNED OFF IS IN ACCORDANCE WITH THE MANUFACTURER'S INSPECTION INSTRUCTIONS
AS DEFINED IN CURRENT APPLICABLE MAINTENANCE MANUAL.

ENGINE ☐
MODULE ☐
SERIAL NUMBER

SERVICE RECORD

PAGE

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

[illegible]

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

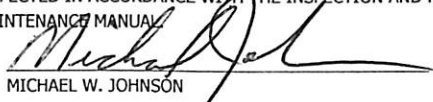
Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
13-Sep-2018	1764.4	1662	1731.3	1634						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
2	790130	NO. 1 ENGINE - ANALYSIS OIL AND FILTER (SOAP)
3	790160	NO. 1 ENGINE - INSPECT CHIP DETECTOR FOR CONTAMINATION

I CERTIFY THAT THIS ENGINE HAS BEEN INSPECTED IN ACCORDANCE WITH THE INSPECTION AND PROCEDURES FOR 150/250 HOUR ENGINE INSPECTION
REFERENCING HONEYWELL TFE 731-40L MAINTENANCE MANUAL

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

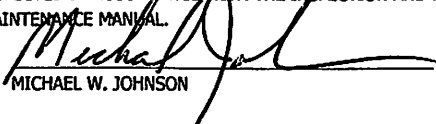
Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
20-Jun-2018	1612.2	1535	1579.1	1507						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - PERFORM 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
2	790130	NO. 1 ENGINE - ANALYSIS OIL AND FILTER (SOAP)
3	790160	NO. 1 ENGINE - INSPECT CHIP DETECTOR FOR CONTAMINATION

I CERTIFY THAT THIS ENGINE HAS BEEN INSPECTED IN ACCORDANCE WITH THE INSPECTION AND PROCEDURES FOR 150/250 HOUR ENGINE INSPECTION
REFERENCING HONEYWELL TFE 731-40L MAINTENANCE MANUAL.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

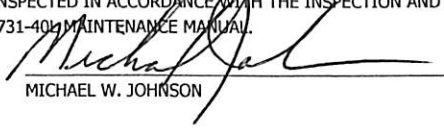
Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
20-Feb-2018	1484.7	1404	1451.6	1376						

No. Task No./Position Description

1 72-AS-720010 NO. 1 ENGINE - ANALYSIS OIL AND FILTER (BASELINE/SPECIAL REQUIREMENT)

I CERTIFY THAT THIS ENGINE HAS BEEN INSPECTED IN ACCORDANCE WITH THE INSPECTION AND PROCEDURES FOR BASELINE SOAP SAMPLE HOUR
ENGINE REFERENCING HONEYWELL TFE 731-40B MAINTENANCE MANUAL.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

ENGINE ☐
MODULE ☐
SERIAL NUMBER _____

SERVICE RECORD

PAGE _____

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

DATE

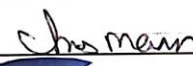
SERVICE RECORD ENTRY

Georgia Crown Distributing Co. Learjet 75, S/N: 496, N877W	Work Order Number: 341416	Date: February 05, 2018 ACTT: 1,461.0 LDGS: 1,388
Engine Serial Number: P-137179 Position: L/H	Engine Time: 1,427.9	Engine Cycles: 1,360

1. Installed Engine in L/H Position of Learjet 75, N877W, S/N: 496 with total time of 1,461.0 Hours and 1,388 Landings. Accomplished all necessary ground checks and adjustments in accordance with the Honeywell TFE 731-20/-40/-50/-60 Light Maintenance Manual and Learjet 45 Maintenance Manual. Serviced Engine with Mobil 254 oil.

Note: Oil and Filter analysis due after initial 25 Hours of Engine Operation.

All maintenance performed on this aircraft / engine was performed in accordance with current regulations of the Federal Aviation Administration and is approved for return to service with respect to the work performed.
Details are on file under W/O# 341416.

Date: February 05, 2018 Signed: Chris Mann   for

StandardAero CRS No., GW4R221M Augusta, GA 30906

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AS DEFINED IN CURRENT APPLICABLE MAINTENANCE MANUAL.

ENGINE ☐
MODULE ☐
SERIAL NUMBER _____

SERVICE RECORD

PAGE _____

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

DATE



*Bush Field Airport
1550 Hangar Road
Augusta, GA 30906-9684*

*FAA Repair Station # GW4R221M
Telephone: (706) 771-5600
Fax: (706) 793-0469*

Customer: GEORGIA CROWN	Work Order Number: 340798	Date: January 22, 2018
Engine S/N: P-137179	Engine Time: 1427.9	Engine Cycles: 1360

- Disassembled Engine as Necessary for Repair due to Metal Contamination in Oil. Installed the Following Parts:

Part Nomenclature	Part Number	Part Serial Number	Quantity	Condition
FAN STATOR VANE	3060378-1	NSN	56	REPAIRED
CARBON SEAL #3	3060150-3	15-169020-01531	1	NEW
CARBON SEAL #1	3060457-1	17-152826-61799	1	NEW
LPC1 STATIONARY SHROUD	3071873-6	NSN	1	OVERHAULED
CARBON SEAL #4	3060437-1	17-152826-65619	1	NEW
#5 BEARING	3075016-1	17-151725-06001	1	NEW
CARBON SEAL #5	3060436-1	17-152826-61491	1	NEW
FUEL PUMP DRIVE COUPLING	3070639-1	NSN	1	NEW

- Accomplished **150-250, 500-650, 500-850, 1000-1300, 1500-1650 HR** Periodic Routine Inspections
- See Appropriate Section of Logbook for Service Bulletins and AD's addressed this event.
- Reassembled Engine Using New Consumables. Accomplished Engine Certification Test Cell Run, Vibration Survey, Fan Balance, Leak Check, and Ops Check. All work Accomplished I/A/W TFE731-40 LMM 72-03-06 Rev. 12 and HMM 72-03-07 Rev. 11.

NOTE: S.O.A.P. SAMPLE DUE IN 25 HOURS.

This aircraft or component has been inspected and work described above found airworthy for return to service.

DATE: 22/JAN/2018, SIGNED: Mark Meredith

Standard Aero; Augusta, GA
Repair Station GW4R221M

A handwritten signature in black ink, appearing to read 'Mark Meredith', is written over a blue rectangular stamp. The stamp contains the letters 'AG' and the number '5'.

MEDRA 6.0.83 - Data Reduction - Performance Margins

TEST IDENTIFICATION

TFE731-40BR-1B S/N: 137179 Work order number: 340798
 Test date: 01/22/2018 Test time: 16:35:18
 RED Version: 6.40 PGM Version: 6.77
 Reduced date: 01/22/2018 Reduced time: 16:57:25
 Reason for test: Unscheduled Core Entry

Time since new: 1427.9 Cycles since new: 1360
 Build/Run: 1/1 EEC/DEEC SG:

Customer: GEORGIA CROWN
 Aircraft model: Lear 75 Aircraft S/N: unk
 Test Cell Code: GASAGS Engine location: 1

Data recorded by: 001346 Data entered by: AGS
 Comments:

Test Cell Acquired Data

Takeoff Rating Margins

		at T/O Thrust		at T/O N1	
TAMB -	°F		103.0		103.0
Thrust -	LB force		3850		
N1 -	RPM				19308
Fn Margin -	LB force	0 @	0	16 @	3878
T45 Margin -	°F	70 @	1779	64 @	1779
N1 Margin -	RPM	234 @	19458	150 @	19458
N2 Margin -	RPM	0 @	0	994 @	31485

APR Rating Margins

		at APR T/O Fn		at APR T/O N1	
TAMB -	°F		112.0		112.0
Thrust -	LB force		3850		
N1 -	RPM				19461
Fn Margin -	LB force	0 @	3850	16 @	3878
T45 Margin -	°F	76 @	1819	70 @	1819
N1 Margin -	RPM	235 @	19611	150 @	19611
N2 Margin -	RPM	0 @	0	1076 @	31800

Atmospheric Conditions

Average Ambient T1 = 70.6 °F
 Average Ambient Pressure = 14.69 psia
 Average Relative Humidity = 68.85 %
 N1 Compensation Value = 4.0 (150 RPM)

CERT. SHEETS

P-137179

W/O # 340798

January 22, 2018



StandardAero
CRS# GW4R221M

1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170004099656Y14 8007013016-50	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC Production Approval 1720 East Grant Street PC413NM PHOENIX AZ 85034					5. Work Order/Contract/Invoice Number: 950130 Page 1 of 1	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	SEAL, SEGMENTED	3060150-3	2	15-169020-01531 ← See Continuation	NEW	
12. Remarks: AIRWORTHINESS APPROVAL Block 10 Serial Number(s): (Continued): 15-169020-01587.						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: <i>Florie McCrone</i>		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Florie McCrone		13e. Date (dd/mm/yyyy): 26/DEC/2017		14d. Name (Typed or Printed):		14e. Date(dd/mm/yyyy):

User / Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.



1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170004049381Y14 8006972125-70	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC Production Approval 1720 East Grant Street PC413NM PHOENIX AZ 85034					5. Work Order/Contract/Invoice Number: 949184 Page 1 of 1	
6.Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	SEAL, HYDRODYNAMIC CARBON, NO. 1	3060457-1	10	17-152826-61795 See Continuation	NEW	
12. Remarks: AIRWORTHINESS APPROVAL Block 10 Serial Number(s): (Continued): 17-152826-61801, 17-152826-61769, 17-152826-61774, 17-152826-61797, 17-152826-61796, 17-152826-61794, 17-152826-61799, 17-152826-61773, 17-152826-61772.						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: 		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Steve Mittelstadt		13e. Date (dd/mmm/yyyy): 13/DEC/2017		14d. Name (Typed or Printed):		14e. Date(dd/mmm/yyyy):
User / Installer Responsibilities It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.						



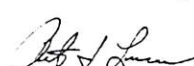
1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170003978117Y15 330397543	
4. Organization Name and Address:		Honeywell International Inc 1944 E Sky Harbor Circle PHOENIX AZ 85034			Repair Station ZN3R030M	
5. Work Order/Contract/Invoice Number: N/A 330397815 Page 1 of 1						

6.Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:
001	SHROUD LPC 1STG	3071873-6	1	N/A	OVERHAULED

12. Remarks:
 THE SERVICE SPECIFIED HAS BEEN ACCOMPLISHED IN ACCORDANCE WITH:
 HMM 72-02-71 Rev 11, OCT/01/2008
 ORI P34538 Rev A, OCT/14/2014

SEE ATTACHED CAFÉ FOR A SUMMARY OF THE MAINTENANCE/WORK ACCOMPLISHED

SEE ATTACHED DOCUMENTS AS APPLICABLE FOR WORK PERFORMED
 CERTIFIES THAT THE WORK SPECIFIED IN BLOCK 11/12 WAS CARRIED OUT IN ACCORDANCE WITH EASA PART 145 AND IN RESPECT TO THAT WORK THE COMPONENT IS CONSIDERED READY FOR RELEASE TO SERVICE UNDER EASA PART 145 APPROVAL NO. EASA 145.4136

13a. Certifies the items identified above were manufactured in conformity to: ☐ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.		14a. ☒ 14 CFR 43.9 Return to Service ☒ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.	
13b. Authorized Signature:	13c. Approval/Authorization No.:	14b. Authorized Signature:	14c. Approval/Certificate No.:
		 	ZN3R030M
13d. Name (Typed or Printed):	13e. Date(dd/mmm/yyyy):	14d. Name (Typed or Printed):	14e. Date(dd/mmm/yyyy):
		Albert J Lucas	28/NOV/2017

User / Installer Responsibilities

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1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170004022415Y14 8006963029-10	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC 1720 East Grant Street PHOENIX AZ 85034 Production Approval PC413NM					5. Work Order/Contract/Invoice Number: 948670 Page 1 of 1	
6.Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	SEAL, HYDRODYNAMIC CARBON, NO. 4	3060437-1	6	17-152826-65585 See Continuation	NEW	
12. Remarks: AIRWORTHINESS APPROVAL Block 10 Serial Number(s): (Continued): 17-152826-65582, 17-152826-65579, 17-152826-65617, 17-152826-65620, 17-152826-65619.						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: 		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Steve Mittelstadt		13e. Date (dd/mm/yyyy): 07/DEC/2017		14d. Name (Typed or Printed):		14e. Date(dd/mm/yyyy):

User / Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.



1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20180004180344Y14 8007061301-10	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC Production Approval 1720 East Grant Street PC413NM PHOENIX AZ 85034					5. Work Order/Contract/Invoice Number: 951910 Page 1 of 1	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	BEARING BALL THR RTR	3075016-1	1	17-151725-06001	NEW	
12. Remarks: AIRWORTHINESS APPROVAL						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: <i>Florie McCrone</i>		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Florie McCrone		13e. Date (dd/mm/yyyy): 16/JAN/2018		14d. Name (Typed or Printed):		14e. Date(dd/mm/yyyy):
User / Installer Responsibilities It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.						



1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170004007169Y14 8006951911-210	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC Production Approval 1720 East Grant Street PC413NM PHOENIX AZ 85034					5. Work Order/Contract/Invoice Number: 948468 Page 1 of 1	
6.Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	SEAL, HYDRODYNAMIC CARBON, NO. 5	3060436-1	1	17-152826-61491 ←	NEW	
12. Remarks: AIRWORTHINESS APPROVAL						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: 		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): Cornet Bonchis		13e. Date (dd/mmm/yyyy): 05/DEC/2017		14d. Name (Typed or Printed):		14e. Date(dd/mmm/yyyy):

User / Installer Responsibilities

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1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20170003169612Y14 8006418021-30	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC 1720 East Grant Street PHOENIX AZ 85034				Production Approval PC413NM		
				5. Work Order/Contract/Invoice Number: 000932403 Page 1 of 1		
6.Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	SHAFT, SHOULDER	3070639-1	2	N/A	NEW	
12. Remarks: AIRWORTHINESS APPROVAL SERIALIZATION NOT REFERENCED IN BLOCK 10 IS NOT REQUIRED OR TRACEABLE BY HONEYWELL INTERNATIONAL INC. REFERENCE FAA ORDER 8130.21						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: <i>Florie McCrone</i>		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		
13d. Name (Typed or Printed): Florie McCrone		13e. Date (dd/mm/yyyy): 06/JUN/2017		14c. Approval/Certificate No.:		
				14d. Name (Typed or Printed):		
				14e. Date(dd/mm/yyyy):		

User / Installer Responsibilities

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Honeywell Rental Engine

TFE 731-40BR-1B

S/N: P-137145

TSN: 871.2

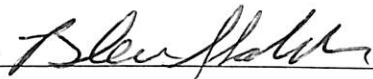
N877W

CSN: 481

- Installed engine in #1 position of Learjet 45-496 with TAT: 1427.9 and LND: 1360.
- Performed post installation operational checks, leak checks, and adjustments.
Serviced engine oil to correct level with Mobil 254.
- Work performed IAW Honeywell TFE 731-40 LMM 72-03-06 revision 12 and aircraft MM. No discrepancies noted.

All maintenance on this Engine was performed in accordance with current regulations of the Federal Aviation Administration FAR 91.409 (f) (3) and is approved for return to service with respect to the work accomplished. For further details, reference W.O. 339512 at this agency. Standard Aero – CRS# XB13606K 17250 Chanute Road, Houston, Texas 77032.

By: Bleu Stalder



12-30-2017



Learjet 75

N877W

S/N: 45-496

TAT: 1427.9

LDGS: 1360

- Removed ship engine PN: TFE731-40BR-1B, SN: P-137179 with TSN: 1427.9 and CSN: 1360 from the #1 position for repairs due to metal in oil system.
- Installed rental engine PN: TFE731-40BR-1B, SN: P-137145 with TSN: 871.2 and CSN: 481 in the #1 position.
- Performed post installation operational checks, leak checks, and adjustments.
Serviced engine oil to correct level with Mobil 254.
- Work performed IAW Honeywell TFE 731-40 LMM 72-03-06 revision 12 and aircraft MM. No discrepancies noted.

All maintenance on this Engine was performed in accordance with current regulations of the Federal Aviation Administration FAR 91.409 (f) (3) and is approved for return to service with respect to the work accomplished. For further details, reference W.O. 339512 at this agency. Standard Aero – CRS# XB13606K 17250 Chanute Road, Houston, Texas 77032.

By: Bleu Stalder



12-30-2017



Position #1

TFE 731-40BR-1B

S/N: P-137179

TSN: 1427.9

N877W

CSN: 1360

- Removed engine from #1 position of Learjet 45-496 with TAT: 1427.9 and LND: 1360 for repairs due to excessive metal in oil.
- Work performed IAW Honeywell TFE 731-40 LMM 72-03-06 revision 12 and aircraft MM. No discrepancies noted.

All maintenance on this Engine was performed in accordance with current regulations of the Federal Aviation Administration FAR 91.409 (f) (3) and is not approved for return to service with respect to the work accomplished. For further details, reference **W.O. 339512** at this agency. **Standard Aero** – CRS# **XB13606K 17250** Chanute Road, Houston, Texas 77032.

By: Bleu Stalder  12-30-2017



StandardAero

GEORGIA CROWN DISTRIBUTING CO.
5290 ARMOUR ROAD
COLUMBUS, GA, USA, 31909

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
05-Dec-2017	1406.6	1344	1406.6	1344						

No. Task No./Position Description

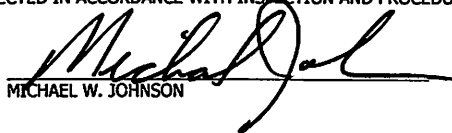
1 057110

NO. 1 ENGINE - PERFORM 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS
INSTRUCTIONS

I CERTIFY THAT THIS ENGINE HAS BEEN INSPECTED IN ACCORDANCE WITH INSPECTION AND PROCEDURES FOR 150-250 INSPECTION UNDER

TFE731 CMM.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

ENGINE ☐
 MODULE ☐
 SERIAL NUMBER _____

SERVICE RECORD

PAGE _____

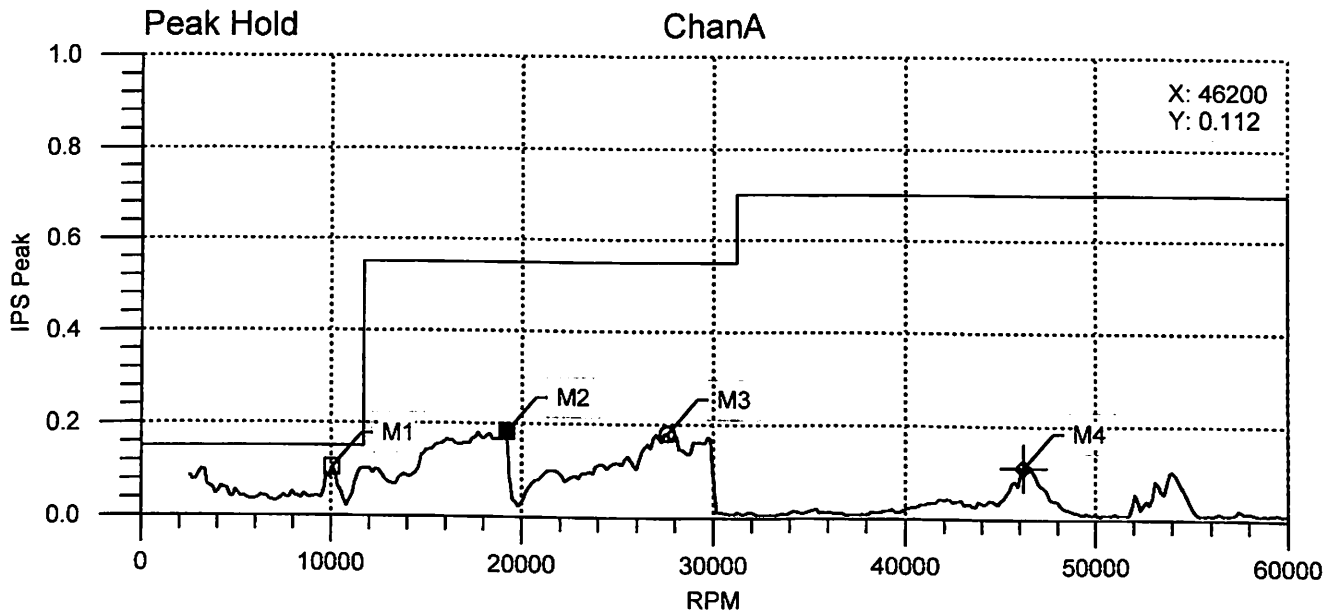
DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER.

