



AIMCO

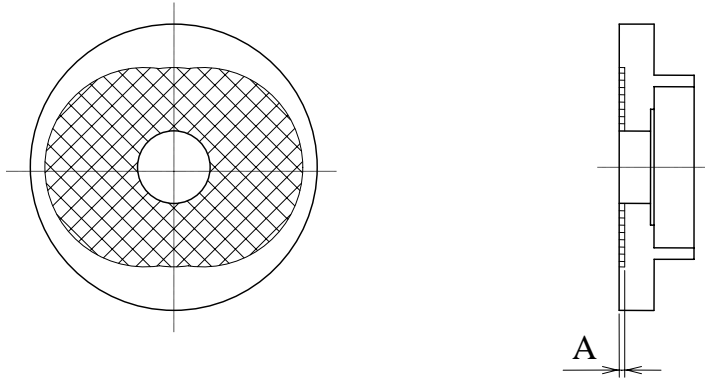
ULT Series Repair Limits Manual

Contents

<u>ULT Series</u>	<u>Page Number</u>
1. Rear Plate	1
2. Cylinder	2
3. Rotor	3
4. Blade	4
5. Front Plate	5
6. Anvil	6
7. Driving Blade	7
8. Rear Liner Plate	8
9. Liner	9
10. Front Liner Plate	10

Repair Limits - ULT Series

Rear Plate

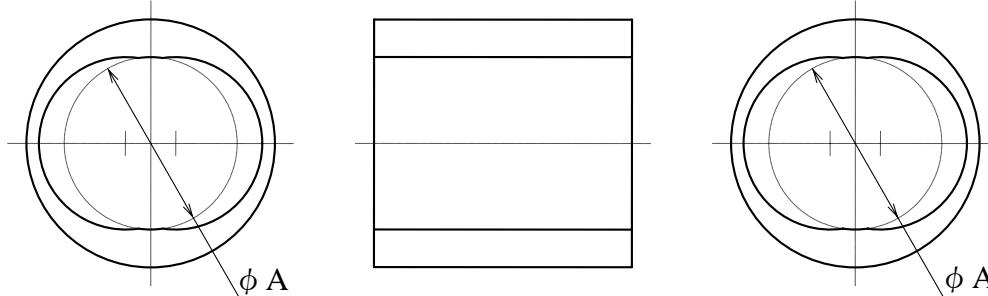


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
144-285-0	ULT-30D	A	----	0.03	ULT-30D
128-285-5	ULT-30SD	A	----	0.03	ULT-30SD
128-285-6	ULT-40S	A	----	0.03	ULT-40(S)(SD)
128-285-8	ULT-50S	A	----	0.03	ULT-50(S)(SD)(SL)(SDL)
145-285-6	ULT-60	A	----	0.03	ULT-40(D) ULT-50(D)(L)(DL) ULT-60(D)(L)(DL)
129-285-2	ULT-60S	A	----	0.03	ULT-60(S)(SD)(SL)(SDL) ULT-70(S)(SL)
147-285-6	ULT-70	A	----	0.03	ULT-70(L)
147-285-8	ULT-90	A	----	0.03	ULT-90(L)
148-285-2	ULT-100	A	----	0.03	ULT-100(L)
130-285-2	ULT-130	A	----	0.03	ULT-130(L)

