



INCREMENTAL CHANGE

Release Notification Date: 04/22/2022

SPM 70-48-22 REPLACEMENT OF RING-LOCK SELF-LOCKING INSERT

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### HIGHLIGHTS

<u>HIGHLIGHT REFERENCE</u>	<u>DESCRIPTION OF CHANGE</u>
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tk70-48-22-350-801	Technical Change: Added special procedure for the removal and replacement of the ring-locked self-locking inserts.
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TASK 70-48-22-350-801

1. General.

A. This repair provides the instructions for the removal and replacement of ring-locked self-locking inserts.

2. Tools and Equipment.

Subtask 70-48-22-350-001

- Drill Set
- Drill Stop Collar Set
- Drive Tool
- Swage Tool
- Hex Head Drive
- Wrenches (Allen keys)
- Punch
- Pointed Pick
- Shop Vacuum
- 0.3215-24 UNJF-3B tap
- 0.3750-24 UNJF-3B tap
- 0.4375-20 UNJF-3B tap
- 0.4375-28 UNJEF-3B tap
- Bolt - Inconel 718 (Bolt thread 0.2500-28 UNJF-3A, Pitch diameter 0.2243-0.2251 inch (5.698-5.717 mm))
- Bolt - Inconel 718 (Bolt thread 0.3125-24 UNJF-3A, Pitch diameter 0.2827-0.2836 inch (7.180-7.203 mm) (standard bolt 0.3125-24))
- Bolt - Inconel 718 (Bolt thread 0.375-24 UNJF-3A, Pitch diameter 0.3450-0.3460 inch)

- (8.763-8.788 mm)) (standard bolt 0.375-24)
- 0.250 inch (6.35 mm) heavy duty flat washer with 0.063 inch (1.60 mm) minimum thickness x 0.50 inch (12.7 mm) minimum outer diameter
- 0.3125 inch (7.938 mm) heavy duty flat washer with 0.060 inch (1.52 mm) minimum thickness x 0.62 inch (15.7 mm) minimum outer diameter
- 0.375 inch (9.52 mm) heavy duty flat washer with 0.060 inch (1.52 mm) minimum thickness x 0.75 inch (19.0 mm) minimum outer diameter

3. Consumable Materials.

Subtask 70-48-22-350-002

**NOTE:** Equivalent alternatives can be used for Consumable Materials.

<u>Consumable Product</u>	<u>No.</u>
3M-250 Tape	C10-189
Tape, Plastic	C10-021
Oil, Engine Lubricating	C02-019, C02-023
Primer Paint	C03-100

4. Procedure.

Subtask 70-48-22-350-003

A. Procedure for removal of the ring-locked self-locking insert.

**NOTE:** You can replace the insert without damage to the threads of the parent material. Ring-locked self-locking inserts use an oval shaped ring with serrations to tighten and lock the insert in its position.

- (1) If necessary, clean the work area prior to attempt any repairs to prevent contamination of the assembly.
- (2) Remove the non-serviceable threaded insert and ring-lock from the assembly. Refer to Figure 1, Figure 4, Figure 6, and as follows:
  - (a) Use a plug or tape C10-189 or C10-021 to seal the openings around the repair area in the assembly to prevent contamination or other means to protect the assembly from contamination. Use tape C10-021 or C10-189 to cover the inner side of the bolt holes repaired on the engine case to prevent debris that fall through the bolt holes.

**WARNING:** METAL PARTICLES FROM DRILLING CAN CAUSE DAMAGE, INJURY, OR IRRITATION TO YOU. USE PERSONAL PROTECTION EQUIPMENT.

**CAUTION:** DO NOT DRILL INTO THE ASSEMBLY PARENT MATERIAL. DAMAGE TO THE ASSEMBLY WILL OCCUR.

**CAUTION:** MAKE SURE THAT THE ASSEMBLY DOES NOT MOVE DURING THE DRILLING PROCEDURE. DAMAGE TO THE ASSEMBLY CAN OCCUR.

- (b) With the correct use of the size drill bit with stop collar, set the collar to a drill depth of 0.090 inch (2.28 mm), align the drill bit with the center-line of the damaged insert, and drill into the insert.
- (c) Use a vacuum during the drilling procedures to reduce the possibility that metal particles contaminates the assembly.
- (d) Use a punch to assist the removal of the ring-lock as follows:
  - 1 Put the punch on one end of the ring-lock and use a hammer to tap the punch lightly.
  - 2 Carefully, lift the ring-lock from the oval shaped counterbore hole.
- (e) Use the correctly sized allen key or locally manufactured installation drive tool to remove the damaged insert.
  - 1 The damaged insert cannot be used again and should be discarded.
- (f) Remove all the unwanted material from the assembly repair area.
- (3) Do a visual inspection of the threads in the assembly repair area. Refer to Figure 6 and as follows:
  - (a) If necessary, remove the high metal from the threaded hole with a tap to chase the threads.
  - (b) Use clean compressed air to remove the loose metal chips from the tapped hole.
  - (c) If more than the first thread remains damaged after to chase the threads, this part cannot be repaired by this procedure.
- (4) Blend the counterbore and countersink by hand to remove the high metal. Refer to TASK 70-42-00-350-002 (70-42-00, Blending and Removal of High Metal Procedures).

**NOTE:** Full removal of the high metal in the counterbore and countersink will decrease the risk of interference in the ring-lock installation and prevent further removal of the ring-lock.

**WARNING:** USE EYE PROTECTION WHEN YOU USE COMPRESSED AIR TO CLEAN, COOL, OR DRY PARTS OR TOOLS. PARTICLES CAN CAUSE AN INJURY TO YOUR EYES. ENSURE COMPRESSED AIR PRESSURE IS LESS THAN 30 PSIG (207 KPA). DO NOT POINT COMPRESSED AIR AT YOURSELF OR OTHER PERSONS.

