

T-065 Instructions for Continued Airworthiness

Instructions for Continued Airworthiness Extex Replacement Parts for RR250

Engine Application(s):	All Rolls Royce / Allison 250 engine models.
Compliance:	As required.
Notes:	Refer to OEM's published data for installation, engine operation, and disassembly.
Revisions:	A Dated: 7/02/08 Initial Release. B Dated: 8/27/09 Updated EXTEX to TIMKEN. C Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.

As part of the FAA approval process, Extex demonstrated that the OEM's published Instructions for Continued Airworthiness (ICA) is applicable to and may be used for all Extex replacement parts except as noted in Section 2. Extex Supplemental ICA is also available for product listed in Section 3.

Section 1: General Instructions:

1. Refer to the OEM's published data for instructions for engine disassembly, cleaning, inspection, rework, Ass'y, operation, and testing.
2. All work must be performed at an FAA-approved repair facility.
3. Except as noted in Section 2B, you may use the OEM ICA for the equivalent OEM part to inspect, repair, and overhaul the Extex Product.
4. Extex recommends that, whenever applicable, you comply with the Supplemental Extex ICA listed in Section 3.
5. Products inspected or repaired/reworked in accordance the Supplemental Extex ICA may be classified as serviceable, repaired, or overhauled at the discretion of the certifying entity.

Section 2: Required Extex Instructions for Continued Airworthiness:

- A) Use the following Extex ICA for the product listed below whenever applicable to your situation:

Part Number	Nomenclature	Service Document	Topic
E23031938-C, E6878426-C	2 nd Stage Turbine Nozzle Ass'y	T-009	Inspection limits and repair for coated nozzles.
E23031938-UC, E6878426-UC	2 nd Stage Turbine Nozzle Ass'y	T-012	Installation Procedure for 'uncut' blade paths.
E23032335-UC, E23055438-UC	Un-Cut 2 nd Stage Turbine Nozzle	T-026	Installation Procedure for 'uncut' blade paths.
E23038218-C505	1 st Stage Turbine Nozzle Ass'y	T-013	Inspection limits and repair for coated nozzles.
E23039791-1	Compressor Adapter Couplings	T-061	Remove From Service
E23053330	C47 2nd Stage Turbine Nozzle Assembly	T-071	Installation Procedure for 'uncut' blade paths.
E23064637-2P	Two Piece Diffuser	T-068	Installation Rework Instructions
E6878426	2 nd Stage Nozzle	T-049	Rework For C20B Installation

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P/N(s): Various – See Tables

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Part Number	Nomenclature	Service Document	Topic
E6888529	Starter Generator Gearshaft	T-050	Installation Instructions
E6888547-UC	Un-Cut Power Turbine Oil Sump Cover Ass'y	T-045	Installation Procedure for 'uncut' seal diameters.
E6898977	Turbine to Compressor Couplings	T-062	Remove certain serial numbers from service.
E6898785	PTO Gear	T-075	Remove certain serial numbers from service.
E6893673	Torquemeter Gear	T-076	Inspection of certain serial numbers
E23039791, E23039791-1,-2,-3; EH23039791, EH23039791-1,-2,-3	Compressor Splined Adapter Coupling	T-081	Remove from Service
E23008020	Turbine Tie Bolt	T-090	Remove from Service
E23057111, E23057112, E23057114, E23057115, E23057116	Compressor Wheels	T-099	Corrosion Inspection
E23075442	Gearshaft Ass'y, Helical Torquemeter Gear	T-100	Re-identification of certain serial numbers.

B) You cannot use OEM ICA and must use only Extex ICA for the product listed below:

None Listed.

Section 3: Supplemental Extex Instructions for Continued Airworthiness:

Extex has issued supplemental ICA for products listed below.

