

**T-032 Inspection Limits and Repair**

**Compressor Coupling Adapter**

<b>Engine Application(s):</b>	250-C28B, C28C, C30, C30G, C30G/2, C30M, C30P, C30S
<b>Subject:</b>	Inspection and Rework Procedures for the E23005271-1, -2, -3/EH23005271-1, -2, -3 Compressor Coupling Adapter.
<b>Compliance:</b>	Any time the Compressor Coupling Adapter is removed for overhaul. Refer to the following Table and Figure for Inspection and Rework Limits.  Table 1: Inspection and Rework Limits Figure 1: Dimensional Inspection Limits
<b>Notes:</b>	Refer to OEM's published data for installation, engine operation, and disassembly.
<b>Revisions:</b>	N/C Dated: 07/30/97 Initial Release. A Dated: 01/05/01 Added P/Ns E23005271-1, -2, -3/EH23005271-1, -2, -3. B Dated: 09/04/09 Updated EXTEX to TIMKEN. C Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.

**T-032 Inspection Limits and Repair**

E23005271-1, -2, -3  
EH23005271-1, -2, -3  
**Compressor Coupling Adapter  
Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
Cracks Indications, visual and MPI*.	Cracks are not acceptable.	No Repair.	Install new or serviceable Coupling Adapter.
External Spline Tooth Wear	Maximum of 0.001 inch wear normal to spline tooth profile. Minimum over pin diameter (measured in two places): 0.8998 inch over 0.060 inch pins.	No Repair.	Install new or serviceable Coupling Adapter if Service Limit is exceeded.
Spline Tooth Damage (metal displacement): chips, gouges, grooves, nicks, spalling, corrosion, pitting, etc.	Spline tooth damage is not acceptable.	No Repair.	Install new or serviceable Coupling Adapter if Service Limit is exceeded.
Internal Spline Tooth Wear	Maximum of 0.001 inch wear normal to spline tooth profile. <b>** See Note Below.</b> Maximum between pin diameter (measured in two places): 0.7414 inch between 0.054 inch pins.	No Repair.	Install new or serviceable Coupling Adapter if Service Limit is exceeded.
Localized Galling of Splines	Galling is not acceptable.	Maximum depth: 0.005 inch. Any length.	Remove buildup or sharp edges with Arkansas stone.
Dimensional Inspection (Pilot Diameter "A" and Pitch Diameter Run Out)	Check for compliance with Figure 1.  Match Pilot Diameter to Impeller to maintain 0.000 to 0.001 inch interference.	No Repair.	Install new or serviceable Coupling Adapter if Service Limit is exceeded.

**NOTES:**

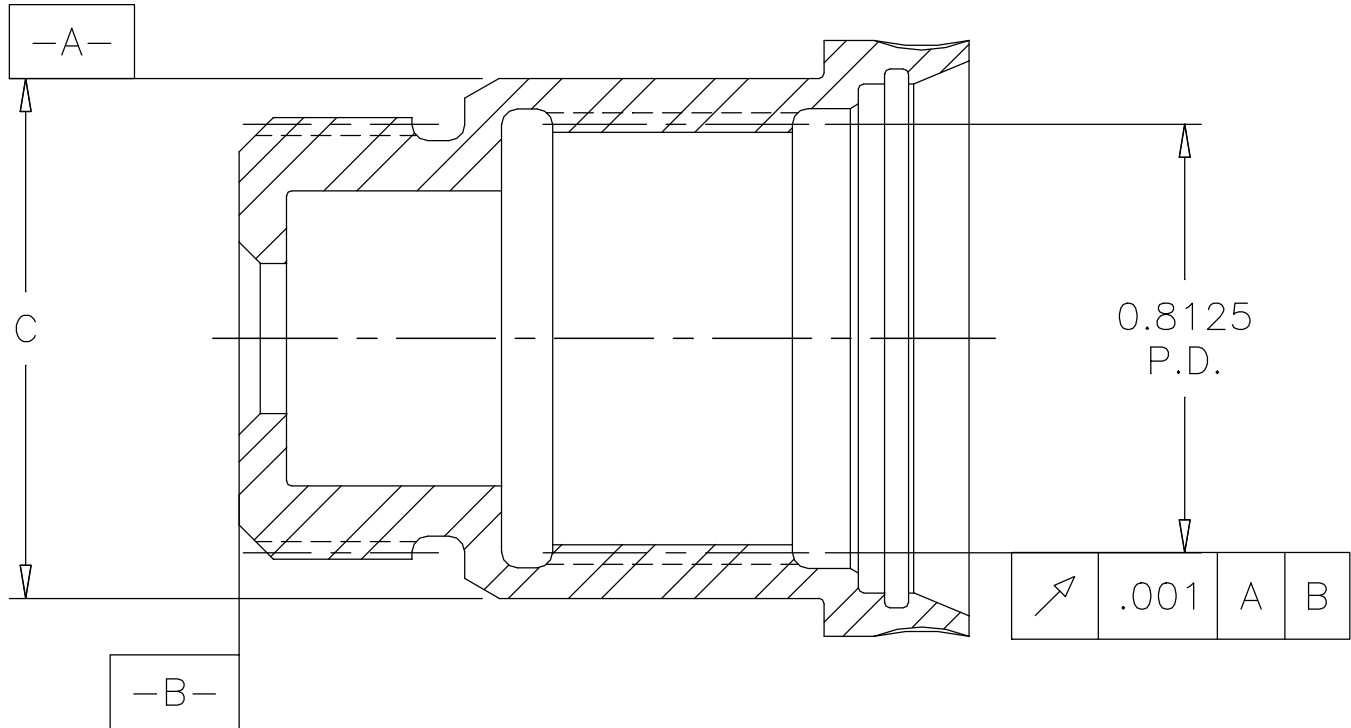
- \* MPI technique as follows:           A) Circular between heads  
  AND  
  B) Longitudinal in a coil

- \*\* Use of OEM NO-GO gauge, 23060752, is permitted in lieu of over pin measurement.

**TABLE 1**

**T-032 Inspection Limits and Repair**

E23005271-1, -2, -3  
EH23005271-1, -2, -3  
**Compressor Coupling Adapter  
Dimensional Inspection**



- IF UNACCEPTABLE WEAR IS FOUND ON COUPLING ADAPTER OR SPUR ADAPTER GEARSHAFT, REPLACE BOTH PARTS AS A SET.
- DIMENSIONS ARE IN INCHES.

**FIGURE 1**

DASH	DIA. C
-1	.9855-.9860
-2	.9875-.9880
-3	.9895-.9900

**TABLE 2**