DATE	HOURS THIS FLIGHT	CYCLES THIS FLIGHT	ACCUMULATIVE TOTALS				DESCRIPTION OF WORK PERFORMED
			HOURS		CYCLES		
			SINCE NEW	SINCE O/H	SINCE NEW	SINCE O/H	
							TOTALS BROUGHT FORWARD
Engine Log Book Entry							
Customer: Georgia Crown Aviation			Work Order Number: 340452			Date: 12-25-2017	
Serial Number: 45-496		Tail Number: N877W		Model: Lear 75		ACFT: 1427.9	
Engine Position: 1		Engine S/N: P-137179		Engine Time: 1427.9		Engine Cycles: 1360	
Trouble shot cause of chip detector CAS message. Performed SOAP sample and installed new oil filter P/N 3070945-1. Inspected chip detector, collected metal particles, and submitted SOAP sample and all labeled particles collected from oil filter bowl, AGB drain cavity, and TGB drain plug, along with and previous particles collected by customer from chip detector accumulated from latest flight to Jet Care requesting immediate analysis. Per Honeywell Engineering, immediate inspection required due to major M50 particles found. No further action at this time. AGB and TGB oil drained. All maintenance performed IAW Honeywell TFE731-40BR LMM 72-03-96 Rev. 12, Dated May 31, 2013. Details on file under StandardAero W/O: 340452. Note: Engine requires inspection and subsequent repair prior to return to service.  StandardAero Date: 12-25-2017, Signed  (L) 101 for Brian Lewandowski CRS# GW4R221M, Augusta, GA.							
							TOTALS TO DATE

Customer: N877W
Started: 10/23/2017 09:16.03
A/C Reg: 179
Eng S/N: 137739
Eng Pos: 1
Condition: ACCEL
Channel A: ChanA

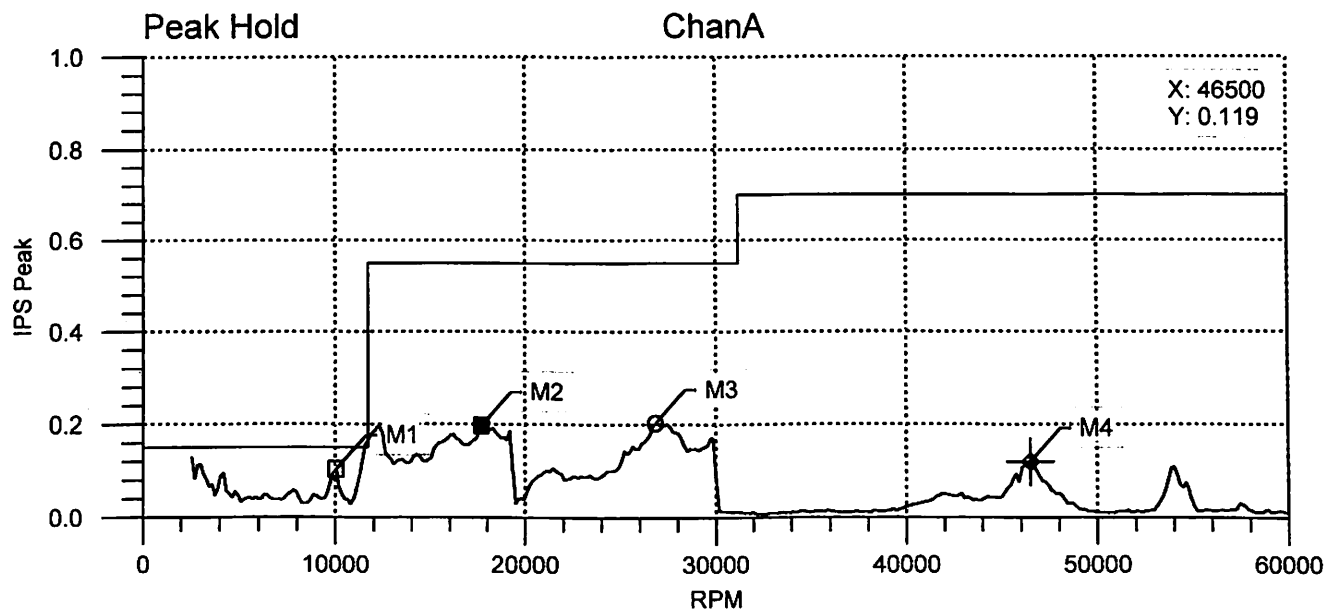
Status: CD
Finished: Yes
A/C Total TM: 0.0
TSO: 0.0
TSN: 0.0



===== Peak List =====				
X (RPM)	Y (IPS Peak)	Frequency (RPM)	Amplitude (IPS Peak)	Label
10050	0.105	10050.00	0.105	M1
19200	0.182	19200.00	0.182	M2
27600	0.180	27600.00	0.180	M3
46200	0.112	46200.00	0.112	M4

Customer: N877W
Started: 10/23/2017 09:20.01
A/C Reg: 179
Eng S/N: 137
Eng Pos: 1
Condition: ACCEL
Channel A: ChanA

Status: CD
Finished: Yes
A/C Total TM: 0.0
TSO: 0.0
TSN: 0.0



===== Peak List =====				
X (RPM)	Y (IPS Peak)	Frequency (RPM)	Amplitude (IPS Peak)	Label
10050	0.103	10050.00	0.103	M1
17700	0.197	17700.00	0.197	M2
26850	0.202	26850.00	0.202	M3
46500	0.119	46500.00	0.119	M4

Honeywell Diskbal Fan**DiskBal Version 2.70****Part File Version 2.7****10-23-2017 19:04:38****Operator thomas**

Disk Part Number 3060287 FAN Civil
Balance Radius 1
Disk Serial Number 13-162246-00731
Assembly Part Number 3060155-6

Engine Serial Number 1371793428.1
Work Order 339093

Sample Statistics (gm)

Minimum 3337.100
Maximum 3497.300
Average 3441.366
Range 160.200
Disk Unbalance(oz-inch) **
Disk Unbalance Angle 0
Assy Unbalance Amt.(oz-inch) 0.278
Assy Unbalance Angle 318

Disk Slot	Blade No.	Moment(gm-in)
1	Blade 1	3427.800
2	Blade 2	3448.800
3	Blade 3	3384.500
4	Blade 4	3497.300
5	Blade 5	3408.000
6	Blade 6	3480.400
7	Blade 7	3405.000
8	Blade 8	3473.800
9	Blade 9	3417.100
10	Blade 10	3470.400
11	Blade 11	3413.800
12	Blade 12	3465.900
13	Blade 13	3422.100
14	Blade 14	3458.700
15	Blade 15	3441.100
16	Blade 16	3460.200
17	Blade 17	3337.100
18	Blade 18	3491.100
19	Blade 19	3433.800
20	Blade 20	3446.300
21	Blade 21	3475.900
22	Blade 22	3476.400
23	Blade 23	3396.900
24	Blade 24	3470.200
25	Blade 25	3380.400
26	Blade 26	3469.800
27	Blade 27	3425.500
28	Blade 28	3470.000
29	Blade 29	3428.900
30	Blade 30	3463.800

Honeywell Diskbal Fan

DiskBal Version 2.70

Part File Version 2.7

10-23-2017 19:13:47

Operator thomas

Disk Part Number 3060287 FAN Civil
Balance Radius 1
Disk Serial Number 13-162246-00731
Assembly Part Number 3060155-6

Engine Serial Number 1371793428.1
Work Order 339093

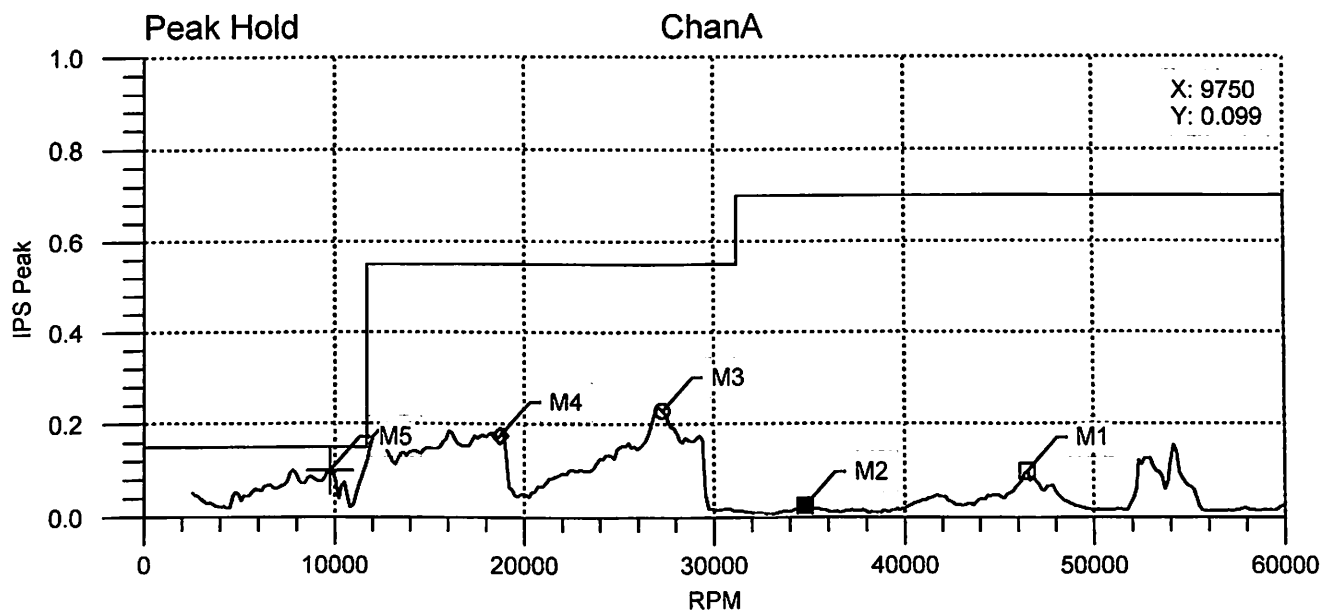
Sample Statistics (gm)

Minimum 3337.100
Maximum 3497.300
Average 3441.366
Range 160.200
Disk Unbalance(oz-inch) 0.000
Disk Unbalance Angle 0
Assy Unbalance Amt.(oz-inch) 0.001
Assy Unbalance Angle 283

Disk Slot	Blade No.	Moment(gm-in)
1	Blade 4	3497.300
2	Blade 17	3337.100
3	Blade 19	3433.800
4	Blade 18	3491.100
5	Blade 20	3446.300
6	Blade 27	3425.500
7	Blade 25	3380.400
8	Blade 15	3441.100
9	Blade 2	3448.800
10	Blade 30	3463.800
11	Blade 24	3470.200
12	Blade 3	3384.500
13	Blade 21	3475.900
14	Blade 28	3470.000
15	Blade 29	3428.900
16	Blade 8	3473.800
17	Blade 6	3480.400
18	Blade 7	3405.000
19	Blade 5	3408.000
20	Blade 11	3413.800
21	Blade 9	3417.100
22	Blade 12	3465.900
23	Blade 1	3427.800
24	Blade 13	3422.100
25	Blade 22	3476.400
26	Blade 16	3460.200
27	Blade 14	3458.700
28	Blade 23	3396.900
29	Blade 10	3470.400
30	Blade 26	3469.800

Customer: 137179
Started: 10/24/2017 08:18.01
A/C Reg:
Eng S/N: 137179
Eng Pos: 1
Condition: ACCEL
Channel A: ChanA

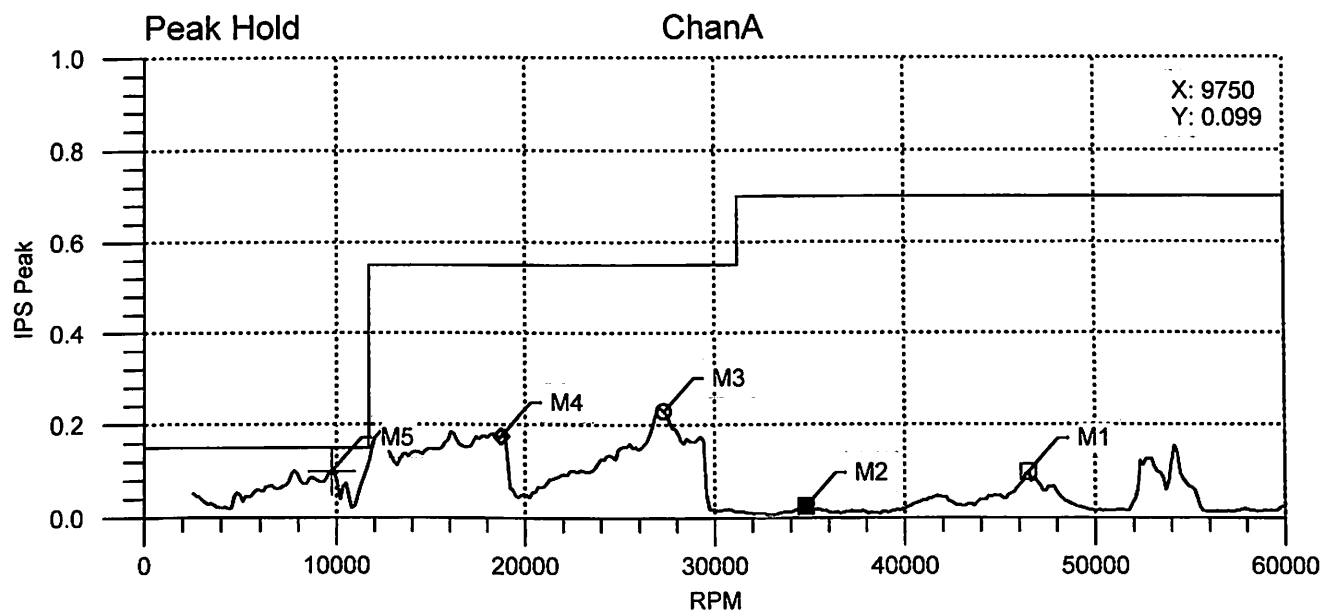
Status: CD
Finished: Yes
A/C Total TM: 0.0
TSO: 0.0
TSN: 0.0



===== Peak List =====				
X (RPM)	Y (IPS Peak)	Frequency (RPM)	Amplitude (IPS Peak)	Label
9750	0.099	9750.00	0.099	M5
18750	0.175	18750.00	0.175	M4
27300	0.228	27300.00	0.228	M3
34800	0.024	34800.00	0.024	M2
46500	0.098	46500.00	0.098	M1

Customer: 137179
Started: 10/24/2017 08:18.01
A/C Reg:
Eng S/N: 137179
Eng Pos: 1
Condition: ACCEL
Channel A: ChanA

Status: CD
Finished: Yes
A/C Total TM: 0.0
TSO: 0.0
TSN: 0.0



===== Peak List =====				
X (RPM)	Y (IPS Peak)	Frequency (RPM)	Amplitude (IPS Peak)	Label
9750	0.099	9750.00	0.099	M5
18750	0.175	18750.00	0.175	M4
27300	0.228	27300.00	0.228	M3
34800	0.024	34800.00	0.024	M2
46500	0.098	46500.00	0.098	M1

SERVICE RECORD ENTRY

StandardAero

Bush Field Airport
1550 Hangar Road
Augusta GA 30906-9684

FAA Repair Station No: GW4R221M
Telephone (706)771-5600

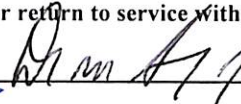
Customer: Georgia Crown LEARJET 45, S/N: 496, N877W	Work Order Number: 339091, 339093	Date: October 24, 2017 ACTT: 1,373.0 LDGS: 1,300
Engine Serial Number: P-137179 Position: L/H	Engine Time: 1,373.0	Engine Cycles: 1,300

1. Dynamically balanced fan assembly to .09 IPS in accordance with Honeywell TFE 731- 40 Light Maintenance Manual 72-03-06 Rev. 12.
2. Accomplished Fan Vibration Survey and found all parameters to be within acceptable limits in accordance with Honeywell TFE 731- 40 Light Maintenance Manual 72-03-06 Rev. 12.
3. Accomplished required operational and leak checks in accordance with Honeywell TFE 731- 40 Light Maintenance Manual 72-03-06 Rev. 12.
4. Accomplished Vibration Survey in accordance with Honeywell TFE 731-20/-40/-50/-60 Light Maintenance Manual 72-03-06 Rev. 12. Results on file.

All maintenance performed on this aircraft / engine was performed in accordance with current regulations of the Federal Aviation Administration and is approved for return to service with respect to the work performed. Details are on file under W/O# 339091, 339093.

Date: October 24, 2017,

Signed: Don M Savage Jr



AG
76

for

StandardAero CRS No., GW4R221M Augusta, GA 30906



Lear 75
N877W
45-496

Georgia Crown Aviation Department

201 Airport Parkway
LaGrange Georgia 30240

Part Number 3062075-1
Model TFE731-40BR-1B
Engine TTSN: 1274.4

Serial number P137179
Engine TCSN: 1219

Date: August 3, 2017

Removed alternator air/oil seal part number 3075815-1
sn 12-152825-19927. Installed new air/oil seal part number
3075815-1 sn 17-152826-50305 IAW Honeywell 731 LMM.

I certify that this engine has been inspected or repaired in accordance with current Federal Aviation Regulation Part 91.409 (F) (3). All test operational tests were performed in accordance with the manufacturer's engine maintenance manual or component maintenance manual. This aircraft is approved for return to service.



Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**

GEORGIA CROWN DISTRIBUTING CO.
5290 ARMOUR ROAD
COLUMBUS, GA, USA, 31909

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
Jun-2017	1211.4	1175	1211.4	1175						

No.	Task No./Position	Description
1	057110	NO. 1 ENGINE - PERFORM 150 TO 250 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
2	057130	NO. 1 ENGINE - PERFORM 500 TO 650 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
3	057140	NO. 1 ENGINE - PERFORM 500 TO 850 HOUR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
4	057150	NO. 1 ENGINE - PERFORM 1000 TO 1300 HR ROUTINE PERIODIC INSP PER MANUFACTURERS INSTRUCTIONS
5	710130	NO. 1 ENGINE - INSPECT TAILPIPE/LPT3 ROTOR ASSEMBLY-VISUALLY INSPECT FOR FOREIGN OBJECT DAMAGE, THERMAL DISTRESS, AND LEAKS.
6	710140	NO. 1 ENGINE - INSPECT INLET/FAN AREA - INSPECT FOR FOREIGN OBJECT DAMAGE AND LEAKAGE (REFER TO PARAGRAPH 4.B)
7	714010	NO. 1 ENGINE - CHECK ELECTRICAL WIRES AND CONNECTIONS - VISUALLY INSPECT FOR SECURITY AND DAMAGE
8	715010	NO. 1 ENGINE - CHECK PLUMBING LINES AND CONNECTIONS - VISUALLY INSPECT FOR SECURITY, LOOSE OR BROKEN CLAMPS OR BRACKETS, LEAKS, CRACKS, CUTS, OR RUBBING
9	727010	NO. 1 ENGINE - INSPECT BYPASS STATOR VANE ASSEMBLY.
10	730120	NO. 1 ENGINE - REPLACE FUEL FILTER ELEMENT
11	732120	NO. 1 ENGINE - INSPECT MOTIVE FLOW FUEL PUMP DRIVE SPLINE
12	790130	NO. 1 ENGINE - ANALYSIS OIL AND FILTER (SOAP)
13	790140	NO. 1 ENGINE - PERFORM OIL CHANGE
14	790150	NO. 1 ENGINE - INSPECT CHIP DETECTOR FOR CONTAMINATION AND PERFORM RESISTANCE CHECK
15	790160	NO. 1 ENGINE - INSPECT CHIP DETECTOR FOR CONTAMINATION
16	793315	NO. 1 ENGINE - CHECK OIL FILTER BYPASS VALVE CIRCUIT/THERMAL LOCKOUT SWITCH

CERTIFY THAT THIS ENGINE HAS BEEN INSPECTED IN ACCORDANCE WITH INSPECTION AND PROCEDURES FOR 1200 INSPECTION UNDER

TFE731 LMM

Work Performed By:

MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:



Georgia Crown Aviation Department

Lear 75
N877W
45-496

201 Airport Parkway
LaGrange Georgia 30240

Part Number 3062075-1
Model TFE731-40BR-1B
Engine TTSN: 1074.3

Serial number P137179
Engine TCSN: 1046

Date: 2.21.2017

1. 057110 NO. 1 ENGINE - PERFORM 150 TO 250 HR ROUTINE PERIODIC INSP
PER MANUFACTURERS INSTRUCTIONS

I certify that this engine has been inspected or repaired in accordance with current Federal Aviation Regulation Part 91.409 (F) (3). All test operational tests were performed in accordance with the manufacturer's engine maintenance manual or component maintenance manual. This aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**



Georgia Crown Aviation Department

Lear 75
N877W
45-496

201 Airport Parkway
LaGrange Georgia 30240

Part Number 3062075-1
Model TFE731-40BR-1B
Engine TTSN: 907.7

Serial number P137179
Engine TCSN: 906

Date: October 12, 2016

0157110 Engine 1 150/250 Routine Inspection

790130 Oil and Filter SOAP

790160 Inspect Chip Detector

I certify that this engine has been inspected or repaired in accordance with current Federal Aviation Regulation Part 91.409 (F) (3). All test operational tests were performed in accordance with the manufacturer's engine maintenance manual or component maintenance manual. This aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**



Lear 75
N877W
45-496

Georgia Crown Aviation Department

201 Airport Parkway
LaGrange, Georgia 31909

Aircraft TTSN: 801.5 Aircraft TCSN: 803
Engine 1 Part Number: 3062075-1
Engine 1 Model: TFE731-40BR-1B
Engine 1 Serial Number: P137179
Engine TTSN: 801.5
Engine TCSN: 803
Date: July 7, 2016

Completed the following tasks:

1. 057110 150-250 Hour Routine Periodic Inspection
2. 057140 500-850 Hour Routine Periodic Inspection
3. 710130 Inspect Tail Pipe/LPT3 Rotor
4. 710140 Inspect Inlet/ Fan for FOD Damage
5. 714010 Inspect Electrical Wires and Connections
6. 761330A DEEC Download

I certify that this engine has been inspected in accordance with current Federal Aviation Regulation Part 91.409 (F) (3) and current aircraft and engine manufacturer's maintenance manuals. All functional and operational checks were satisfactory and this aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**



Lear 75
N877W
45-496

Georgia Crown Aviation Department

201 Airport Parkway
LaGrange Georgia 30240

Part Number 3062075-1
Model TFE731-40BR-1B
Engine TTSN: 614.0

Serial number P137179
Engine TCSN: 600

Date: March 5, 2016

Completed the following tasks

1. **057110** Number 1 Engine 150-250 Routine Periodic Inspection
 - **790130** Oil Analysis and Filter
 - **790160** Inspect Chip Detector for Contamination

2. **057130** Number 1 Engine 500-650 Routine Periodic Inspection
 - **730120** Replace Fuel Filter
 - **732120** Inspect Motive Flow Fuel Pump Drive Spline
 - **790150** Inspection Chip Detector for Contamination

I certify that this engine has been inspected or repaired in accordance with current Federal Aviation Regulation Part 91.409 (F) (3). All test operational tests were performed in accordance with the manufacturer's engine maintenance manual or component maintenance manual. This aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**



N877W
45-496
TFE731-40BR-1B

Georgia Crown Aviation Department
5290 Amour Road
Columbus Georgia 31909

Part Number 3062075-1

Serial Number: P137179

TTSN: 497.80

TCSN: 489

Date: December 14, 2015

Completed 150/250 Hour Engine Routine Periodic Inspection per Honeywell

TFE731-40 LMM.

- Completed Oil and Filter (SOAP) Inspection
- Inspected Chip Detector for Contamination

I certify that this engine has been repaired in accordance with current Federal Aviation Regulations and approved for return to service.


Michael W. Johnson

Georgia Crown Aviation Department

Aviation Maintenance Technician

Airframe and Powerplant License Number: **3481311**

SERIAL NUMBER

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

PAGE

PX. 7-51

ENGINE ☒
MODULE ☐
SERIAL NUMBER

SERVICE RECORD

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

PAGE _____

DATE

HOURS
THIS
FLIGHT



N877W
45-496
TFE731-40BR-1B

Georgia Crown Aviation Department

5290 Amour Road
Columbus Georgia 31909

Part Number 3062075-1

Serial Number: P137179

TTSN: 162.5

TCSN: 158

Date: March 26, 2015

Completed 150/250 Hour Engine Routine Periodic Inspection per Honeywell

TFE731-40 LMM.

- Completed Oil and Filter (SOAP) Inspection
- Inspected Chip Detector for Contamination

I certify that this engine has been repaired in accordance with current Federal Aviation Regulations and approved for return to service.

Michael W. Johnson

Michael W. Johnson

Georgia Crown Aviation Department

Aviation Maintenance Technician

Airframe and Powerplant License Number: **3481311**

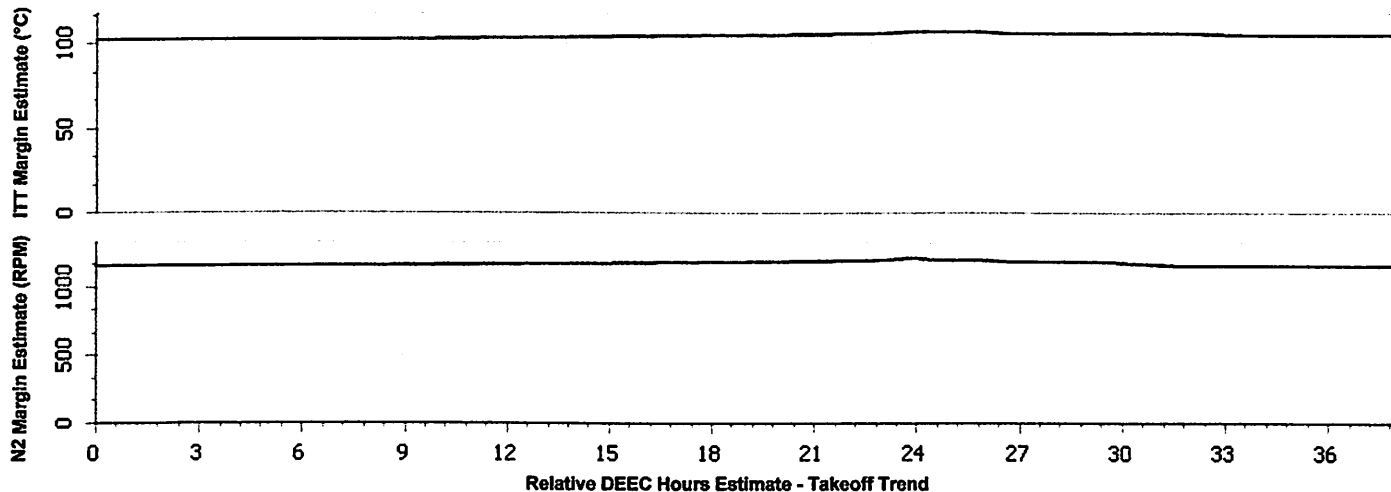
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TOTALS TO DATE

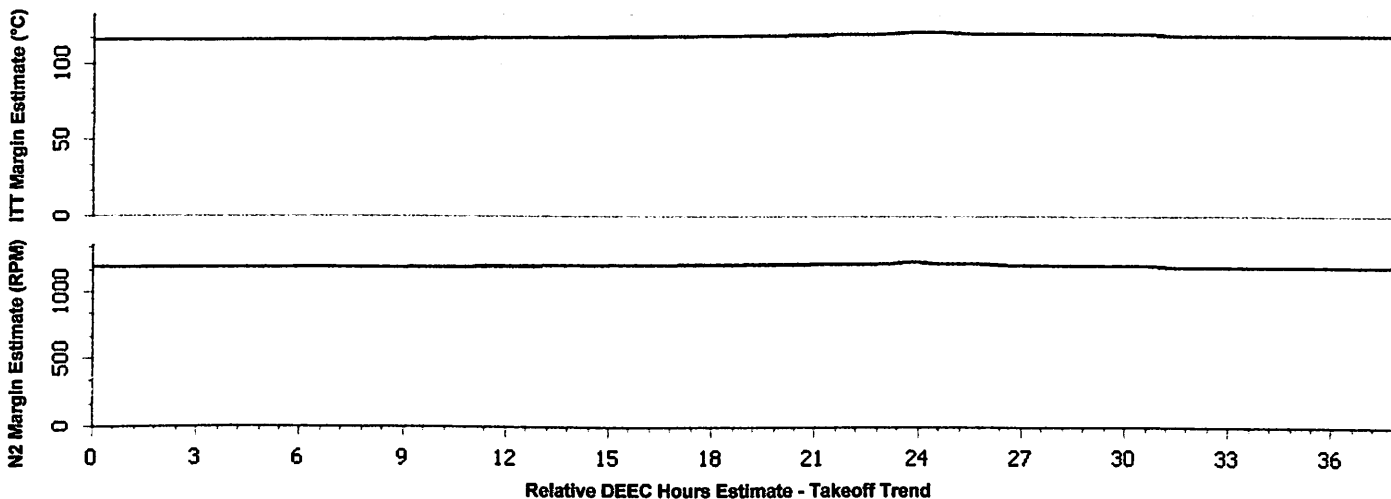
Trend Plot - N877W

AIRCRAFT	SERIAL/REGNO: 45-496/N877W	MODEL: LEARJET 75	MANUFACTURER: BOMBARDIER INCORPORATED
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ENGINE NO. 1	SERIAL/PART: P137179/3062075-1	MODEL: TFE731-40BR-1B	MANUFACTURER: HONEYWELL
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ENGINE NO. 2	SERIAL/PART: P137180/3062075-1	MODEL: TFE731-40BR-1B	MANUFACTURER: HONEYWELL
--------------	--------------------------------	-----------------------	-------------------------



CAMP is authorized by Honeywell to provide engine performance trend monitoring for the TFE731 propulsion engines.

Engine Status Review - N877W

OWNER: GEORGIA CROWN DISTRIBUTING CO.
ADDRESS: PO BOX 7908
 COLUMBUS, GA 31908
PHONE: 706-322-0086
FAX: 706-322-9583

OPERATOR: GEORGIA CROWN DISTRIBUTING CO.
ADDRESS: PO BOX 7908
 COLUMBUS, GA 31908
PHONE: 706-322-0086
FAX: 706-322-9583

AIRCRAFT SERIAL/REGNO: 45-496/N877W MODEL: LEARJET 75 MANUFACTURER: BOMBARDIER INCORPORATED

IN-SERVICE DATE: N/A

LAST ACTUALS:

99 AFL as of 14-Jan-2015
 2700 APH as of 14-Jan-2015
 103.60 HRS as of 14-Jan-2015

ENGINE NO. 1 SERIAL/PART: P137179/3062075-1 MODEL: TFE731-40BR-1B MANUFACTURER: HONEYWELL

INSTALLED ON: 21-Aug-2014

LAST ACTUALS:

99 ENC as of 14-Jan-2015
 103.60 HRS as of 14-Jan-2015

OPEN FAULT CODES: 4

SOAP STATUS: NORMAL

SOAP STATUS DATE: 12-Dec-2014

Engine Health Status

Last Upload Date	Last Run Date	Last Review Date	Certified CAMP Analyst	Status
29-Dec-2014	29-Dec-2014	31-Dec-2014	RAJASHEKAR AVULA	✓ Normal

Takeoff Trend Status

Baseline Date	Last Data Date	ITT Margin Estimate (°C)	N2 Margin Estimate (RPM)	# of Snapshots	Status
N/A	29-Dec-2014	105	1156	14	✓ Trend Normal

ENGINE NO. 2 SERIAL/PART: P137180/3062075-1 MODEL: TFE731-40BR-1B MANUFACTURER: HONEYWELL

INSTALLED ON: 21-Aug-2014

LAST ACTUALS:

99 ENC as of 14-Jan-2015
 103.60 HRS as of 14-Jan-2015

OPEN FAULT CODES: 6

SOAP STATUS: NORMAL

SOAP STATUS DATE: 12-Dec-2014

Engine Health Status

Last Upload Date	Last Run Date	Last Review Date	Certified CAMP Analyst	Status
29-Dec-2014	29-Dec-2014	31-Dec-2014	RAJASHEKAR AVULA	✓ Normal

Takeoff Trend Status

Baseline Date	Last Data Date	ITT Margin Estimate (°C)	N2 Margin Estimate (RPM)	# of Snapshots	Status
N/A	29-Dec-2014	118	1185	14	✓ Trend Normal

Dear MICHAEL JOHNSON,

This statement is to inform you of the status of your aircraft under CAMP's Engine Health Monitoring program. Below you will find a summarized overview of your fleet grouped by aircraft model with the aircraft having the most severe status listed first. In the pages that follow you will find a detailed EHM status report for each aircraft selected for this report.

AIRCRAFT SUMMARY						
REG #	ENGINE SERIAL #	POSITION	LAST UPLOAD DATE	LAST RUN DATE	LAST REVIEW DATE	STATUS
LEARJET 75						
N877W	P137179	1	29-Dec-2014	29-Dec-2014	31-Dec-2014	✓ Normal
	P137180	2	29-Dec-2014	29-Dec-2014	31-Dec-2014	✓ Normal
SEVERITY LEGEND						
✓ Normal	■ Notification	■ Recommendation	■ Advisory	■ Critical		

All timestamps in this report are represented in UTC.

We encourage you to contact our office should you have any questions or concerns.

North-America: **1-844-CAMP-EHM (226-7346)**

International: **450-640-3286**

E-mail: TrendSupport@CAMPSystems.com

Data: TrendData@CAMPSystems.com

Fax: **800-750-5655**

Website: www.campsystems.com

CAMP Systems International

375 boul. Roland-Therrien, Suite 140

Longueuil, Quebec, J4H4A6

Canada

SERIAL NUMBER

SERVICE RECORD

PAGE

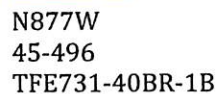
DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

[illegible]

SERIAL NUMBER

**HOURS
THIS
FLIGHT**



TFE731-40BR-1B

Serial Number: P137179

TCSN: 47

Date: December 9, 2014

1. Removed N1 Compensator part number 3060735-4 serial number 1316909400706.

Installed overhauled N1 Compensator part number 3060735-4 serial number 981309700388

In accordance with Honeywell LMM 77-10-03. Operational test proved satisfactory.

2. Performed recommended 25 Hour SOAP sample per Honeywell LMM. No leaks noted on engine run. Service engine with Mobil 254.

I certify that this engine has been repaired in accordance with current Federal Aviation Regulations and approved for return to service.

Michael W. Johnson

Georgia Crown Aviation Department

Aviation Maintenance Technician

Airframe and Powerplant License Number: 3481311

TE NUMBER

MED

PX-3107-51

SERIAL NUMBER

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

PAGE _____

[illegible]

BOMBARDIER
the evolution of mobility

Learjet Inc.
Wichita Service Center
Bldg 7, Dock 10, 8220 W. Harry
Wichita, KS 67209-2924
1-316-946-2000
FAA/CRS # LK2R981K

**Non-Routine
Aircraft/Component
Service Order**

Page 1 of 1

THIS FORM IS USED TO DOCUMENT MAINTENANCE PERFORMED IN ACCORDANCE WITH PROCEDURE 3.5 - CRT/AOG

1. Work Order Number: 175733		2. Registration: N 877W		3. Aircraft Model and S/N: 45-426	
4a. Aircraft		4b. Engine 1		4c. Engine 2	
Hrs: 28.8	Cyc: 36	Hrs: 28.8	Cyc: 36	Hrs: 28.8	Cyc: 36
5. Preliminary inspection performed (stamp or signature) Robert Em				6. INDICATE RII OR OTHER SPECIAL 135/121 OPERATOR REQUIREMENT	

7. SvO # 11350944	8. WRITTEN BY: Robert Em	9. DATE: 12/3/14	10. AUTHORIZED BY: Robert Em
11. DISCREPANCY/TASK: 0001- LH Eng Roll Back and went to MM. rpspt and again went to MM, Amber LH Fault			
12. CORRECTIVE ACTION: FOUND FAULT 112 RANG OUT HI COMPESATOR, NO DEFECTS NOTED. SWAPPED DEECS L/H TO R/H & R/H TO L/H, FAULT CLEARED SWAPPED DEECS BACK TO ORIGINAL POSITION. ALL WORK DONE PER HONEYWELL LMM ch 72-00 Rev 12			

13. ESTIMATE HOURS		14. WARRANTY CONSIDERATION: YES ☐ / NO ☐		15. PERFORMED BY & DATE: 12-3-14		16. CHECKED BY & DATE: 12-3-14	
--------------------	--	---	--	--	--	--	--

SvO # 11351025	WRITTEN BY:	DATE:	AUTHORIZED BY:
DISCREPANCY/TASK: 0002-			

CORRECTIVE ACTION:	
NOT USED	

ESTIMATE HOURS:		WARRANTY CONSIDERATION YES ☐ / NO ☐		PERFORMED BY & DATE:		CHECKED BY & DATE:	
-----------------	--	--	--	----------------------	--	--------------------	--

SERIALIZED or ROTABLE COMPONENT INFORMATION						
OPERATION #	NOMENCLAT	PART NUMBER OFF	SERIAL # OFF	PART NUMBER ON	SERIAL # ON	TSN/TSO (IF APPLICABLE)
17	18	19	20	21	22	23
0001	L/H DEEC	2118882-8001	93-B70058			
0001	R/H DEEC	2118882-8001	103-B70061			

FINAL INSPECTION AND AIRWORTHINESS RELEASE	
The aircraft identified above was repaired and inspected in accordance with current Federal Aviation Regulations and found airworthy with respect to the work performed/completed. (Airworthiness Release may exclude discrepancies not worked/completed)	
24. INSPECTORS SIGNATURE Robert Em	25. DATE OF RELEASE 12-3-14

ENGINE ☒
MODULE ☐
SERIAL NUM

SERVICE RECORD

PAGE _____

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

[illegible]

SERIAL NUMBER P137179

SERVICE RECORD

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

[illegible]

TFE731-40BR

Honeywell

TRACKING NO:	004	FSE WORK INSTRUCTION NUMBER:	731-40-P14-004
--------------	-----	------------------------------	----------------

DESCRIPTION OF WORK: This work instruction is required to repair a delaminated composite bypass duct load spreader and some minor scratches.

