

	REGISTRO RECORD	REVISÃO REVISION 01
CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS Service Sheet	PÁGINA PAGE 1/14

COMPONENTE Component	O.S W.O	MODELO Model	PN	SN
FUEL CONTROL UNIT		DP-F2 Main Fuel Control Unit	442569-1	

IDENTIFICAÇÃO IDENTIFICATION	
TÍTULO	FICHA PARA REGISTROS DE TESTE DA FUEL CONTROL UNIT
TITLE	FUEL CONTROL UNIT TEST SHEET

PUBLICAÇÃO PUBLICATION	REFERÊNCIA REFERENCE	TLN	DATA DATE
COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST	73-20-85	TLN02341	Dec. 21,2020 Revision 01
CONJUNTO MAIOR MAIN PART			
		PN	SN

TESTE DA UNIDADE DE CONTROLE DE COMBUSTÍVEL FUEL CONTROL UNIT TEST				
ITEM Item	PROCEDIMENTOS TOLERÂNCIAS Procedures Serviceable limits	Resultado Result	Data Date	Executante Performed by
A	Monte a FCU na bancada de teste, usando o adaptador estriado e o adaptador de montagem. <i>Assemble the Main Fuel Control Unit to the test stand, using spline adapter and mounting adapter, or equivalent.</i>			
B	Remova o plugue e instale o adaptador PN 2561527. Remova o plugue e instale um adaptador padrão nas portas. <i>Remove plug and install PN 2561527 adapter. Remove plug and install a standard adapter into ports.</i>			
C	Remova o contra pino, porca e espaçador do eixo de aceleração. Instale o Quadrante de Aceleração PN 2550131 na extremidade do eixo de aceleração e torquee de 40-45 lb.in. <i>Remove cotter pin, nut, and spacer from throttle shaft. Assemble PN 2550131 throttle quadrant and pointer on the end of throttle shaft and tighten to 40-45 lb.in.</i>			
D	Mantenha uma pressão Po de 10-30 psig na conexão de Po, exceto quando houver outra especificação. Mantenha a pressão P2 dentro de ± 10 psi do valor especificado em pressões abaixo de 300 pph e dentro de ± 25 psig em pressões mais altas, usando a válvula reguladora de contrapressão Pn. <i>Maintain a Po pressure of 10-30 psig on Po pressure gage, except where otherwise specified. Maintain P2 pressure within ± 10 psi of the value specified at pressures below 300 pph and within ± 25 psig at higher pressures, using Pn back pressure regulator valve.</i>			
E	Antes da calibração e teste da FCU, realize um teste de vazamento de ar externo. <i>Prior to calibration and test of the main fuel control unit, carry out an external air leakage test.</i>			
F	Se o vazamento de ar for considerado excessivo, meça Px-PY com Pc a 100 psia, RPM a zero e alavanca de aceleração no máximo. Px deve ser medido na tampa de alavanca de relação do fole. Px-Py não deve exceder 1.2 in.Hg. <i>If leakage is considered excessive, measure Px-Py with Pc at 100 PSIA, RPM at zero and throttle angle at maximum. The Px shall be measured at the bellows ratio lever cover. The Px-Py should not exceed 1.2 in.Hg</i>			

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ESPECIFICAÇÕES DE CALIBRAÇÃO CALIBRATION SPECIFICATION

TEST SPECIFICATION		Number	Rev.
		T.S. 13476	1
		Sheet 1 of 8	
Orig By: *	Chk By: *	Project Leader: *	MFG Approval: *
Date:	Test Stand No.:	Operator:	S/N:
Unit: Automatic Fuel Control		Model: DP-F2	P/N: 442569

