



Facet Part Nos: Assembly 574997-01
Element 054025-01
Boeing Part Nos: Assembly 10-3332-6
Element 10-3332-7

40 GPM Skydrol 500 Filter Assembly

Specifications

Rated Flow: 40 gpm

Fluid: Skydrol 500 A

Maximum differential Pressure Through Bypass (Rated Flow and 100°±10°F): 90 psi (maximum)

Degree of Filtration: 10 micron maximum

Operating Pressure: 100 psi

Proof Pressure: 200 psi

Burst Pressure: 400 psi

Temperature Range: -65°F to +160°F

Bypass Valve Cracking Pressure: 55±5 psid

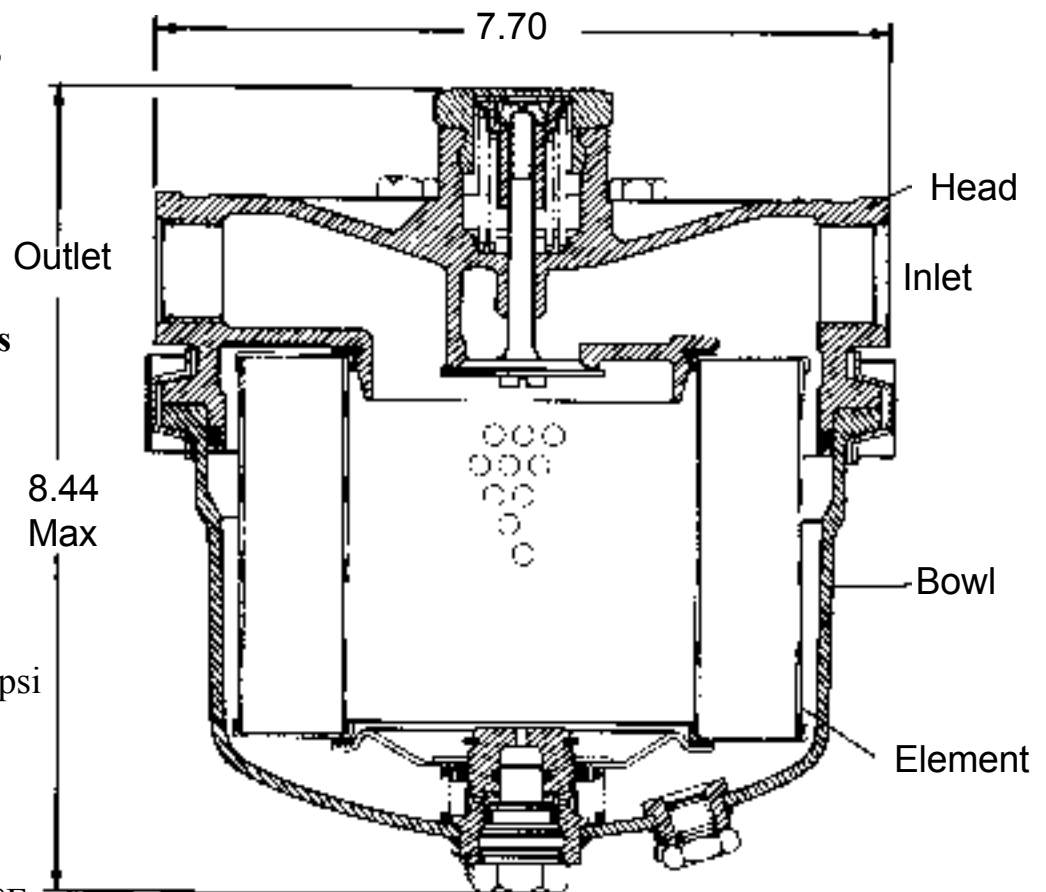
Differential Indicator Operates: 45±5 psi

Inoperable Below: 35±15°F

Housing Material: Aluminum alloy (anodized)