REFERENCED DOCUMENTS

DOCUMENT NUMBER	REV.	TITLE
3061300-7		DUCT, BYPASS, UPPER
3061300-8		DUCT, BYPASS, LOWER

REQUIRED PARTS / MATERIAL

PART NUMBER	QTY REM.	QTY INST.	F/N	SERIAL NUMBER	NOMENCLATURE
Hysol EA 9394					Adhesive
Base CA-3000/F-Clear Activator 3000B- MIL-PRF-22750					Epoxy Topcoat

AFFECTED ENGINE P137179
SERIAL NUMBERS:

COMMENTS: Activity is to repair the bypass duct.

	Signature	Date
FSE Work Instruction Approved by:	Tony D'Angelo Digitally signed by Tony DN: cn=Tony, o, ou, email=anthony.dangelo@honeywell.com, c=US Date: 2014.08.19 09:37:39 -0700	
Work Completed by (HON Representative):	<i>Jim Beasley</i>	8-22-14 (QC71)
Work Accepted by (Honeywell FSE):	<i>Jim Beasley</i>	8-22-14 (QC71)
Field Service Report (FSR) Number:		

TRACKING NO:	004	FSE WORK INSTRUCTION NUMBER:	731-40-P14-004
--------------	-----	------------------------------	----------------

GENERAL:

This instruction is required to repair the bypass duct.

Engine log book entry will be required.

DETAILED INSTRUCTIONS:**Scratches in Finish**

1. Ensure that the scratches do not extend into the composite fabric (are less than 0.008 inch deep).

CAUTION: ABRASE SURFACE ONLY ENOUGH TO PROVIDE SURFACE TEXTURE FOR CLEAR EPOXY TOPCOAT ADHESION.

2. Using 320 – 600 grit wet or dry sand paper, lightly hand abrade surface to be coated, then blow off surfaces with low pressure compressed air to remove dust.
3. Wipe surfaces clean with a clean, lint-free cloth moistened with solvent (acetone or isopropyl alcohol). Turn or replace the cloth and continue to clean until no evidence of abrasive or dirt is visible.
4. Prepare the epoxy topcoat (~~Base CA 3000/F Clear, Activator 30004~~ ^{MIL-PRF-22750} ^{QC71}) per manufacturer's instructions.
5. Brush the topcoat onto the surface using a non-contaminating paintbrush applying an even coat.
6. Allow the epoxy topcoat to cure in accordance with manufacturer's instructions.

Delaminated Load Spreader

1. Prepare adhesive (Hysol EA 9394) per manufacturer's instructions.
2. Load adhesive into a syringe.
3. Apply the adhesive to the stiffener and position the stiffener on the composite flange. Use pins to align the stiffener holes to the flange. Lightly clamp stiffener in place.
4. Clean-up excessive adhesive around the stiffener and flange. The adhesive should completely fill the area between the stiffener radius and the composite flange radius. Bolt holes must be free of adhesive.
5. Allow the adhesive to cure per manufacturer's instructions while clamped.

TFE731-40BR

Honeywell

TRACKING NO:	004	FSE WORK INSTRUCTION NUMBER:	731-40-P14-004
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Make an entry in the engine log book.

- a. Date, T/T, inspection performed per FSE WI 731-40-P14-004. Work completed by (FSE name) (quality stamp). Honeywell Production Certificate PC413NM.

TFE731-40BR

Honeywell

TRACKING NO:	002B	FSE WORK INSTRUCTION NUMBER:	731-40-P14-002B
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DESCRIPTION OF WORK: Reason for revision – correct blade retainer part number, change recording of blade machining lot numbers to optional and add requirement for LPT2 rotor life limit card entry.

Disassemble engine to remove the LPT2 rotor assembly for inspection.

Please record each of the 52 blade casting lot numbers on the sheet provided and forward the information to engineering: anthony.dangelo@honeywell.com.

Recording the machining lot number of the blades is desirable but not required.

REFERENCED DOCUMENTS

DOCUMENT NUMBER	REV.	TITLE
3060608-5	--	LPT2 ROTOR ASSEMBLY

REQUIRED PARTS / MATERIAL

PART NUMBER	QTY REM.	QTY INST.	F/N	SERIAL NUMBER	NOMENCLATURE
3061829-1		AR			Blade Retainer
PCS5720		AR			Compound
73563-21		1			T-Lock, Turbine
PCS5723		AR			Compound
73563-10		1			T-Lock, Turbine monopole sensor
3060642-1		1			Gasket, Aft Bearing Cover
		AR			Scotch tape
M83248/1-012		1			Packing
651-534-9612		1			E-Seal, Turbine
M83248/1-013		2			Packing
M83248/1-011		2			Packing
Engine Serial Number				LPT2 Rotor Serial Number	
P137179	1			12-156103-00739	
P137179		1		12-156103-00173	

AFFECTED ENGINE SERIAL NUMBERS:

P137149, P137150, P137159, P137160, P137171, P137172, P137173, P137174, P137175, P137176, P137177, P137178, P137179, P137180, P137181, P137182, P137183, P137184, P137185, P137186, P137187, P137188, P137189, P137190, P137191, P137192, P137193, P137194

TRACKING NO:	002B	FSE WORK INSTRUCTION NUMBER:	731-40-P14-002B
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COMMENTS: Activity is to access the LPT2 rotor assembly and inspect the LPT2 blades. Also, record the casting lot numbers (machining lot numbers optional) on pages 4 and 5 of this instruction. The location of the lot numbers is shown in the detailed instructions attached.

Rotor assemblies shall have each of the 52 blades inspected by eddy current. As an option, the rotor assembly may be returned to Honeywell for inspection. Replacement rotor assemblies will have eddy current inspection stamps on each blade (see detailed instructions).

Any blades that fail eddy current inspection must be replaced with a blade with an eddy current inspection stamp, or, perform the eddy current inspection on any blade that does not contain the stamp.

Please return blades that fail eddy current inspection to Honeywell at the following address:

Honeywell Aerospace
3131 East Airline
Phoenix, AZ 85034
Attn: NDE Engineering MS 403-NDT

All LPT2 rotor assemblies shall be returned to:

Honeywell Engines
RHAC TEAM PLANT 1015
111 South 34TH Street
Phoenix, AZ. 85072

	Signature	Date
FSE Work Instruction Approved by:	Tony D'Angelo Digitally signed by Tony DN: cn=Tony, o, ou, email=anthony.dangelo@honeywell.com, c=US Date: 2014.06.26 06:50:40 -07'00'	
Work Completed by (HON Representative):	Jim Beasley HON/FSE	11-13-14 (GC71)
Work Accepted by (Honeywell FSE):	Jim Beasley HON/FSE	11-13-14 (GC71)
Field Service Report (FSR) Number:		

TRACKING NO:	002B	FSE WORK INSTRUCTION NUMBER:	731-40-P14-002B
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GENERAL:

This instruction is required to remove the LPT2 rotor assembly for inspection. Detailed instructions are attached for engine disassembly, inspection and reassembly.

Engine log book and LPT2 life limit card entries will be required.

DETAILED INSTRUCTIONS:

1. See attached for detailed instructions.
2. Check and ensure proper engine operation – perform leak check and vibration survey.
3. Make an entry in the engine log book.
 - a. Date, T/T, inspection performed per FSE WI 731-40-P14-002B. If required, record the LPT2 Rotor Assy PN, SN removed and LPT2 Rotor Assy PN, SN installed. Work completed by (FSE name) (quality stamp). Honeywell Production Certificate PC413NM.
4. Provide a copy of the engine log book page after sign-off by scanning it and email to engineering: anthony.dangelo@honeywell.com.
5. LPT2 Rotor assemblies eddy current inspected and installed into engines must have an entry made on the back of the Life Limit Card as follows:
 - a. DATE – date on which the inspection was performed
 - b. Signature and Stamp – shall be that of the eddy current inspector

LIFE LIMITED PART REPAIR RECORD		
DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE
6/24/2014	Inspection per 21-15477	Name and UQR stamp

TFE731-40BR

Honeywell

TRACKING NO:	002B	FSE WORK INSTRUCTION NUMBER:	731-40-P14-002B
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TFE731-40BR ENGINE S/N

[illegible]

See Attached

Honeywell

Outgoing LPT2 Blade PN 3075424 Data Form

NOTE: Document the blade dash number, blade casting, and machining lot numbers for each blade.

If the blade dash number or machining lot number is not visible on the blade, it is not required to record the dash number or machining lot number for that blade, but casting lot number is required.

After form has been completed and is ready for submission, click "Submit Form".

Enter the engine serial number as the new file name, and click "Save" to save to your computer hard drive. An email window will open with the file attached, add any email address for copy, if desired, and press send.

Date of Inspection: 7/12/14

Inspector: Mark Stroot

Inspection Facility: Bombardier Wichita

Aircraft SN: 45-485 496 1B 

Engine SN: P-137179

Engine TSN: 0

Engine CSN: 0

LPT2 Rotor Assy PN: 3060608-5

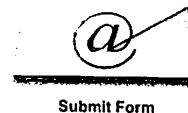
LPT2 Rotor Assy SN: 12-156103-00173

LPT2 Rotor Assy TSN: 0

LPT2 Rotor Assy CSN: 0

Record Data for LPT2 Blades, PN 3075424 Being Installed							
Blade Position	Blade Dash Number	Blade Casting Lot Number	Blade Machining Lot Number	Blade Position	Blade Dash Number	Blade Casting Lot Number	Blade Machining Lot Number
1	-2	ECWM	HM-4154	27	-2	ECLN	HM-3128
2	-2	ECNL	HM-3129	28	-2	ECMD	HM-3129
3	-2	ECLR	HM-3128	29	-2	ECLW	HM-3129
4	-2	ECLM	HM-3129	30	-2	ECLP	HM-3128
5	-2	ECPA	HM-3106	31	-2	ECMD	HM-3128
6	-2	ECLW	HM-3128	32	-2	ECMD	HM-3129
7	-2	ECNK	HM-3129	33	-2	ECMD	HM-3129
8	-2	ECLY	HM-3129	34	-2	ECLN	HM-3128
9	-2	ECLR	HM-3129	35	-2	ECMF	HM-3129
10	-2	ECLP	HM-3128	36	-2	ECLP	HM-3129
11	-2	ECLU	HM-3128	37	-2	ECMR	HM-3106
12	-2	ECLY	HM-3129	38	-2	ECMD	HM-3129
13	-2	ECLU	HM-3128	39	-2	ECPA	HM-3106
14	-2	ECLU	HM-3128	40	-2	ECMT	HM-3106
15	-2	ECNE	HM-3128	41	-2	ECLT	HM-3128
16	-2	ECNL	HM-3128	42	-2	ECMJ	HM-3128
17	-2	ECNG	HM-3128	43	-2	ECLW	HM-3128
18	-2	ECNE	HM-3106	44	-2	ECMJ	HM-3128
19	-2	ECNE	HM-3052	45	-2	ECNK	HM-3129
20	-2	ECMG	HM-3129	46	-2	ECMG	HM-3129
21	-2	ECMD	HM-3129	47	-2	ECNL	HM-3128
22	-2	ECMD	HM-3129	48	-2	ECMF	HM-3129
23	-2	ECMD	HM-3129	49	-2	ECMH	HM-3128
24	-2	ECMD	HM-3129	50	-2	ECMD	HM-3129
25	-2	ECLR	HM-3128	51	-2	ECLN	HM-3129
26	-2	ECMF	HM-3128	52	-2	ECLN	HM-3128

NOTE: All blades must be identified with an EC inspection acceptance ink stamp.
Form will be emailed to tfedata@honeywell.com



TFE731-40BR

Honeywell

TRACKING NO:	002B	FSE WORK INSTRUCTION NUMBER:	731-40-P14-002B
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[illegible]

TFE731-40BR

DIS-ASSEMBLY INSTRUCTIONS TO REMOVE AND REPLACE P/N 3060608-5 LPT2 ROTOR ASSEMBLY

See supplemental instructions (following) for performing eddy current inspection of the LPT2 rotor assembly and for LPT2 blade replacement.

Part	70060013-906	P/N Desc	70060013 LMAASA -40 P&E INSTALLATION	Alternate MOT#	000*	Rev	G	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	500	OP Desc	number 6 BRG TUBES - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

CAUTION:

Use back-up wrenches
when securing tubing.

CAUTION:

Maintain proper clearance
between tubing and surrounding
hardware when installing.

1. Install FN112 and 129
oil tubes with hardware
indicated.
2. Install FN E071 & FN E072 to N1 lead
and FN D112 as shown using hardware
indicated.

Parts [14]

SEQ	Part	FindNo	Name	Qty	AltQty
	MS9556-06	D427	SCREW, MACHINE	4	
	PCS5720(QS3166)	D490	COMPOUND (NPC60301-1 REF)		A/R
	211-536-9104	E071	CLAMP	1	
	211-536-9106	E072	CLAMP, LOOP	1	
	MS9556-06	E096	SCREW, MACHINE	1	
	MS21043-3	E114	NUT, SELF-LOCKING	1	
	PCS5723	E151	ANTISEIZE, MOLYDISULFIDE		A/R

Parts [14]

Tools [0]

REMOVE TAILPIPE COVER

REMOVE #6 OIL SUPPLY AND SCAVENGE TUBES AND CLAMPS (NEXT PAGE) AS SHOWN.

Part	70060013-906	P/N Desc	70060013 LMAASA -40 P&E INSTALLATION	Alternate MOT#	000*	Rev	G	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	500	OP Desc	number 6 BRG TUBES - INSTALL	Work Center		Setup Time		Run Time											

Instructions
Reference Documents [5]

CAUTION:

Use back-up wrenches
when securing tubing.

CAUTION:

Maintain proper clearance
between tubing and surrounding
hardware when installing.

1. Install FN112 and D129
oil tubes with hardware
indicated.
2. Install FN E071 & FN E072 to N1 lead
and FN D112 as shown using hardware
indicated.

Parts [14]

SEQ	Part	FindNo	Name	Qty	AltQty
	3060909-1	D112	TUBE ASSY, METAL	1	
	3060964-1	D129	TUBE ASSY	1	
	3060646-1	D250	RETAINER PLATE	1	
	3060647-1	D251	RETAINER PLATE	1	
	M83248/1-013	D305	PACKING	2	
	M83248/1-011	D360	Packing, O-Ring	2	
	MS9556-06	D425	SCREW MACHINE	1	

Attachments

REMOVE N1 MONOPOLE AND COVER

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0230	OP Desc	N1 SENSOR - INSTALL	Work Center		Setup Time		Run Time											

Instructions

NOTE:
Ensure cover is seated flush and maintain downward force when securing.
1. Install FN87 gasket and FN88 exciter/cover assy with bolts.

**INITIAL TORQUE OF COVER ON THIS OPERATION.
FINAL TORQUE TO BE DONE AT LATER OPERATION**

2. Install FN138 sensor as shown.

Attachments

12 O'CLOCK

301 30 210 (9) PLACES 87 88 301 30 211 (2) PLACES 301 50 138 VIEW P-P

TORQUE BOLTS TO SECURE N1 SPEED SENSOR TO TAILPIPE (2) PLACES

Parts [6]

SEQ	Part	FindNo	Name	Qty	AltQty
	3060642-1	0087	GASKET COVER	1	
	3060658-5	0088	COVER - EXCITER	1	
	3060714-4	0138	SENSOR SPEED NI MONO		REF
	MS9556-07	0210	BOLT	9	
	MS9556-31	0211	MACHINE BOLT	2	
	PCS5720(QS3166)	0301	COMPOUND (NPC60301-1 REF)		A/R

Tools [2]

Rev	Part	Name
-	MAT2386	BREAKER BAR
-	T216734	TANGED WRENCH

Parts [6] Tools [2]

REMOVE EXCITER GEAR NUT. (SEE NEXT PAGE FOR TOOLING)

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0210	OP Desc	EXCITER GEAR NUT - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

- TRACEABLE ITEM THIS OPERATION -

1. Install FN84 nut with FN304 lubricant and FN85 lock-key as shown.
2. Torque nut per procedure below and record on build sheet FORMULA 8.

TORQUING PROCEDURE:

- Initial torque nut to 1200 in/lbs
- Locate lock-key slot that best aligns
- Back-off nut and install lock-key
- Retorque nut to 1200 in.lbs
- Apply additional torque for alignment

- DO NOT EXCEED 1400 IN/LBS -

- Bend lock-key into slot

Parts [3]

SEQ	Part	FindNo	Name	Qty	AltQty
1	3070163-1	0084	SLOTTED NUT	1	
2	73563-10	0085	KEY NUT LKG	1	
3	PCS5723(QS3043)	0304	MOLY LUBE (QS3043)		A/R

Parts [3]

Tools [2]

Attachments

TOOLING →

304
84
INITIAL TQ - 1200 IN/LBS
MAXIMUM TQ - 1400 IN/LBS

85

TOOLING FOR REMOVING EXCITER GEAR NUT OR ALTERNATE EQUIVALENT TOOLING

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0210	OP Desc	EXCITER GEAR NUT - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

- TRACEABLE ITEM THIS OPERATION -

1. Install FN84 nut with FN304 lubricant and FN85 lock-key as shown.
2. Torque nut per procedure below and record on build sheet FORMULA 8.

