

**T-018 Inspection Limits and Repair**

**Compressor Oil Seal and Ring**

|                               |   |
|-------------------------------|---|
| <b>Engine Application(s):</b> | 250-B15G,<br>250-C18, C18A, C18B, C18C<br>250-C20, C20B, C20F, C20J, C20S, C20W<br>250-C30G, C30M, C30P, C30R, C30S   |
| <b>Subject:</b>               | Inspection and Rework Procedures for the A6871902, E6871902, A6887619 & E6887619 Compressor Front Bearing Oil Seal and Seal Mating Ring.  |
| <b>Compliance:</b>            | Any time the Compressor Front Bearing Oil Seal and Seal Mating Ring are removed during repair or overhaul. Refer to the Figure and Table for Inspection and Rework Procedures.  |
| <b>Notes:</b>                 | Replaces Service Letter T95-006 issued by Superior Turbine on May 31, 1995. Refer to OEM's published data for installation, engine operation and disassembly.   |
| <b>Revisions:</b>             | N/C Dated: 01/30/97 Initial Release.<br>A Dated: 12/03/97 Updated format.<br>B Dated: 01/26/01 Updated format.<br>C Dated: 09/09/09 Updated EXTEX to TIMKEN.<br>D Dated: 2/02/16 Updated Timken to EXTEX Engineered Products. |

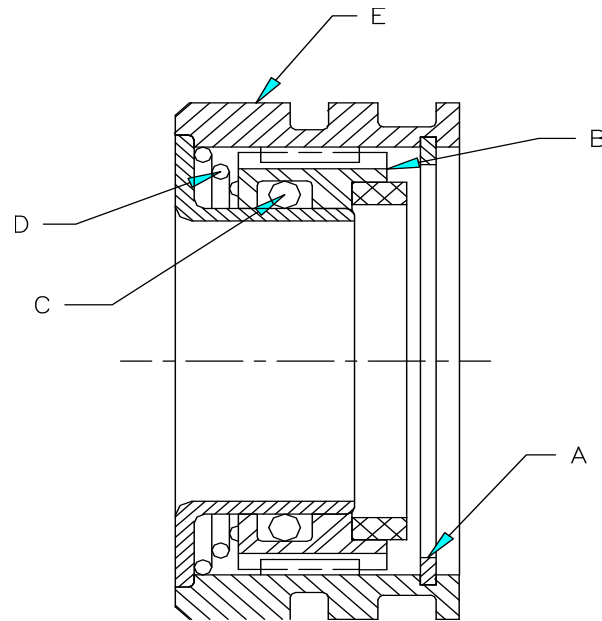
**A6871902, E6871902, A6887619 & E6887619  
Inspection and Rework Limits**

| Condition     | Service Limit        | Repair Limit   | Corrective Action   |
|---------------|----------------------|--|---|
| Seal Flatness | 6 Helium Light Bands | Thickness diameter under 0.209 inch or scratches or cracks on the mating ring seal face.<br>Cracks, scratches or chips extending more than 10% of seal ring assembly lapped carbon face. | Lap within 3 helium light bands.<br><b>OR</b><br>Replace mating ring and/or seal ring assembly in accordance with Figure 1. |

**TABLE 1**

**Compressor Front Bearing Oil Seal Repair**

**T-018 Inspection Limits and Repair**



REPLACE SEAL ASSEMBLY, PACKING AND SPRING AS FOLLOWS:

- REMOVE RETAINING RING (A).
- REMOVE SEAL RING ASSY (B), PACKING (C), AND SPRING (D) FROM THE SEAL HOUSING (E).
- CLEAN THE SEAL HOUSING AND RETAINING RING USING MINERAL SPIRITS AND A SOFT BRISTLE BRUSH.
- INSTALL THE REPLACEMENT SPRING IN THE SEAL HOUSING.
- PLACE THE NEW PACKING IN THE REPLACEMENT SEAL RING.
- INSTALL THE SEAL RING ASSY IN THE SEAL HOUSING.
- SECURE WITH THE RETAINING RING, AND THEN MEASURE THE ID OF THE RETAINING RING TO 0.856 INCH MIN. THIS WILL ASSURE THAT THE RETAINING RING HAS NOT YIELDED IN ASSEMBLY OR DISASSEMBLY.

**FIGURE 1**