Element Material: Microfil® media

Weight(dry): 8.0 lbs maximum

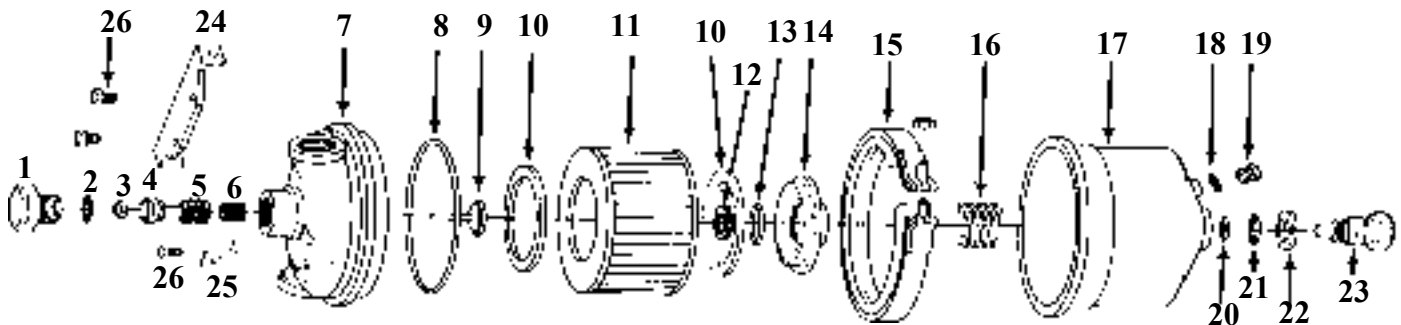


**Facet Part Nos: Assembly 574997-01
Element 054025-01
Boeing Part Nos: Assembly 10-3332-6
Element 10-3332-7**

Parts List

Item No.	Part No.	Nomenclature	No. per Assembly	Item No.	Part No.	Nomenclature	No. per Assembly
1	503947	Plug Head	1	14	049077	Element - Retainer	1
2	051048	O-ring (NAS 1612-16)	1	15	031601	Coupling - V-band	1
3	569146	Nut	1	16	047236	Spring	1
4	053946	Guide - Valve	1	17	053945	Bowl (Alum Anodized)	1
5	054008	Spring - Valve	1	18	051047	O-ring (NAS 1612-4)	1
6	054006	Spring - Valve	1	19	031699	Plug - Bowl Drain	1
7	031602	Head (Alum Anodized)	1	20	052493	O-ring (NAS 1611-013)	1
8	049413	O-ring (NAS 1611-259)	1	21	052494	O-ring (NAS 1611-016)	1
9	054054	Valve	1	22	910721	Backup Ring (MS 28774-016)	1
10	049736	Gaskets	2	23	051389	Indicator Assembly	1
11	054025-01	Element - Filter	1	24	051099	Bracket	1
12	054007	Retainer	1	25	031638	Bracket	1
13	049404	O-ring (NAS 1611-121)	1	26	031683	Bolts (Steel)	3

O-ring - See Boeing Document D6-3614 for approved source.



Maintenance and Overhaul Instructions

Element Replacement: Drain filter by removing plug (Item 19) from bowl. Unscrew nut from V-band coupling (Item 15) and remove (Item 11) from head (Item 7). Do not pry or wedge the V-band coupling during disassembly. Remove gasket (Item 10) from head and replace with new gasket.

Remove retainer (Item 12) and remove element retainer (Item 14) and replace gasket (same as Item 10).

Wash metal parts with suitable solvent such as trichloroethylene, carbon tetrachloride, stoddard solvent, etc. Remove all excess solvent by drying with lint free cloth or by blowing with prefiltered air.

Replace O-ring packing (Item 8) on head. Replace O-ring (Item 13). Insert element retainer (Item 14) and retainer (Item 12). Lubricate all parts with Skydrol 500. Place new filter element in bowl and seat on gasket.

Push bowl and element onto head. Lubricate inside of V-groove on V-band coupling with hydraulic fluid. Clamp bowl to head with torque of 140 to 160 in. lbs. Install new O-ring packing (Item 18) on drain plug. Lubricate with hydraulic fluid and screw into bowl. Torque to 25 in. lbs. Secure with lockwire.

Relief Valve Testing: Relief valve has been adjusted at the factory to open at 55±5 psi. To test, install a dummy element which will seal off flow from inlet to outlet. Reassemble the bowl. Apply hydrostatic pressure to inlet. Leakage through valve must not exceed 3 cc per minute before cracking.

Relief Valve Repair: Remove the bowl and element as detailed under "Element Replacement". Disassemble valve parts from top of head in the order of position shown on exploded view. Remove valve (Item 9) from inside the head.

Repair damaged valve seat by lapping valve to seat. Spread a film of lapping compound, Federal Spec SS-C-614 on valve and seat in head. Use a screwdriver in slot of valve for short rotating motions with light pressure. Clean head and valve thoroughly before reassembly.

Replace O-ring packing (Item 2). Adjust valve by means of nut (Item 3). Torque plug (Item 1) to 50 in. lbs. Lockwire plus (Item 1) to head.

Indicator Assembly Repair: Remove indicator assembly (Item 23). Clean, following instructions of element replacement. Remove and replace O-rings (Items 20 and 21). Reassemble with torque of 25 in. lbs.

Indicator Assembly Testing: Indicator has been adjusted at the factory to operate at 45±5 psi. Remove the bowl and element as detailed under "Element Replacement." Insert dummy non-porous element and reassemble. To test, apply hydrostatic pressure to inlet. Indicator must operate at 45±5 psi. Replacement of indicator is required if nonoperative within tolerance.