TORQUING PROCEDURE:

- Initial torque nut to 1200 in/lbs
- Locate lock-key slot that best aligns
- Back-off nut and install lock-key
- Retorque nut to 1200 in.lbs
- Apply additional torque for alignment

- DO NOT EXCEED 1400 IN/LBS -

- Bend lock-key into slot

A) INITIAL TQ 1200 IN/LBS

B) LOCATE LOCK-TAB SLOT THAT BEST ALIGNS

C) BACK-OFF NUT AND INSTALL LOCK-KEY IN SLOT

D) RE-TORQUE TO 1200 IN/LBS

E) APPLY ADDITIONAL TQ TO ALIGN LOCK-KEY WITH SLOT

- DO NOT EXCEED 1400 IN/LBS -



- MAINTAIN 90° ANGLE -



STANDARD TQ WRENCH



T216734



MAT2386 (OR EQUIVALENT)

Tools [2]

Rev	Part	Name
-	MAT2386	BREAKER BAR
-	T216734	TANGED WRENCH

Parts [3]

Tools [2]

REMOVE EXCITER GEAR (SEE NEXT PAGE FOR TOOLING)

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0200	OP Desc	EXCITER GEAR - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

- TRACEABLE ITEM THIS OPERATION -

1. Install FN83 gear using T216732 as shown.

Parts [1]

SEQ	Part	FindNo	Name	Qty	AltQty
	3060601-2	0083	EXCITER, SPEED SENSO	1	

Parts [1]

Tools [1]



TOOLING FOR EXCITER GEAR REMOVAL (OR EQUIVALENT)

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0200	OP Desc	EXCITER GEAR - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

- TRACEABLE ITEM THIS OPERATION -

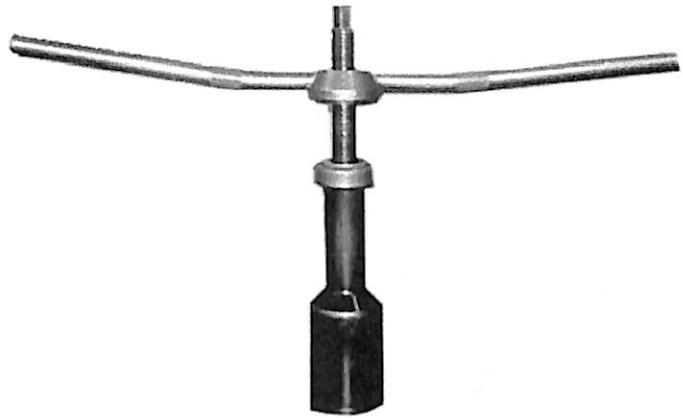
1. Install FN83 gear using T216732 as shown.

Tools [1]

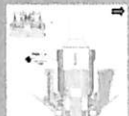
Rev	Part	Name
-	T216732	INSTALL, #6 BEARING

Parts [1]

Tools [1]



T216732




SECURE TOP REAR MOUNT TO LIFTING DEVICE, REMOVE BRACKETS AND LPT FLANGE BOLTS AS SHOWN.

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0170	OP Desc	LPT FLANGE - SECURE	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

1. Remove LPT module slave bolts at this time.

2. Install washer on 'BOLT HEAD' side in positions identified by blue circles when securing flange.

3. Install fn's D201, E033, and G002 in positions identified by red circles using hardware shown.

4. Install fn 207 bolts (93) places as shown.

5. Tighten all bolts and nuts to torque shown.

Attachments

Parts [8]

SEQ	Part	FindNo	Name	Qty	AltQty
	AS3237-10	0207	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED	93	
	MS21043-4	0236	NUT	120	
	NAS620C416	0272	WSHR,FLT 1/4-RDC OD.063	2	
	AS3237-11	0293	BOLT, MACHINE - DOUBLE HEXAGON EXTENDED	27	
	PCS5720(QS3166)	0301	COMPOUND (NPC60301-1 REF)		A/R
	3073465-1	D201	BRACKET OIL TUBES	1	
	MS9593-037	E033	BRACKET	1	
	3072586-1	G002	BRACKET	11	

Parts [8]

Tools [0]

UNSTRETCH GROUP PER INSTRUCTIONS BELOW USING TOOLING SHOWN OR EQUIVALENT
REMOVE FN 102 NUT (3071740-1)

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline		Cell	
Step	0150	OP Desc	LPT - STRETCH	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

1. Install stretch shaft tool (approx. 9 full turns) then back-off shaft 1/4 turn.
2. Install remaining tooling.
3. Apply approx. 4500 psig. and secure nut.
4. Remove tooling.

CAUTION: Ensure pick-up gear is removed prior to unstretching of tie-shaft (if installed).

UNSTRETCH:

- Install stretch shaft (approx. 9 turns)
- Back off shaft 2 & 1/2 turns
- Bottom out shaft nut
- Back off shaft nut 3 full turns
- Apply approx. 4500 psig.
- Back off LPT nut
- Release psig. and remove tooling

4500 PSIG.

UNSTRETCH

30 TON PUMP & CYLINDER

T216777 (NUT TOOL)

T216777-130 (ADAPTER)

T216777-2 (SHAFT)

T216775-10 (NUT)

MAT2212-3

T216776

Parts [0]

CAREFULLY REMOVE TURBINE AND REAR MOUNT FROM ENGINE. NOTE: PHOTOS DEPICT VERTICAL REMOVAL. HORIZONTAL REMOVAL POSSIBLE SUPPORTING WEIGHT OF LPT MODULE FROM CENTER MOUNT CLEVIS USING OVERHEAD CRANE OR LIFT. REMOVE ALL FASTENERS, WITH LPT ASSY HOOKED TO VERTICAL LIFT. GENTLY ROCK LPT ASSY AFT FOR REMOVAL . PLACE LPT MODULE ON BENCH FOR FURTHER DISASSEMBLY.

Part	3060022-26	P/N Desc	POWER SECTION ASSY	Alternate MOT#	000*	Rev	A	Rel. Date		Prog_ID		Eng Chg Ltr	AK	P/L Chg Ltr	CJ	Outline	Cell
Step	0120	OP Desc	TAIL PIPE ASSY - INSTALL	Work Center		Setup Time		Run Time									

Instructions
Reference Documents [5]

CAUTION:
Exercise care not to damage curvics when lowering tail pipe assembly onto tie-shaft.

1. Carefully lower the LP turbine module down over the LP tie shaft. Exercise care not to damage the curvics when lowering the turbine assembly onto the tie-shaft. Align the off-set bolt pattern of the transition duct and plenum case at the 12 o'clock position. Initially align the dykem marks (tie shaft to 3rd stage rotor.)

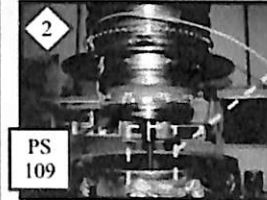
2. Rotate turbine rotor group approximately 5 degrees, counter-clock-wise, AFT looking forward, to purposely mis-align the curvic couplings.

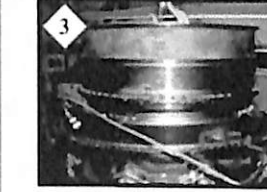
3. Gently continue lowering the turbine module until the FWD curvic coupling of the turbine group comes in contact with the AFT curvic coupling on the compressor group.
DO NOT COMPLETELY REMOVE ALL THE TENSION FROM THE HOIST AT THIS TIME.

4. Gently rotate the turbine module back approximately 5 degrees clock-wise to engage the curvic coupling between the compressor and the turbine. When the curvic coupling engages, you should feel

Attachments


PS 33


PS 109









ALL HOLES ON THIS FLANGE SHOULD HAVE THE SAME GAP

SAME ENGAGEMENT ALL AROUND

Parts [2]

SEQ	Part	FindNo	Name	Qty	AltQty
1	3060022-914	0033	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	REF	
2	651-534-9612	0109	SEAL	REF	

Tools [1]

REMOVE ITEMS SHOWN BELOW AND ON NEXT PAGE USING TOOLING SHOWN ON 3RD PAGE (OR EQUIVALENT TOOLING)

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	370	OP Desc	THRUST PLATE - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

- TRACEABLE ITEM THIS OPERATION -

1. Install FN79 thrust plate, FN80 spring, and FN82 ring.

2. Compress items with T272748 & T216769 and install FN81 retainer ring.

Attachments

Parts [4]

SEQ	Part	FindNo	Name	Qty	AltQty
	3071296-1	A0079	PLATE	1	
	3000005-5	A0080	WASHER SPRING	1	
	M27426-3171D	A0081	RINGS, RETAINING, SPIRAL	1	
	3071287-1	A0082	RING, RETAINING	1	

Parts [4]

Tools [4]

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	360	OP Desc	number 6 BEARING - INSTALL	Work Center		Setup Time		Run Time											

Instructions

- TRACEABLE ITEM THIS OPERATION -

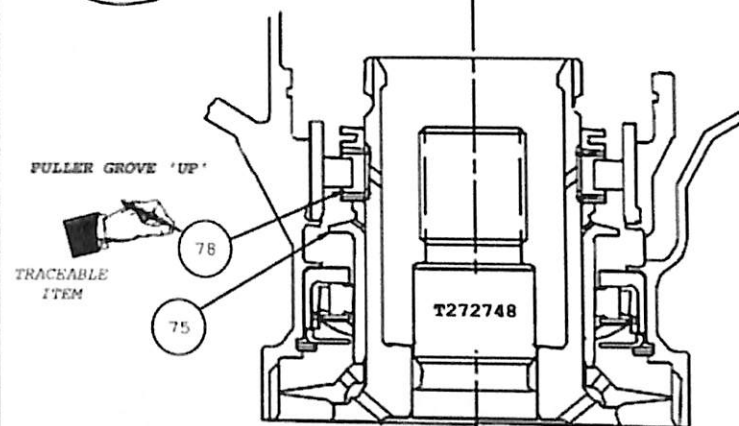
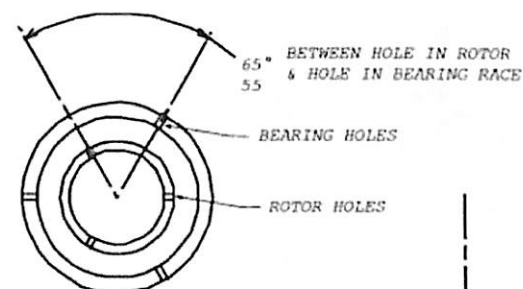
1. Install FN75 seal rotor.

CAUTION: Ensure bearing puller grooves are up.

2. Using T272748 & T216732-1 press inner race of FN78 bearing onto shaft and offset oil passage holes as shown.

3. Position bearing rollers inward and install outer race with chamfered edge down.

Attachments



Parts [2]

SEQ	Part	FindNo	Name	Qty	AltQty
1	3070344-2	A0075	ROTOR SEAL	1	
2	358750-2	A0078	BEARING, ROLLER	1	

Parts [2] Tools [4]

REMOVE REAR BEARING SUPPORT HOUSING FROM ASSEMBLY

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	350	OP Desc	TAIL PIPE - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

NOTE: Position off-set hole identified with 'C' at 12 O'CLOCK position.

1. Install FN35 rear bearing support assy.
2. Secure rear bearing support assy to transition duct with hardware shown.

Attachments

Parts [4]

SEQ	Part	FindNo	Name	Qty	AltQty
	3073718-3	A0035	SUPPORT, BEARING HOUSING, REAR - NO. 6		REF
	MS9556-07	A0208	BOLT	54	
	MS21043-3	A0238	NUT, SELF-LOCKING	54	
	PCS5720	A0301	COMPOUND		A/R

Parts [4]

Tools [0]

TOOLING FOR REMOVAL OF ITEMS ON PREVIOUS PAGE

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	360	OP Desc	number 6 BEARING - INSTALL	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

Attachments

- TRACEABLE ITEM THIS OPERATION -

1. Install FN75 seal rotor.

CAUTION: Ensure bearing puller grooves are up.

2. Using T272748 & T216732-1 press inner race of FN78 bearing onto shaft and offset oil passage holes as shown.

3. Position bearing rollers inward and install outer race with chamfered edge down.

T272748
DUMMY SHAFT

T216732-1
BRG INSTALLER

T216801
BRG PULLER

T216769
SNAP RING
INSTALLER

Tools [4]

Rev	Part	Name
-	T216732-1	BEARING INSTALLER
-	T216769	INSTALLATION & REMOVAL TOOL- RETAINING RING (WAVE WASHER DEPRESSOR)
-	T216801	BEARING PULLER
C	T272748	Dummy Tie Rod, Nut and Wrench

Parts [2]

Tools [4]

TOOLING TO UNSTRETCH TURBINE GROUP

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	280	OP Desc	STRETCH LP TURBINE SHAFT	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

1. VERIFY TOOLING SET NUMBER.
2. MEASURE ZERO (BEFORE STRETCH) DIMENSION AND RECORD IN BUILD SHEET FORMULA 1.
3. INSTALL T216778 STRETCH FIXTURE. STRETCH TURBINE GROUP TO OBTAIN .0076-.0096 STRETCH.
 - * BOTTOM OUT TOOLING KNURLED NUT AND WING NUT.
 - * LOAD TO APPROX 2250 PSIG.
 - * BOTTOM OUT SHAFT NUT.
 - * RELEASE PRESSURE AND REMOVE TOOLING.
4. MEASURE STRETCH AND RECORD IN BUILD SHEET FORMULA 1.
5. BEND LOCK KEY THAT BEST LINES UP WITH SLOT IN TURBINE SHAFT.
 - * ENSURE UNBENT LOCK KEY DOES NOT PROTRUDE OR IS PUSHED BACK AGAINST SHAFT.

Attachments



T216778-908 STRETCH CART



T216778 STRETCH TOOL

Tools [3]

Rev	Part	Name
-	T216773-910	WRENCH
-	T216778	STRETCH FIXTURE BASE
-	T231119	LP TURB MIC FIXTURE

Parts [2]

Tools [3]

UNSTRETCH THE TURBINE GROUP USING TOOLING SHOWN ON NEXT PAGE (OR EQUIVALENT)

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	280	OP Desc	STRETCH LP TURBINE SHAFT	Work Center		Setup Time		Run Time											

Instructions

1. VERIFY TOOLING SET NUMBER.

2. MEASURE ZERO (BEFORE STRETCH) DIMENSION AND RECORD IN BUILD SHEET FORMULA 1.

3. INSTALL T216778 STRETCH FIXTURE. STRETCH TURBINE GROUP TO OBTAIN .0076-.0096 STRETCH.

- * BOTTOM OUT TOOLING KNURLED NUT AND WING NUT.
- * LOAD TO APPROX 2250 PSIG.
- * BOTTOM OUT SHAFT NUT.
- * RELEASE PRESSURE AND REMOVE TOOLING.

4. MEASURE STRETCH AND RECORD IN BUILD SHEET FORMULA 1.

5. BEND LOCK KEY THAT BEST LINES UP WITH SLOT IN TURBINE SHAFT.

- * ENSURE UNBENT LOCK KEY DOES NOT PROTRUDE OR IS PUSHED BACK AGAINST SHAFT.

Reference Documents [5]

Attachments

Parts [2]

SEQ	Part	FindNo	Name	Qty	AltQty
	3070177-2	0018	NUT		REF
	PCS5720	0023	COMPOUND		A/R

Parts [2]

Tools [3]

REMOVE 3070177-2 NUT AND 3RD STAGE WHEEL ASSEMBLY 3060626-8 USING T216774 LIFTING LUG OR EQUIVALENT.

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY		Alternate MOT#	000*	Rev	C	Rel. Date	Prog_ID	Eng Chg Ltr	P/L Chg Ltr	Outline	Cell	
Step	220	OP Desc	INSTALL SHAFT NUT	Work Center	Setup Time	Run Time									

Instructions

Reference Documents [5]

Attachments

****INSTALL OR ASSEMBLE****

1: FN18 SHAFT NUT WITH FN23 COMPOUND TO 3RD STAGE WHEEL ASSEMBLY. SECURE FINGER TIGHT.

* USE T216773-910 WRENCH TO INSTALL NUT.

3rd STAGE WHEEL ASSEMBLY

23 18

LUBRICATE NUT THREADS AND NUT FACE. SECURE FINGER TIGHT

Parts [2]

SEQ	Part	FindNo	Name	Qty	AltQty
1	3070177-2	0018	NUT	REF	
2	PCS5720	0023	COMPOUND	A/R	

Parts [2]

Tools [1]

REMOVE THIRD STAGE NOZZLE ASSEMBLY

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	180	OP Desc	INSTALL 3RD STAGE NOZZLE	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

****RECORD TRACEABILITY****

1: FN4 3RD STAGE NOZZLE.

****INSTALL OR ASSEMBLE****

2: FN4 THIRD STAGE NOZZLE.

* ALIGN OFFSET HOLE To 12:00.

* SECURE WITH SLAVE HARDWARE.

Attachments

SECURE TO TRANSITION DUCT WITH SLAVE HARDWARE (4) PLACES

REF 4

Parts [1]

SEQ	Part	FindNo	Name	Qty	AltQty
1	3060655-6	0004	NOZZLE ASSY LPT 3STG	1	

Parts [1]

Tools [0]

REMOVE SECOND STAGE ROTOR ASSEMBLY 3060608-5.

Part	3060022-914	P/N Desc	3060022 LMAASA -40 TURBINE & REAR MOUNT ASSY	Alternate MOT#	000*	Rev	C	Rel. Date		Prog_ID		Eng Chg Ltr		P/L Chg Ltr		Outline		Cell	
Step	170	OP Desc	INSTALL 2ND STAGE WHEEL ASSY	Work Center		Setup Time		Run Time											

Instructions

Reference Documents [5]

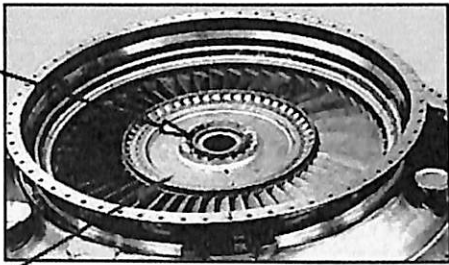
****INSTALL OR ASSEMBLE****

CAUTION CLEAN CURVICS PRIOR TO INSTALLING WHEEL ASSEMBLIES.

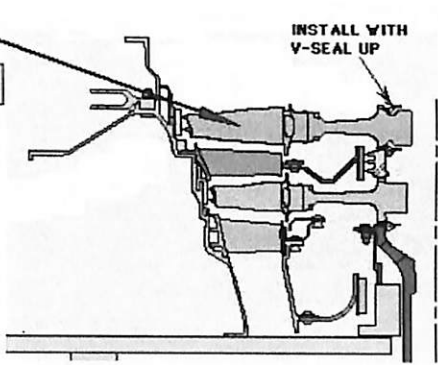
1: FN6 2ND STAGE WHEEL ASSY WITH V-SEAL UP AS SHOWN.

* ALIGN CURVIC HIGH MARKS HIGH TO HIGH.

