

**P/N(s):** A23031938-UC,  
E23031938-UC,  
E6878426-UC, &  
E23072654-UC

**SERVICE BULLETIN T-012**

Revision: F

Issued: 2/02/16

**Un-Cut 2<sup>nd</sup> Stage Turbine Nozzle Assembly**

<b>Engine Application(s):</b>	250-B17F, B17F/1, B17F/2 250-C20, C20B, C20F, C20J, C20S, C20W 250-C20R, C20R/1, C20R/2, C20R/4, C20R/1(RS), C20R(ST), C20R/2(SP)
<b>Subject:</b>	Installation Procedure for the A23031938-UC, E23031938-UC, E6878426-UC & E23072654-UC 2 <sup>nd</sup> Stage Turbine Nozzle Assembly.
<b>Compliance:</b>	<p>The A23031938-UC, E23031938-UC, E6878426-UC &amp; E23072654-UC nozzles are manufactured with additional machining stock remaining on the 1<sup>st</sup> and 2<sup>nd</sup> turbine wheel blade path diameters. This allows the overhaul facility to custom machine the nozzle for specific turbine wheels to optimize performance.</p> <p>Before installation of the nozzle assembly, machine the blade paths, per approved procedures, to allow the desired radial blade tip clearance.</p> <p>Re-identify the part as 'A23031938', 'E23031938', "E23072654", or 'E6878426' by removing the '-UC' from the part number marking. If the '-UC' is ink stamped, remove with MEK. If '-UC' is permanently marked, remove by vibro-peening an "X" over the '-UC'.</p> <p>Inspect Nozzle at time of O/H using Inspection Limits and Repair T-009.</p>
<b>Notes:</b>	Replaces Service Letter T94-021 issued by Superior Turbine on September 26, 1994. Refer to the OEM's published data for installation, engine operation and disassembly.
<b>Revisions:</b>	N/C Dated: 01/30/97 Initial Release. A Dated: 12/01/97 Updated format. Added P/N E6878426. B Dated: 01/23/01 Updated format. C Dated: 07/26/02 Added P/N E23072654-UC. D Dated: 07/06/06 Changed ".010" to "additional". E Dated: 09/09/09 Updated EXTEX to TIMKEN. F Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.