



South Bend, Indiana 46620, U.S.A.

# Service Bulletin

## Fuel Systems

Bulletin No.: RS-71 Rev.1

Date: 10-1-79

Revised: 2-18-80

Subject: REDESIGN OF THE LOCKING METHOD OF THE REGULATOR STEM NUT ON ALL MODEL  
RSA FUEL INJECTORS.

1. PLANNING INFORMATION:

A. EFFECTIVITY:

<u>Model No.</u>	<u>Parts List No.</u>	
RSA-5AB1	2524199-9, -10 2524254-7, -8 2524378-7, -8 2524573-1	2524216-8, -9 2524262-6, -7 2524712-3, -5, -6
RSA-5AD1	2524054-7, -8 2524147-9, -10 2524189-7, -8 2524242-6, -7 2524291-7, -8 2524307-6, -7 2524335-6, -7 2524348-7, -8 2524450-5, -6 2524475-4, -5 2524575-4, -5 2524592-4, -5 2524634-4, -5 2524673-4, -5 2524688-4, -5 2524742-4, -5	2524145-8, -9 2524171-7, -8 2524213-7, -8 2524243-7, -8 2524297-6, -7 2524328-6, -7 2524341-6, -7 2524359-6, -7 2524459-5, -6 2524550-4, -5 2524590-4, -5 2524623-4, -5 2524640-4, -5 2524682-4, -5 2524723-4, -5 2524752-3, -4
RSA-7AA1	2524347-4, -6	
RSA-7DA1	2524624-1, -2	
RSA-10AD1	2524030-7, -8 2524163-10, -11 2524255-6, -7 2524311-6, -7	2524152-6, -7 2524175-6, -7 2524256-8, -9 2524757-3, -4

1. PLANNING INFORMATION: (Continued)

RSA-10DB1	2524267-6, -7	2524275-11, -12
	2524276-7, -8	2524423-7, -8
	2524593-4, -5	2524649-6, -7
	2524799-1	
RSA-10DB2	2524501-5, -6	2524708-4, -5
RSA-10ED1	2524273-8, -9	2524298-8, -9
	2524366-6, -7	2524420-7, -8
	2524422-5, -6	2524477-7, -8
	2524491-5, -6	2524492-4, -5
	2524500-5, -6	2524556-5, -6
	2524582-4, -5	2524601-4, -5
	2524693-4, -5, -6, -7	2524709-3, -4
	2524733-3, -4	2524811-1
RSA-10ED2	2524791-1, -2, -3	

B. REASON:

To describe a redesigned method of retaining adjusting nut on the regulator stem.

C. DESCRIPTION:

Instructions for application of Loctite Grade 640 to adjusting nut and exposed threads of regulator nut stem.

D. COMPLIANCE:Operating Activities:

Not applicable.

Overhaul Activities:

Applicable to overhaul facilities only. Use this procedure in lieu of procedures set forth in following Service Bulletins;

RS-68 dated 8-20-79, Amendment 1 dated 8-29-79, Amendment 2 dated 9-6-79.

RS-69 dated 8-20-79, Amendment 1 dated 8-29-79.

RS-70 dated 8-20-79, Amendment 1 dated 8-30-79.

This is a recurring bulletin and must be complied with at each overhaul.

E. APPROVAL:F. MANPOWER:

No additional man-hours required during overhaul.

1. PLANNING INFORMATION: (Continued)G. MATERIAL AVAILABILITY:

Loctite Grade 640 (Purchased locally)

H. TOOLING:

Torque Watch Model 651C2 purchased from:  
Waters Mfg. Inc.  
Wayland, Massachusetts 01778, or equivalent  
Loctite Applicator P/N 2550999 (Manufactured locally, See Figure 2).

I. WEIGHT AND BALANCE:

Not affected.

J. REFERENCES:

SERVICE BULLETINS: RS-68 dated 8-20-79, Amendment 1 dated 8-29-79,  
Amendment 2 dated 9-6-79.

RS-69 dated 8-20-79, Amendment 1 dated 8-29-79.

RS-70 dated 8-20-79, Amendment 1 dated 8-30-79.

K. PUBLICATIONS AFFECTED:

Overhaul Manuals for following Model Fuel Injectors:

(1) RSA-5AB1 Form No. 15-419.

(2) RSA-5AD1 Form No. 15-381.

(3) RSA-7AA1 Form No. 15-520.