CALIBRATION SPECIFICATION

- A. See AEEI-48403 for location of adjustments and pressure taps.
- B. Connect TS-E2 Slave Sensor to control Mechanically position sensor needle to dial indicator readings as designated on sensor for +105°, +59° and -50° temp stations A fixture conforming to the requirements of AEEI 48418 may be used as an alternative.
- C. (1) Install throttle quadrant fixture with a 4.0 lb. load applied to throttle lever to hold lever against maximum throttle stop.
- (2) Index throttle quadrant to 90° T.A. Torque throttle quadrant fixture to 40-45 in-lbs.
- D. Control rotation CW as viewed from control shaft end.
- E. Maintain Po pressure of 10 to 30 PSIG at control by-pass tap.
- F. P2 must conform to AEEI 48403 Fig 3 at all nozzle flow test points, except where Pn limit is required.
- G. Set test conditions (Temp, RPM,, Supply, Pc) in the sequence indicated by numbers 1, 2, 3, etc.
- (a) When two numbers are listed, set and then trim test condition in the sequence indicated.
- (b) Approach all speeds, total fuel supplies, and Pc settings from a lower value, except at hysteresis points.
- H. All adjustments are to be properly torqued
Test points indicated (*) require special attention and are to be checked following proper torquing.
- | | | | |
|-------------------------------------|----|--|--------------|
| 1. Metering valve orifice torque | 35 | | 40 in. lbs. |
| 2. By-pass setting torque | 25 | | 35 in. lbs. |
| 3. Min. M/V stop (breakaway) torque | 4 | | 20 in. lbs. |
| 4. Max. flow M/V stop torque | 20 | | 25 in. lbs. |
| 5. Max. gov. eccentric torque | 7 | | 7.5 in. lbs. |
| 6. Max. throttle, stop torque | 20 | | 25 in. lbs. |

***APPLICABLE SIGNATURES AND DATES ON FILE**

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						TEST SPECIFICATION				T.S. 13476		
										SHEET	SHEETS	REV.
										2	of 8	1
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi		
						MIN	REC	MAX				
7.	Idle speed stop torque					20		25 in. lbs.				
8.	Flow body to drive body					20		25 in. lbs.				
9.	Drive body adapter to drive body					25		30 in. lbs. In 5 in. lbs. increments				
10.	Py Bleed					9		11 in. lbs.				
I.	Speed for Test Points indicated by (#) is to be set to ± 2 RPM of specified value. All other points are to be set within ± 20 RPM of specified value.											
J.	Total supply is to be set to ± 20 PPH of the specified value or within limits when shown.											
K.	Before calibration, check for external air leakage using MIL-PRF-25567 TYPE I. Slow bubbling is permitted at the joint of drive body and flow body, at the joint of drive body and drive body air adapter, at the torsion shaft cover and at the bellows and torsion shaft locknuts. No leakage is permitted at any other point Pc = 100 psia. If leakage is considered excessive, measure Px-Py when Pc = 100 psia, RPM = 0, and T/A = Max. Px to be measured at the bellows ratio lever cover.											
	Px - Py = +1.2 " Hg. maximum											

						TEST SPECIFICATION				T.S. 13476		
										SHEET	SHEETS	REV.
										3	of 8	1
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi		
						MIN	REC	MAX				
<u>CHECK RELIEF VALVE OPENING</u>												
	(a) Cap outlet port.											
	(b) Increase P1 pressure until fuel supply is within supply limits specified and observe P1-Po differential.											
	(c) If P1-Po differential is out of limits, shim as required. Add shims to increase differential.											
	(d) If valve has been re-shimmed, torque plug to 15-20 in-lb and locknut to 70-80 in-lb.											
1.01	1 0	4 200-275	2 MAX	3 +105	4 85.0	Relief valve opening P1-Po			950	1000 PSI		
<u>CHECK PRESSURIZING VALVE OPENING</u>												
	(a) Outlet line connected to control.											
	(b) Increase P1 pressure until required fuel supply is obtained, and observe P1-Po differential.											
	(c) If P1-Po differential is out of limits, shim as required. Add shim to increase differential.											
	(d) If valve cover has been removed and re-assembled, torque screws to 4.5-5.0 in-lb in 1 in-lb increments maximum while alternating between the screws.											
1.02	1 0	5 100	2 MAX	3 +105	4 85.0	Pressurizing valve opening P1-Po			55	68 PSI		
<u>METERING VALVE ORIFICE AND BY-PASS HEAD (P1-P2" HG) SETTING</u>												
	(a) Test points 2.01 through 2.03 are interrelated and should be recorded after all three (3) adjustments have been made.											
	(b) If at T.P. 2.03, P1-P2 is higher than 41 in. Hg, remove by-pass valve cover and replace existing spacer P/N 3240905 with thicker spacer P/N 3240905-1. If P1-P2 is lower than 33 in. Hg, remove and discard existing spacer.											
	(c) Re-torque the by-pass valve retaining screws to 20 in.lb. in increments of 5 in.lb. and recalibrate T.P. 2.01 to 2.03.											