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

Repair Limits - ULT Series

Cylinder



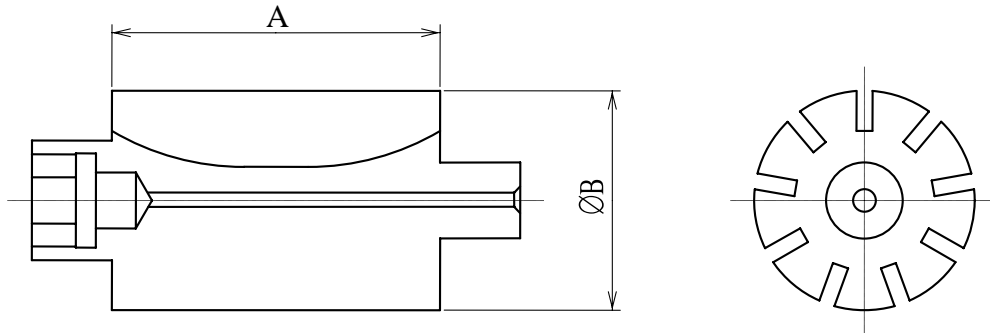
Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
144-286-0	ULT-30D	A	22	22.041	ULT-30D
128-286-5	ULT-30SD	A	22	22.041	ULT-30SD
147-286-0	ULT-40D	A	23.5	23.541	ULT-40(D)
145-286-0	ULT-50	A	23.5	23.541	ULT-50(D)(L)(DL)
128-286-8	ULT-50S	A	23.5	23.541	ULT-40S(SD) ULT-50S(SD)(SL)(SDL)
145-286-6	ULT-60	A	23.5	23.541	ULT-60(D)(L)(DL)
129-286-2	ULT-60S	A	23.5	23.541	ULT-60S(SD)(SL)(SDL)
147-286-6	ULT-70	A	24.5	24.541	ULT-70(L)
129-286-6	ULT-70S	A	23.5	23.541	ULT-70S(SL)
147-286-8	ULT-90	A	30	30.041	ULT-90(L)
148-286-2	ULT-100	A	32	32.045	ULT-100(L)
130-286-2	ULT-130	A	36	36.045	ULT-130(L)

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 - ULT Series

Rotor

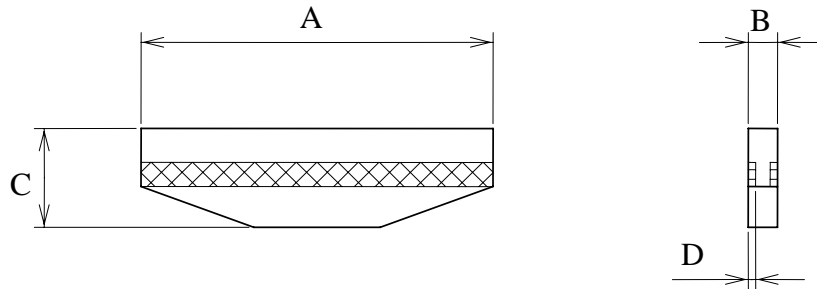


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
		A	B		
144-287-0	ULT-30D	A	32	31.945	ULT-30D(SD)
		B	22	21.938	
145-287-0	ULT-50	A	32	31.945	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	23.5	23.438	
145-287-6	ULT-60	A	38	37.945	ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	23.5	23.438	
147-287-6	ULT-70	A	45	44.945	ULT-70(L)
		B	24.5	24.438	
129-287-6	ULT-70S	A	48	47.945	ULT-70S(SL)
		B	23.5	23.438	
147-287-8	ULT-90	A	45	44.945	ULT-90(L)
		B	30	29.938	
148-287-2	ULT-100	A	45	44.945	ULT-100(L)
		B	32	31.938	
130-287-2	ULT-130	A	53	52.945	ULT-130(L)
		B	36	35.938	