- (5) Use clean compressed air to remove the loose metal chips from the tapped hole.
- (6) If required, clean the counterbore.
- (7) Do a dimensional inspection of the counterbore. Refer to Figure 2 and as follows:
  - (a) If the dimensions do not agree with the limits, you cannot repair the assembly with this procedure.
- (8) Do an inspection of the threads in the hole that is repaired as follows:
  - (a) If the threads are not serviceable, you cannot repair the assembly with this procedure.

B. Procedure for the Installation of the Ring-Lock Self-Locking Insert

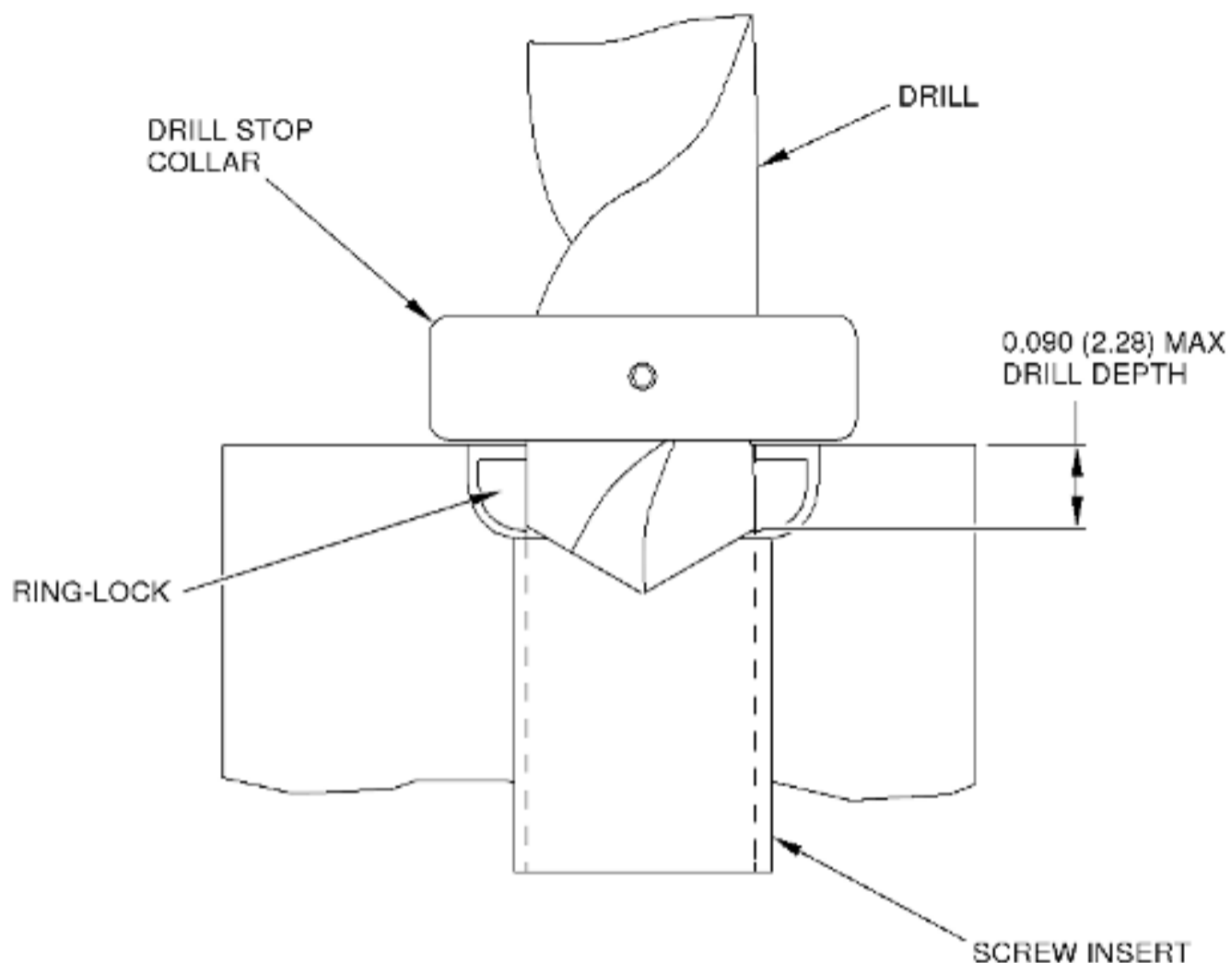
**NOTE:** You can replace the insert without damage to the threads of the parent material.

- Ring-locked self-locking inserts use an oval shaped ring with serrations to tighten and lock the insert in its position.
- (1) Install the new insert and the new ring-lock in the assembly. Refer to Figure 2, Figure 3, Figure 4, and as follows:
    - (a) Make sure that you remove all the unwanted material from the threaded hole and the counterbore before you install the new threaded insert and the ring-lock.
    - (b) Use the same size insert as the damaged threaded insert that you removed.
    - (c) Install the new threaded insert into the threaded hole of the assembly as follows:
      - 1 If the assembly is not aluminum, apply engine lubricating oil C02-019 or C02-023 to the insert OD as necessary to assist with insert installation.
      - 2 If the assembly is aluminum, wet install the insert and ring-lock as follows:
        - a Apply paint C03-100 on the shanks, threads, and bearing surface of the insert and ring-lock.
      - 3 Put the insert into the threaded hole with the correctly sized allen key wrench or locally manufactured installation drive tool and as follows:
        - a Install the insert in the case until the top face of the insert is 0.010-0.030 inch (0.25-0.76 mm) below the assembly surface.
  - (2) Install the new ring-lock on the threaded insert and into the oval shaped hole of the assembly. Refer to Figure 3 and as follows:
    - (a) The word TOP on the ring-lock must face out from the assembly.
    - (b) Align the serrations on the threaded insert with the serrations of the ring-lock.
  - (3) Swage the new threaded insert into the ring-lock. Refer to Figure 3, Figure 5, and as follows:
    - (a) Make a swage tool to meet the dimension requirements.
    - (b) Put the swage tool into the screw insert and the ring-lock.
    - (c) Push the ring-lock to make contact with the bottom of the counterbore.
    - (d) Use a hammer to tap the swage tool until the nylon stop washer of the swage tool touches the pad on the assembly.
  - (4) Remove the swage tool.
  - (5) Do an inspection of the insert and ring-lock. Refer to Figure 3 and as follows:
    - (a) Use 10X magnification.
    - (b) Make sure that the insert serrations are swaged into the serrations of the ring-lock.
    - (c) Make sure that the ring-lock is a minimum of 0.002 inch (0.05 mm) below the assembly surface.
    - (d) Use a pointed pick to try to lift the ring-lock with light hand pressure on the pick and make sure that the ring-lock does not lift out of the counterbore.
- CAUTION:** DO NOT CONTINUE TO SCREW THE STANDARD BOLT THROUGH THE SCREW INSERT WHEN YOU DO A CHECK OF THE MINIMUM LOCKING TORQUE. DAMAGE TO THE ASSEMBLY WILL OCCUR.
- (6) Do a check of the self-locking torque of the threaded insert. Refer to Figure 7 and as follows:
    - (a) Install the correct size bolt and washer into the replaced ring-locked self-locking insert.