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TEST SPECIFICATION		T.S. 13476								
		SHEET 4	SHEETS of 8							
		REV. 1								
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi
						MIN	REC	MAX		
2.01*	3 5800	4-6 1350	1 MAX	2 +105	5 40.0	203		212		
Adjust head and orifice, P1-P2 = 26-42" IIG										
2.02*	2900	720	30-32	+105	40.0	80		84		Pn = 75-90
Set minimum M/V stop after removing Py line.										
2.03*	5800	1350	MAX	+105	70.0	367		373		
Retrim head and re-adjust 2.01-2.02 if out of limits.										
						P2 = 365		415	PSIG	
						Pc-Px		1.0"	HG Max	
						Px-Py		1.2"	IIG Max	
As per note (b) Check appropriate box										
		Original spacer								
		Spacer removed								
		Spacer replaced								
2.04*	5800	1350	MAX	+105	100.0	506		520		
Set maximum M/V stop										
2.05	5800	1350	MAX	+105	40.0	-10		+10		
Hysteresis of T.P. 2.01										
<u>ENRICHMENT SPRING SETTING</u>										
3.01	3-7 5800	4-6 1350	1 MAX	2 -50	5 55.0	X		X	Record Nozzle Flow	
3.02#	5100	1170	MAX	-50	55.0	-13		-17		
Adjust enrichment spring to obtain 13 to 17 PPH less than 3.01. Increasing spring tension increases difference. To verify setting, approach enrichment speed from 4600 RPM. (Re-check T.P. 3.01 & 3.02 after adjustment).										

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TEST SPECIFICATION						T.S. 13476				
						SHEET 5 of 8	SHEETS 8	REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi
						MIN	REC	MAX		
4.01	3 4000	4-6 1000	1 MAX	2 -50	5 40.0	172		183	Pn = 100-110 psig	
						Pc-Px 8.5			11.5" HG	
						Px-Py			1.2" HG Max	
<u>MAX. GOVERNOR SPRING SETTING</u>										
(a) Adjust eccentric shaft to meet flow limits. (b) If unable to set with eccentric, maximum T.A. may be varied within T.A. limits. (c) If unable to set with eccentric or maximum T.A. maintain eccentric shaft scribe line and determine amount of RPM off. (d) Split control and adjust gov. spring as required (CW adj. of governor spring delays break, approximately 1 flat on adj. nut per 50 RPM). (e) If gov. slope is not in limits, select Py bleed P/N 2525107.										
Py #58 #66 (higher number bleed to increase difference in flow).										
5.01#*	5 6350	4-7 1440	1 	2 +59	3-6 85.0	325		355		
Set Governor Break T.A. at 89° - 91°						Px-Py			"HG	
5.02#*	6500	1530	"	+59	85.0	105		125		
Diff from T.P. 5.01 (Gov. Slope)						Px-Py			"HG	
5.03*		1440	"	+59	85.0	X		X		
Hysteresis within - 50							+0 RPM of T.P. 5.01			
						Px-Py			"HG	
<u>IDLE SPEED STOP SETTING AND PICK-UP ANGLE</u>										
(a) At test point 6.02 increase T.A. until 4 PPH max fuel flow from 6.01 is observed (T.A. where flow starts to increase is pick-up angle). (b) If throttle cam pick-up angle is out of limits, replace governor spring.										
1) Use a higher numbered spring if pick-up angle exceeds 56° diff. from T.P. 6.01. 2) Use a lower numbered spring if pick-up angle is less than 52° diff. from T.P. 6.01. 3) Adjust spring tension to same load as set on spring removed. 4) Re-set gov. break at test point 5.01 and re-run T.P.s 5.02 and 5.03 inclusive. 5) Re-set idle stop screw at test point 6.01.										

