



UL Series Repair Limits Manual

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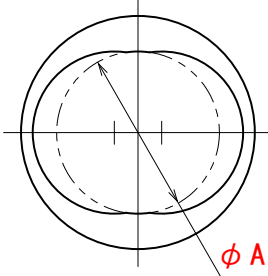

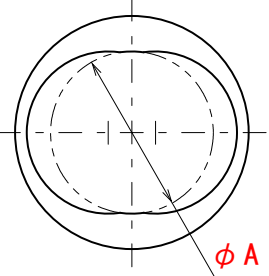
Repair Limits - UL Series

REPAIR LIMITS	UL Rear Plate	1/1
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Note: Make sure that neither deformation nor damage is observed.

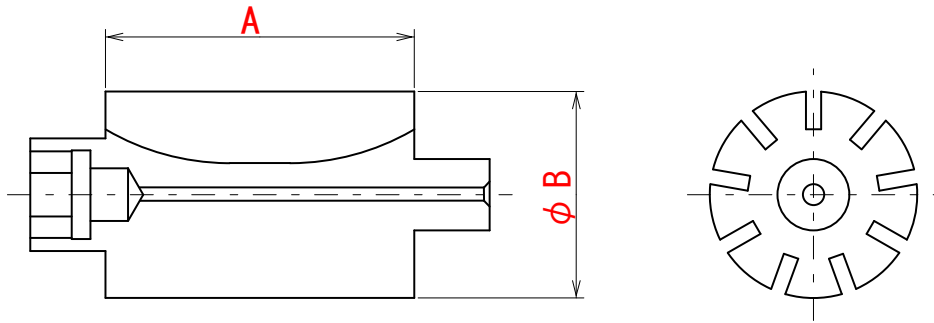
CODE NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
143-285-0	UL40	A	-----	0.03	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
147-285-2	ALPHA-L61	A	-----	0.03	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V) UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
143-285-8	UL70	A	-----	0.03	UL70, UL70(TM)
143-285-9	UL90	A	-----	0.03	UL90, UL90(TM)
155-285-0	UL100	A	-----	0.03	UL100, UL100(TM)

Repair Limits - UL Series

REPAIR LIMITS	UL Cylinder	1/1		
				
<p>Note 1: Make sure that neither deformation nor damage is observed.</p> <p>Note 2: Make sure that the inner surface is flat and smooth, not wavelike.</p>				
PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS	REPAIR LIMITS	PART USED TO THE FOLLOWINGS
142-286-8	UL30	A 20	20.041	UL30, UL30D
143-286-0	UL40	A 20	20.041	UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
143-286-3	UL50	A 23.5	23.541	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
147-286-2	ALPHA-L61	A 23.5	23.541	UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
143-286-8	UL70	A 24.5	24.541	UL70, UL70(TM)
143-286-9	UL90	A 30	30.041	UL90, UL90(TM)
155-286-0	UL100	A 32	32.041	UL100, UL100(TM)

Repair Limits - UL Series

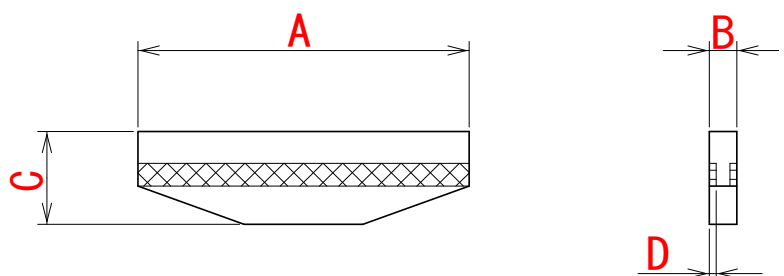
REPAIR LIMITS	UL Rotor	1/1
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Note: Make sure that neither deformation nor damage is observed.

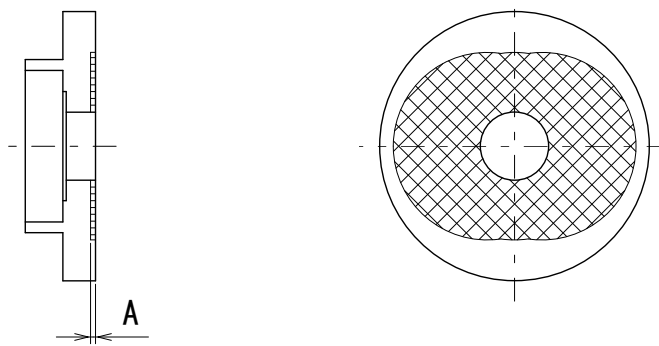
PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
		A	B		
143-287-0	UL40	A	32	31.945	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
		B	20	19.938	
143-287-3	UL50	A	32	31.945	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
		B	23.5	23.438	
147-287-3	ALPHA-L61	A	38	37.945	UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
		B	23.5	23.438	
143-287-8	UL70	A	45	44.945	UL70, UL70(TM)
		B	24.5	24.438	
147-287-8	ULT90	A	45	44.945	UL90, UL90(TM)
		B	30	29.938	
155-287-0	UL100	A	45	44.945	UL100, UL100(TM)
		B	32	31.938	

