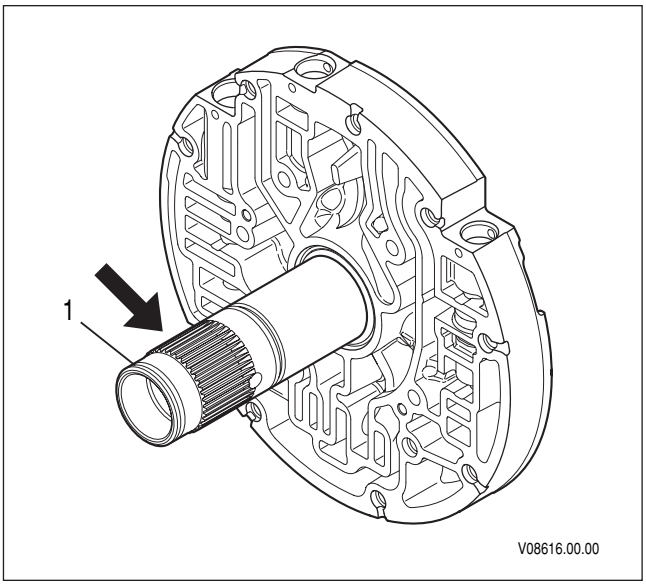
b. Ground Sleeve Inspection



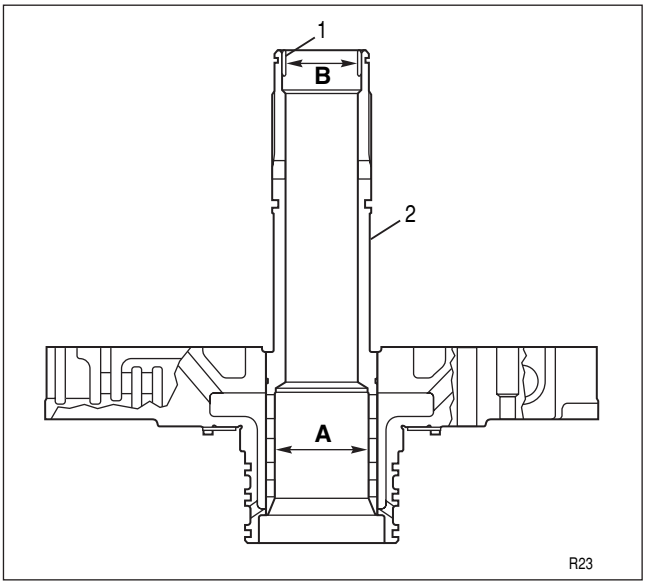
NOTE:

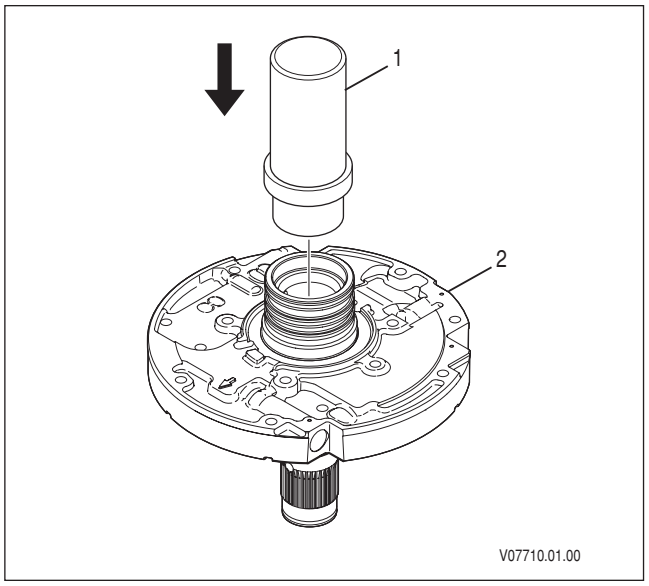
- **The ground sleeve bushing and bearing are replaced with the ground sleeve installed in the front support.**
  - **— Replace the needle bearing if the bearing is damaged.**
  - **— Replace the bushing if the bushing is damaged or the ID specification is not met.**
- **The only time the ground sleeve is pressed from the front support is to replace the ground sleeve.**
  - **— The new ground sleeve comes with a pre-installed bushing.**
  - **— Replace the ground sleeve if the ground sleeve splines or sealring bore specification is not met.**
- **The bearing must be removed to replace the ground sleeve. If the ground sleeve and the bearing both need replacing, replace the ground sleeve first.**
- **Replace the ground sleeve if it does not meet specifications.**