Attachments



INSTALL WITH V-SEAL UP



6

ALIGN CURVIC HIGH MARKS HIGH TO HIGH

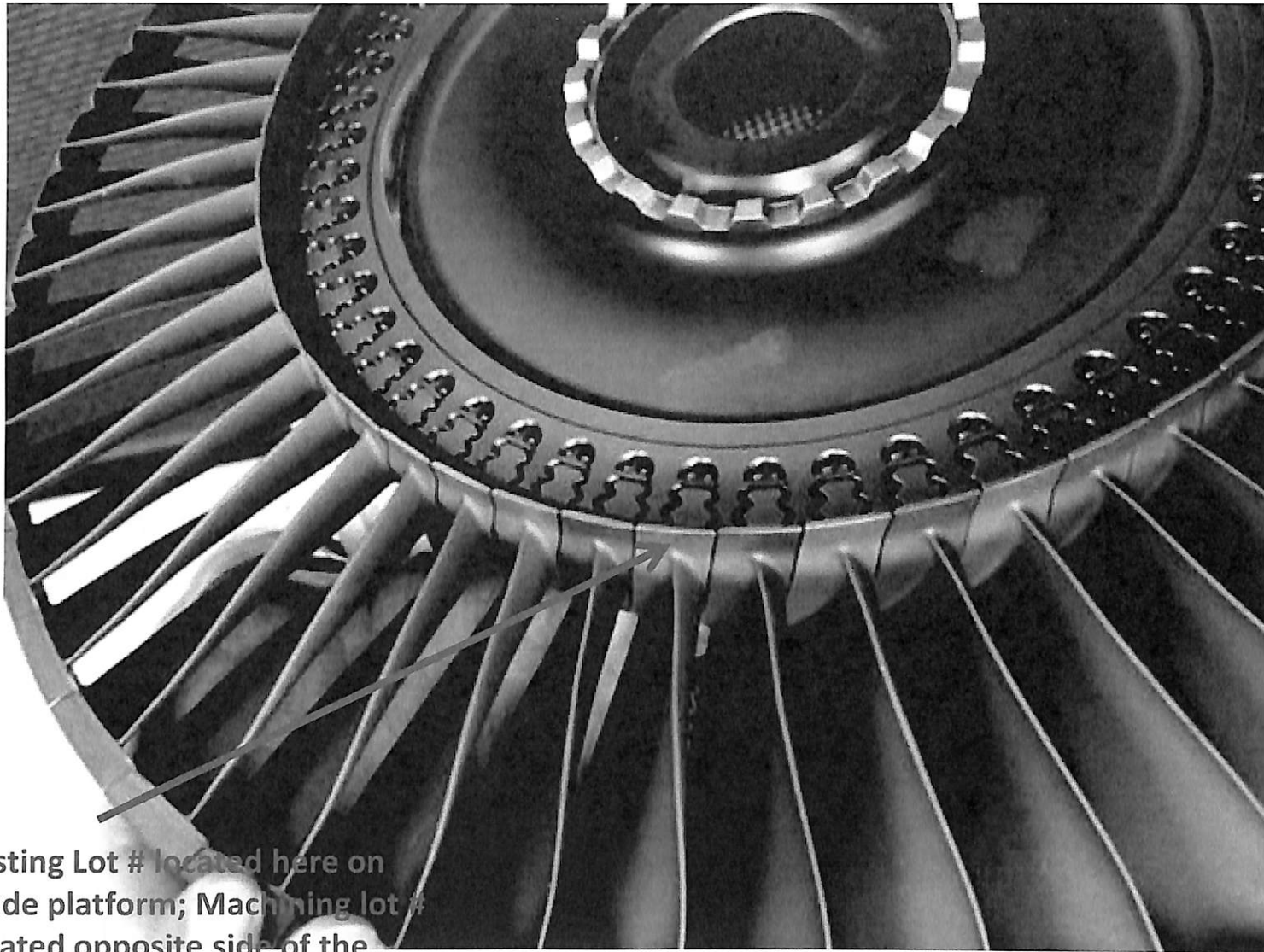
INSTALL WITH V-SEAL UP

Parts [1]

SEQ	Part	FindNo	Name	Qty	AltQty
1	70060034-1	0006	TURBINE ROTOR ASSY - LP, SECOND STAGE	1	

Parts [1]

Tools [0]



Casting Lot # located here on
blade platform; Machining lot #
located opposite side of the
blade platform

Refer to Supplemental Instructions

- Refer to the following supplemental instructions to eddy current inspect the rotor assembly or replace individual blades.
 - When the inspection or blade replacement is complete, proceed to the next slide for reassembly
- If a replacement rotor assembly was received, proceed to the next slide for reassembly.

Reassembly

- Follow disassembly instructions in reverse.
 - Record serial number of LPT2 rotor removed and forward back to Phoenix.
 - Record serial number of LPT2 rotor installed.
 - Record the casting lot numbers (machining lot numbers optional)
 - Validate that each blade on rotor to be installed contains an eddy current (E, ET, EC) inspection stamp – see examples on next slide. If there is no stamp, blade must be eddy current inspected.
 - NOTE: Re-use E-seal (PN 651-534-9612) unless damaged
 - Dents, distortion, cracks or other damage that would cause leaks
 - Perform ground run of engine to verify proper engine operation, leak check and vibration survey
 - When completed, make log book entry per FSE instructions
 - Make entry on LPT2 Life Limit Card: Date of inspection, signature and stamp of certified eddy current inspector (see below)

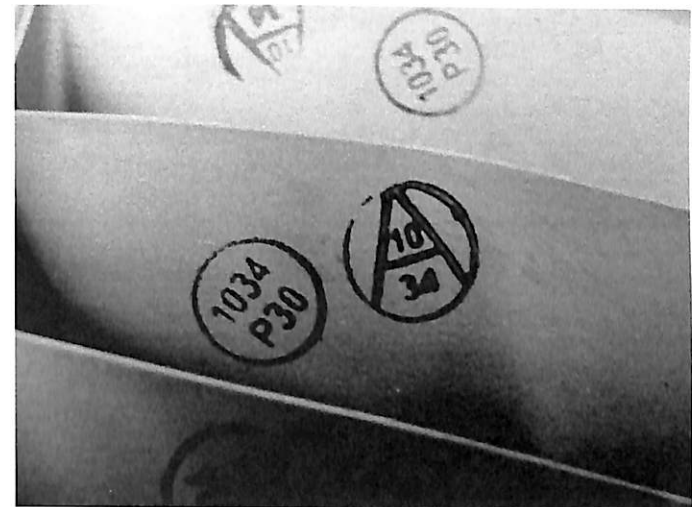
LIFE LIMITED PART REPAIR RECORD		
DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE
6/24/2014	Inspection per 21-15477	Name and UQR stamp

Stamps containing E, ET, EC indicate Eddy Current.



Above – E58 stamp indicates eddy current inspection

Right – These blades have not been
eddy current inspected



Supplemental Instructions

(A) For performing Eddy Current Inspection

Perform eddy current inspection of the LPT2 blades installed in the rotor assembly as follows:

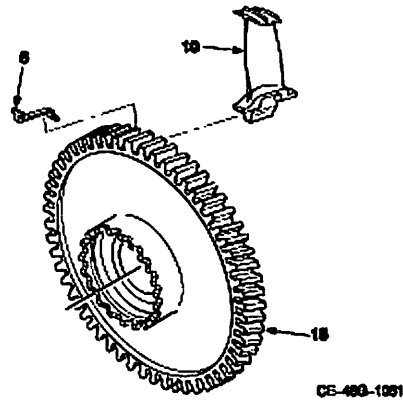
1. Reference Procedure 21-15477.
2. The procedure must be performed by a trained and certified inspector using the equipment and processes specified in procedure 21-15477. Contact Honeywell for a list of certified inspectors.
3. Any blades that fail eddy current inspection shall be replaced by the instructions below.
4. LPT2 Rotor assemblies that pass eddy current inspection (having replaced blades or not) for installation into an engine must have an entry made on the back of the Life Limit Card as follows:
 - a. DATE – date on which the inspection was performed
 - b. Signature and Stamp – shall be that of the eddy current inspector

LIFE LIMITED PART REPAIR RECORD		
DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE
6/24/2014	Inspection per 21-15477	Name and UQR stamp

(B) For Replacing Individual LPT2 Blades

1. Remove all blades from the LPT2 rotor assembly

NOTE: Chart the location of all blades on rotor disk to aid balancing after assembly.
2. Chart location of all blades to rotor disk (i.e. using numbers etc.)
3. Remove all turbine blades:
 - a. Bend blade retainers (5, figure 1) away from base of turbine blades (10). Slide turbine blades out, then remove and discard blade retainers.
 - b. Weigh turbine blades that are to be replaced for selecting replacement turbine blades near the same weight.



- 5. BLADE RETAINER
- 10. TURBINE BLADE

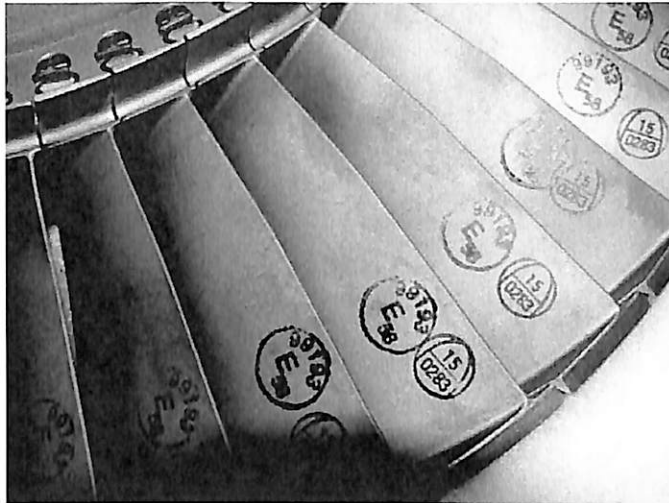
- 15. ROTOR DISC

Figure 1 - LPT2 Rotor Assembly

NOTE: Record part number, casting lot number and machining lot number of removed and replacement blades; use pages 3 and 4 of this work instruction.

Record part number and casting lot number of replacement blades on Life Limited Parts Log Card.

NOTE: Validate that each replacement blade contains an eddy current (E, ET, EC) inspection stamp; see examples below:



4. Install turbine blades on LPT2 rotor assembly:

- a. With all turbine blades removed, perform single plane balance of LPT2 rotor disk. Mark heavy point and record unbalance in grams for use in selecting blades during assembly.
- b. Select replacement turbine blade as near to the weight of removed turbine blade as possible.
- c. Record on Maintenance Record of Life Limited Part Log Card replacement blade part number followed by casting lot number, date and rotor assembly cycles.

CAUTION: DO NOT BEND OR REFORM BLADE RETAINERS PRIOR TO INSTALLATION. ANY REFORMING OR BENDING OF BLADE RETAINERS WILL RESULT IN INCREASED STRESS IN THE INSTALLED RETAINER AND COULD RESULT IN RETAINER CRACKS ,SEPARATION, AND POSSIBLE ENGINE DAMAGE.

NOTE: Do not reuse any blade retainers.

- d. Install blade retainers into LPT2 rotor assembly rotor disk with all preformed tabs on the same side of rotor disc (figure 2).

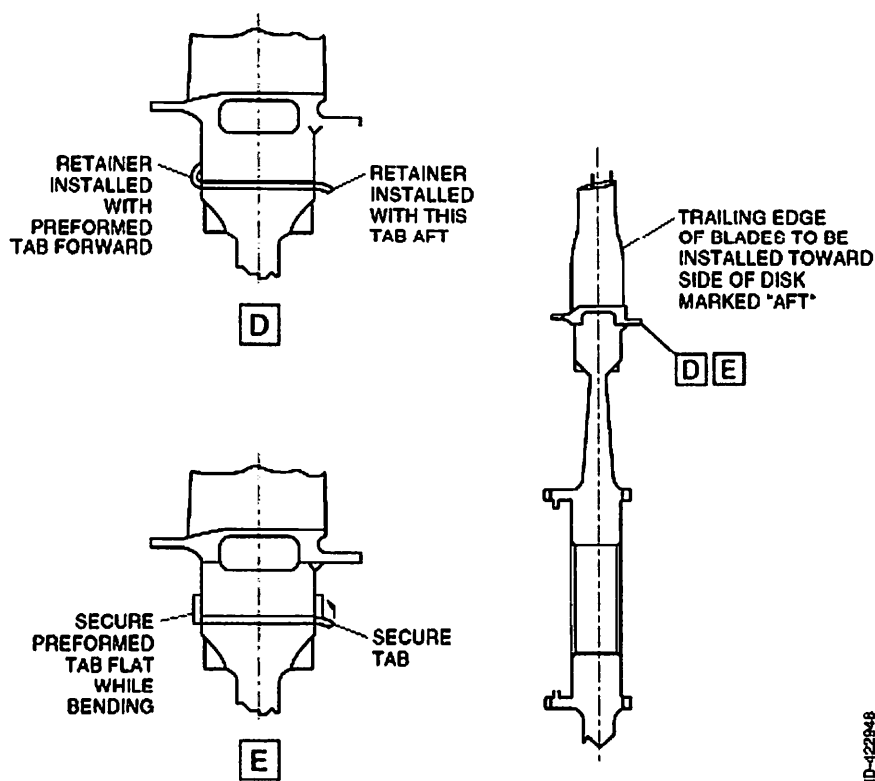


Figure 2 - Blade Retainer Orientation

CAUTION: DO NOT FORCE TURBINE BLADES INTO ROTOR DISC. USE ONLY HAND PRESSURE WHEN SLIDING TURBINE BLADES INTO FIR TREE OF ROTOR DISC AND OVER BLADE RETAINERS. IF RESISTANCE IS PRESENT, INVESTIGATE CAUSE (E.G. BENT RETAINER, BURR ON BLADE RETAINER GROOVE, ETC.).

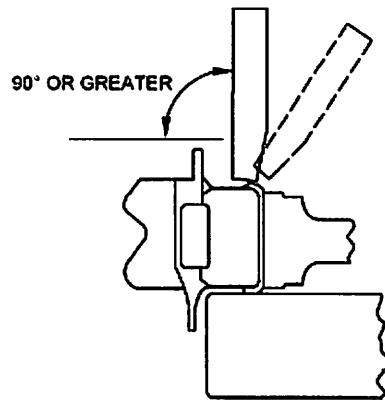
- e. Install blades provided by Honeywell (PN 3075424-2 or -3) as follows:
 - i. Install all turbine blades into rotor disc at location previously charted in Step 2.
 - ii. To install last turbine blade, move approximately 12 to 20 blades (six to ten on either side) opposite direction of preformed end of blade retainer. Start the last turbine blade into rotor disc with Z-gap aligned with adjacent turbine blade, then move all turbine blades in unison forward into rotor disc.
- f. Check for misalignment of knife edges on LPT2 rotor assembly turbine blades. Misalignment of knife edges of adjacent turbine blades must not exceed **0.068 inch (1.73 mm)**.

CAUTION: TOOLING USED TO BEND RETAINER MUST BE ALUMINUM OR NICKEL. TOOLING OTHER THAN ALUMINUM OR NICKEL COULD RESULT IN MATERIAL TRANSFER FROM TOOL TO ROTOR DISC OR TURBINE BLADE CAUSING SUBSEQUENT FAILURE OF ROTOR DISC OR TURBINE BLADE.

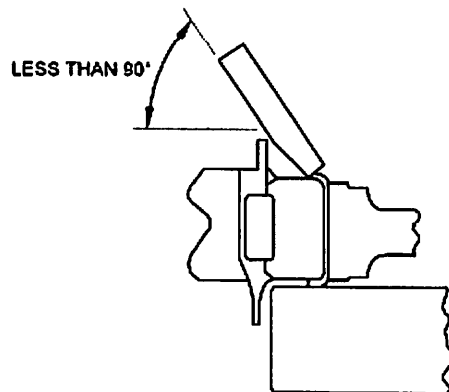
- g. Bend tab of blade retainer on LPT2 rotor assembly as follows:

NOTE: Preformed tab of blade retainer (figure 2) must be held flush against face of rotor disc and turbine blade before opposite tab is bent up and into face of disc.

- i. With preformed tab of blade retainer held flush against face of rotor disc, bend tab as shown in figure 2. When forming retainer, do not apply force at less than a 90 degree angle from the rotor disc face; see figure 3.
- ii. Make sure after bending, tab is in firm contact with turbine blade, but not sharply creased at bend line.
- iii. Inspect bent tabs with 10X magnification and if blade retainer tabs are cracked, replace blade retainer. Removal of a cracked blade retainer requires removal and replacement of all blade retainers.



NOTE:
Acceptable forming technique - End of tab set with tool held at 90 degrees or greater from the disc axial face.



NOTE:
Unacceptable forming technique - End of tab set with tool held less than 90 degrees from the disc axial face. This may create a tighter axial fit of the blade, but results in a reduced retainer bend radius, and a high residual stress condition.

Figure 3 - Blade Retainer Installation

- h. Check turbine blades and blade retainers after installation is completed on LPT2 rotor assembly as follows:
 - i. Check for relative movement between the turbine blade and rotor disc. Relative movement between the turbine blade and rotor disc along the fir tree center axis shall not exceed **0.025 inch (0.64 mm)**.
 - i. Blade retainers may not be reused (reformed) after they have been formed, with the exception of the adjustments that follows. When adjusting blade retainer, do not force at less than a 90 degree angle from the rotor disc face; see figure 3.
 - i. If relative movement is greater than the limit in step h(i), adjust the blade retainer using an approved form tool. Blade retainer can be adjusted only one time to obtain specified value.
 - ii. If blade retainer was adjusted, inspect adjusted tabs with 10X magnification. Cracks are not acceptable.
 - iii. If blade retainer tabs are cracked, replace blade retainer. Removal of a cracked blade retainer requires removal and replacement of all blade retainers.
- 5. Measure and record rotor assembly diameter using LPT blade loading kit 298125-1. Pay particular attention to the locations where the replacement blades are installed.

LPT2 rotor assembly diameter = **15.212 +/- 0.004 inches (386.385 +/- 0.102 mm)**.

If diameter is not met, contact engineering.

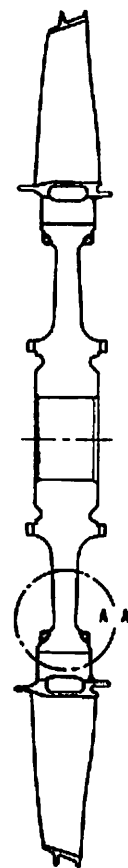
- 6. Balance assembly of rotor disc, turbine blades and blade retainers using components of 289905-2 rotor assembly balancing kit as follows:
 - a. Install 290701-1 coupling or 831413-2 adapter on LPT2 rotor assembly forward curvic and 831413-1 adapter on aft curvic. Secure with 290566-4 or 290566-6 tie bolt and 290565-1 nut.
 - b. Install assembly in standard balancing machine.

NOTE: If unbalance is greater than **0.3 ounce-inch**, reposition blades for optimum balance prior to any grinding of balance material.

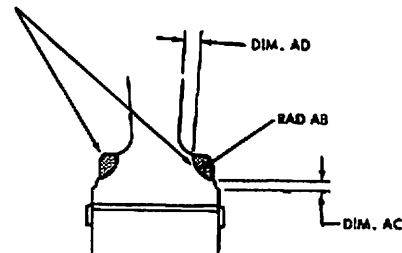
When removing material for balancing, two areas at least 1 inch wide and 180 degrees apart must remain without material removal to permit dimensional inspection of rotor assembly.

- c. Balance LPT2 rotor assembly on curvic couplings to an accuracy of **0.059 ounce-inch**. Material removal shall leave no corners or edges sharper than **0.125 inch (3.175 mm)** radius and shall have a surface finish of **63 microinches** or better; see figure 4.
- d. Remove LPT2 rotor assembly from standard balancing machine and remove balance kit parts.

NOTE: If replacing damaged blade retainers only, balancing of the rotor assembly is not required if the same turbine blades removed are reinstalled in the same location charted at removal.



