

Inspection Limits & Repair T-010

Compressor Adapter Coupling

Engine Application(s):	A250-C20, C20B, C20F, C20J, C20S, C20W		
Compliance:	Any time the Compressor Adapter Coupling is removed for overhaul. Refer to the Table 1 and Figure 1 for Inspection and Rework Limits.		
	Table 1: Inspection and Rework Limits Figure 1: Dimensional Inspection Limits for A6898561/E6898561/EH6898561 Figure 2: Dimensional Inspection Limits for A23039791/E23039791/E23039791-1, -2, -3 EH23039791-1, -2, -3		
Notes:	Replaces Service Letter T94-013 issued by Superior Turbine on June 13, 1994. Refer to OEM's published data for installation, engine operation and disassembly.		
Revisions:	Rev. N/C	1/30/97	Original issue.
	Rev. A	1/14/99	Updated format, added P/N A23039791/E23039791/E23039791-1, -2, -3, EH23039791-1,-2,-3
	Rev. B	1/20/01	Added P/N EH6898561.
	Rev. C	8/21/03	ECO# 1361: REVISE PAGE 4 FRETTING INSPECTION NOTE.
	Rev. D	2/02/16	Revised to EXTEX Engineered Products.

**A23039791/E23039791
A6898561/E6898561/EH6898561
E23039791-1, -2, -3/EH23039791-1,-2,-3
Compressor Adapter Coupling
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): 0.8994 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, 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.	No Repair.	Install new or serviceable Coupling Adapter if Service Limit is exceeded.

REPAIR

P/N(s): **A23039791, E23039791
 A6898561, E6898561
 E23039791-1, -2, -3
 EH23039791-1,-2,-3
 EH6898561**

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	** See Note Below. Maximum between pin diameter (measured in two places): 0.6762 inch between 0.054 inch pins.		
Localized Galling of Splines	Galling is not acceptable.	Maximum depth: 0.005 inch. Any length.	Remove buildup or sharp edges with Arkansas stone.

- * MPI technique as follows: A) Circular between heads
 AND
 B) Longitudinal in a coil
- ** Use of OEM NO-GO gauge, 23060750, is permitted in lieu of over pin measurement.

