

**T-094 Inspection Limits and Repair**

Revision: C

Issued: 2/08/16

<b>Engine Application(s):</b>	250-B17, B17B, B17C, B17D, B17E, B17F, B17F/1, B17F/2, C20, C20B, C20C, C20F, C20R, C20R/1, C20R/2, C20S		
<b>Compliance:</b>	Any time the helical torque meter gearshaft is removed. Refer to Table 1 and Figure 1 as applicable for Inspection and Rework Limits.		
<b>Notes:</b>	Refer to OEM's published data for installation, engine operation and disassembly.		
<b>Revisions:</b>	N/C	5/31/06	Initial Release.
	A	8/07/09	Updated EXTEX to TIMKEN.
	B	5/08/12	Added Timken part number 23035299AL
	C	2/08/16	Updated Timken to EXTEX Engineered Products.

**E23035299 / E23075442 / E23035299AL**  
**Helical Torque Meter Gearshaft Assembly**  
**Inspection Limits and Repair**

Condition	Service Limit	Repair Limit	Corrective Action
Wear limits and dimensional inspection	Slight normal wear with all mating parts in good condition. Check for compliance with Figure 1.	No Repair.	Remove sharp edges by stoning. Install new or serviceable Gearshaft Assembly if Service Limits are exceeded or if there is evidence of healed prior scuffing.
Spalling (Use 2X Magnification)	Very light spalling as witnessed by matte worn area over a maximum of 35% of tooth area.	No Repair.	Remove sharp edges by stoning.
Scuffing	Scuffing when accompanied by wearoff of metal pickup if gear assembly is still matched with mating gears.	No Repair.	Remove sharp edges by stoning.
Cracks In Radii Root Corners Of Spline Teeth Or In Line Or Parallel In Close Proximity On Involute Of A Gear Toothside (Visual With Magnification).	None.	No Repair.	Replace.
Nicks And Dents	Max. of 0.010 inch length, width, or dia. And without sharp corners.	Max. of 0.060" length, width, or dia. After sharp corners are removed.	Remove sharp edges by stoning.
Tooth Damage Which Involves Metal Displacement To The Degree That Subsurface Damage Is Detected By MPI.	None.	No Repair.	Replace.

**Table 1**

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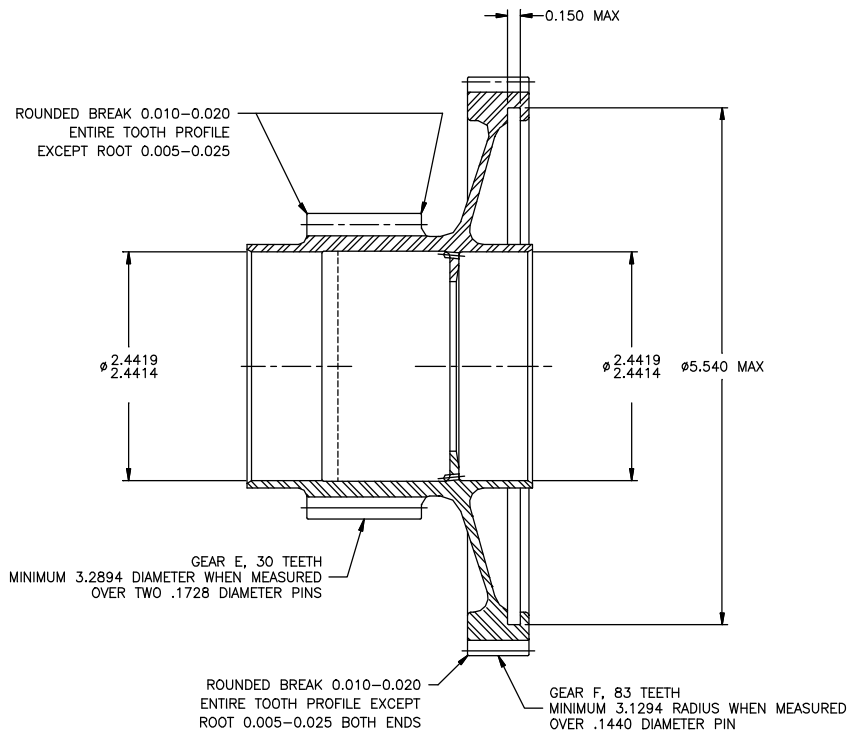
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**NOTES:**

MPI technique as follows:

- A) Circular between heads  
AND
- B) Longitudinal in a coil

No cracks allowed.



**Dimensions Are In Inches**  
**FIGURE 1**