Part Number	Nomenclature	Service Document
E23001801	Outer PT Coupling Nut	T-005
E23001832	Nozzle Assembly, Pressure Oil, Power Turbine Support	T-093
E23004529	Hastelloy X Combustion Liner Assembly	T-024
E23005271-1,-2,-3	Compressor Coupling Adapter	T-032
E23007530	Hastelloy X Combustion Liner Assembly	T-024
E23008020	Turbine Tie Bolt	T-006; T-090
E23008030	Turbine Tie Bolt	T-027
E23008064	First Stage Turbine Nozzle	T-029
E23008064-738	First Stage Turbine Nozzle	T-029
E23008089	Spur Adapter Gearshaft	T-031
E23008090	Spur Adapter Gearshaft	T-031
E23008614	Combustion Liner	T-041
E23030974	Turbine Splined Adapter	T-033
E23030981	Inner PT Coupling Nut	T-005
E23030982	Inner PT Coupling Nut	T-005
E23031494	#8 Bearing Stationary Labyrinth Seal	T-089
E23031921	Spur Adapter Gearshaft Assembly	T-011
E23031922	Spur Adapter Gearshaft Assembly	T-011

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Part Number	Nomenclature	Service Document
E23031938	2 nd Stage Turbine Nozzle Assembly	T-009
E23031938-C	2 nd Stage Turbine Nozzle Assembly	T-009
E23031938-UC	2 nd Stage Turbine Nozzle Assembly	T-012
E23032263	Energy Absorbing Ring	T-034
E23032283-1,-2,-3	Bearing Cage	T-052
E23032326	Vertical Firewall Assembly	T-073
E23032335	Second Stage Turbine Nozzle	T-028
E23032335-UC	Un-cut Second Stage Turbine Nozzle	T-026
E23032345	Compressor Coupling, Turbine	T-055
E23032327	Rotating No. 5 Labyrinth Seal	T-083
E23032328	Rotating No. 5 Labyrinth Seal	T-083
E23034608	Power Turbine Oil Sump Cover	T-040
E23034784	Spur Adapter Gearshaft Assembly	T-011
E23035175	Internal Energy Absorbing Ring	T-079
E23035299	Helical Torquemeter Gearshaft Assembly	T-094
E23037403	PT Inner Shaft; Inspection and Rework of Power Turbine Inner Shafts	T-016; T-051
E23037413	PT Outer Shaft	T-015
E23037446	Rotating Labyrinth Seals	T-084
E23038136	Power Turbine Outer Shaft	T-042
E23038137	Power Turbine Inner Shaft; Inspection and Rework of Power Turbine Inner Shafts	T-039; T-051
E23038218	Uncoated 1 st Stage Turbine Nozzle Assembly	T-001
E23038218-247,-P	1 st Stage Turbine Nozzle Assembly	T-022
E23038218-738,-P	1 st Stage Turbine Nozzle Assembly	T-022
E23038218-C505	Coated 1 st Turbine Nozzle Assembly	T-013
E23038219-247,-P	1 st Stage Turbine Nozzle Assembly	T-022
E23038219-738,-P	1 st Stage Turbine Nozzle Assembly	T-022
E23051119	Diffuser	T-057
E23053330	Uncut 2 nd Stage Turbine Nozzle	T-026; T-071
E23054648	Energy Absorbing Rings	T-034
E23055438	Second Stage Turbine Nozzle	T-028
E23055438-UC	Un –cut Second Stage Turbine Nozzle	T-026
E23056108	Hastelloy X Combustion Liner Assembly	T-024
E23056633	Spur Adapter Gearshaft	T-031
E23056634	Spur Adapter Gearshaft	T-031
E23057111	Compressor Wheel	T-021; T-099
E23057112	Compressor Wheel	T-021; T-099
E23057114	Compressor Wheel	T-021; T-099
E23057115	Compressor Wheel	T-021; T-099
E23057116	Compressor Wheel	T-021; T-099
E23060429	Hastelloy X Combustion Liner Assembly	T-024
E23061212	Hastelloy X Combustion Liner Assembly	T-024
E23061213	Hastelloy X Combustion Liner Assembly	T-024
E23061216	Hastelloy X Combustion Liner Assembly	T-024
E23061922	4 th Stage Turbine Nozzle	T-048
E23062028-738	First Stage Turbine Nozzle	T-029
E23062029	Second Stage Turbine Nozzle	T-028