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

Repair Limits - ULT Series

Blade

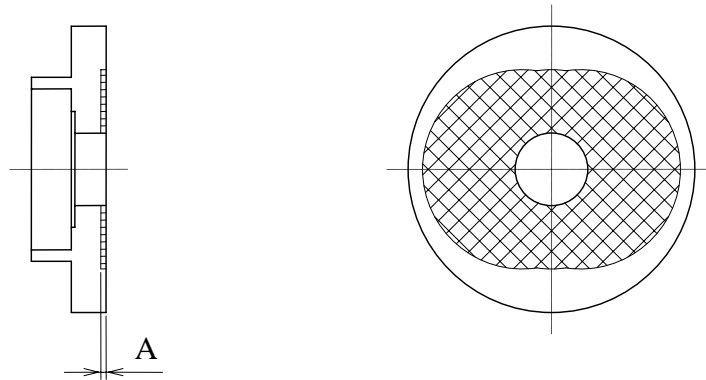


Part Number	Model Number	Standard Dimensions		Repair Limit	Parts Used With
		A	B		
144-288-0	ULT-30D	A	32	31.84	ULT-30D(SD)
		B	1.65	1.61	
		C	7.4	7.28	
		D	-----	0.1	
145-288-0	ULT-50	A	32	31.85	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-2	ALPHA-L61	A	38	37.85	ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-6	ULT-70	A	45	44.83	ULT-70(L)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
129-288-6	ULT-70S	A	48	47.83	ULT-70S(SL)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-8	ULT-90	A	45	44.83	ULT-90(L)
		B	1.85	1.81	
		C	10.8	10.68	
		D	-----	0.1	
148-288-2	ULT-100	A	45	44.83	ULT-100(L)
		B	1.85	1.81	
		C	11.8	10.68	
		D	-----	0.1	
130-288-2	ULT-130	A	53	52.83	ULT-130(L)
		B	2.35	2.31	
		C	12.8	12.68	
		D	-----	0.1	

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

Repair Limits - ULT Series

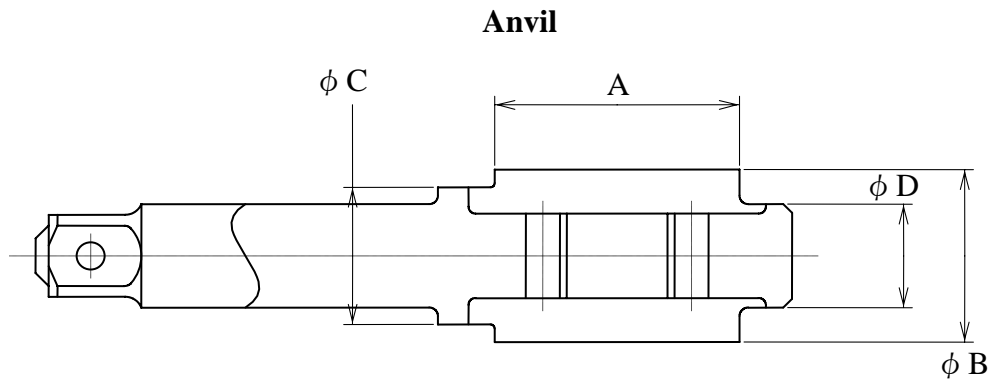
Front Plate



Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
144-289-0	ULT-30D	A	----	0.03	ULT-30D
128-289-5	ULT-30SD	A	----	0.03	ULT30SD
128-289-8	ULT-50S	A	----	0.03	ULT-40S(SD) ULT-50S(SD)(SL)(SDL) ULT-60S(SD)(SL)(SDL) ULT-70S(SL)
145-289-6	ULT-60	A	----	0.03	ULT-40(D) ULT-50(D)(L)(DL) ULT-60(D)(L)(DL)
147-289-6	ULT-70	A	----	0.03	ULT-70(L)
147-289-8	ULT-90	A	----	0.03	ULT-90(L)
148-289-2	ULT-100	A	----	0.03	ULT-100(L)
130-289-2	ULT-130	A	----	0.03	ULT-130(L)

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

Repair Limits - ULT Series



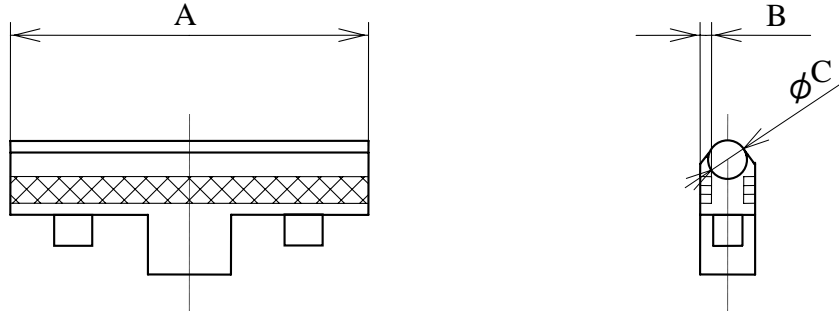
Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
144-350-0	ULT-30D	A	21	20.95	ULT-30D(SD)
		B	18	17.935	
		C	12	11.973	
		D	10	9.96	
145-350-2	ULT-50D	A	21	20.95	ULT-40D(SD) ULT-50D(DL)(SD)(SDL)
		B	18	17.935	
		C	15	14.973	
		D	12	11.96	
145-350-7	ULT-60D	A	26	25.95	ULT-60D(DL)(SD)(SDL)
		B	18	17.935	
		C	15	14.973	
		D	12	11.96	
145-319-0	ULT-50	A	21	20.95	ULT-40(S) ULT-50(L)(S)(SL)
		B	18	17.935	
		C	15	14.973	
		D	12	11.96	
145-319-6	ULT-60	A	26	25.95	ULT-60(L)(S)(SL)
		B	18	17.935	
		C	15	14.973	
		D	12	11.96	
147-319-6	ULT-70	A	28	27.95	ULT-70(L)(S)(SL)
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
147-319-8	ULT-90	A	30	29.95	ULT-90(L)
		B	23	22.94	
		C	19.9	19.87	
		D	14	13.95	
148-319-2	ULT-100	A	35	34.95	ULT-100(L)
		B	26	25.94	
		C	19.9	19.87	
		D	16	15.95	
130-319-2	ULT-130	A	40	39.95	ULT-130(L)
		B	27	26.94	
		C	19.9	19.87	
		D	16	15.95	

