

# 50 POINT QUALITY CHECK

<b>COMPTESSOR COVER</b>	
√	Compressor inlet, outlet flanges
√	Bearing housing, backplate mating surface
√	Contour free of gouges
√	Compress wheel to housing contour tolerance
√	Noise baffle secure and free of debris
√	Annual slot free of debris
<b>COMPRESSOR WHEEL</b>	
√	Blades free of bends or fractures
√	Rubbing or foreign object induced damage on blade profile
√	Bore area tolerance and finish
√	Nose cone and backface square
√	Back face, balance or wear defects
<b>LOOSE COMPONENTS</b>	
√	All thrust faces free of wear
√	Square of all surfaces
√	Piston ring groove and flinger groove
√	Piston ring to groove tolerance
√	Bore to shaft tolerance
<b>TURBINE SHAFT WHEEL</b>	
√	Wheel blades for fractures or blade defection
√	Heat erosion on blade tips
√	Shaft journal surfaces
√	Bearing to journal tolerance
√	Piston ring seal area and flinger groove
√	Piston ring to groove tolerance
√	Shaft run-out
√	Shaft wheel balance
√	The square of shaft-step-down and threads

<b>BACKPLATES, INSERTS</b>	
√	Mating and clamping surfaces
√	Piston ring bore and thrust surface
√	Seal ring to bore tolerances
<b>POST ASSEMBLE</b>	
√	Radial and Axial clearance
√	Freedom of rotation
√	Housing alignment
√	Wastegate setting
√	Gasket and studs
√	Sundry items
<b>BEARING HOUSING</b>	
√	All mating surfaces
√	Bearing bore surface
√	Bearing to journal tolerance
√	Piston ring seal area and ring tolerance
√	Oil feed and drain flanges and threads
√	Water feed and drain threads
<b>TURBINE HOUSING</b>	
√	Slip joint or flange mating surfaces
√	Heat shield & centre housing mating surfaces
√	Scroul and contour crack free
√	Free of heat erosion and scale
√	Threads, studs and clamping surfaces
√	Convolute free of foreign objects
<b>ROTOR ASSEMBLE</b>	
√	Dynamic, static balance and VSR testing
√	Run out