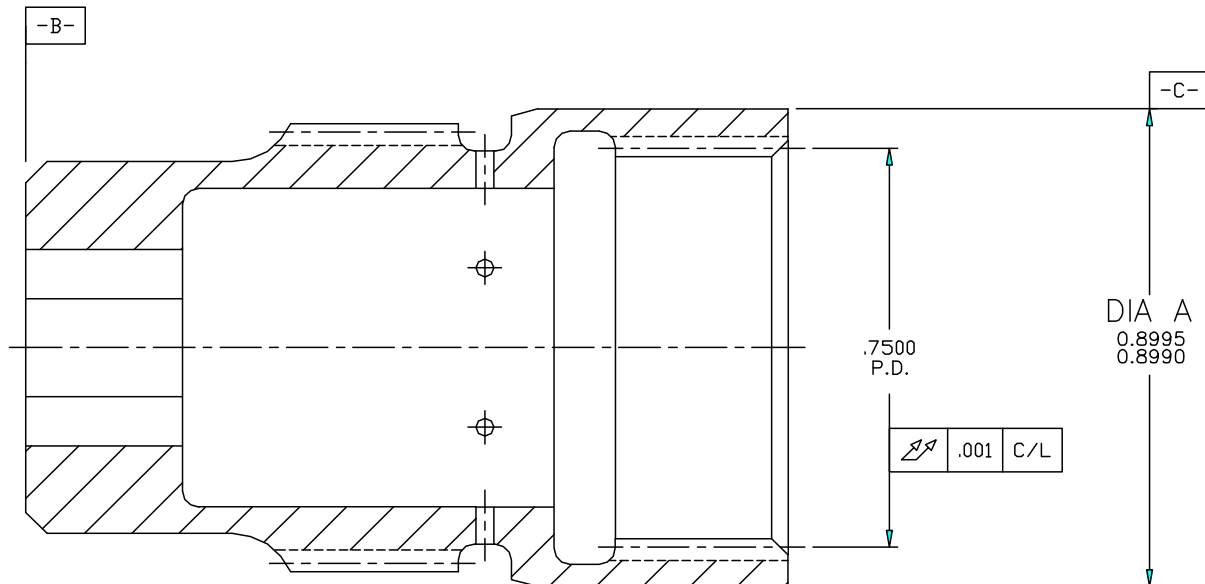
TABLE 1

Inspection Limits & Repair T-010

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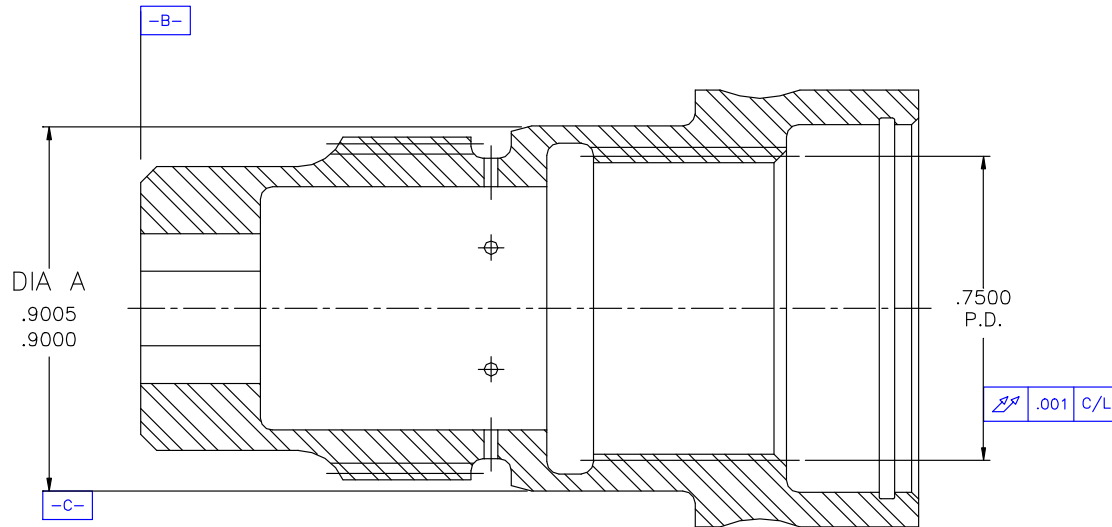
A6898561/E6898561/EH6898561 Compressor Adapter Coupling Dimensional Inspection



- CENTERLINE -CL- IS DEFINED BY SURFACES -B- AND -C-.
- IF UNACCEPTABLE WEAR IS FOUND ON COUPLING ADAPTER OR SPUR ADAPTER GEARSHAFT, REPLACE BOTH PARTS AS A SET.
- WHEN THE COUPLING ADAPTER IS REPLACED DUE TO SPLINE WEAR, THE ROTOR DOES NOT REQUIRE REBALANCING. PD RUNOUT CHECK MUST BE PERFORMED.
- DIMENSIONS ARE IN INCHES.
- INSPECT THE OD FOR FRETTING.
- IF ANY FRETTING IS FOUND, REPLACE THE ADAPTOR AND SEND THE FRETTED ADAPTER TO EXTEX, Ltd. FOR EVALUATION.
- MEASURE (2 PLACES, 90° APART) AND RECORD DIAMETER. ENSURE THAT WHEN ADAPTER IS ASSEMBLED INTO IMPELLER WITH NO.2 BEARING REMOVED, THE RESULTING FIT IS .000 TO .0015 TIGHT.

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FIGURE 1
A23039791/E23039791
E23039791-1, -2, -3/EH23039791-1,-2,-3
Compressor Adapter Coupling Dimensional Inspection



DIA A

P/N	DIA
A23039791	.9000-.9005
E23039791	.9000-.9005
E23039791-1	.9000-.9005
E23039791-2	.9020-.9025
E23039791-3	.9040-.9045
EH23039791-1	.9000-.9005
EH23039791-2	.9020-.9025
EH23039791-3	.9040-.9045

- CENTERLINE -CL- IS DEFINED BY SURFACES -B- AND -C-.
- IF UNACCEPTABLE WEAR IS FOUND ON COUPLING ADAPTER OR SPUR ADAPTER GEARSHAFT, REPLACE BOTH PARTS AS A SET.
- WHEN THE COUPLING ADAPTER IS REPLACED DUE TO SPLINE WEAR, THE ROTOR DOES NOT REQUIRE REBALANCING. PD RUNOUT CHECK MUST BE PERFORMED.
- DIMENSIONS ARE IN INCHES.
- INSPECT THE OD FOR FRETTING. IF ANY FRETTING IS FOUND, REPLACE THE ADAPTER AND SEND THE FRETTED ADAPTER TO EXTEX, Ltd. FOR EVALUATION.

REPAIR

P/N(s): A23039791, E23039791
A6898561, E6898561
E23039791-1, -2, -3
EH23039791-1,-2,-3
EH6898561

Revision: D

Issued: 2/02/16

Inspection Limits & Repair T-010

- MEASURE (2 PLACES, 90° APART) AND RECORD DIAMETER. ENSURE THAT WHEN ADAPTER IS ASSEMBLED INTO IMPELLER WITH NO.2 BEARING REMOVED, THE RESULTING FIT IS .000 TO .0015 TIGHT.

FIGURE 2