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TEST SPECIFICATION						T.S. 13476			
						SHEET 6	SHEETS of 8	REV. 1	

TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi
						MIN	REC	MAX		
6.01#*	4 3200	1-7 800	5 30-32	2 +59	3-6 30.0	104		112		
Set idle stop screw (CW adj. increase flow) Decrease and reset speed after adjustment.										
6.02#	3200	800		+59	30.0					Pn = 95-105
Throttle pick-up angle difference 52° 56° of T.P. 6.01										
Spring Stripe										
<u>LOW END OF ACCELERATION FLOW AND THROTTLE MOVEMENT EFFECT</u>										
(a) After recording nozzle flow at test point 7.02 move throttle to 30° T.A.										
(b) Observe nozzle flow change and record.										
7.01	3 815	5 200	4 40	2 +59	1 Local	60		X		Pn = 75 psig Min.
7.02	2100	670	40	+59	25.0	113		124		Pn = 95-105 psig
Move T.A. to 30° 5 PPH maximum decrease										
<u>MAX IDLE RESET STOP ADJ.</u>										
Hold idle reset lever against idle reset stop and adjust stop to meet flow limits.										
8.01#	1 5000	4-6 1170	5 -	2 +59	3-7 55.0	188		197		
Set Max idle reset stop Record T.A.										
<u>CUT-OFF MODULATION AND CUT-OFF LEAKAGE</u>										
A. At test point 9.01, set test condition with 20° T.A.										
(a) Move throttle to 30° T.A. and observe nozzle flow change.										
(b) If nozzle flow change is excessive –										
(1) Reset throttle to 20° T.A.										
(2) Back off override adj. nut on cut-off link.										
(3) Adjust cut-off link longer to meet max flow change limit.										

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TEST SPECIFICATION						T.S. 13476				
						SHEET 7 of 8	SHEETS 8	REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi
						MIN	REC	MAX		
9.01	3 2000	4-6 500	1 20	2 +105	5 A.R.	160		170		
						Nozzle Flow Change 4 PPH MAX				
B. At test point 9.02 check cut-off leakage.										
(a) Remove nozzle outlet from control. (b) Set total supply with throttle in cut-off position (Highest T.A. position where no leakage is observed at outlet fitting). (c) Increase T.A. to permit flow out the outlet fitting. (d) Decrease T.A. as required until no leakage is observed at outlet fitting (Observe T.A.). (e) If T.A. is out of limits, shim cut-off valve seat by removing shims under C.O. valve seat to increase T.A. (002" thickness shim changes T.A. approximately 2"). (f) Same Pc as established for T.P. 9.01.										
9.02	2000	500	8-10	+105	-				P1-P2	
						0 0.5 cc/MIN Cut-off leakage P1 pressure 250 PSIG MAX				
C. At test point 9.03 (-5° T.A.)										
(a) Observe P1 pressure (b) Adjust override nut for 005" to 010" clearance between nut and bushing. (c) Adjust upper lever (idle reset lever) stop to just contact lever. (d) At 0° T.A. lower C.O. lever to be within ± 5° of horizontal.										
9.03	3 2000	4-6 500	1 -5	2 +105	5 -				P1 PSIG	
						Pc same as in T.P. 9.01, P1 same or less than T.P. 9.02				
9.04	-		Min-Max-Min		LOCAL					
						Operate thro Lever over full range Throttle Torque 15" LBS MAX				

TEST SPECIFICATION						T.S. 13476				
						SHEET 8 of 8	SHEETS 8	REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P1-P2 "Hg	Pn psi
						MIN	REC	MAX		
EXTERNAL LEAKAGE CHECK										
A. Cap Po at drive flange by-pass tap. B. Remove Po line to control and install Po plug. C. Cap outlet port. D. Set P1 pressure to 1000 PSIG. E. Observe leakage for 2-3 minutes. F. No leakage permitted.										
10.01									OK REJECT	
10.02									X 5.3 lb. max.	
						Checked by				
						Inspected by				

