

T-084 Inspection Limits and Repair

Rotating Labyrinth Seals No. 9-12 & 13-18

Engine Application(s):	250-C30, C30L, C30M, C30P, C30S 250-C30R, C30U, C30G 250-C30G/2, C30R/1 250-C40B 250-C47B, C47M
Subject:	Inspection and Rework Procedure for Rotating Labyrinth Seal: E23037446.
Compliance:	Any time the Labyrinth Seal is removed. Refer to the Table for Inspection and Rework Limits.
Notes:	Refer to OEM's published data for installation, engine operation and disassembly.
Revisions:	N/C Dated: 2/15/05 Initial release. A Dated: 8/12/09 Updated EXTEX to TIMKEN. B Dated: 2/05/16 Updated Timken to EXTEX Engineered Products.

Rotating Labyrinth Seal

Condition	Service Limit	Repair Limit	Corrective Action
Cracks (MPI)	None.		Replace.
Nicks or gouges	None.		Repair or replace.

Seal No.	Minimum After Metal Removal	Acceptable Rework
9-12	2.712 in Dia.	All seal knives must meet the desired clearance.
13-18	2.206 in Dia.	All seal knives must meet the desired clearance.

NOTES:

- * Maintain .001 in. FIR concentricity about center axis of wheel blade tip or seal knife edge features if reworked.
- ** Remove burrs on wheel blade tip or seal knife edge but do not break sharp edges if reworked.

TABLE 1