**NOTE:** If the hole in the washer is too small for the bolt to pass through, you can use a washer with larger inner diameter as long as head of the bolt will not go through the washer. Make sure to use a washer with specified thickness.
    - (b) Use a torque wrench to torque the installed bolt in the torque range and as follows:
      - 1 The lock-ring can rotate in the counter bore if the torque range is met.

**NOTE:** Torque check is not required for inserts 2838M72P02 and 2838M72P05.
    - (c) Remove the bolt and flat washer from the threaded insert.
- CAUTION:** MAKE SURE THAT CONTAMINANTS DO NOT FALL IN THE ASSEMBLY. DAMAGE TO THE ASSEMBLY CAN OCCUR.
- (7) Remove any masking tape, plugs, or other means that were used to keep contaminants from the entering assembly.

\* \* \* FOR ALL

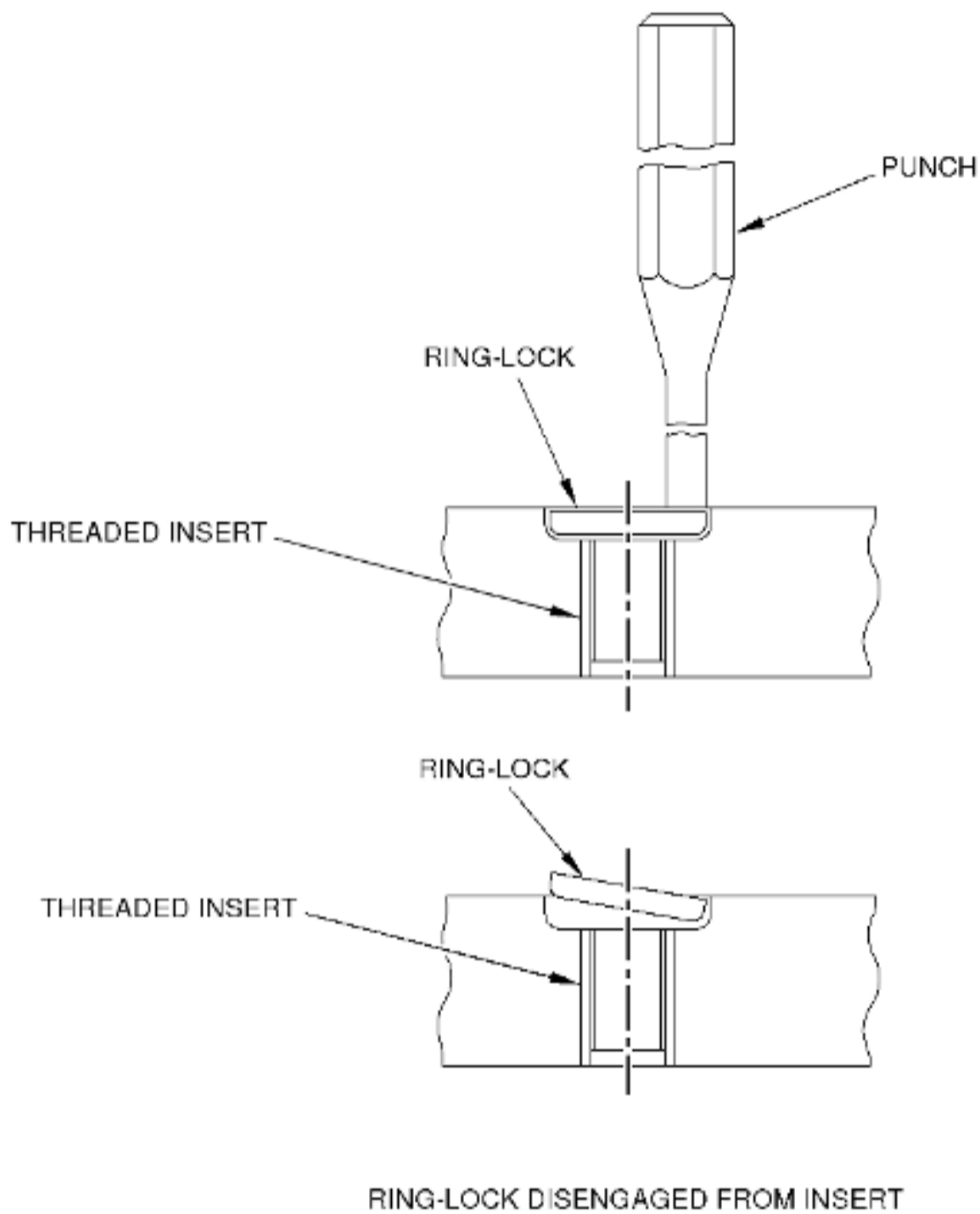


**NOTE:**  
DIMENSIONS ARE IN INCHES WITH  
MILLIMETERS IN PARENTHESES.

6035400-00

Figure 1 (Sheet 1) Ring-Lock and Threaded Insert Removal

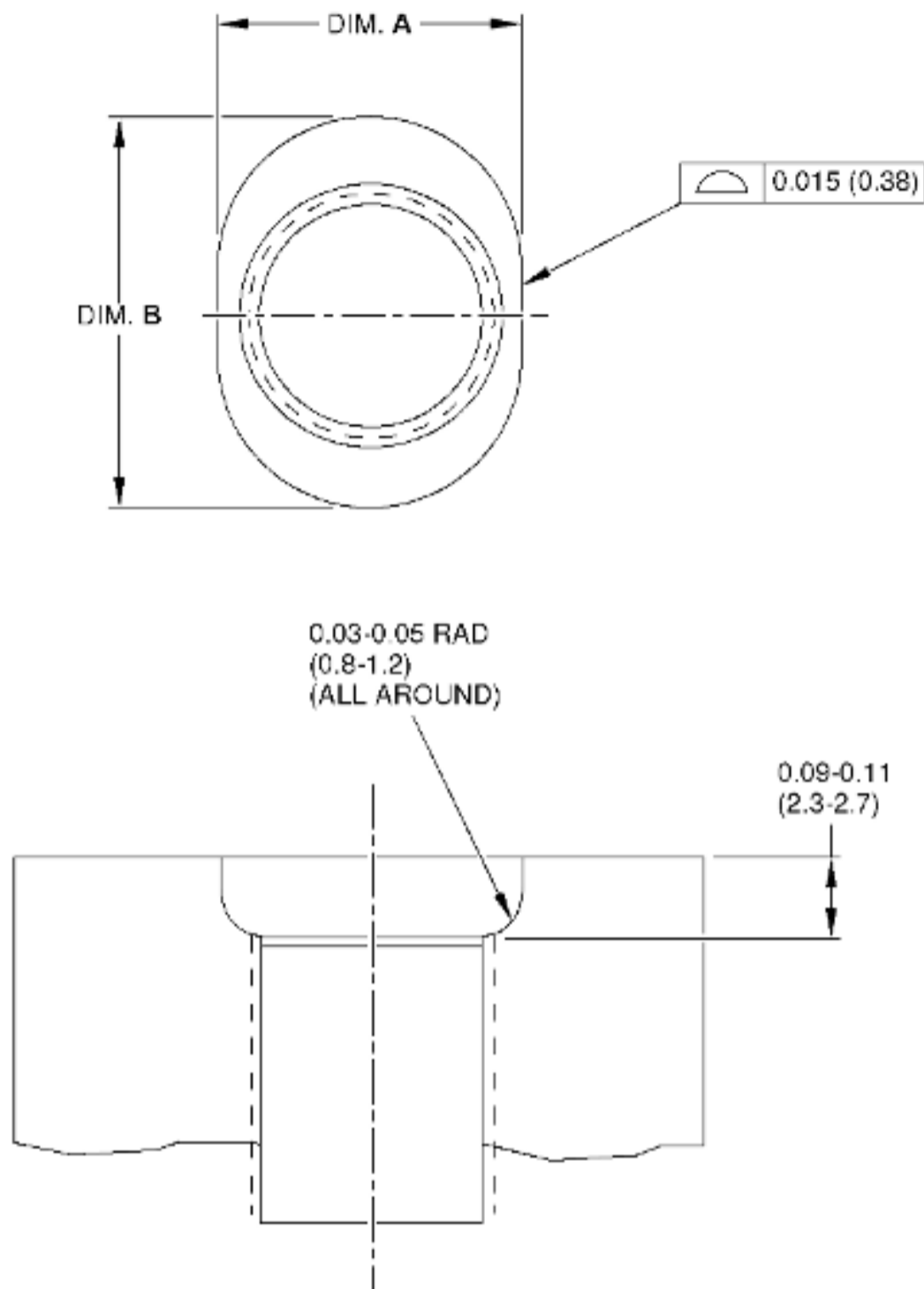
\* \* \* FOR ALL



6035401-00

Figure 1 (Sheet 2) Ring-Lock and Threaded Insert Removal

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**NOTE:**  
DIMENSIONS ARE IN INCHES WITH  
MILLIMETERS IN PARENTHESES.

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Figure 2 (Sheet 1) Ring Lock Counterbore Dimensions and Threaded Insert/Ring-Lock Part Numbers