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ESPECIFICAÇÕES DE AUDIÇÃO AUDIT SPECIFICATION
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TEST SPECIFICATION		Number T.S. 13477	
		Sheet 1 of 6	Rev. 1
Orig By: *	Chk By: *	Approved by: *	MGF Approval: *
Date:	Test Stand No.:	Operator:	S/N:
Unit: Automatic Fuel Control		Model: DP-F2	P/N: 442569

AUDIT SPECIFICATION

- A. See AEEI 48403 for location of adjustments and pressure taps.
- B. Connect TS-E2 Slave Sensor to control. Mechanically position sensor needle to dial indicator readings as designated on sensor for +105°, +59° and -50° temp. stations. A fixture conforming to the requirements of AEEI 48418 may be used as an alternative.
- C. (1) Install throttle quadrant fixture with a 4.0 lb. load applied to throttle lever to hold lever against maximum throttle stop.
 (2) Index throttle quadrant to 90° T.A. torque throttle quadrant fixture to 40-45 in-lbs.
- D. Control rotation CW as viewed from control shaft end.
- E. Maintain Po pressure of 10 to 30 PSIG at control by – pass tap.
- F. P2 must conform to AEEI 48403 Fig. 3 at all nozzle flow test points, except where Pn limitis required.
- G. Set test conditions (Temp., RPM, Supply, Pc) in the sequence indicated by numbers 1,2,3, etc.
 - a) When two numbers are listed, set and then trim test condition in the sequence indicated.
 - b) Approach all speeds, total fuel supplies, and Pc settings from a lower value, except at hysteresis points.
- H. Speed for test points indicated by (#) is to be set to ±2 RPM of specified value. All other points are to be set within ±20 RPM of specified value.
- I. Total supply is to be set to ± 20 PPH of the specified value or within limits when shown.

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TEST SPECIFICATION						T.S. 13477				
						SHEET 2	SHEETS of 6	REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW,PPH			P ₁ -P ₂ "Hg	P _n psi
						MIN	REC	MAX		

CHECK RELIEF VALVE OPENING

a) Cap outlet port.

b) Increase P1 pressure until fuel supply is within supply limits specified and observe P1-Po differential.

1.01	1 0	5 200-275	2 MAX	3 +105	4 85.0					
Relief valve opening						P1-Po	950		1000 PSI	

CHECK PRESSURIZING VALVE OPENING

a) Outlet line connected to control.

b) Increase P1 pressure until required fuel supply is obtained, and observe P1-Po differential.

1.02	1 0	5 100	2 MAX	3 +105	4 85.0					
Pressurizing valve opening						P1 – Po	52		70 PSI	

METERING VALVE ORIFICE AND BYPASS HEAD (P1 – P2 “HG) SETTING

2.01	3 5800	4-6 1350	1 MAX	2 +105	5 40.0	201		214	
P1 – P2 = 24– 43 “HG.									
2.02	2900	720	30-32	+105	40.0	80		85	
P _n =75-90 psig. Remove Py line									
2.03	5800	1350	MAX	+105	70.0	363		376	
						Pc – Px		1.5” HG Max.	
						Px – Py		1.2” HG Max.	
						P2 365		415 PSIG	

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								SHEET 3	SHEETS of 6	REV. 1
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW, PPH			P ₁ -P ₂ "Hg	P _n psi
						MIN	REC	MAX		
2.04	3 5800	4-6 1350	1 Max	2 +105	5 100.0	505		525		
2.05	5800	1350	Max	+105	40.0	-10		+10		
Hysteresis of T.P. 2.01										
<u>ENRICHMENT SPRING SETTING</u>										
3.01	3-7 5800	4-6 1350	1 MAX	2 -50	5 55.0	X		X	Record nozzle flow	
3.02#	5100	1170	"	-50	55.0	-9		-21		
Approach enrichment speed from 4600 RPM. Nozzle flow to be 9 to 21 PPH less than 3.01										
4.01	3 4000	4-6 1000	1 MAX	2 -50	5 40.0	168		187		
Pc-Px 8.5 11.5" HG										
<u>MAX. GOVERNOR SPRING SETTING</u>										
5.01#	5 6350	4-7 1440	1 MAX	2 +59	3-6 85.0	310		370		
5.02#	6500	1530	"	+59	85.0	100		130		
Diff. from T.P. 5.01 (Gov. Slope).										
5.03		1440	"	"	"	X		X		
Hysteresis within -50 +0 RPM of T.P. 5.01										

