

Process	SLS34/54 Service	Cell / Department	Service & Aftermarket
Operation description	Blade Removal & Re-fitting		
Reason for re-issue	Original Issue		



1. Remove (3) cap head screws from the drive end fan cowl



2. Mark the cowl & body, then remove cowl



3. Carefully remove fan using a set of pullers as shown (or tap from the rear using a blunt chisel or screwdriver)



4. Remove key from shaft



5. Disconnect oil pipe from fitting



6. Remove (6) cap screws from side plate

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7. Carefully prise side plate from the body and remove.



9. Remove old blades from rotor.  
(rotating the rotor helps when removing the blades)



8. Remove side plate (and if possible gasket) to expose rotor & blades

**NOTE:**  
Ensure oil injection orifice is clear & free from debris!



10. Check rotor & inside of body to ensure there are no blades or debris remaining (blow out using an airline)



11. Lightly oil blades on both sides using a clean paint brush

12. Insert blades into rotor slots. Note: depending on the machine rotation, depends which way the blades are located/orientated

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Clean this mating face & side plate

13. If shim is damaged, remove & clean body & side plate mating surfaces. Measure & note the shim thickness



14. Obtain shim of same thickness as before. Lay over side plate and line up with dowl pins & holes.



Apply grease

15. Apply some grease to inside of shaft seal in side plate & shaft. Push side plate over shaft taking care not to damage the seal.



16. Tap side plate & locate into body using existing dowel pins



17. Secure side plate to body using (8) cap screws. Check to see if machine runs free by rotating shaft



18. Add clock (DTI) to m/c and check end float. (If not correct as per specification it will then be necessary to remove side plate and repeat steps 13-18)

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19. Re-attach oil pipe (blow through the oil pipes to ensure they are clear of any debris)



22. Re-fit cowl using (3) cap head screws. Ensure rotor runs freely. Also, ensure blades drop freely



20. Clean key. Tap key back into keyway on shaft



21. Push fan over shaft & tap 'fully home'

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