\* \* \* FOR ALL

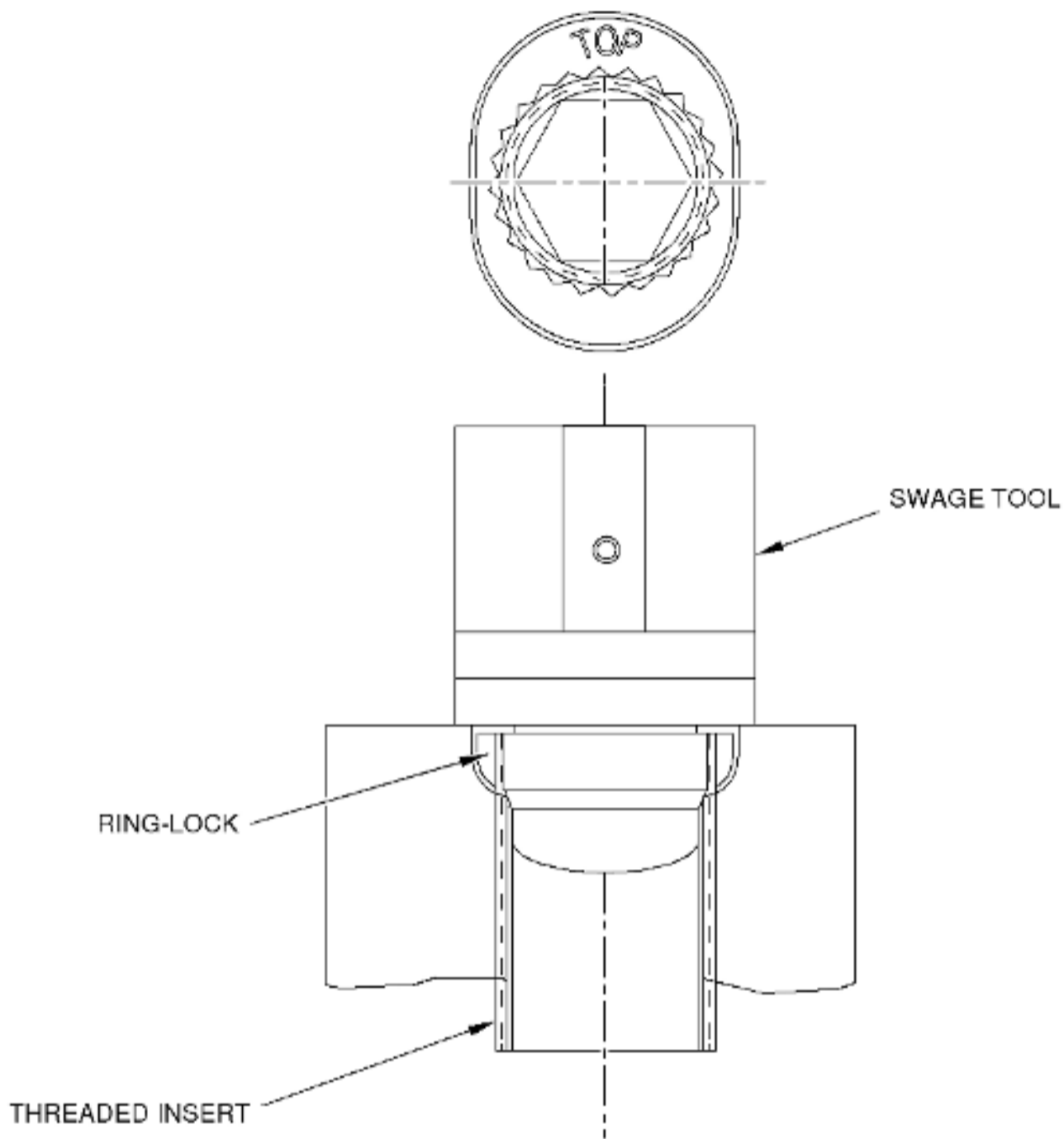
THREADED INSERT P/N	RING-LOCK P/N	INSERT KIT P/N	DIM. A (+/- 0.015 (0.37))	DIM. B (+/- 0.015 (0.37))
1693M83P04 1693M83P13 1693M83P15 1693M83P18 1693M83P19	1689M74P02 1689M74P06 1689M74P08 1689M74P06 1689M74P08	-- 738L579G10 738L579G11 738L579G08 738L579G09	0.438 (11.11)	0.550 (13.97)
1693M83P07 1693M83P08 1693M83P17	1689M74P04 1689M74P04 1689M74P11	738L579G05 738L579G06 735L579G07	0.500 (12.70)	0.610 (15.49)
1693M83P11 1693M83P12 1693M83P14	1689M74P05 1689M74P07 1689M74P09	738L579G02 738L579G03 738L579G04	0.563 (14.29)	0.670 (17.02)
2644M69P02 2644M69P08 2644M69P14 2838M72P02 2630M98P02 2630M98P08 2630M98P14 2630M98P20	2644M69P03 2644M69P09 2644M69P15 2388M72P03 2630M98P03 2630M98P09 2630M98P15 2630M98P21	2644M69P01 2644M69P07 2644M69P13 2638M72P01 2630M98P01 2630M98P07 2630M98P13 2630M98P19	0.500 (12.70)	0.610 (15.49)
2644M69P05 2644M69P17 2838M72P05 2630M98P05 2630M98P17	2644M69P06 2644M69P18 2838M72P06 2630M98P06 2630M98P18	2644M69P04 2644M69P16 2838M72P04 2630M98P04 2630M98P16	0.563 (14.28)	0.670 (17.02)

**NOTE:**  
 DIMENSIONS ARE IN INCHES WITH  
 MILLIMETERS IN PARENTHESES.

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Figure 2 (Sheet 2) Ring Lock Counterbore Dimensions and Threaded Insert/Ring-Lock Part Numbers