1. Inspect the splines of ground sleeve (1) for damage and wear. No visible wear is allowed.

2. Measure the ID of ground sleeve (2) at the turbine shaft sealring bore (Dimension A). Maximum ID is 45.450 mm (1.7894 inch).

3. Measure the ID of ground sleeve bushing (1) (Dimension B). Maximum ID is 33.820 mm (1.3315 inch).



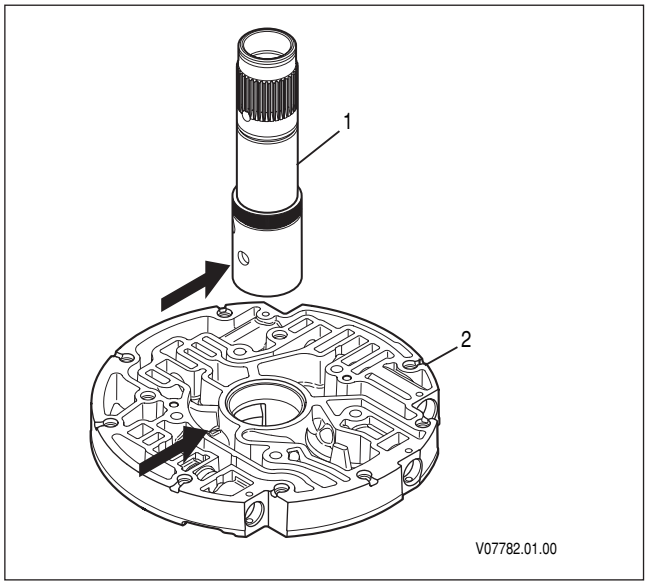


c. Ground Sleeve Replacement

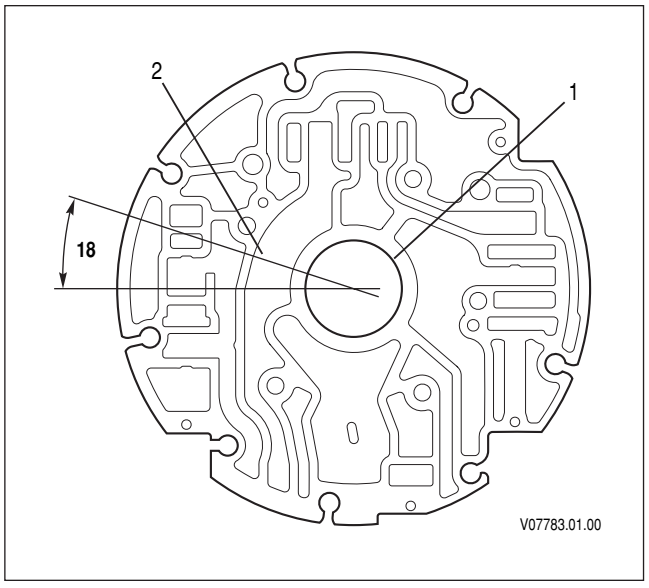
Tools Required

- J 43765 Ground Sleeve Installer/Remover

1. Remove the bearing per Paragraph 5–8**d**.
2. Position front support (2) on a press bed so that it is supported by wooden blocks and the ground sleeve is facing down.
3. Install the short end of J 43765-2 (1) into the rear of the front support.
4. Press the ground sleeve from front support (2).