Repair Limits - UL Series

REPAIR LIMITS		UL Blade		1/1	
					
Note: Make sure that neither deformation nor damage is observed.					
PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
143-288-0	UL40	A	32	31.85	UL30, UL30D
		B	1.35	1.31	UL30(TM) , UL30D(TM)
		C	6.7	6.58	UL40, UL40D
		D	-----	0.1	UL40(TM) , UL40D(TM)
143-288-3	UL50	A	35	34.85	UL50, UL50D, UL50(TM)
		B	1.65	1.61	UL50D(TM) , UL50D(V)
		C	8.3	8.18	
		D	-----	0.1	
147-288-2	ALPHA-L61	A	38	37.85	UL60, UL60D, UL60(TM)
		B	1.65	1.61	UL60D(TM) , UL60D(V)
		C	8.3	8.18	
		D	-----	0.1	
147-288-6	ULT70	A	45	44.83	UL70, UL70(TM)
		B	1.65	1.61	
		C	8.3	8.18	
		D	-----	0.1	
147-288-8	ULT90	A	45	44.83	UL90, UL90(TM)
		B	1.85	1.81	
		C	10.8	10.68	
		D	-----	0.1	
148-288-2	ULT100	A	45	44.83	UL100, UL100(TM)
		B	1.85	1.81	
		C	11.8	11.68	
		D	-----	0.1	

Repair Limits - UL Series

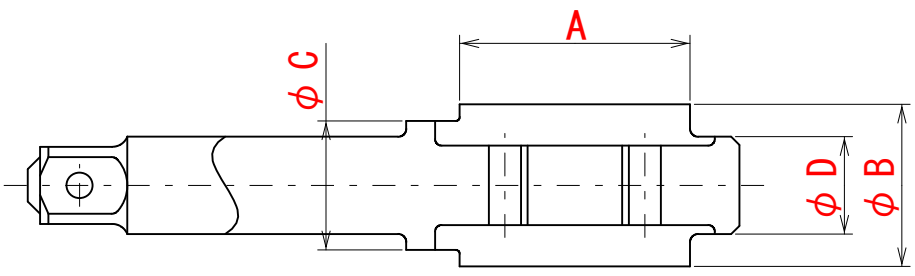
REPAIR LIMITS	UL Front Plate	1/1
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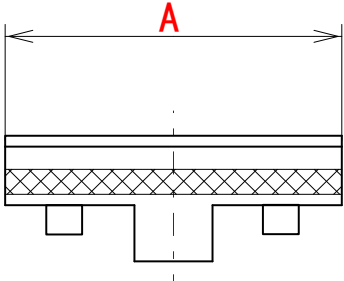
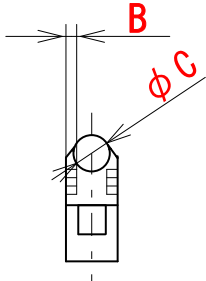
Note: Make sure that neither deformation nor damage is observed.

PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
144-289-0	ULT30D	A	----	0.03	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
147-289-3	ALPHA-L61	A	----	0.03	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V) UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
143-289-8	UL70	A	----	0.03	UL70, UL70(TM)
143-289-9	UL90	A	----	0.03	UL90, UL90(TM)
148-289-2	ULT100	A	----	0.03	UL100, UL100(TM)

Repair Limits - UL Series

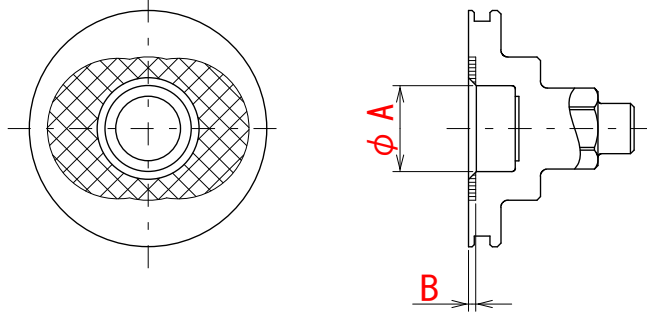
REPAIR LIMITS		UL Anvil		1/1	
					
<p>Note 1: Make sure that neither deformation nor damage is observed.</p> <p>Note 2: Make sure that no damage on contact surface is observed.</p>					
PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS	REPAIR LIMITS	PART USED TO THE FOLLOWINGS	
143-319-0	UL40	A	21	20.95	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
		B	18	17.925	
		C	14	13.973	
		D	10	9.96	
143-319-3	UL50	A	22	21.95	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
		B	20	19.91	
		C	16	15.973	
		D	12	11.96	
143-319-6	UL60	A	25	24.95	UL60, UL60(TM)
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-350-7	UL60D	A	25	24.95	UL60D, UL60D(TM) UL60D(V)
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-319-8	UL70	A	28	27.95	UL70, UL70(TM)
		B	20	19.94	
		C	16	15.973	
		D	12	11.96	
143-319-9	UL90	A	30	29.95	UL90, UL90(TM)
		B	24	23.94	
		C	19.9	19.87	
		D	15	14.95	
155-319-0	UL100	A	35	34.95	UL100, UL100(TM)
		B	27	26.94	
		C	19.9	19.87	
		D	16	15.95	

