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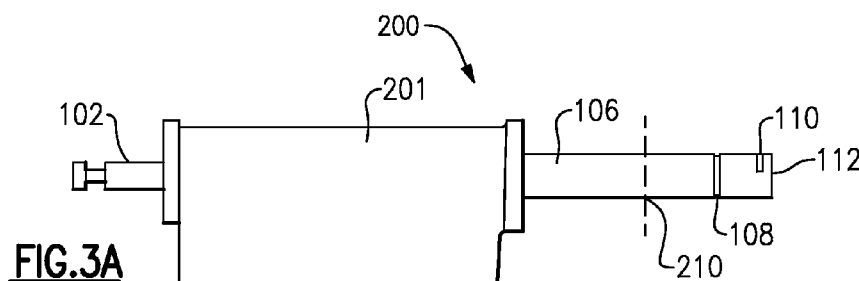
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(54) Title: METHOD TO REPAIR VARIABLE VANES



(57) Abstract: A variable vane having an airfoil, an inner trunnion shaft and an outer trunnion shaft, with the outer trunnion shaft having a threaded hole and a groove extending around a circumference of the outer trunnion shaft is repaired by removing a portion of the outer trunnion shaft leaving a shaft stub. A repair detail is prepared having an outer peripheral shaft portion with a nominal outer diameter. The repair detail further has a pilot portion extending forwardly and having a smaller outer diameter than an outer diameter of the nominal outer diameter. The shaft stub has a remaining bore portion, which is a portion of the threaded hole. The pilot portion is sized to be received within the remaining bore portion. The pilot is inserted into the remaining bore portion. The repair detail is welded to the shaft stub. A repaired variable vane is also disclosed.