(4) RSA-7DA1 Form No. 15-633.

(5) RSA-10AD1 Form No. 15-433.

(6) RSA-10DB1 Form No. 15-471.

(7) RSA-10DB2 Form No. 15-542.

(8) RSA-10ED1 Form No. 15-458.

(9) RSA-10ED2 Manual not published.

SERVICE BULLETINS: RS-68 dated 8-20-79, Amendment 1 dated 8-29-79,  
Amendment 2 dated 9-6-79.

RS-69 dated 8-20-79, Amendment 1 dated 8-29-79.

RS-70 dated 8-20-79, Amendment 1 dated 8-30-79.

2. ACCOMPLISHMENT INSTRUCTIONS:

A. During preset and calibration perform the following additional steps:

Step 1. Use a slave nut during preset to determine required shimming and to insure a minimum of (2) two threads are protruding above nut after final calibration.

CAUTION: Remove excess Loctite from exterior of nut and inspect that Loctite remains in center of nut. If excess Loctite is allowed to flow down stem, the air diaphragm can become locked in place.

NOTE: Verify that stem is free of oil and grease before proceeding with following steps.

Step 2. When preset has been completed, remove slave nut. Install a new standard parts list nut, that has been submersed in Loctite Grade 640. Check running torque of nut/stem combination with a torque watch. A minimum of 2 ounce/inches must be met. If not, discard nut and install a new nut.

Step 3. Proceed with final calibration.

Step 4. Prior to wiring control, visually inspect for two (2) threads minimum protrusion of the stem. Verify Loctite Grade 640 (green color) was applied. Check torque on nut with torque watch. Nut must not move when  $3 \pm 1/4$  ounce/inches torque is applied.

Step 5. Add one drop of Loctite Grade 640 to protruding threads on stem with Loctite applicator P/N 2550999.

B. Complete assembly of fuel injector. Lockwire in accordance with latest applicable Overhaul Manuals or Service Bulletins.

C. IDENTIFICATION:

When Bendix Energy Controls Division makes a change to a parts list, it is identified by a new issue number. This issue number is shown as a dash number (e.g -11) after the basic parts list number. If a certain issue

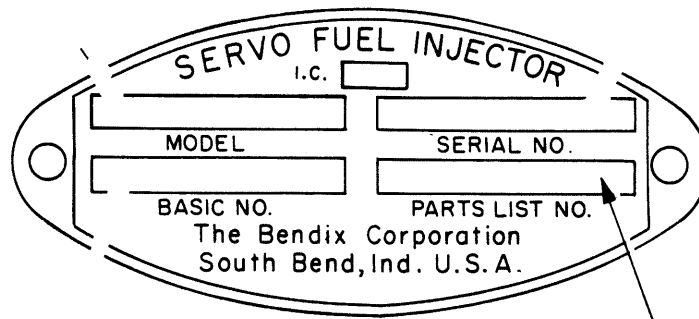


Figure 1.

2. ACCOMPLISHMENT INSTRUCTIONS: (Continued)

number cannot be incorporated at time of updating, it must be listed as a "less issue". For example; when changing from 2524199 issue 9 to issue 11, and issue 10 is not included at this time, the updated injector now becomes an issue 11 "less" issue 10. This is shown on the name plate by stamping the parts list issue number as 2524199-11-10, (See figure 1). Reidentify old parts list to new parts list upon accomplishment of this Service Bulletin.

<u>Model No.:</u>	<u>Old Parts List No.:</u>	<u>New Parts List No.:</u>
RSA-5AB1	2524199-9	2524199-11-10
	2524199-10	2524199-11
	2524216-8	2524216-10-9
	2524216-9	2524216-10
	2524254-7	2524254-9-8
	2524254-8	2524254-9
	2524262-6	2524262-8-7
	2524262-7	2524262-8
	2524378-7	2524378-9-8
	2524378-8	2524378-9