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 - ULT Series

Driving Blade



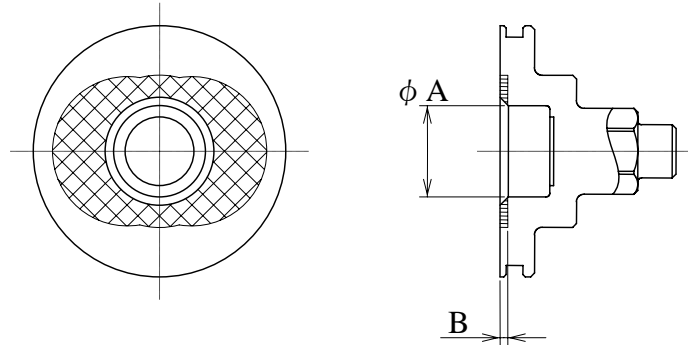
Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
145-440-0 (145-974-0 for Roller)	ULT-30	A	21	20.95	ULT-30D(SD)
		B	-----	0.1	
		C	2.5	2.48	
145-440-0 (145-974-0 for Roller)	ULT-50	A	21	20.95	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	-----	0.1	
		C	2.5	2.48	
145-440-6 (145-974-6 for Roller)	ULT-60	A	26	25.95	ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	-----	0.1	
		C	2.5	2.48	
147-440-6 (147-974-6 for Roller)	ULT-70	A	28	27.95	ULT-70(L)(S)(SL)
		B	-----	0.1	
		C	2.5	2.48	
147-440-8 (147-974-8 for Roller)	ULT-90	A	30	29.95	ULT-90(L)
		B	-----	0.1	
		C	2.5	2.48	
148-440-2 (148-974-2 for Roller)	ULT-100	A	35	34.95	ULT-100(L)
		B	-----	0.1	
		C	3	2.98	
130-440-2 (130-974-2 for Roller)	ULT-130	A	40	39.95	ULT-130(L)
		B	-----	0.1	
		C	3	2.98	