MATERIAL MAY BE REMOVED FROM THIS AREA FOR BALANCING. DO NOT UNDERCUT BASIC PROFILE. BASIC PROFILE OF DISC IS FORMED BY RADIUS AB, AND STEP DIMENSIONS AC AND AD. REMOVE MATERIAL EQUALLY FROM BOTH SIDES. NO MATERIAL REMOVAL IN TWO AREAS ONE INCH WIDE, 180° APART, TO PERMIT DISC DIMENSIONAL INSPECTION.



DETAIL A A

FIRST AND SECOND STAGE ROTOR ASSEMBLY

1-490-101

REPAIRED LIMITS

RAD AB	0.200 inch (5.08 mm) minimum
DIM AC	0.030 inch (0.76 mm) minimum
DIM AD	0.040 inch (1.02 mm) minimum

Figure 4 - Rotor Assembly Balancing Requirements

ENGINE ☒ MODULE ☐

SERIAL NUMBER P137179

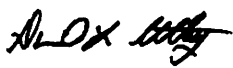
SERVICE RECORD

DESCRIPTION OF INSPECTIONS, REPAIRS AND OVERHAULS

ENDORSE ALL INSPECTIONS AND REPAIRS WITH NAME, RATING AND CERTIFICATE NUMBER

PAGE 2

DATE	HOURS THIS FLIGHT	CYCLES THIS FLIGHT	ACCUMULATIVE TOTALS				DESCRIPTION OF WORK PERFORMED
			HOURS		CYCLES		
			SINCE NEW	SINCE O/H	SINCE NEW	SINCE O/H	
							TOTALS BROUGHT FORWARD
							Removed From 45-485 To Reallocate
							To 45-496 16 AUG 2014
19 AUG 2014							
							THIS ENGINE SERVICED WITH <u>Mobil Jet 254 OIL</u> ENGINE S/N <u>P137179</u> DATE <u>19 Aug 2014</u> LEARJET QA INSTALLED ON ACFT <u>45-496</u> ON THE <u>LEFT</u> SIDE DATE <u>21 Aug 2014</u> LEARJET QA
22 Aug 2014							Accomplished FSE Work Instruction 731-40-P14-004 IAW, HON PC413 NM. Jim Brasley HON/FSE
13 Nov 2014							Accomplished FSE Work Instruction 731-40-P14-002B IAW, HON PC413 NM.
							Replaced LPT2 Rotor Assy. PN 3060608-5 SN Off: 12-156103-00739 SN On: 12-156103-00173
							Jim Brasley HON/FSE
22 NOV 14							
TOTAL PRODUCTION FLIGHT TEST TIME			HOURS: 5.9		CYCLES: 5		
SIGNATURE:			DATE: November 22, 2014				
BRENT A. DUNGAN Quality Assurance Engineer			LEARJET INC. One Learjet Way, Wichita, KS 67209 FAA Production Certificate 329CE				
			5.9		5		TOTALS TO DATE

1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 890004003195Y14 8003210215-10	
4. Organization Name and Address: Honeywell International Inc 111 South 34th Street Phoenix AZ 85072				Production Approval PC413NM		5. Work Order/Contract/Invoice Number: PO0616768 Page 1 of 1
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	ENGINE ASSEMBLY TURBOFAN; TFE731-40BR-1B	3062075-1	1	P137179	NEW	
12. Remarks: AIRWORTHINESS APPROVAL-ENGINE.						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: 		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:
13d. Name (Typed or Printed): David Utley		13e. Date (dd/mm/yyyy): 08/FEB/2014		14d. Name (Typed or Printed):		14e. Date(dd/mm/yyyy):
User / Installer Responsibilities It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.						



**SERVICE BULLETIN
RECORD**

Aircraft Customer Engine Production Applicability Report

According to manufacturer records, the service bulletins listed in this report are applicable to this engine/APU as of the date of this report. After engine/APU delivery, the record of service bulletin compliance depends on compliance reports being forwarded to Honeywell from the service facilities.

NOTE: Check all service bulletins issued after the date of this report for applicability to this engine/APU.

Information regarding this report may be obtained by contacting:

The Honeywell Aero Customer Care Center
PHONE US/Canada: 800-601-3099 International: 602-365-3099
Fax: 602-365-3345

Measurement & Reporting
Reliability, Maintainability & System Safety
Honeywell International, Inc.

RMSS Measurement & Report: , Honeywell Aerospace
Production Applicability, Sorted by Status [#APP105]

Printed on: 01/30/2014

for Engine Serial Number:137179 Model: TFE731-40BR-1B

Run by: E086098

Status	Number	Latest Rev.	Cmp.	Title	Effectivity
--------	--------	----------------	------	-------	-------------

Status Codes: P = Production incorporation
S = See service bulletin for effectivity
Effectivity: NA= Not applicable by serial number.
See service bulletin for effectivity

Compliance Code: R = Recommended Service Bulletin
O = Optional Service Bulletin
I = Informative Service Bulletin

Page 1



Georgia Crown Aviation Department

Lear 75
N877W
45-496

201 Airport Parkway
LaGrange, Georgia 31909

Aircraft TTSN: 913.3 Aircraft TCSN: 913
Engine 1 Part Number: 3062075-1
Engine 1 Model: TFE731-40BR-1B
Engine 1 Serial Number: P137179
Engine TTSN: 913.3
Engine TCSN: 913
Date: October 25, 2016

Completed the following tasks:

TFE731-73-5145
Paragraph E(2)

Fuel Flow Transmitter Line and
Bracket Service Bulletin
Inspection

I certify that this engine has been inspected in accordance with current Federal Aviation Regulation Part 91.409 (F) (3) and current aircraft and engine manufacturer's maintenance manuals. All functional and operational checks were satisfactory and this aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**

Operator: GEORGIA CROWN DISTRIBUTING CO.				Work Card No.: TFE731-73-5145 PARA E (2)			
Serial No.: P137179		Model: TFE731-40BR-1B		Workorder No.: _____			
Part: 3062075-1		Reg No.: N877W					
A/C Serial 45-496							

	Date(DD/MMM/YYYY)	A/C HRS	AFL	ENG. HRS	ENC		
Due At		910.9		910.9			
Accomplished	25-OCT-16	913.3	913				

TECHNICIAN SIGNATURE:  KIND OF CERTIFICATE & NO.: AP3481311
 [MICHAEL W. JOHNSON]

>SB TFE731-73-5145
 PARA E (2)

NO. 1 ENGINE - ACCOMPLISH, SERVICE BULLETIN INSPECTION

☒ COMPLIED WITH
 ☐ DECLINED
 ☐ DEFERRED
 ☐ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
 Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: Performed recurring 25 Hour Inspection per TFE731-73-5145 part 3B.(1)(2). No defects noted. Next Inspection due 938.3.

TECH MS INSP _____ LABOR-HRS _____
 HRS.THS _____

GEORGIA CROWN DISTRIBUTING CO.
5290 ARMOUR ROAD
COLUMBUS, GA, USA, 31909

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
04-Oct-2017	1339.7	1279	1339.7	1279						

No. Task No./Position Description

1 TFE731-72-5221

NO. 1 ENGINE - REPLACE SPECIFIC IDENTIFIED LOW PRESSURE SECOND STAGE TURBINE (LPT2) ROTOR
BLADES, PN 3075424-2, -3, SERVICE BULLETIN

Method Of Compliance: NOT APPLICABLE

Update Note: NA PER ENGINE MODEL LISTED IN SB.

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F) (3) AND
APPROVED FOR RETURN TO SERVICE

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:



aviation from the ground up™

BOMBARDIER

UNSCHEDULED

Operator: **GEORGIA CROWN DISTRIBUTING CO.**Work Card No.: **TFE731-72-5221**Serial No.: **P137179**Model: **TFE731-40BR-1B**Part: **3062075-1**

Workorder No.: _____

A/C Serial **45-496**Reg No.: **N877W**

	Date(DD/MMM/YYYY)	A/C HRS	AFL	ENG. HRS	ENC		
Due At							
Accomplished	04-OCT-17	1339.70	1279				

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F) (3) AND APPROVED FOR RETURN TO SERVICE

TECHNICIAN SIGNATURE: Michael W. Johnson KIND OF CERTIFICATE & NO.: AP3481311

FAA 2012-16-14

NO. 1 ENGINE - ENGINE - LPT2 ROTOR BLADES - REMOVE/INSPECT

Amendment No: _____

Effective Date: 01-OCT-2012

Next Compliance Due Date Hours/Other: _____

☐ COMPLIED WITH☐ DECLINED☐ DEFERRED☒ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: _____

TECH

MJ

INSP _____

LABOR-HRS
HRS.THS _____

SB TFE731-72-5221

NO. 1 ENGINE - REPLACE SPECIFIC IDENTIFIED LOW PRESSURE SECOND STAGE TURBINE (LPT2) ROTOR BLADES, PN 3075424-2, -3, SERVICE BULLETIN

☐ COMPLIED WITH☐ DECLINED☐ DEFERRED☒ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: _____

TECH

MJ

INSP _____

LABOR-HRS
HRS.THS _____

04-OCT-2017

WID: 26608438-1

Return completed copy via email to fax@campsystems.com

© CAMP SYSTEMS

Total Pages = _____, Initial 1 of 2



Total Pages = _____, Initial _____.



StandardAero

Page 1 of 1

SERVICE BULLETIN STATUS THIS VISIT

ENGINE SERIAL: P 137179 ENGINE MODEL NO: TFE731-40BR-1B 3062075-1

TSN: 1427.9 CSN: 1360

STATUS	DATE	BULLETIN	REV	CAT	DESCRIPTION
C/W	1/22/2018	72-5232	R1	2	RWK COMPOSITE FAN STATOR VANES
N/A	1/22/2018	72-5251	R0	2	E/C SPECIFIC LPT2 BLADES P/N 3075424
N/A	1/12/2018	72-5256	R0	1	IDENTIFY AND REPLACE SPECIFIC FAN DISCS P/N 3060287-2
C/W	1/22/2018	73-0001	R1	2	CHR1-73-0001 / RWK FOR 73-5146

StandardAero, AUGUSTA, GA
Certified Repair Station GW4R221M

By:

1/22/2018



LEGEND: C/W=Complied With; PCW= Previously Complied With; N/A= Not Applicable; DPC= Due At Part Change; NAT= Not Applicable At This Time

GEORGIA CROWN DISTRIBUTING CO.
LAGRANGE CALLAWAY AIRPORT
203 AIRPORT PARKWAY
LAGRANGE, GA, USA, 30240

TFE731-40BR-1B 3062075-1 S/N: P-137179

On Aircraft Reg: N877W Serial: 45-496

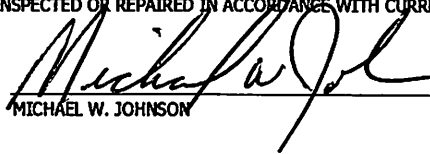
Work Order #: _____

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
21-Sep-2021	0	0	2966.2	2956						

No.	Task No./Position	Description
1	TFE731-72-5256 R01 (D201506000058 R01)	NO. 1 ENGINE - BYPASS SECTION - IDENTIFY AND REPLACE SPECIFIC FAN DISKS, PN 3060287-2, WITH SUSPECT SHOT PEENED ROLLED EDGES ON TFE731-20 AND -40 ENGINE MODELS, SERVICE BULLETIN Method Of Compliance: NOT APPLICABLE - NA BY SERIAL NUMBER

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F)(3) AND APPROVED FOR RETURN TO SERVICE.

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

MECHANIC AP3481311

Work Inspected By:

Certificate #:



Georgia Crown Aviation Department

Lear 75
N877W
45-496

201 Airport Parkway
LaGrange Georgia 30240

Part Number 3062075-1
Model TFE731-40BR-1B
Engine TTSN: 915.5

Serial number P137179
Engine TCSN: 917

Date: November 4, 2016

Service Bulletin TFE731-73-5145 PARA E (3) NO. 1 ENGINE

Method of Compliance: COMPLIED WITH

Update Note: COMPLETED SB PER SERVICE BULLETIN INSTRUCTIONS.

I certify that this engine has been inspected or repaired in accordance with current Federal Aviation Regulation Part 91.409 (F) (3). All test operational tests were performed in accordance with the manufacturer's engine maintenance manual or component maintenance manual. This aircraft is approved for return to service.

Michael W. Johnson
Aircraft Maintenance Technician
Airframe and Powerplant License Number: **3481311**

Operator: **GEORGIA CROWN DISTRIBUTING CO.**

Work Card No.: **TFE731-73-5145 PARA E (3)**

Serial No.: **P137179**

Model: **TFE731-40BR-1B**

Part: **3062075-1**

Workorder No.: _____

A/C Serial **45-496**

Reg No.: **N877W**

	Date(DD/MMM/YYYY)	A/C HRS	AFL	ENG. HRS	ENC		
Due At							
Accomplished	04-NOV-16	915.50	917				

TECHNICIAN SIGNATURE: _____

[MICHAEL W. JOHNSON]

KIND OF CERTIFICATE & NO.: **AP3481311**

SB TFE731-73-5145 PARA E
(3)

NO. 1 ENGINE - ACCOMPLISH, SERVICE BULLETIN REPLACEMENT

☒ COMPLIED WITH

☐ DECLINED

☐ DEFERRED

☐ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: _____

TECH

MLJ

INSP _____

LABOR-HRS
HRS.THS _____

1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG			3. Form Tracking Number: 20160002182773Y14 8005829392-10	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC 1944 E SKY HARBOR CIRCLE PHOENIX AZ 85034				5. Work Order/Contract/Invoice Number: 5001084364 Page 1 of 1		
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:	
001	TUBE ASSEMBLY METAL	3061288-1	2	N/A	NEW	
12. Remarks: EXPORT AIRWORTHINESS APPROVAL: THIS ARTICLE MEETS THE SPECIAL REQUIREMENTS OF CANADA. SERIALIZATION NOT REFERENCED IN BLOCK 10 IS NOT REQUIRED OR TRACEABLE BY HONEYWELL INTERNATIONAL INC. REFERENCE FAA ORDER 8130.21						
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☒ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.			
13b. Authorized Signature: <i>Florie McCrone</i>		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		
13d. Name (Typed or Printed): Florie McCrone		13e. Date (dd/mm/yyyy): 24/OCT/2016		14c. Approval/Certificate No.:		
				14d. Name (Typed or Printed):		
				14e. Date (dd/mm/yyyy):		

User / Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.

1. Approving Civil Aviation Authority/Country: FAA/United States		2. AUTHORIZED RELEASE CERTIFICATE FAA Form 8130-3, AIRWORTHINESS APPROVAL TAG				3. Form Tracking Number: 20160002182774Y14 8005829392-20	
4. Organization Name and Address: HONEYWELL INTERNATIONAL INC Production Approval 1944 E SKY HARBOR CIRCLE PC413NM PHOENIX AZ 85034						5. Work Order/Contract/Invoice Number: 5001084364 Page 1 of 1	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial Number:	11. Status / Work:		
001	TUBE, METAL, FLOW DIVIDER - FLOW METER	70060172-1	2	N/A	NEW		
12. Remarks: EXPORT AIRWORTHINESS APPROVAL: THIS ARTICLE MEETS THE SPECIAL REQUIREMENTS OF CANADA. SERIALIZATION NOT REFERENCED IN BLOCK 10 IS NOT REQUIRED OR TRACEABLE BY HONEYWELL INTERNATIONAL INC. REFERENCE FAA ORDER 8130.21							
13a. Certifies the items identified above were manufactured in conformity to: ☒ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☒ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.				
13b. Authorized Signature: 		13c. Approval/Authorization No.: ODA-602216-NM		14b. Authorized Signature:		14c. Approval/Certificate No.:	
13d. Name (Typed or Printed): Florie McCrone		13e. Date (dd/mm/yyyy): 24/OCT/2016		14d. Name (Typed or Printed):		14e. Date (dd/mm/yyyy):	
User / Installer Responsibilities							
It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article. Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1. Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.							

Operator: **GEORGIA CROWN DISTRIBUTING CO.**

Work Card No.: **75-73-01 R1**

Serial No.: **45-496**

Model: **LEARJET 75**

Reg No.: **N877W**

Workorder No.: _____

Due At	Date(DD/MMM/YYYY)	A/C HRS	AFL	APH			
Accomplished	04-NOV-16	915.5	917				

TECHNICIAN SIGNATURE: _____

Michael W. Johnson
[MICHAEL W. JOHNSON]

KIND OF CERTIFICATE & NO.: **AP3481311**

SB 75-73-01 R1

ENGINE FUEL AND CONTROL - ENGINE FUEL FLOW TRANSDUCER BRACKET REPLACEMENT, SERVICE BULLETIN

☒ COMPLIED WITH

☐ DECLINED

☐ DEFERRED

☐ NOT APPLICABLE

*All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"*

Compliance Note: _____

TECH

MS

INSP _____

LABOR-HRS
HRS.THS _____

AUTHORIZED RELEASE CERTIFICATE

FAA form 8130-3, AIRWORTHINESS APPROVAL TAG

1. Approving Civil Aviation

Authority/Country:

FAA / United States

2.

3. Form Tracking Number:

890101950703 - 1

4. Organization Name and Address:

PRODUCTION CERTIFICATE 329CE

Learjet Inc.

251A Wille Road, Des Plaines, Illinois US 60018-1817

5. Work Order/Contract/Invoice
Number:

7078278

6. Item: 7. Description:

1 KIT. ACC. BRACKET, METER

8. Part Number:

4573140001-801

9. Quantity:

1

10. Serial Number:

N/A

11. Status/Work:

New

12. Remarks: AIRWORTHINESS APPROVAL

DETAIL MS29512-10 HAS A SHELF LIFE EXP. DATE OF 12/31/2030.

This document has been issued according to an approved computer generated signature procedure

13a. Certifies the items identified above were manufactured in conformity to:

☒ Approved design data and are in a condition for safe operation.☐ Non-approved design data specified in Block 12.14a. ☐ 14 CFR 43.9 Return to Service ☐ Other regulation specified in Block 12

Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.

13b. Authorized Signature:

Steve H. Zielinski

13c. Approval/Authorization No.:

ODA-501508-CE

14b. Authorized Signature:

14c. Approval/Certificate No.:

13d. Name (Typed or Printed):

Steve Zielinski

13e. Date (dd/mm/yyyy):

21/OCT/2016

14d. Name (Typed or Printed):

14e. Date (dd/mm/yyyy):

User/Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the engine/propeller/article.

Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/installer ensures that his/her airworthiness authority accepts engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in block 1.

Statements in Blocks 13a and 14a do not constitute installation certification. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.

FAA Form 8130-3(2-14)

Paperwork Reduction Act Statement:

An agency may not conduct or sponsor, and a person is not required to respond to, a collection of information unless it displays a currently valid OMB control number associated with this collection of information is 2120-0018. Comments concerning the accuracy of this burden and suggestions for reducing the burden should be directed to the FAA at: 800 Independence Ave. SW, Washington, DC 20591, Attn: Information Collection Clearance Officer, ABA-20

NSN: 0052-00-012-9005

CERTIFIED TRUE COPY of the original certificate retained on file with Bombardier Q.A.