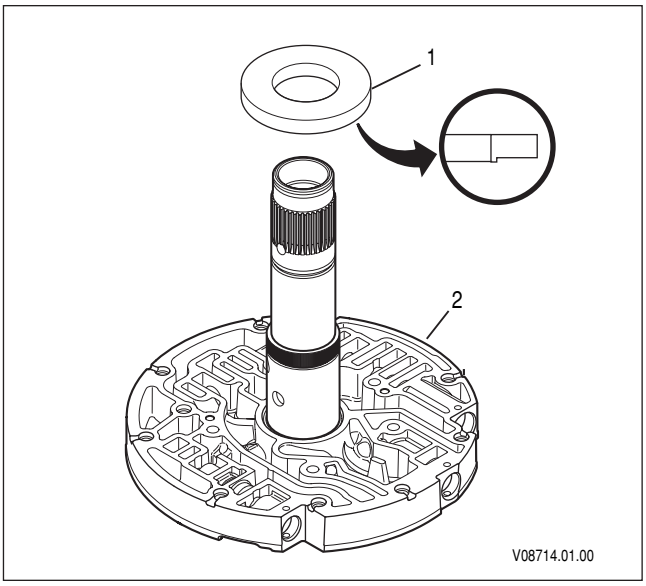


5. Position front support (2) on the work table so that the rear hub is facing down.
6. Align the ground sleeve with the front support so that the sleeve is centered over the front support and the rear of the sleeve is facing down.

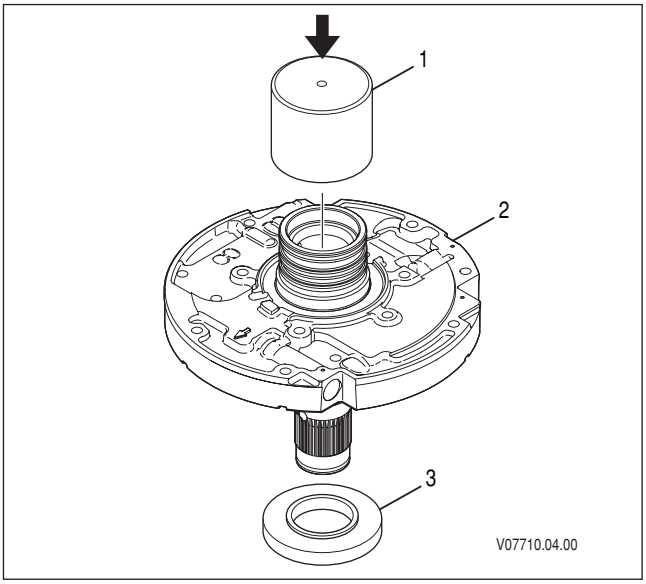


7. Rotate ground sleeve (1) until the lowest (and smallest) hole in the ground sleeve is aligned with fluid passage (2). Arrows indicate the holes that must align.
8. Gently tap the ground sleeve into the front support until the front support holds the ground sleeve in a vertical position.

9. Align J 43765-1 (1) so that the lip of the tool is down.
10. Install J 43765-1 (1) onto the ground sleeve.



11. While holding J 43765-1 (3) in place, turn over the front support/ground sleeve and place J 43765-1 on a press.
12. Install J 43765-3 (1) into the rear hub of front support (2).
13. Press on J 43765-3 until the ground sleeve seats.



14. Check the Total Indicated Runout (TIR) of the ground sleeve as follows.
    - Install the OD (D) of front support (1) in a lathe.
    - Using a dial indicator, make sure front support (1) surface (C) is square with the OD (D) of the front support.
    - Check the TIR along ground sleeve axis (B) at the ground sleeve pitch diameter (A). The TIR must not exceed 0.20 mm (0.008 inch).
15. If the bearing does not need replacing, install the bearing per Paragraph 5–8**d**.