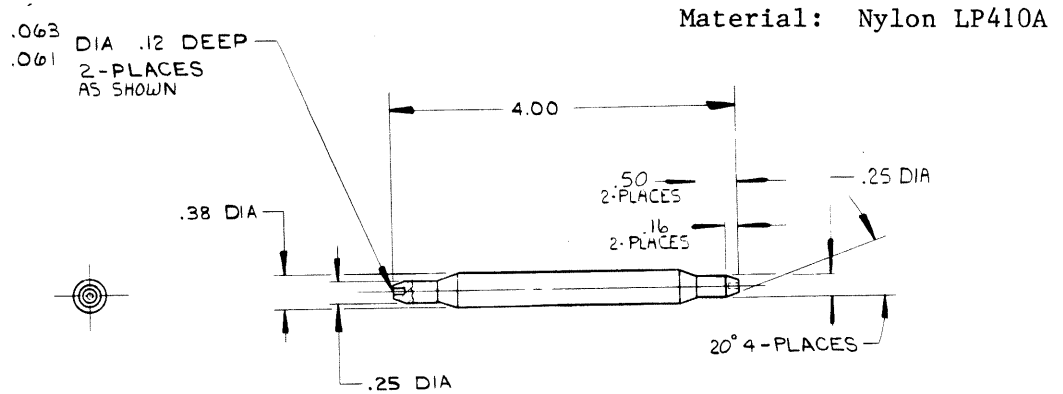


Figure 2. Loctite Applicator P/N 2550999

2. ACCOMPLISHMENT INSTRUCTIONS: (Continued)

<u>Model No.:</u>	<u>Old Parts List No.:</u>	<u>New Parts List No.:</u>
RSA-5AB1 (Cont.)	2524573-1	2524573-2
	2524712-3	2524712-7-6-5
	2524712-5	2524712-7-6
	2524712-6	2524712-7
RSA-5AD1	2524054-7	2524054-9-8
	2524054-8	2524054-9
	2524145-8	2524145-10-9
	2524145-9	2524145-10
	2524147-9	2524147-11-10
	2524147-10	2524147-11
	2524171-7	2524171-9-8
	2524171-8	2524171-9
	2524189-7	2524189-9-8
	2524189-8	2524189-9
	2524213-7	2524213-9-8
	2524213-8	2524213-9
	2524242-6	2524242-8-7
	2524242-7	2524242-8
	2524243-7	2524243-9-8
	2524243-8	2524243-9
	2524291-7	2524291-9-8
	2524291-8	2524291-9
	2524297-6	2524297-8-7
	2524297-7	2524297-8
	2524307-6	2524307-8-7
	2524307-7	2524307-8
	2524328-6	2524328-8-7
	2524328-7	2524328-8
	2524335-6	2524335-8-7
	2524335-7	2524335-8
	2524348-7	2524348-9-8
	2524348-8	2524348-9
	2524359-6	2524359-8-7
	2524359-7	2524359-8
	2524450-5	2524450-7-6
	2524450-6	2524450-7
	2524459-5	2524459-7-6
	2524459-6	2524459-7
	2524475-4	2524475-6-5
	2524475-5	2524475-6
	2524550-4	2524550-6-5
	2524550-5	2524550-6
	2524575-4	2524575-6-5
	2524575-5	2524575-6
	2524590-4	2524590-6-5
	2524590-5	2524590-6
2524592-4	2524592-6-5	
2524592-5	2524592-6	
2524623-4	2524623-6-5	
2524623-5	2524623-6	

## 2. ACCOMPLISHMENT INSTRUCTIONS: (Continued)

<u>Model No.:</u>	<u>Old Parts List No.:</u>	<u>New Parts List No.:</u>
RSA-5AD1 (Cont.)	2524634-4	2524634-6-5
	2524634-5	2524634-6
	2524640-4	2524640-6-5
	2524640-5	2524640-6
	2524673-4	2524673-6-5
	2524673-5	2524673-6
	2524682-4	2524682-6-5
	2524682-5	2524682-6
	2524688-4	2524688-6-5
	2524688-5	2524688-6
	2524723-4	2524723-6-5
	2524723-5	2524723-6
	2524742-4	2524742-6-5
	2524742-5	2524742-6
	2524752-3	2524752-5-4
	2524752-4	2524752-5
RSA-7AA1	2524347-4	2524347-7-6
	2524347-6	2524347-7
RSA-7DA1	2524624-1	2524624-3-2
	2524624-2	2524624-3
RSA-10AD1	2524030-7	2524030-9-8
	2524030-8	2524030-9
	2524152-6	2524152-8-7
	2524152-7	2524152-8
	2524163-10	2524163-12-11
	2524163-11	2524163-12
	2524175-6	2524175-8-7
	2524175-7	2524175-8
	2524255-6	2524255-8-7
	2524255-7	2524255-8
	2524256-8	2524255-10-9
	2524256-9	2524256-10
	2524311-6	2524311-8-7
	2524311-7	2524311-8
	2524757-3	2524757-5-4
2524757-4	2524757-5	
RSA-10DB1	2524267-6	2524267-8-7
	2524267-7	2524267-8
	2524275-11	2524275-13-12
	2524275-12	2524275-13
	2524276-7	2524276-9-8
	2524276-8	2524276-9
	2524423-7	2524423-9-8
	2524423-8	2524423-9
	2524593-4	2524593-6-5
	2524593-5	2524593-6

