

T-004 Service Information

P/N(s): A6890040, E6890040, 23062750, E23073533, and E250-10003

Revision: G

Issued: 2/28/18

Subject:	1 st Stage Turbine Nozzle Shield Assembly inspection and repair procedures.
EXTEX Part Numbers:	A6890040, E6890040, E23062750, E23073533, E250-10003
Installation(s):	Rolls Royce (Allison) 250-B15, B17, B17F, C18, C20 Series, C20R Series
Revision History:	<p>Rev NC – Dated: 01/30/97 Initial release. Rev A - Dated: 11/27/97 Updated format. Rev B - Dated: 01/15/98 Haynes 230 was AMS 5798. Rev C - Dated: 02/01/01 Updated format. Rev D - Dated: 01/31/03 Updated format and added P/N E23073533. Rev E - Dated: 09/10/09 Updated EXTEX to TIMKEN. Rev F - Dated: 02/02/16 Updated Timken to EXTEX Engineered Products. Rev G - Dated: 02/28/18 Updated document to current format. Added PN E250-10003</p>
Reason:	Supplemental Instruction for Continued Airworthiness (ICA)
Description:	This document is supplemental information for the owner / operator provides the owner/operator with optional inspection and repair procedures. The inspection results determine if the article is serviceable in its current condition, if the article is repairable per this instruction, or if the component requires replacement.
Applicability:	All EXTEX 1 st Stage Nozzle Shields of the listed part numbers listed.
Accomplishment Instructions:	<ol style="list-style-type: none"> 1. Refer to OEM's published data for instructions for engine disassembly, cleaning, inspection, rework, assembly, operation, and testing. 2. Perform all work at a repair facility approved by the FAA or appropriate airworthiness authority. 3. Refer to Table 1 for Inspection and Repair Procedures. Refer to Table 2 for recommended weld and braze materials. 4. You may also use the OEM Instructions for Continued Airworthiness (ICA) to inspect, repair, and return the EXTEX article to service.
Approval:	The FAA has approved this document.
Notes:	Replaces Service Letter T94-003 issued by Superior Turbine on February 11, 1994. Please contact your EXTEX Engineered Products representative with any questions.

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TABLE 1: SERVICE AND REPAIR LIMITS

Condition	Service Limit	Repair Limit	Corrective Action
Cracks, Visual and FPI*, circumferentially around heat shield spot weld(s)	Crack(s) less than 50% of distance around spot weld are acceptable.	Crack(s) up to 100% of distance around spot weld.	Weld repair or replace heat shield or replace Assembly.
Cracks, Visual and FPI*, in all other areas including radially from around heat shield spot welds.	No cracks are acceptable.	Any amount.	Weld repair or replace cracked detail(s) or Assembly.
FPI* indications (line type) in braze area joining saddles to inner or outer band.	Acceptable up to 0.12 inch Max**.	Line indications in braze only.	Replace Saddle(s) or replace Assembly.
Saddle Wear (outer side)	Minimum distance across saddle 0.339 inch. AND Minimum lip thickness: 0.010 inch.	No repair.	Replace Saddle(s) or replace Assembly.

NOTES:

* FPI per approved Water Washable technique.

** Indications in the adjacent band or saddle base material are not acceptable.

TABLE 2: RECOMMENDED WELD / BRAZE MATERIAL

P/N	MATERIAL	WELD ROD	BRAZE ALLOY
A6890040	Hast X	Hast X	BNi-10 or N99622 (UNS)
E6890040	Hast X	Hast X	BNi-10 or N99622 (UNS)
E23062750	Haynes 230	Haynes 230 or Hast X	BNi-10 or N99622 (UNS)
E23073533	Haynes 230	Haynes 230 or Hast X	BNi-10 or N99622 (UNS)
E250-10003	Haynes 230	Haynes 230 or Hast X	BNi-10 or N99622 (UNS)

Parts meeting the above criteria are eligible for return to service.