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						SHEET 4	SHEETS of 6		REV. 1	
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	P _c psia	NOZZLE FLOW, PPH			P ₁ -P ₂ "Hg	P _n psi
						MIN	REC	MAX		

IDLE SPEED STOP SETTING AND PICK-UP ANGLE

(a) At test point 6.02 increase T.A. until 4 PPH max. fuel flow from 6.01 is observed. (T.A. where flow starts to increase is pick-up angle).

6.01#	4 3200	1-7 800	5 30-32	2 +59	3-6 30.0	103		113
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P_n=75-90 psig

6.02#	3200	800		+59	30.0			
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P_n = 75-90 psig. Throttle cam pick-up angle. Diff. of T.P. 6.01 52° 56°

LOW END OF ACCELERATION, CURVE AND THROTTLE MOVEMENT EFFECT

(a) After recording nozzle flow at test point 7.02 move throttle to 30° T.A.
(b) Observe nozzle flow change and record.

7.01	3 815	5 200	4 40	2 +59	1 Local	60		X	P _n =75 psig Min.
7.02	2100	670	40	+59	25.0	111		126	

Move. T.A. to 30° 5 PPH maximum decrease

MAX. IDLE RESET STOP ADJ.

(a) Install interlink tool as per AEEI 15849 Fig. 3.

8.01#	1 5000	4-6 1170	5 -	2 +59	3-7 55.0	188		197
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Record T.A.

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		TEST SPECIFICATION				T.S. 13477				
						SHEET 5 of 6		REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW,PPH			P ₁ -P ₂ "Hg	P _n psi
						MIN	REC	MAX		
<u>CUT-OFF MODULATION AND CUT-OFF LEAKAGE</u>										
A. At test point 9.01, set test condition with 20° T.A. (a) Move throttle to 30° T.A. and observe nozzle flow change.										
9.01	3 2000	4-6 500	1 20	2 +105	5 A.R.	160			170	
						Nozzle flow change			4 PPH MAX.	
B. At test point 9.02 check cut-off leakage. (a) Remove nozzle outlet line from control. (b) Set total supply with throttle in cut-off position. (Highest T.A. position where no leakage is observed at outlet fitting). (c) Increase T.A. to permit flow out the outlet fitting. (d) Decrease T.A. as required until no leakage is observed at outlet fitting (Observe T.A.). (e) Same Pc as established for T.P. 9.01.										
9.02	2000	500	8-10	+105					P1-P2	
	0								P1 pressure	250 PSIG Max.
C. At test point 9.03 (-5° T.A.). (a) Observe P1 pressure. (b) Upper lever (idle reset lever) stop to just contact lever. (c) At 0° T.A. lower C.O. lever to be within ±5° of horizontal. (d) Pc same at T.P. 9.01.										
9.03	3 2000	4-6 500	1 -5	2 +105	5 A.R.				P1	
						P1 pressure equal to or less than T.P. 9.02			PSIG	
9.04	-		Min-Max-Min		LOCAL	Remove interlink tool.				
						Throttle Torque			15" LBS. MAX	

		TEST SPECIFICATION				T.S. 13477				
						SHEET 6 of 6		REV. 1		
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	TEMP °F	Pc psia	NOZZLE FLOW,PPH			P ₁ -P ₂ "Hg	P _n psi
						MIN	REC	MAX		
<u>EXTERNAL LEAKAGE CHECK</u>										
A. Cap Po at drive flange by-pass tap. B. Remove Po line to control and install Po plug. C. Cap outlet port. D. Set P1 pressure to 1000 PSIG. E. Observe leakage for 2-3 minutes. F. No leakage permitted.										
						OK		REJECT		
Record shipping weight						X		5.3 lb. max.		
Checked by										
Inspected by										

