

T-002 Inspection Limits and Repair

Turbine to Compressor Coupling

Engine	250-B15G
Application(s):	250-B17F, B17F/1, B17F/2 250-C18, C18A, C18B, C18C 250-C20, C20B, C20F, C20J, C20S, C20W, C20R, C20R/1, C20R/2, C20R/4
Subject:	Inspection and Rework Procedures for the A6898977 & E6898977 Turbine to Compressor Coupling.
Compliance:	Any time the Coupling is removed during overhaul. Refer to the following Table for Inspection and Rework Procedure.
Notes:	Replaces Service Letter T94-001 issued by Superior Turbine on February 11, 1994. Refer to OEM's published data for installation, engine operation and disassembly.
Revisions:	N/C Dated: 01/30/97 Initial Release. A Dated: 11/26/97 Updated format. B Dated: 01/22/01 Updated format. C Dated: 09/10/09 Updated EXTEX to TINKEN. D Dated: 02/02/16 Updated Timken to EXTEX Engineered Products.

T-002 Inspection Limits and Repair

**A6898977 & E6898977 Turbine to Compressor Coupling
Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
Crack Indication, visual and MPI*	Cracks are not acceptable.	No Repair.	Install new or serviceable Coupling
Inclusions	Any inclusion extending into the spline root is NOT acceptable. Nonmetallic inclusions may be acceptable as follows: At Spline teeth radii root corners provided no progression is evident. AND 0.25 inch maximum length on shaft when not crossing (i.e. parallel to) the material flow lines.	No Repair.	Install new or serviceable Coupling if Service Limit is exceeded.
Spline Tooth Wear	Maximum of 0.001 inch wear normal to spline tooth profile. ** See Note Below Maximum over pin diameter (measured in two places): 0.6775 inch over 0.054 inch pins.	No Repair.	Install new or serviceable Coupling if spline wear Service Limit is exceeded.
Spline Tooth Damage (metal displacement): chips, gouges, grooves, nicks, spalling, etc.	Spline tooth damage is not acceptable.	No Repair.	Install new or serviceable Coupling if Service Limit is exceeded.
Rough or Sharp Edges	Rough or sharp edges are not acceptable. No imperfections are acceptable after blending.	After blending, spline tooth wear service limits are met.	Blend using crocus cloth or Arkansas stone. Install new or serviceable coupling if Service Limit is exceeded.
Imperfections After Blending	None.	None.	Replace.

NOTES:

* MPI technique as follows: A) Circular between heads
AND

B) Longitudinal in a coil

** Use of OEM NO-GO gauge, 23060757, is permitted in lieu of over pin measurement.

TABLE 1