



# **UL Series Repair Limits Manual**



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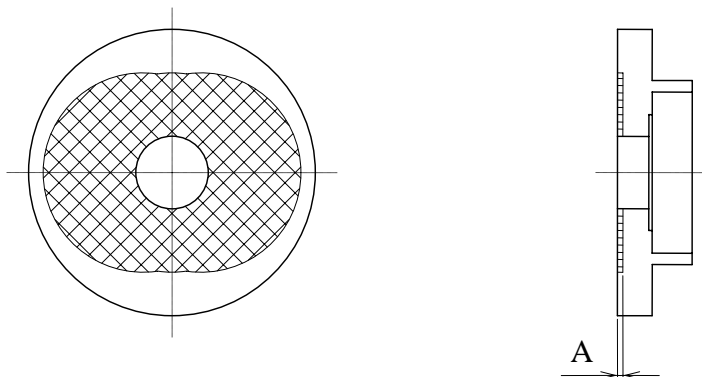
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# Repair Limits - UL Series

## UL Rear Plate

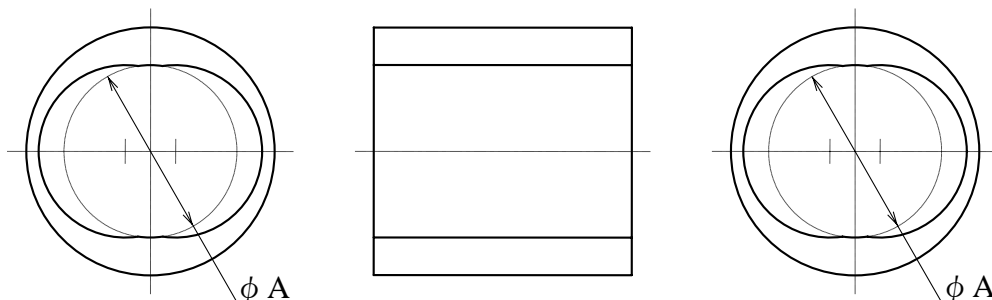


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
		A	-----		
143-285-0	UL-40	A	-----	0.03	UL-30(D) UL-40(D)
147-285-2	ALPHA-L61	A	-----	0.03	UL-50(D) UL-60(D)
143-285-8	UL-70	A	-----	0.03	UL-70
143-285-9	UL-90	A	-----	0.03	UL-90

**NOTE:** Make sure there is no damage or deformation observed.

## Repair Limits - UL Series

### UL Cylinder



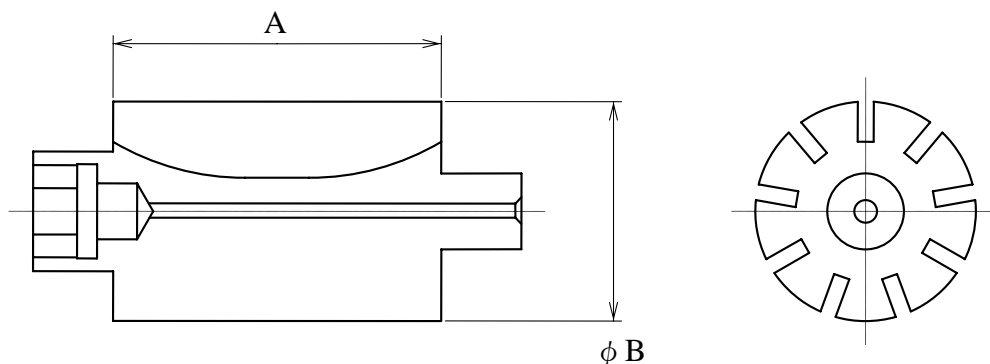
Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
142-286-8	UL-30	A	20	20.041	UL-30(D)
143-286-0	UL-40	A	20	20.041	UL-30(D) UL-40(D)
143-286-3	UL-50	A	23.5	23.541	UL-50(D)
147-286-2	ALPHA-L61	A	23.5	23.541	UL-60(D)
143-286-8	UL-70	A	24.5	24.541	UL-70
143-286-9	UL-90	A	30	30.041	UL-90

**NOTE #1:** Make sure there is no damage or deformations observed.

**NOTE #2:** Make sure the inner surface is flat and smooth - not wavelike.

## Repair Limits - UL Series

### UL Rotor

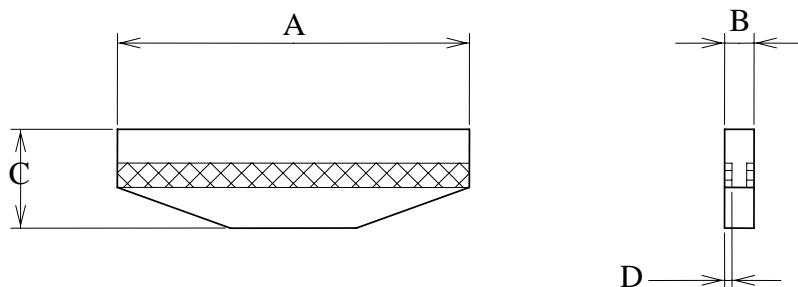


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
		A	B		
143-287-0	UL-40	A	32	31.945	UL-30(D) UL-40(D)
		B	20	19.938	
143-287-3	UL-50	A	32	31.945	UL-50(D)
		B	23.5	23.438	
147-287-3	ALPHA-L61	A	38	37.945	UL-60(D)
		B	23.5	23.438	
143-287-8	UL-70	A	45	44.945	UL-70(D)
		B	24.5	24.438	
147-287-8	ULT-90	A	45	44.945	UL-90
		B	30	29.938	