\* \* \* FOR ALL



**NOTES:**

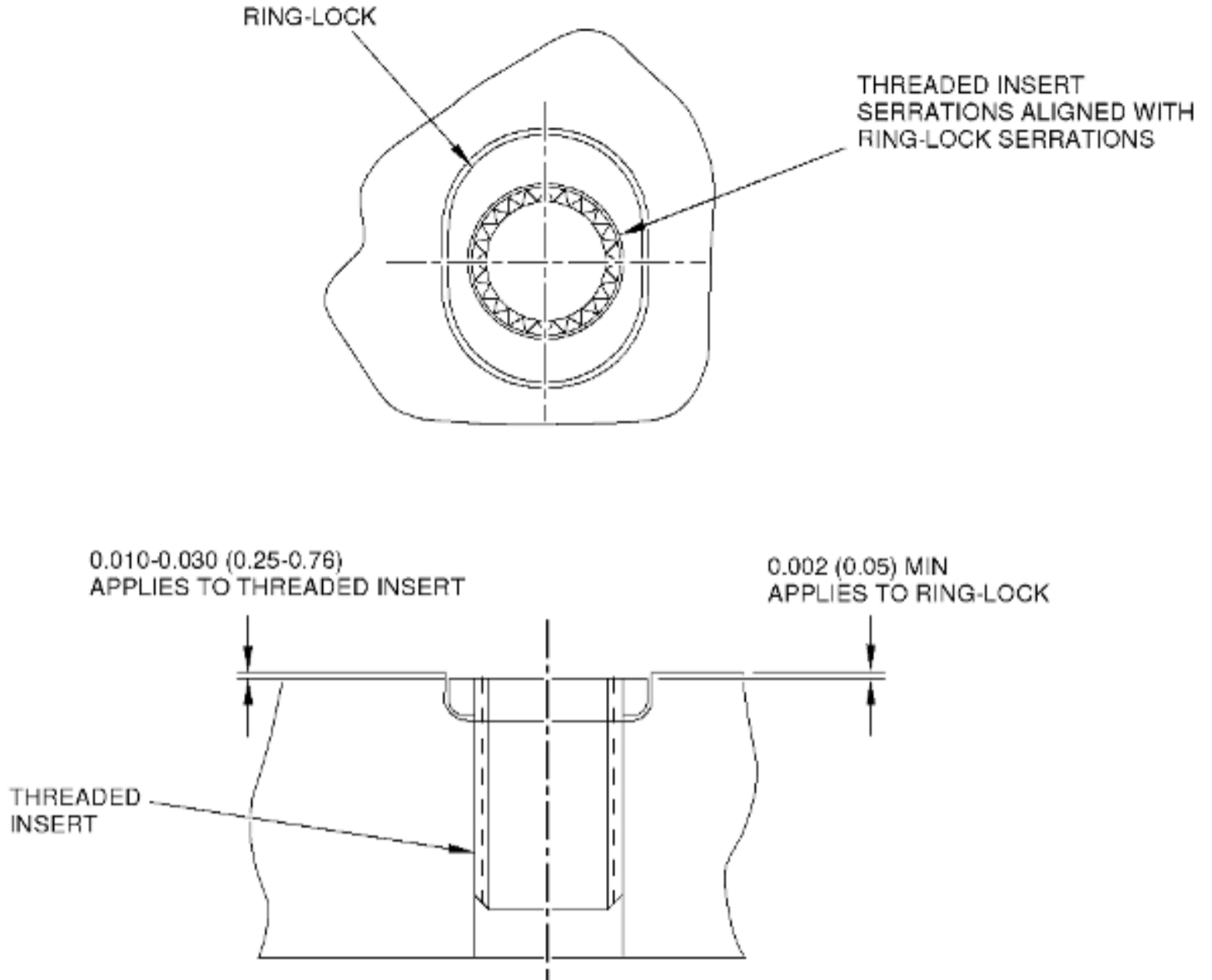
1. DIMENSIONS ARE IN INCHES WITH MILLIMETERS IN PARENTHESES.
2. APPLIES TO ALL THREADED INSERTS.

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Figure 3 (Sheet 1) Ring-Lock and Threaded Insert Installation Swage Tool

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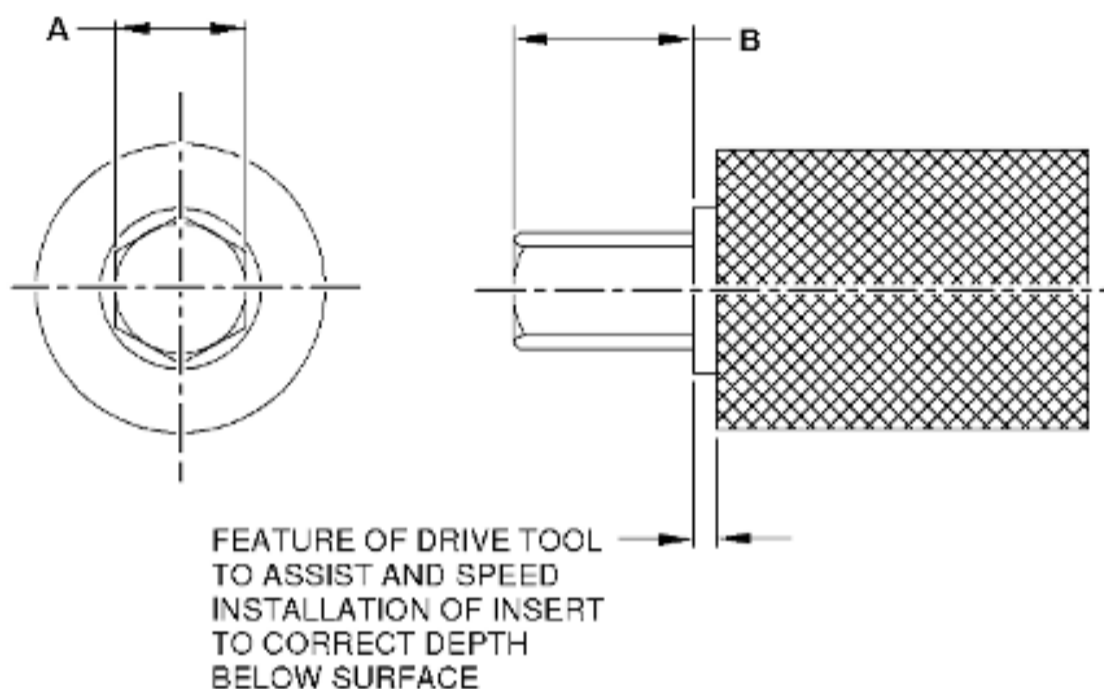
**NOTES:**

