

## T-007 Inspection Limits and Repair

### Compressor Tie Bolt

**Engine Application(s):** 250-C20, C20B, C20F, C20J, C20S, C20W

**Subject:** Inspection and Rework Procedure for the A6871259 & E6871259 Compressor Tie Bolt.

**Compliance:** Any time the Compressor Tie Bolt is removed. Refer to the Figure and Table for Inspection and Rework Procedures.

Table 1: Inspection and Rework Limits

Figure 1: Repair Procedure

**Notes:** Replaces Service Letter T94-009 issued by Superior Turbine on February 11, 1994. Refer to the OEM's published data for installation, engine operation and disassembly.

**Revisions:**

N/C	Dated: 01/30/97	Initial release.
A	Dated: 11/28/97	Updated format.
B	Dated: 01/23/01	Updated format.
C	Dated: 09/20/02	Added plating specifications to Figure 1.
D	Dated: 09/10/09	Updated EXTEX to TIMKEN.
E	Dated: 2/02/16	Updated Timken to EXTEX Engineered Products.

**T-007 Inspection Limits and Repair**

**A6871259 & E6871259 Tie Bolt, Compressor Assembly  
Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
Cracks, visual and MPI*	Cracks are not acceptable.	No Repair.	Replace Tie Bolt.
Corrosion Pitting	Base metal pitting is not acceptable on mutes. Maximum material removal is .0005 inch elsewhere.	Polish to remove pits. Do not remove base material from mutes.  Re-plate in accordance with Figure 1.	Replace Tie Bolt if pits cannot be removed by polishing or the Service Limit is exceeded.
Dimensionally Inspect Per Figure 1.	Shown in Figure 1.	Repair and re-plate in accordance with Figure 1.	Replace Tie Bolt when Service Limit is exceeded.

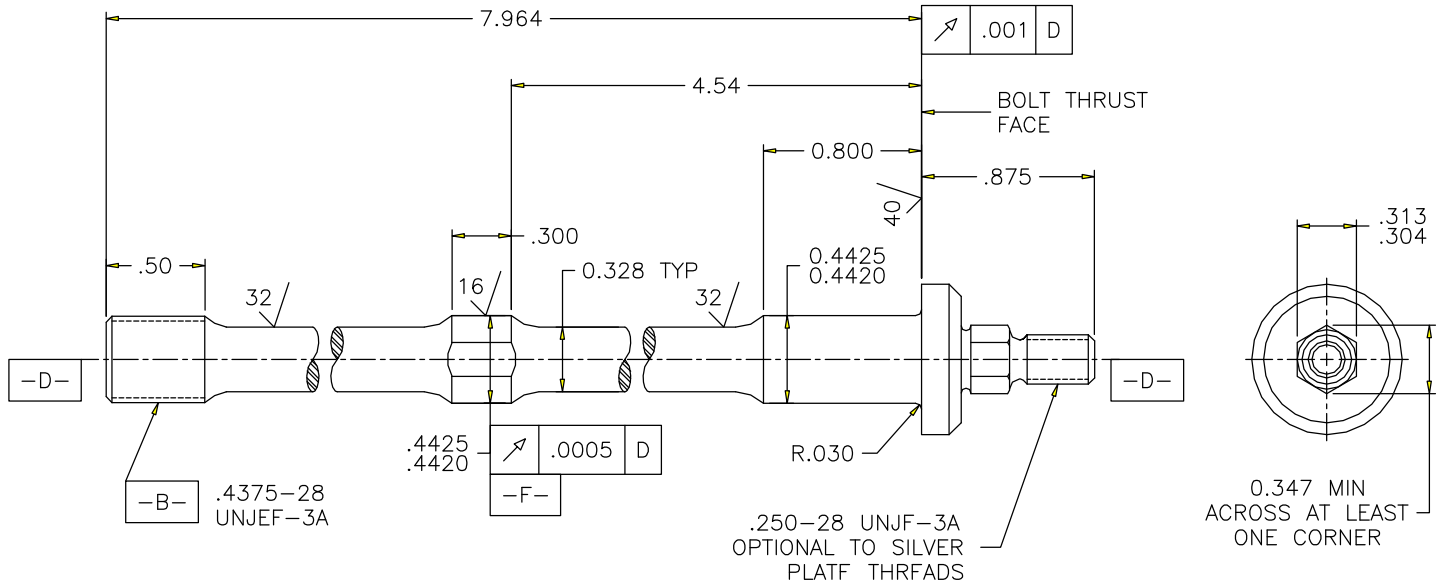
**NOTE:**

\* MPI technique as follows: A) Circular between heads  
AND  
B) Longitudinal in a coil

**TABLE 1**

**T-007 Inspection Limits and Repair**

**A6871259 & E6871259 Compressor Tie Bolt  
Repair Procedure**



- AXIS D-D ESTABLISHED BY PD OF THREAD B AND DIA. C.
  - FEATURES SHALL BE CONCENTRIC AND SQUARE TO -D- WITHIN THE RUNOUT SPECIFIED.
  - BREAK SHARP EDGES TO 0.010 BEFORE PLATING, UNLESS OTHERWISE SPECIFIED.
  - SILVER PLATE PER AMS 2412 TO 0.0001-0.0003 THICK UNLESS OTHERWISE SPECIFIED.
- ALL DIMENSIONS TO BE MET AFTER PLATING.
- DIA. C, DIA. F, AND THRUST FACE OF BOLT CAN BE RESTORED BY ELECTROLESS NICKEL PLATING PER AMS 2405 TO 0.010 IN. MAX. THICKNESS.
  - DIA. F PLATING CAN INCLUDE STRADDLE CUT FLATS.
  - DIMENSIONS ARE IN INCHES.

**FIGURE 1**