**NOTE:** Make sure there is no damage or deformations observed.

## Repair Limits - UL Series

### Blade

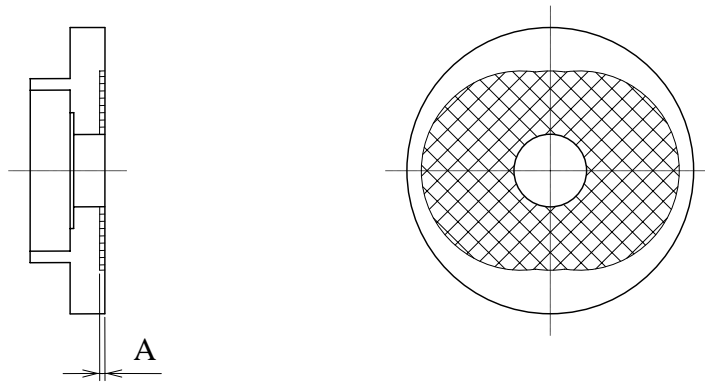


Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
143-288-0	UL-40	A	32	31.85	UL-30(D) UL-40(D)
		B	1.35	1.31	
		C	6.7	6.58	
		D	-----	0.1	
143-288-3	UL-50	A	35	34.85	UL-50(D)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-2	ALPHA-L61	A	38	37.85	UL-60(D)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-6	ULT-70	A	45	44.83	UL-70
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-8	ULT-90	A	45	44.83	UL-90
		B	1.85	1.81	
		C	10.8	10.68	
		D	-----	0.1	

**NOTE:** Make sure there is no damage or deformations observed.

## Repair Limits - UL Series

### Front Plate

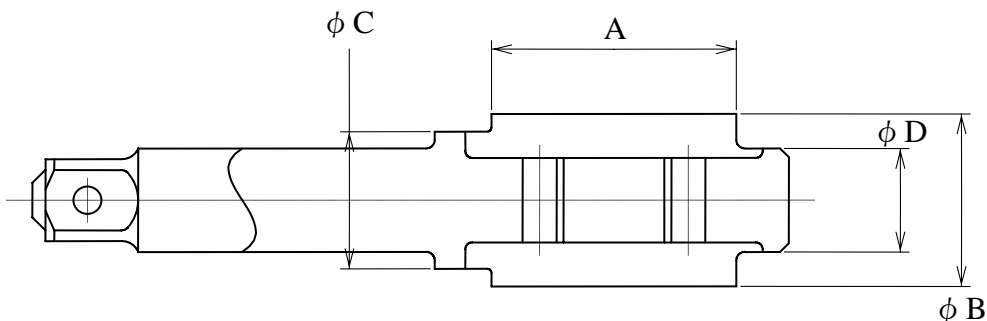


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
144-289-0	ULT-30D	A	----	0.03	UL-30(D) UL-40(D)
147-289-3	ALPHA-L61	A	----	0.03	UL-50(D) UL-60(D)
143-289-8	UL-70	A	----	0.03	UL-70
143-289-9	UL-90	A	----	0.03	UL-90

**NOTE:** Make sure there is no damage or deformations observed.

## Repair Limits - UL Series

### Anvil



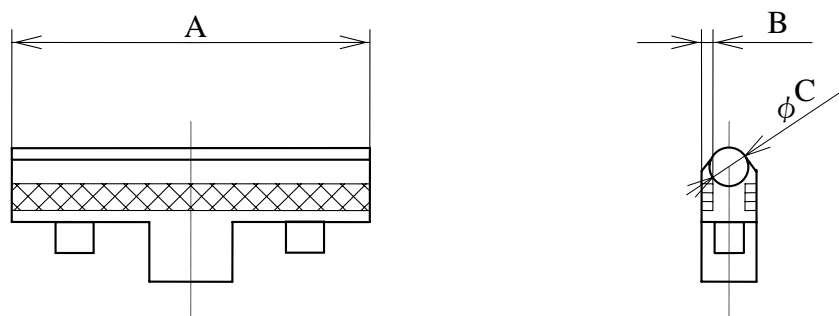
Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
143-319-0	UL-40	A	21	20.95	UL-30(D) UL-40(D)
		B	18	17.925	
		C	14	13.973	
		D	10	9.96	
143-319-3	UL-50	A	22	21.95	UL-50(D)
		B	20	19.91	
		C	16	15.973	
		D	12	11.96	
143-319-6	UL-60	A	25	24.95	UL-60
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-350-7	UL-60D	A	25	24.95	UL-60(D)
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-319-8	UL-70	A	28	27.95	UL-70
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-319-9	UL-90	A	30	29.95	UL-90
		B	24	23.94	
		C	19.9	19.87	
		D	15	14.95	