	REGISTRO RECORD	REVISÃO REVISION 01
	CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS Service Sheet

FICHA DE REGISTRO DO PRE-FLUXO | PRE-FLOW RECORD SHEET

TEST SPECIFICATION		Number T.S. 13478	Rev. 1
		Sheet 1 of 2	
Orig By: *	Chk By: *	Project Leader: *	MFG Approval: *
Date:	Test Stand No.	Operator:	S/N:
Unit: Automatic Fuel Control		Model: DP-F2	P/N:

PRE-FLOW RECORD SHEET

ASSEMBLY P/NO _____ S/NO _____

See parts list index sheet for pre-flow specification. Serial numbers to be recorded as detailed below.

DRIVE BODY ASSEMBLY PRE-FLOW P.NO. _____ Case No _____

Load lbs.	Air Pressure psig (psia) ± 2	Pressure Drop Across #70 Bleed Inches of Kerosene			
		Min.	Rec.	Max.	
4.0	75 (90)	0.0		10.0	= A
.64	75 (90)	0.0		Must be within 5" Ker of A	
Gap between governor spool and roller				.003"	.007"

Record Py Bleed Size		Torque	9		11 in. lb.
Record Px Bleed Size		Torque	9		11 in. lb.
Record Pa Bleed Size		Torque	9		11 in. lb.
Record Spring Stripe	1 5				

Pc (P.S.I.A.)	Pc-Px Pressure Drop Across #53 Bleed (In. Hg.)		
	Min.	Rec.	Max.
40	9.8		10.8
*40	0		2.8

***NOTE** Close enrichment valve
 Spring Load = See process

Record Spring Load lbs.

Note Approach setting from .4 lbs. above setting force required. The nominal setting force may vary at times and may be adjusted as required to suit current Test Cell results.

	REGISTRO RECORD	REVISÃO REVISION 01
	CODIGO CODE IAS-RG-0223	FICHA DE SERVIÇOS Service Sheet

		TEST SPECIFICATION		T.S. 13478				
				SHEET 2 of 2 SHEETS 2	REV. 1			
TEST POINT	SPEED RPM	SUPPLY PPH	THRO DEG.	COND DEG	Pc psia	NOZZLE FLOW, PPH MIN REC MAX	P1-P2 "Hg	Pn psi

DIMENSIONAL CHECKS ON DRIVE SHAFT

- Distance of spline end of shaft from mounting face
Dimension 'X' = inch
- End play of Drive Shaft inch
- Run out of Drive Shaft when rotated T.I.R. inches

FLOW BODY ASSEMBLY P/No _____ Case No _____

Torque tube loading – Record dial indicator reading 0.014" 0.018" at 10 in. lb. torque

METERING VALVE TRAVEL PRE-FLOW

Test Point	Air Pressure psia	Min.	Metering Valve Travel	Max.	
1.1	15	X	0.000	X	Zero dial indicator
1.2	50	.0315		.0375	Adjust m.v. ratio lever
1.3	90	X		X	Record Deflection
1.4	50	within		.002	Hysteresis from T.P. 1.2
2.1	25	-.008		-.011	Vent Py to atmosphere Adjust bellows min. stop to obtain required metering valve travel.
Metering Valve Lever Position					.055
Lock wire M.V. Ratio Lever					Yes

Bellows S/N _____ Bellow deflection _____

Torsion Tube Deflection .146" .186" Torsion Shaft S/N: _____

Shim dimension 0 .080" Metering Valve S/N: _____

By – pass valve spacer installed, check appropriate box:

No spacer	☐
P/N 3240905	☐
P/N 3240905-1	☐

Checked by _____ Inspected by _____

Observações Remarks			
Aprovação Approval	Nome Name	Data Date	Assinatura Signature