1. DIMENSIONS ARE IN INCHES WITH MILLIMETERS IN PARENTHESES.
2. APPLIES TO ALL THREADED INSERTS.

6035405-00

Figure 3 (Sheet 2) Ring-Lock and Threaded Insert Installation Swage Tool

\* \* \* FOR ALL



5035406-00

Figure 4 (Sheet 1) Drive Tool Dimensions

\* \* \* FOR ALL

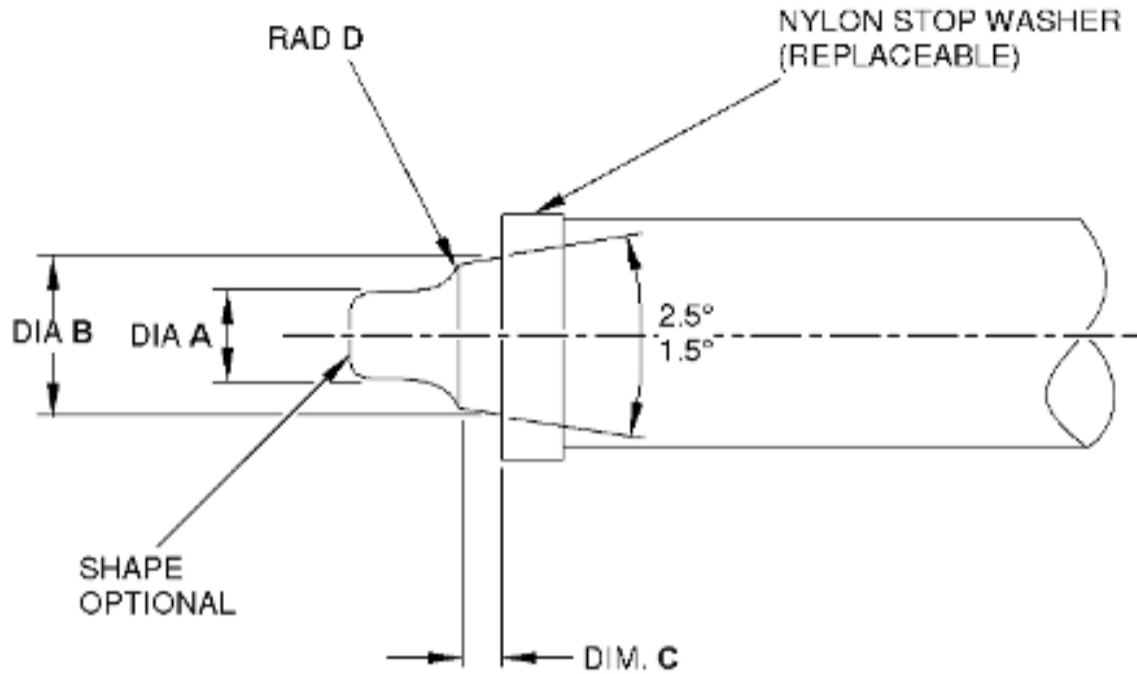
THREADED INSERT P/N	INSERT KIT P/N	A		B
		MIN	MAX	
1693M83P04	--	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
1693M83P07	738L579G05	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
1693M83P08	738L579G06	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
1693M83P11	738L579G02	0.307 (7.80)	0.317 (8.05)	0.331 (8.41)
1693M83P12	738L579G03	0.307 (7.80)	0.317 (8.05)	0.331 (8.41)
1693M83P13	738L579G10	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
1693M83P14	738L579G04	0.307 (7.80)	0.317 (8.05)	0.331 (8.41)
1693M83P15	735L579G11	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
1693M83P17	738L579G07	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
1693M83P18	738L579G08	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
1693M83P19	738L579G09	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2644M69P08	2644M69P07	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2644M69P20	2644M69P19	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2630M98P08	2630M98P07	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2644M69P02	2644M69P01	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2644M69P14	2644M69P13	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2630M98P02	2630M98P01	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2630M98P14	2630M98P13	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2644M69P05	2644M69P04	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
2644M69P17	2644M69P16	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
2838M72P02	2838M72P01	0.199 (5.05)	0.209 (5.31)	0.227 (5.77)
2838M72P05	2838M72P04	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
2630M98P05	2630M98P04	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)
2630M98P17	2630M98P16	0.251 (6.38)	0.258 (6.55)	0.266 (6.76)

**NOTE:**  
 DIMENSIONS ARE IN INCHES WITH  
 MILLIMETERS IN PARENTHESES.

6035407-00

Figure 4 (Sheet 2) Drive Tool Dimensions

\* \* \* FOR ALL



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Figure 5 (Sheet 1) Swage Tool Dimensions

\* \* \* FOR ALL

THREADED INSERT P/N	INSERT KIT P/N	A MAX	B (+/- 0.0006)	C (+/- 0.005)	RAD D (+/- 0.010)
1693M83P04	--	0.197	0.2805	0.032	0.032
1693M83P07	738L579G05	0.256	0.345	0.032	0.039
1693M83P08	738L579G06	0.256	0.345	0.032	0.039
1693M83P11	738L579G02	0.315	0.4085	0.032	0.043
1693M83P12	738L579G03	0.315	0.4085	0.032	0.043
1693M83P13	738L579G10	0.197	0.2805	0.032	0.032
1693M83P14	738L579G04	0.315	0.4085	0.032	0.043
1693M83P15	735L579G11	0.197	0.2085	0.032	0.032
1693M83P17	738L579G07	0.256	0.345	0.032	0.039
1693M83P18	738L579G08	0.197	0.2085	0.032	0.032
1693M83P19	738L579G09	0.197	0.2085	0.032	0.032
2644M69P08	2644M69P07	0.197	0.2085	0.032	0.032
2644M69P20	2644M69P21	0.197	0.2085	0.032	0.032
2630M98P08	2630M98P07	0.197	0.2085	0.032	0.032
2644M69P02	2644M69P01	0.197	0.2085	0.032	0.032
2644M69P14	2644M69P13	0.197	0.2085	0.032	0.032
2838M72P02	2838M72P01	0.197	0.2085	0.032	0.032
2630M98P02	2630M98P01	0.197	0.2085	0.032	0.032
2630M98P14	2630M98P13	0.197	0.2085	0.032	0.032
2644M69P05	2644M69P04	0.256	0.345	0.032	0.039
2644M69P17	2644M69P16	0.256	0.345	0.032	0.039
2838M72P05	2838M72P04	0.256	0.345	0.032	0.039
2630M98P05	2630M98P04	0.256	0.345	0.032	0.039
2630M98P17	2630M98P16	0.256	0.345	0.032	0.039