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

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

Repair Limits - ULT Series

Rear Liner Plate

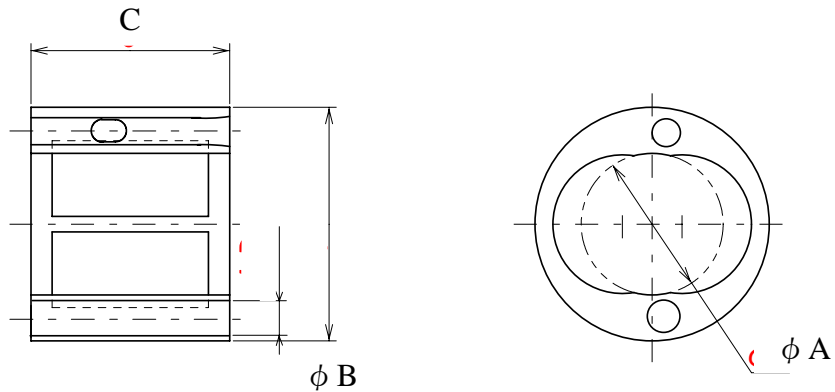


Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
144-901-0	ULT-30D	A	10	10.023	ULT-30D(SD)
		B	-----	0.01	
145-901-0	ULT-50	A	12	12.023	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(SD)(SL)(SDL)
		B	-----	0.01	
145-901-6	ULT-60	A	12	12.023	ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	-----	0.01	
147-901-6	ULT-70	A	12	12.023	ULT-70(L)(S)(SL)
		B	-----	0.01	
147-901-8	ULT-90	A	14	14.023	ULT-90(L)
		B	-----	0.01	
148-901-2	ULT-100	A	16	16.023	ULT-100(L)
		B	-----	0.01	
130-901-2	ULT-130	A	16	16.023	ULT-130(L)
		B	-----	0.01	

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

Repair Limits - ULT Series

Liner

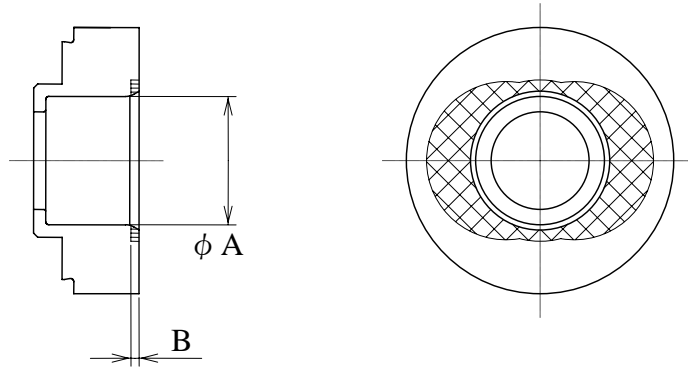


Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
		A	B		
144-902-0	ULT-30D	A	16	16.015	ULT-30D(SD)
		B	28.5	28.485	
		C	21	20.99	
		D	4.5	4.54	
145-902-0	ULT-50	A	18	18.015	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	30	29.985	
		C	21	20.99	
		D	4.5	4.54	
145-902-6	ULT-60	A	18	18.015	ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	30	29.985	
		C	26	25.99	
		D	4.5	4.54	
147-902-6	ULT-70	A	20	20.015	ULT-70(L)(S)(SL)
		B	33	32.985	
		C	28	27.99	
		D	4.5	4.54	
147-902-8	ULT-90	A	23	23.015	ULT-90(L)
		B	38	37.985	
		C	30	29.99	
		D	5	5.04	
148-902-2	ULT-100	A	26	26.015	ULT-100(L)
		B	42	41.985	
		C	35	34.99	
		D	5	5.04	
130-902-2	ULT-130	A	27	27.015	ULT-130(L)
		B	46	45.985	
		C	40	39.99	
		D	5	5.04	

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

Repair Limits - ULT Series

Front Liner Plate



Part Number	Model Number	Standard Dimensions		Repair Limit	Tools Used With
144-901-0	ULT-30D	A	16	16.03	ULT-30D(SD)
		B	-----	0.01	
145-904-6	ULT-60	A	16	16.03	ULT-40(D)(S)(SD) ULT-50(D)(L)(DL)(S)(SD)(SL)(SDL) ULT-60(D)(L)(DL)(S)(SD)(SL)(SDL)
		B	-----	0.01	
147-904-6	ULT-70	A	16	16.03	
		B	-----	0.01	ULT-70(L)(S)(SL)
147-904-8	ULT-90	A	19.9	19.935	ULT-90(L)
		B	-----	0.01	
148-904-2	ULT-100	A	19.9	19.935	ULT-100(L)
		B	-----	0.01	
130-904-2	ULT-130	A	19.9	19.935	ULT-130(L)
		B	-----	0.01	

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

Notes

Notes



AIMCO

Corporate Headquarters

1204 E Maple Road
Troy, MI 48083
248-583-1180
FAX 248-583-7115

10000 SE Pine Street
Portland, OR 97216
800-852-1368
FAX 800-582-9015
www.aimco-global.com

Ave. Morones Prieto 2110 Pte.
Col. Loma Larga
Monterrey, NL CP 64710, Mexico
011-52-81-1001-1600
FAX 011-52-81-1001-1630

Global Assembly Solutions™

LIT-MAN430
Rev. 2/2008
Printed in USA
©2008 AIMCO