**NOTE #1:** Make sure there is no damage or deformations observed.

**NOTE #2:** Make sure no damage on the contact surface is observed.

## Repair Limits - UL Series

### Driving Blade



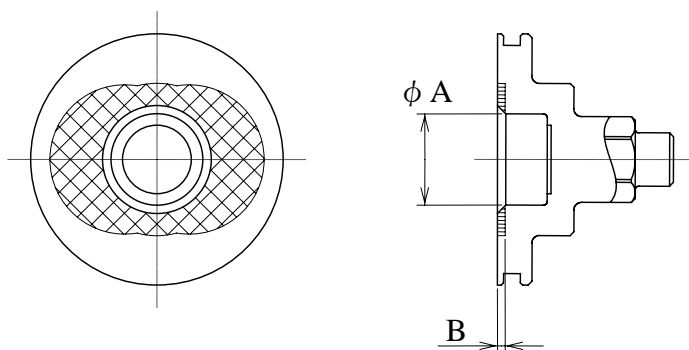
Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
143-440-0 (143-974-0 for Roller)	UL-40	A	21	20.95	UL-30(D) UL-40(D)
		B	-----	0.1	
		C	2.5	2.48	
143-440-3 (143-974-3 for Roller)	UL-50	A	22	21.95	UL-50(D)
		B	-----	0.1	
		C	2.5	2.48	
143-440-6 (143-974-6 for Roller)	UL-60	A	25	24.95	UL-60(D)
		B	-----	0.1	
		C	2.5	2.48	
147-440-6 (147-974-6 for Roller)	ULT-70	A	28	27.95	UL-70
		B	-----	0.1	
		C	2.5	2.48	
147-440-8 (147-974-8 for Roller)	ULT-90	A	30	29.95	UL-90
		B	-----	0.1	
		C	2.5	2.48	

**NOTE #1:** Make sure there is no damage or deformations observed.

**NOTE #2:** Make sure no damage on the contact surface is observed.

## Repair Limits - UL Series

### Rear Liner Plate

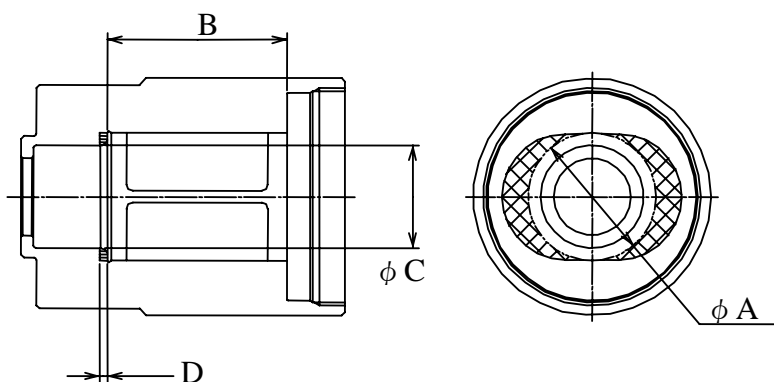


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
143-901-0	UL-40		10	10.023	UL-30(D)
			20	0.01	UL-40(D)
143-901-3	UL-50	A	12	12.023	UL-50(D)
		B	-----	0.01	
143-901-6	UL-60		12	12.023	UL-60(D)
			-----	0.01	
143-901-8	UL-70	A	12	12.023	UL-70
		B	-----	0.01	
143-901-9	UL-90	A	15	15.023	UL-90
		B	-----	0.01	

**NOTE:** Make sure there is no damage or deformations observed.

## Repair Limits - UL Series

### Liner



Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
142-902-8	UL-30	A	18	18.015	UL-30(D)
		B	21	21.015	
		C	14	14.03	
		D	-----	0.01	
143-902-0	UL-40	A	18	18.015	UL-40(D)
		B	21	21.015	
		C	14	14.03	
		D	-----	0.01	
143-902-3	UL-50	A	18	18.015	UL-50(D)
		B	21	21.015	
		C	14	14.03	
		D	-----	0.01	
143-902-6	UL-60	A	20	20.015	UL-60(D)
		B	25	25.015	
		C	16	16.03	
		D	-----	0.01	
143-902-8	UL-70	A	20	20.015	UL-70
		B	28	28.015	
		C	16	16.03	
		D	-----	0.01	
143-902-9	UL-90	A	24	24.015	UL-90
		B	30	30.015	
		C	19.9	19.935	
		D	-----	0.01	

**NOTE:** Make sure there is no damage or deformations observed.

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## Notes

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