Repair Limits - UL Series

REPAIR LIMITS		UL Driving Blade		1/1	
					
<p>Note 1: Make sure that neither deformation nor damage is observed.</p> <p>Note 2: Make sure that no damage on contact surface is observed.</p>					
PART NUMBER	MOTHER MODEL	STADNARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
143-440-0 (143-974-0 for Roller)	UL40	A	21	20.95	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
		B	-----	0.1	
		C	2.5	2.48	
143-440-3 (143-974-3 for Roller)	UL50	A	22	21.95	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
		B	-----	0.1	
		C	2.5	2.48	
143-440-6 (143-974-6 for Roller)	UL60	A	25	24.95	UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
		B	-----	0.1	
		C	2.5	2.48	
147-440-6 (147-974-6 for Roller)	ULT70	A	28	27.95	UL70, UL70(TM)
		B	-----	0.1	
		C	2.5	2.48	
147-440-8 (147-974-8 for Roller)	ULT90	A	30	29.95	UL90, UL90(TM)
		B	-----	0.1	
		C	2.5	2.48	
148-440-2 (155-974-0 for Roller)	ULT100 (UL100 for Roller)	A	35	34.95	UL100, UL100(TM)
		B	-----	0.1	
		C	3	2.98	

Repair Limits - UL Series

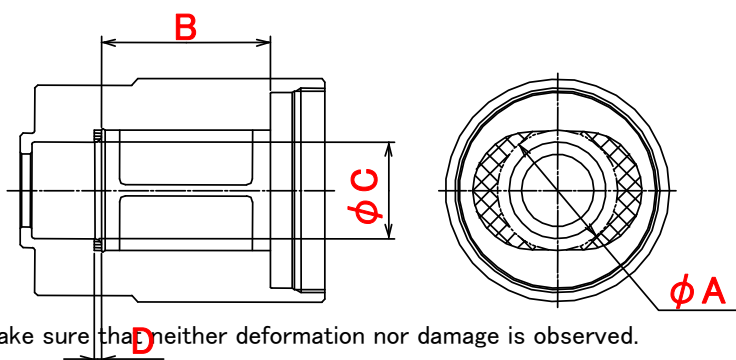
REPAIR LIMITS	UL Rear Liner Plate	1/1
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Note: Make sure that neither deformation nor damage is observed.

PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
		A	B		
143-901-0	UL40	A	10	10.023	UL30, UL30D UL30(TM) , UL30D(TM) UL40, UL40D UL40(TM) , UL40D(TM)
		B	-----	0.01	
143-901-3	UL50	A	12	12.023	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
		B	-----	0.01	
143-901-6	UL60	A	12	12.023	UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
		B	-----	0.01	
143-901-8	UL70	A	12	12.023	UL70, UL70(TM)
		B	-----	0.01	
143-901-9	UL90	A	15	15.023	UL90, UL90(TM)
		B	-----	0.01	
155-901-0	UL100	A	16	16.023	UL100, UL100(TM)
		B	-----	0.01	

Repair Limits - UL Series

REPAIR LIMITS		UL Liner			1/1
 <p style="text-align: center;">Note: Make sure that neither deformation nor damage is observed.</p>					
PART NUMBER	MOTHER MODEL	STANDARD DIMENSIONS		REPAIR LIMITS	PART USED TO THE FOLLOWINGS
142-902-8	UL30	A	18	18.015	UL30, UL30D UL30(TM) , UL30D(TM)
		B	21	21.015	
		C	14	14.03	
		D	-----	0.01	
143-902-0	UL40	A	18	18.015	UL40, UL40D UL40(TM) , UL40D(TM)
		B	21	21.015	
		C	14	14.03	
		D	-----	0.01	
143-902-3	UL50	A	18	18.015	UL50, UL50D, UL50(TM) UL50D(TM) , UL50D(V)
		B	22	22.015	
		C	16	16.03	
		D	-----	0.01	
143-902-6	UL60	A	20	20.015	UL60, UL60D, UL60(TM) UL60D(TM) , UL60D(V)
		B	25	25.015	
		C	16	16.03	
		D	-----	0.01	
143-902-8	UL70	A	20	20.015	UL70, UL70(TM)
		B	28	28.015	
		C	16	16.03	
		D	-----	0.01	
143-902-9	UL90	A	24	24.015	UL90, UL90(TM)
		B	30	30.015	
		C	19.9	19.935	
		D	-----	0.01	
155-902-0	UL100	A	27	27.015	UL100, UL100(TM)
		B	35	35.015	
		C	19.9	19.935	
		D	-----	0.01	



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