

CF34-10E FADEC

Recommended Overhaul Actions

Reasons to Overhaul FADEC

- CF34-10E in service since 2004
- Continued on wing reliability is at risk after 6,000 flight hours
- Stabilizes and increases reliability

Benefits of Base Overhaul

- Provides 18-month or 3,000-hours extended warranty for any replaced electric modules (EMOD) and pressure system units (PSU)
- Incorporates lessons learned from investigations and repair history
- Replaces at risk components and parts
- Expands test coverage (sub-assembly test), complete tear down, and detailed inspections
- Allows for software updates

Scope

- Details in BAE Systems Service Letter SL-CF34 FADEC-002
- Recommended soft time interval of 6,000 hours with pre-G7 EMOD's or 12,000 hours for pre-G9
- Key reliability service bulletins and replacements included in overhaul:
 - Engine controls module replaced with parylene coated version
 - PSU replaced every 24,000 hours (soft time)

A FADEC overhaul performed by FADEC International will extend the life of your unit.

BAE Systems designs, develops, and manufactures highly reliable full authority digital electronic controls (FADEC) and supports them to ensure optimal performance throughout the technology's life cycle. Our robust overhaul process has been developed based upon extensive knowledge of severe engine environments, design attributes, and repair history to increase the reliability of an aging FADEC.

Why overhaul?

- Extends the serviceable lifetime
- Lowers maintenance costs and fleet disruptions
- Minimizes unscheduled removals and future major failures
- Updates hardware and software for enhanced system performance, efficiency, and reliability
- Preemptive repairs lessen expensive in-service failures

What have we learned?

Through regularly conducted reliability reviews, we focus on gathering and analyzing field performance data to understand how the harsh engine environment and cycling affect operation. This process allows us to identify any potential aging or reliability issues that need to be addressed during an electronics overhaul.

- Expected failure times and rates are calculated using original configuration data, shop history repair information, and fleet hour data
- Analyzing gathered data using Six Sigma tools allows us to identify strategies to extend product life cycle

Knowledge gained from critical investigations of repetitive failures, system verification request, and age related deterioration allows us to identify:

- Failure root causes (cracked solder joints, sub-assemblies) can be determined by correlating data from systems with common failures
- Sub-assembly circuit verification and inspection have uncovered issues undetectable at the system level
- Passive front-panel circuitry verification of the shielding/grounding systems allow us to identify any missing resistive paths or paths that should not be present

We develop a tailored overhaul scope of work by collecting, analyzing, and investigating data to develop value added reliability and life extension solutions. The scope of work is reviewed, approved, and recommended by the original engine manufacturer type certificate holder.

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