**NOTE:**  
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 MILLIMETERS IN PARENTHESES.

6035409-00

Figure 5 (Sheet 2) Swage Tool Dimensions

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INSERT	RING-LOCK	KIT P/N	THREADED INSERT REMOVAL DRILL DIA	THREADED HOLE TAP	INT. THREAD DIA / PITCH
1693M83P04	1689M74P02	-	0.2785	5/16-24 UNJF	0.2500-28 (6.35)
1693M83P07	1689M74P04	738L579G05	0.3405	3/8-24 UNJF	0.3125-24 (7.938)
1693M83P08	1689M74P04	738L579G06	0.3405	3/8-24 UNJF	0.3125-24 (7.938)
1693M83P11	1689M74P05	738L579G02	0.4010	7/16-20 UNJF	0.3750-24 (9.52)
1693M83P12	1689M74P07	738L579G03	0.4010	7/16-20 UNJF	0.3750-24 (9.52)
1693M83P13	1689M74P06	738L579G10	0.2785	5/16-24 UNJF	0.2500-28 (6.35)
1693M83P14	1689M74P09	738L579G04	0.4010	7/16-20 UNJF	0.3750-24 (9.52)
1693M83P15	1689M74P08	735L579G11	0.2785	5/16-24 UNJF	0.2500-28 (6.35)
1693M83P17	1689M74P11	738L579G07	0.3405	3/8-24 UNJF	0.3125-24 (7.938)
1693M83P18	1689M74P06	738L579G08	0.2785	5/16-24 UNJF	0.2500-28 (6.35)
1693M83P19	1689M74P08	738L579G09	0.2785	5/16-24 UNJF	0.2500-28 (6.35)
2644M69P02	2644M69P03	2644V69P01	0.3405	3/8-24 UNJF	0.2500-28 (6.35)
2644M69P08	2644M69P09	2644V69P07			
2838M72P02	2838M72P03	2838V72P01			
2644M69P05	2644M69P06	2644V69P04	0.4010	7/16-28 UNJEF	0.3125-24 (7.938)
2838M72P05	2838M72P06	2838V72P04	0.3405	3/8-24 UNJF	0.2500-28 (6.35)
2630M98P02	2630M98P03	2630V98P01			
2630M98P08	2630M98P09	2630V98P07			
2644M69P14	2644M69P15	2644V69P13			
2630M98P14	2630M98P15	2630V98P13	0.4010	7/16-28 UNJEF	0.3125-24 (7.938)
2630M98P20	2630M98P21	2630V98P19			
2630M98P05	2630M98P06	2630V98P04			
2630M98P17	2630M98P18	2630V98P16			
2644M69P17	2644M69P18	2644V69P16			

**NOTE:**  
 DIMENSIONS ARE IN INCHES WITH  
 MILLIMETERS IN PARENTHESES.

6035410-00

Figure 6 Threaded Insert/Ring-Lock/Kit Part Numbers and Threaded Insert Removal Information

\* \* \* FOR ALL

THREADED INSERT P/N	WASHER	BOLT	MIN TORQUE (LBF-IN. (N-m))	MAX TORQUE (LBF-N (N-m))
1693M83P04	A	A	5.3 (0.60)	30.0 (3.39)
1693M83P07	B	B	9.7 (1.10)	60.0 (6.78)
1693M83P08	B	B	9.7 (1.10)	60.0 (6.78)
1693M83P11	C	C	14.2 (1.60)	80.0 (9.04)
1693M83P12	C	C	14.2 (1.60)	80.0 (9.04)
1693M83P13	A	A	5.3 (0.60)	30.0 (3.39)
1693M83P14	C	C	14.2 (1.60)	80.0 (9.04)
1693M83P15	A	A	5.3 (0.60)	30.0 (3.39)
1693M83P17	B	B	9.7 (1.10)	60.0 (6.78)
1693M83P18	A	A	5.3 (0.60)	30.0 (3.39)
1693M83P19	A	A	5.3 (0.60)	30.0 (3.39)
2644M69P02	A	A	5.3 (0.60)	30.0 (3.39)
2644M69P08	A	A	5.3 (0.60)	30.0 (3.39)
2644M69P20	A	A	5.3 (0.60)	30.0 (3.39)
2644M69P05	B	B	9.7 (1.10)	60.0 (6.78)
2630M98P02	A	A	5.3 (0.60)	30.0 (3.39)
2630M98P08	A	A	5.3 (0.60)	30.0 (3.39)
2644M69P14	A	A	5.3 (0.60)	30.0 (3.39)
2630M98P14	A	A	5.3 (0.60)	30.0 (3.39)
2630M98P05	B	B	9.7 (1.10)	60.0 (6.78)
2630M98P17	B	B	9.7 (1.10)	60.0 (6.78)
2644M69P17	B	B	9.7 (1.10)	60.0 (6.78)

WASHER	WASHER DIMENSIONS
A	0.250 (6.35) ID x 0.50 (12.7) MIN OD x 0.062 (1.60) MIN THICKNESS
B	0.3125 (7.94) ID x 0.62 (15.7) MIN OD x 0.060 (1.52) MIN THICKNESS
C	0.375 (9.52) ID x 0.75 (19.0) MIN OD x 0.060 (1.52) MIN THICKNESS

BOLT	MATERIAL	THREAD DETAILS	PITCH DIA
A	INCO 718	0.2500-28 UNJF-3A	0.2243-0.2251 (5.698-5.717)
B	INCO 718	0.3125-24 UNJF-3A	0.2827-0.2838 (7.180-7.203) (STANDARD BOLT 0.3125-24)
C	INCO 718	0.375-24 UNJF-3A	0.3450-0.3460 (8.763-8.788) (STANDARD BOLT 0.375-24)

**NOTE:**  
 DIMENSIONS ARE IN INCHES WITH  
 MILLIMETERS IN PARENTHESES.

6035411-00

Figure 7 Torque Check Requirements

GE Designated: - CONFIDENTIAL Subject to the restrictions on the media