

**T-014 Inspection Limits and Repair**

**Stationary Labyrinth Seal**

<b>Engine Application(s):</b>	250-B15G 250-B17F, B17F/1, B17F/2 250-C18, C18A, C18B, C18C 250-C20, C20B, C20F, C20J, C20S, C20W 250-C20R, C20R/1, C20R/2, C20R/4
<b>Subject:</b>	Inspection and Rework Procedure for the A6877736-1 & -2 & E6877736-1 & -2 Stationary Labyrinth Seal.
<b>Compliance:</b>	Any time the Stationary Labyrinth Seal is removed for overhaul. Refer to the Figures for Inspection and Rework Procedures.
<b>Notes:</b>	Replaces Service Letter T95-001 issued by Superior Turbine on April 1, 1997. Refer to OEM's published data for installation, engine operation and disassembly.
<b>Revisions:</b>	N/C Dated: 01/30/97 Initial release. A Dated: 12/02/97 Updated format. B Dated: 01/26/01 Updated format. C Dated: 09/09/09 Updated EXTEX to TIMKEN. D Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.

A6877736-1 & -2 & E6877736-1 & -2  
**Stationary Labyrinth Seal**  
**Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
Crack Indications, Visual and FPI*	Cracks are not acceptable.	No Repair.	Replace Labyrinth Seal.
Nicks, Scratches, or Damage to silver seal surface	Desired radial clearance with Rotating Labyrinth Seal	Damage to Parent Metal	Replace Silver Coating in accordance with Fig. 1
Fit of Seal in Bore	.0005 to .0015 inch. "tight fit"	Same as Service Limit	Replace Nickel in accordance with Fig. 1

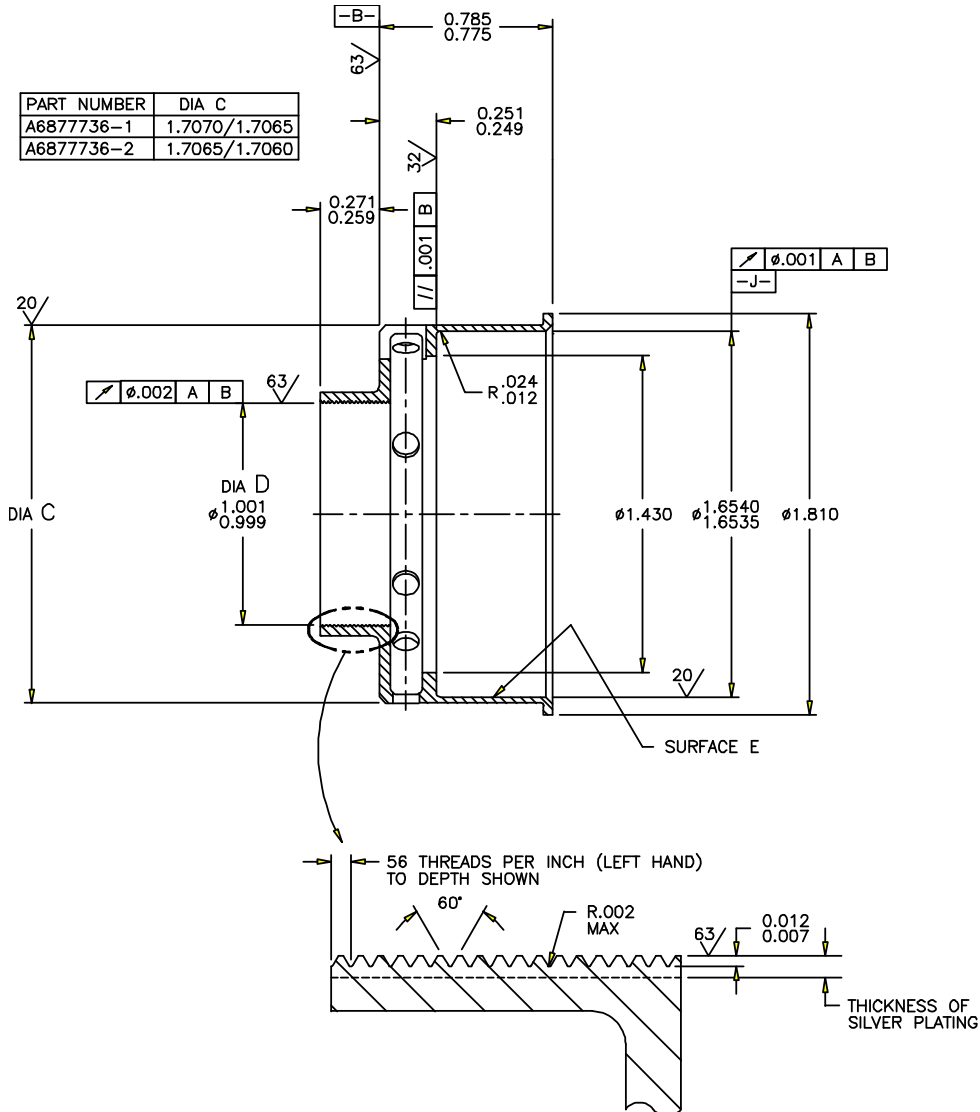
**NOTE:**

\* FPI per approved water washable technique.

**TABLE 1**

**T-014 Inspection Limits and Repair**

**A6877736-1 & -2 & E6877736-1 & -2  
Labyrinth Seal Inspection and Repair**



- NICKEL PLATE SURFACE E 0.0001-0.0003 IN. THICK AND BAKE AT
- 750° +/- 10°F FOR ONE HALF HOUR. OTHER SURFACES OPTIONAL.
- SILVER PLATE DIA. D 0.015-0.025 IN. THICK AFTER MACHINING.
- ALL DIM. TO BE MET AFTER PLATING.
- FINISH ALL OVER 125 MICRO-INCHES UNLESS OTHERWISE SPECIFIED BEFORE PLATING.

**FIGURE 1**