**AIRWORTHINESS
DIRECTIVE**

[illegible]



StandardAero

COMPLETE AD LIST THIS VISIT

Page 1 of 1

ENGINE SERIAL NO: P 137179

ENGINE MODEL NO: TFE731-40BR-1B 3062075-1

TSN: 1427.9

CSN: 1360

<u>AD No.</u>	<u>STATUS</u>	<u>REASON</u>	<u>DATE</u>	<u>SB No.</u>	<u>DESCRIPTION</u>
2017-20-01	N/A	per Disk S/N	12-Jan-18	72-5256	REPLACE FAN DISC
2017-20-01	N/A	per Disk S/N	12-Jan-18	72-5256	REPLACE FAN DISC

STANDARD AERO, AUGUSTA, GA
Certified Repair Station GW4R221M

By:

22-Jan-18



GEORGIA CROWN DISTRIBUTING CO.
5290 ARMOUR ROAD
COLUMBUS, GA, USA, 31909

TFE731-40BR-1B 3062075-1 S/N: P137179

On Aircraft Reg: N877W Serial: 45-496

Work Order #:

Date	A/C HRS	A/C AFL	ENG 1 HRS	ENG 1 ENC	ENG 2 HRS	ENG 2 ENC	APU HRS	APU Starts		
04-Oct-2017	1339.7	1279	1339.7	1279						

No.	Task No./Position	Description
-----	-------------------	-------------

1 FAA 2012-16-14

NO. 1 ENGINE - ENGINE - LPT2 ROTOR BLADES - REMOVE/INSPECT

Method Of Compliance: NOT APPLICABLE

Update Note: NA PER ENGINE MODEL LISTED IN AD

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F) (3) AND
APPROVED FOR RETURN TO SERVICE

Work Performed By:


MICHAEL W. JOHNSON

Certificate #:

AP3481311

Work Inspected By:

Certificate #:

Operator: GEORGIA CROWN DISTRIBUTING CO.				Work Card No.: FAA 2012-16-14			
Serial No.: P137179		Model: TFE731-40BR-1B		Workorder No.: _____			
Part: 3062075-1		Reg No.: N877W					
A/C Serial 45-496							

	Date(DD/MMM/YYYY)	A/C HRS	AFL	ENG. HRS	ENC		
Due At	01-OCT-2017	3000		3000			
Accomplished	04-OCT-17	1339.70	1279				

I CERTIFY THAT THIS AIRCRAFT HAS BEEN INSPECTED OR REPAIRED IN ACCORDANCE WITH CURRENT FEDERAL AVIATION REGULATION 91.409 (F) (3) AND APPROVED FOR RETURN TO SERVICE

TECHNICIAN SIGNATURE: *Michael W. Johnson* KIND OF CERTIFICATE & NO.: AP3481311

> **FAA 2012-16-14 NO. 1 ENGINE - ENGINE - LPT2 ROTOR BLADES - REMOVE/INSPECT**

Amendment No: _____ Effective Date: 01-OCT-2012 Next Compliance Due Date Hours/Other: _____

☐ COMPLIED WITH ☐ DECLINED ☐ DEFERRED ☒ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: AD2012-16-14 is not applicable due to engine model was not listed in AD.

AD2012-16-14 is not applicable due to engine model was not listed in AD.

AD2012-16-14 is not applicable due to engine model was not listed in AD.

TECH

MS

INSP

LABOR-HRS
HRS.THS

SB TFE731-72-5221

NO. 1 ENGINE - REPLACE SPECIFIC IDENTIFIED LOW PRESSURE SECOND STAGE TURBINE (LPT2) ROTOR BLADES, PN 3075424-2, -3, SERVICE BULLETIN

☐ COMPLIED WITH ☐ DECLINED ☐ DEFERRED ☒ NOT APPLICABLE

All text added to the "Note" field will be presented as part of the MOC selection through the application.
Ex: MOC of "Complied With" and a Note of "At Manufacture" will display as "Complied With - At Manufacture"

Compliance Note: AD2012-16-14 is not applicable due to engine model was not listed in AD.

AD2012-16-14 is not applicable due to engine model was not listed in AD.

AD2012-16-14 is not applicable due to engine model was not listed in AD.

TECH

MS

INSP

LABOR-HRS
HRS.THS

04-OCT-2017

WID: 26608032-1

Return completed copy via email to fax@campsystems.com

> INDICATES DUE ITEMS

Operator: **GEORGIA CROWN DISTRIBUTING CO.**

Work Card No.: **FAA 2012-16-14**

Serial No.: **P137179**

Model: **TFE731-40BR-1B**

Part: **3062075-1**

Workorder No.: _____

A/C Serial **45-496**

Reg No.: **N877W**

	Date(DD/MMM/YYYY)	A/C HRS	AFL	ENG. HRS	ENC		
Due At	01-OCT-2017	3000		3000			
Accomplished	04-OCT-17	1339.70	1279				

725020	NO. 1 ENGINE - 2ND-STAGE LOW PRESSURE TURBINE (LPT) DISC	LMM 72-50-04
--------	--	--------------

LIFE LIMIT

REASON REMOVED: (CHECK ONE)	☐ TIME EXPIRED	☐ FAILURE	☐ WORN	☐ LOANER	☐ SCHEDULING CONV
	☐ MOD/UPGRADE	☐ SERVICE	☐ ENGINE CHANGE	☐ TIRE CHANGE	☐ SWAP/TRBLE SHOOT
					☐ DAMAGED
					☐ UNKNOWN

If removed P/N & S/N information is incorrect please provide details below.

REMOVED P/N	3060611-1		S/N	12-156103-00173		LABOR-HRS	☐
INSTALLED P/N			S/N			PART COST\$	☐
INSTALLED TSN	MOS ☐	INSTALLED TSO	MOS ☐	TIME SINCE	MOS ☐	WARRANTY TIME	MOS ☐
	HRS ☐		HRS ☐	REPAIR	HRS ☐	REMAINING	HRS ☐
	LDGS ☐		LDGS ☐		LDGS ☐		LDGS ☐

TECH: _____

INSP: _____

REMARKS : AD2012-16-14 is not applicable due to engine model was not listed in AD.
AD2012-16-14 is not applicable due to engine model was not listed in AD.
AD2012-16-14 is not applicable due to engine model was not listed in AD.

04-OCT-2017

WID: 26608032-2

Return completed copy via email to fax@campsystems.com

> INDICATES DUE ITEMS

© CAMP SYSTEMS

Total Pages = _____, Initial _____.

2 of 2

LIFE LIMITED PARTS

LIFE LIMITED PART LOG

ASSEMBLY NAME:	PART NUMBER:	SERIAL NUMBER:
----------------	--------------	----------------

LIFE LIMITED PART NAME: SPINNER ENG INL	PART NUMBER: 3060156-2	SERIAL NUMBER: 13-5060-00130
--	-------------------------------	-------------------------------------

MANUFACTURED PER FAR PART 21 UNDER
PRODUCTION CERTIFICATE PC413

SIGNATURE OR ACCEPTANCE STAMP: 295

* SEE SERVICE LIFE LIMITS OF CRITICAL LIFE LIMITED COMPONENTS, ENTRIES SHALL CONFORM TO FAR 43.



Honeywell

LIFE LIMITED PART LOG

ASSEMBLY NAME: FAN ROTOR ASSEMBLY

PART NUMBER: 3060155-6

SERIAL NUMBER: 13-162246-00731

LIFE LIMITED PART NAME: DISK, FAN

PART NUMBER: 3060287-2

SERIAL NUMBER: 13-162246-00731

MANUFACTURED PER FAR PART 21 UNDER
PRODUCTION CERTIFICATE PC413

SIGNATURE OR ACCEPTANCE STAMP: 295

[illegible]

* SEE SERVICE LIFE LIMITS OF CRITICAL & LIMITED COMPONENTS, ENTRIES SHALL COMPLY TO FAR 43.

PX-3107-76C
YQML_FRMQM00004

LIFE LIMITED PART LOG

SERIAL NUMBER: 13-162045-00712

SERIAL NUMBER: 13-162045-00712

SIGNATURE OR ACCEPTANCE STAMP: 295

[illegible]

PX-3107-76C
YQML FRMQM00004

[illegible]

PX-3107-76 BACK

[illegible]

PX-3107-76 BACK

[illegible]

PX-3107-76C
YQML FRMQM00004

[illegible]

PX-3107-76 BACK

LIFE LIMITED PART LOG

LIFE LIMITED PART NAME: DISK, AXIAL COMPRESSOR, - STAGE 4	PART NUMBER: 3075326-5	SERIAL NUMBER: 13-162053-54865
---	------------------------	--------------------------------

SERIAL NUMBER: 13-162053-54865

SIGNATURE OR ACCEPTANCE STAMP: 295

* SEE SERVICE LIFE LIMITS OF CRITICAL LIFE LIMITED COMPONENTS, ENTRIES SHALL COMPLY TO FAR 43.

[illegible]

PX-3107-76 BACK

LIFE LIMITED PART LOG	
-----------------------	--

ASSEMBLY NAME:	PART NUMBER:	SERIAL NUMBER:
----------------	--------------	----------------

LIFE LIMITED PART NAME: COMPRESSOR, ROTOR, CENTRIFUGAL	PART NUMBER: 3060371-I	SERIAL NUMBER: 13-182449-09499
--	------------------------	--------------------------------

MANUFACTURED PER FAR PART 21 UNDER
PRODUCTION CERTIFICATE PC413

SIGNATURE OR ACCEPTANCE STAMP: 295

[illegible]

* SEE SERVICE LIFE LIMITS OF CRITICAL LIFE LIMITED COMPONENTS, ENTRIES SHALL COMPLY TO FAR 43

PX-3107-76C
YQML FRM(,M)

[illegible]

PX-3107-76 BACK

[illegible]

PX-3107-76C
YQML_FRMQM00004

[illegible]

PX-3107-76 BACK

[illegible]

PX-3107-76C
YQMI. FRMQM00004

[illegible]

PX-3107-76 BACK

LIFE LIMITED PART LOG

SERIAL NUMBER: 12-156103-01098

SERIAL NUMBER: 12-156103-01098

SIGNATURE OR ACCEPTANCE STAMP: 295

* SEE SERVICE LIMITS OF CRITICAL LIFE LIMITED COMPONENTS, ENTRIES SHALL COME TO FAR 43.

LIFE LIMITED PART MAINTENANCE RECORD

DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE

SERIAL NUMBER: 12-156103-00173

SERIAL NUMBER: 12-156103-00173

SIGNATURE OR ACCEPTANCE STAMP: 190

PX-3107-76C
YQML_FRMQM00004

[illegible]

PX-3107-76 BACK

[illegible]

PX-3107-76C
YQML FRMQM00004

[illegible]

PX-3107-76 BACK

LIFE LIMITED PART MAINTENANCE RECORD

DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE

PX-3107-76 BACK

[illegible]

PX-3107-76C
YQML FRM 100004

[illegible]

PX-3107-76 BACK

[illegible]

17-76C
FRMQM00004

[illegible]

PX-3107-76 BACK

[illegible]

S. ENTRIES SHALL COMPLY TO FAR 43.

PX-3107-76C
YQML_FRMQM00004

[illegible]

PX-3107-76 BACK

[illegible]

FX-3107-76C
YQML FRMOM00004

LIFE LIMITED PART MAINTENANCE RECORD

DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE

LIFE LIMITED PART LOG

SERIAL NUMBER:

SERIAL NUMBER: 13-3300-02415

SIGNATURE OR ACCEPTANCE STAMP: 295

* SEE SERVICE LIFE LIMITS ON CRITICAL LIFE LIMITED COMPONENTS, ENTRIES SHALL COMPLY TO F.M.S.

PX-3107-76

PX-3107-75
YQMI TRM 100004

[illegible]

PX-3107-76 BACK

COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

PART NOMENCLATURE

L. P. FIRST STAGE TURB. NOZZLE ASSY.

PART NUMBER

3060666-11

SERIAL NUMBER

13-3300-02264

SERIES NUMBER

N/R

CHANGE /MOD RECORD

[illegible]

Honeywell

COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

[illegible]

LIFE LIMITED PART MAINTENANCE RECORD

DATE	MAINTENANCE PERFORMED	AUTHORIZED SIGNATURE

PX-3107-76 BACK

[illegible]

PX-3107-76 BACK

NOZZLE DATA SHEET

PRODUCTION

Honeywell International Inc. Engines & Systems

ENGINE S/N: P137179

Outline : 3062075-1

Assy : 3061704-2

Rev : A

Date: 01/30/2014

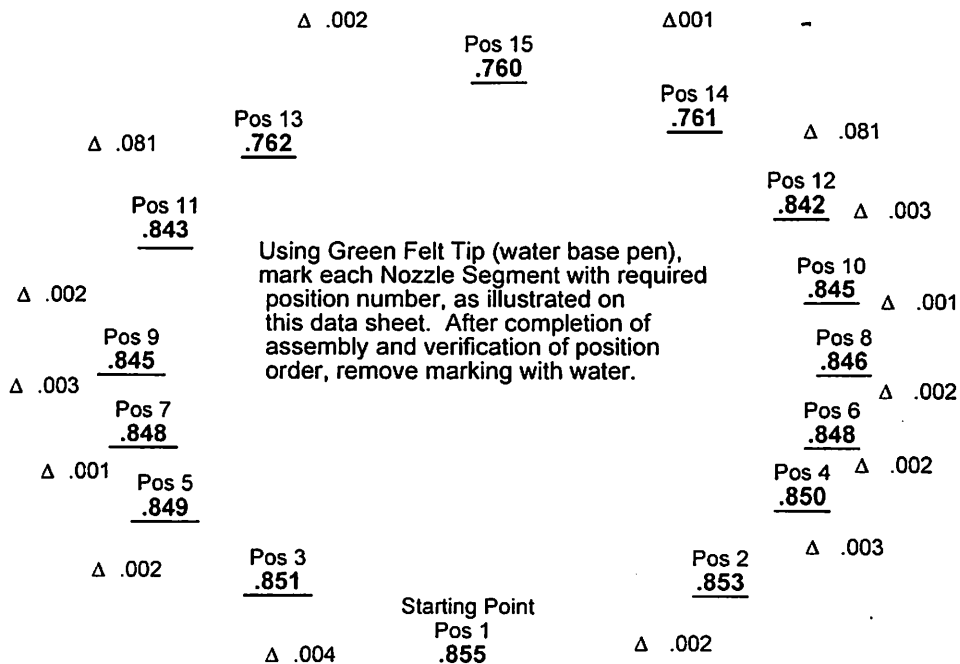
Time: 13:35:05 PM

Prod Eng: EVELYN MALDONADO

Approved: GENE MOYER

POS	PART	AE	ID.NO	LOT
1	3060840-6	.855	3710032	13-1082-311
2	3060840-6	.853	3710026	13-1082-311
3	3060840-6	.851	3742040	13-1082-344
4	3060840-6	.850	3739270	13-1082-340
5	3060840-6	.849	3742042	13-1082-344
6	3060840-6	.848	3739273	13-1082-340
7	3060840-6	.848	3739278	13-1082-340
8	3060840-6	.846	3717189	13-1082-318
9	3060840-6	.845	3742044	13-1082-344
10	3060840-6	.845	3672015	13-1082-273
11	3060840-6	.843	3742046	13-1082-344
12	3060840-6	.842	3739272	13-1082-340
13	3060840-5	.762	2507379	12-1082-107
14	3060840-5	.761	2501006	12-1082-102
15	3060840-5	.760	2557245	12-1082-158

Total AE: 12.458



A5 S/N 13-3300-02264 With an AE of: 24.084

Engineer Approved: But GW E361015

A total of (15) two-vane segments with any combination of 3060840-4, 3060840-5 & 3060840-6 that is required to achieve a flow area of 12.00 to 12.720. The effective flow area of adjacent segments must not vary more than .040 sq in. A maximum variation in adjacent segments of .085 sq in is allowed at two locations only.

A4/A5 Engine Data Sheet

_____ A5 Area: _____ sq. in. Date: _____

TFE731-20/40/50/60

Position Nozzle Segment
Number Part and Dash

Engine Models

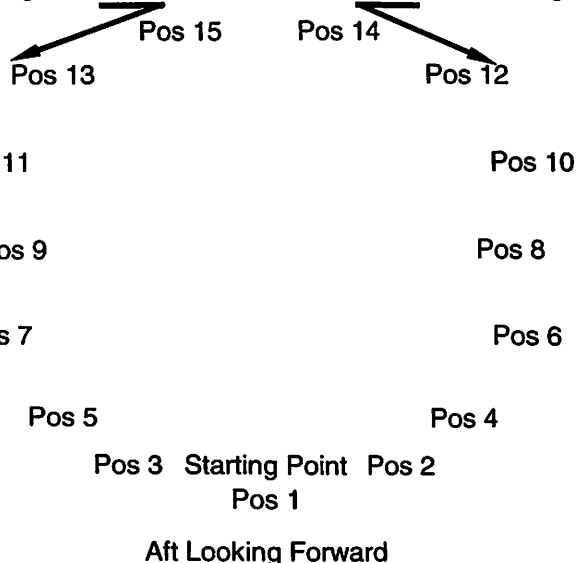
Effective Flow
Area (AE), sq. in

Ascending AE

Decending AE

1.	_____	_____
2.	_____	_____
3.	_____	_____
4.	_____	_____
5.	_____	_____
6.	_____	_____
7.	_____	_____
8.	_____	_____
9.	_____	_____
10.	_____	_____
11.	_____	_____
12.	_____	_____
13.	_____	_____
14.	_____	_____
15.	_____	_____

Total AE: _____



Note: - See applicable maintenance manual for associated procedures.

- Retain completed data sheet with engine log book.

**MPI/CZI Inspection
Record**

Note: The MPI and CZI inspection intervals identified herein are valid as of the time of MPI or CZI maintenance ONLY. These, and other engine inspection intervals, WILL change over time and, as a result, owner/operator is expressly advised NOT to rely on this information for engine maintenance planning and performance. Owner/operator is solely responsible for reviewing all subsequent approved data changes, and for managing any impact such changes may have on engine inspection intervals.

Honeywell TFE731 Turbofan Engine

MPI/CZI Inspection Record

Engine Model: TFE731-40BR-1B Engine Serial No.: P137179

Enter initials or stamp in the C/W block for each inspection accomplished.

Enter calculated hours in the next due block

	MPI		CZI		Facility	Signature/Stamp
	C/W	Next Due	C/W	Next Due		
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						
Date: _____						
TSN: _____						

ACCESSORIES

COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

PART NOMENCLATURE

OIL PUMP

PART NUMBER

3060785-3

SERIAL NUMBER

1316225400143

SERIES NUMBER

N/R

CHANGE /MOD RECORD

[illegible]

COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

PART NOMENCLATURE

DIGITAL ELECTRONIC ENGINE CONTROL

PART NUMBER

2118882-8001

SERIAL NUMBER

103-BP0061

SERIES NUMBER

1

CHANGE /MOD RECORD

[illegible]

COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

PART NOMENCLATURE

FUEL CONTROL

PART NUMBER

3070800-47

SERIAL NUMBER

20397

SERIES NUMBER

6

CHANGE /MOD RECORD

[illegible]



COMPONENT MAINTENANCE / MODIFICATION RECORD CARD

(RECORD CARD MUST TRAVEL WITH COMPONENT, REPAIR STATION OR ENGINE LOG BOOK)

[illegible]