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Part Number	Nomenclature	Service Document
E23062061	First Stage Turbine Nozzle	T-070
E23062750	1 st Stage Turbine Nozzle Shield Assembly	T-004
E23062752	First Stage Nozzle Shield Assembly	T-030
E23062753	1 st Stage Nozzle	T-022; T-066
E23062754	1 st Stage Nozzle	T-022; T-066
E23064637-2P	Two Piece Diffuser	T-068
E23066675	Combustion Liner	T-041
E23068295	Helical Power Take-Off Gear	T-086
E23071309	PT Inner Shaft	T-016
E23071313	Power Turbine Inner Shaft	T-039
E23072654	2 nd Stage Turbine Nozzle Assembly	T-067
E23072654-UC	2 nd Stage Turbine Nozzle Assembly	T-012; T-067
E23073520	Spur Adapter Gearshaft Assembly	T-031
E23073521	Spur Adapter Gearshaft	T-031
E23073533	1 st Stage Turbine Nozzle Shield Assembly	T-004
E23073566	First Stage Nozzle Shield Assembly	T-030
E23075442	Helical Torquemeter Gearshaft Assembly	T-094; T-100
E6808392	Spanner Nut	T-017
E6829641	Spanner Nut	T-017
E6840406	Spanner Nut	T-017
E6840407	Spanner Nut	T-017
E6851531	4 th Stage Nozzle Assembly	T-048
E6870832	Turbine To Pinion Gear Coupling	T-003
E6871259	Compressor Tie Bolt	T-007
E6871902	Compressor Front Bearing Oil Seal Mating Ring	T-018
E6875628	Hastelloy X Combustion Liner Assembly	T-024
E6876878	Spanner Nut	T-017
E6877736-1,-2	Stationary Labyrinth Seal	T-014
E6878426	2 nd Stage Turbine Nozzle Assembly	T-009; T-049
E6878426-C	Second Stage Turbine Nozzle Assembly	T-009
E6878426-UC	Second Stage Turbine Nozzle Assembly	T-012
E6878498	Second Stage Nozzle Assembly	T-082
E6887619	Compressor Front Bearing Oil Seal	T-018
E6887761	Thermocouple Harness	T-008
E6888529	Starter Generator Gearshaft	T-050
E6888547	Power Turbine Support Oil Sump Cover	T-023
E6888547-UC	Un-Cut Power Turbine Support Oil Sump Cover	T-045
E6890040	1 st Stage Turbine Nozzle Shield Assembly	T-004; T-044
E6892828	1 st Stage Turbine Nozzle Shield Assembly	T-030
E6893614	Spanner Nut	T-017
E6893673	Torquemeter Gear	T-076
E6895005	Bearing Retaining Plates	T-019
E6896098	Labyrinth Seal	T-035
E6896408	Spline Lock Nut	T-036
E6898561	Compressor Coupling Adapter	T-010
E6898764	Oil Bellows Seal	T-020

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P/N(s): Various – See Tables

Revision: C Issued: 2/04/16

Part Number	Nomenclature	Service Document
E6898784	Turbine Splined Adapter	T-037
E6898785	Rework of Helical PTO Gearshaft; Power Take Off (PTO) Gear	T-053; T-075
E6898945	Gas Producer Oil Cover Assembly	T-043
E6898977	Turbine to Compressor Coupling	T-002; T-062
E6899081	Combustion Liner	T-041; T-046
E6899239	Spur Adapter Gearshaft Assembly	T-011
EH23005271-1;-2; -3	Compressor Coupling Adapter	T-032
EH23030974	Turbine Splined Adapter	T-033
EH23037413	PT Outer Shaft	T-015
EH6898561	Compressor Coupling Adapter	T-010
EH6898784	Turbine Splined Adapter	T-037