2. ACCOMPLISHMENT INSTRUCTIONS: (Continued)

<u>Model No.:</u>	<u>Old Parts List No.:</u>	<u>New Parts List No.:</u>
RSA-10DB1 (Cont.)	2524649-6	2524649-8-7
	2524649-7	2524649-8
	2524799-1	2524799-2
RSA-10DB2	2524501-5	252401-7-6
	2524501-6	2524501-7
	2524708-4	2524708-6-5
	2524708-5	2524708-6
RSA-10ED1	2524273-8	2524273-10-9
	2524273-9	2524273-10
	2524298-8	2524298-10-9
	2524298-9	2524298-10
	2524366-6	2524366-8-7
	2524366-7	2524366-8
	2524420-7	2524420-9-8
	2524420-8	2524420-9
	2524422-5	2524422-7-6
	2524422-6	2524422-7
	2524477-7	2524477-9-8
	2524477-8	2524477-9
	2524491-5	2524491-7-6
	2524491-6	2524491-7
	2524492-4	2524492-6-5
	2524492-5	2524492-6
	2524500-5	2524500-7-6
	2524500-6	2524500-7
	2524556-5	2524556-7-6
	2524556-6	2524556-7
	2524582-4	2524582-6-5
	2524582-5	2524582-6
	2524601-4	2524601-6-5
	2524601-5	2524601-6
	2524693-4	2524693-8-7-6-5
	2524693-5	2524693-8-7-6
	2524693-6	2524693-8-7
	2524693-7	2524693-8
	2524709-3	2524709-5-4
2524709-4	2524709-5	
2524733-3	2524733-5-4	
2524733-4	2524733-5	
2524811-1	2524811-2	
RSA-10ED2	2524791-1	2524791-4-3-2
	2524791-2	2524791-4-3
	2524791-3	2524791-4

*K.R. Dettweiler*  
 K. R. Dettweiler  
 Manager of Service

# Service Bulletin

## Fuel Systems

Bulletin No.: RS-71, Rev. 1  
Amendment 2  
Date: 10-1-79  
Revised: 2-18-80  
Amendment: 7-20-82

SUBJECT: BENDIX FUEL INJECTOR SYSTEM WITH BELLOWS-TYPE SEAL MODIFICATION  
OF: ALL MODEL ESA FUEL INJECTORS.

NOTE: Amendment 2 establishes the maximum run-on torque.

### 2. ACCOMPLISHMENT INSTRUCTIONS.

Change paragraph (a) Step 2 as follows:

Step 2. When preset has been completed, remove slave nut. Install a new standard parts list nut, which has been submersed in Loctite Grade 640. Check running torque of nut/stem combination with a torque watch. Run-on torque must be a minimum of 2 ounce-inches and a maximum of 14 ounce-inches. If tolerance cannot be met, discard nut and install new one.

*K R Dettweiler*

K. R. Dettweiler  
Manager of Service

# Service Bulletin

## Fuel Systems

Bulletin No.: RS-71  
Amendment 1  
Date: 10-1-79  
Revised: 2-18-80  
Amendment 1: 7-14-80


Subject: REDESIGN OF LOCKING METHOD OF THE REGULATOR STEM NUT ON ALL MODEL RSA  
FUEL INJECTORS.

This Amendment 1 to Service Bulletin RS-71 dated 10-1-79, revised 2-18-80 is issued to remove parts list covered by subject Service Bulletin in paragraph 2 page 7.

2. ACCOMPLISHMENT INSTRUCTIONS:

<u>Model No.</u>	<u>Old Parts List</u>	<u>New Parts List</u>
RSA-7AA1	2524347-4	2524347-7-6

NOTE: Remove the above Parts List.

  
K. R. Dettweiler  
Manager of Service