

## T-079 Inspection Limits and Repair

### Internal Energy Absorbing Ring

**Engine Application(s):** 250-C20B, C20F, C20J, C20S, B17B, B17C, B17D, B17E

**Subject:** Inspection and Rework Procedure for the E23035175, 23035175AL Internal Energy Absorbing Ring.

**Compliance:** Any time the Internal Energy Absorbing Ring is removed for overhaul. Refer to the Figure and Table for Inspection and Rework Limits.

Table 1: Inspection and Rework Limits  
Figure 1: Dimensional Inspection Limits.

**Notes:** Refer to OEM's published data for installation, engine operation and disassembly.

**Revisions:**

N/C	Dated: 7/08/03	Initial Release.
A	Dated: 5/10/07	AMS 5789 was AMS 5798.
B	Dated: 8/13/09	Updated EXTEX to TIMKEN.
C	Dated: 7/02/12	Added 23035175AL to document. Removed references to shaded area in Table 1. "0.015 inch" was "0.015" and "0.254 inch" was "0.254" in Table 1. Corrected Figure 1.
D	Dated: 2/05/16	Updated Timken to EXTEX Engineered Products.

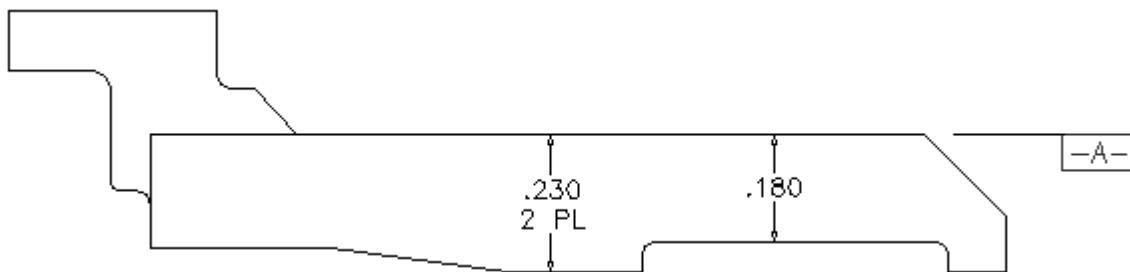
**T-079 Inspection Limits and Repair**

**E23035175/23035175AL Internal Energy Absorbing Ring  
Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
<b>Wear on OD</b>	Minimum thickness 0.180 inch or 0.230 inch as shown in Fig. 1.		Blend smooth up to 0.005 inch deep. Blend out sharp edges only, do not blend if wear pattern is smooth.
<b>Wear on end surface</b>	Blend smooth in indicated end face area up to 0.030 inch deep.		All blending must be smooth and well contoured and limited to areas of fretting wear. There shall be no sharp edges, burrs, cracks or nicks remaining in blending areas.
<b>Wear on ID</b>	Blend smooth in indicated ID area up to 0.015 inch deep. Do not exceed minimum wall thickness.		All blending must be smooth and well contoured and limited to areas of fretting wear. There shall be no sharp edges, burrs, cracks or nicks remaining in blending areas.
<b>Wear on TANGS</b>	Maximum movement of absorbing ring when installed in GP Support is 0.015 inch Max.	0.254 inch Minimum tang width after machining maybe weld repaired.	Weld per AMS 2685 using AMS 5789 or AMS 5837 weld wire. Stress relieve after welding at 1000 °F for 1 hr. Machine to restore tang dimensions per Figure 2.

**TABLE 1**

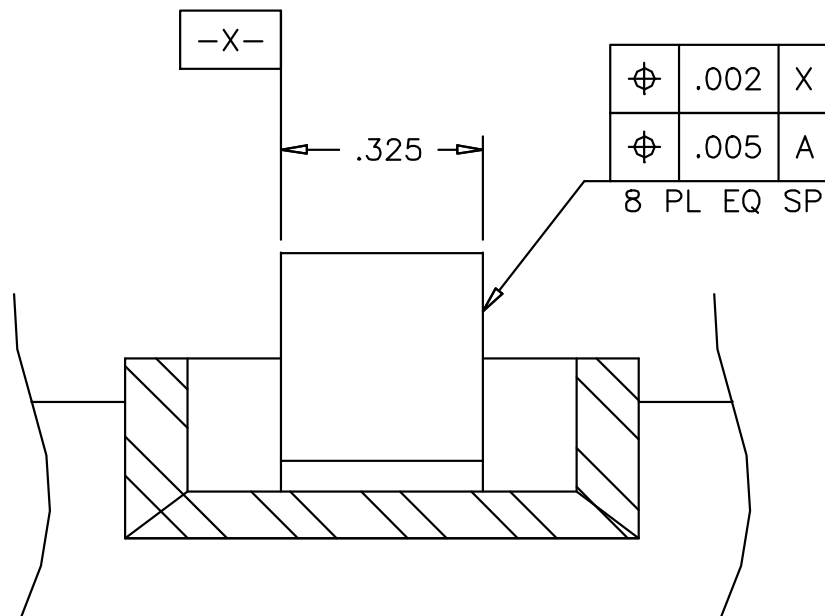
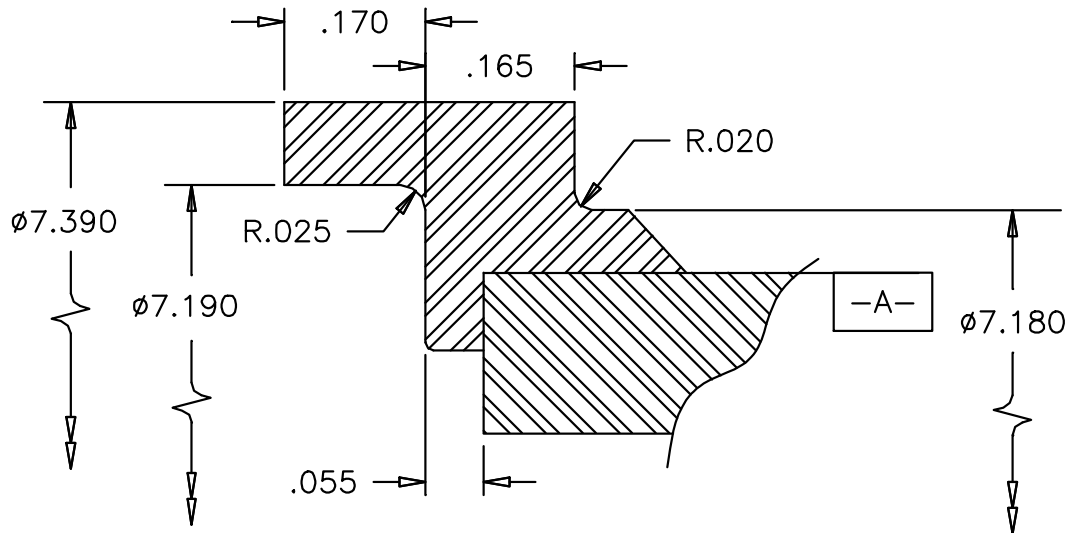
**E23035175/23035175AL  
Internal Energy Absorbing Ring**



**Figure 1**

DIMENSIONS ARE IN INCHES

**T-079 Inspection Limits and Repair**



**Figure 2**