

**T-034 Inspection Limits and Repair**

**Energy Absorbing Rings**

<b>Engine Application(s):</b>	250-C28B, C28C 250-C30, C30G, C30G/2, C30M, C30P, C30S
<b>Subject:</b>	Inspection and Rework Procedure for the E23032263 and E23054648 Energy Absorbing Rings.
<b>Compliance:</b>	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.
<b>Notes:</b>	Refer to OEM's published data for installation, engine operation and disassembly.
<b>Revisions:</b>	N/C Dated: 7/30/97 Initial release. A Dated: 1/26/01 Updated format. B Dated: 7/08/03 Added tang repair. C Dated: 5/14/07 AMS 5789 was AMS 5798. D Dated: 6/11/07 Added E23054648. E Dated: 9/04/09 Updated EXTEX to TIMKEN. F Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.

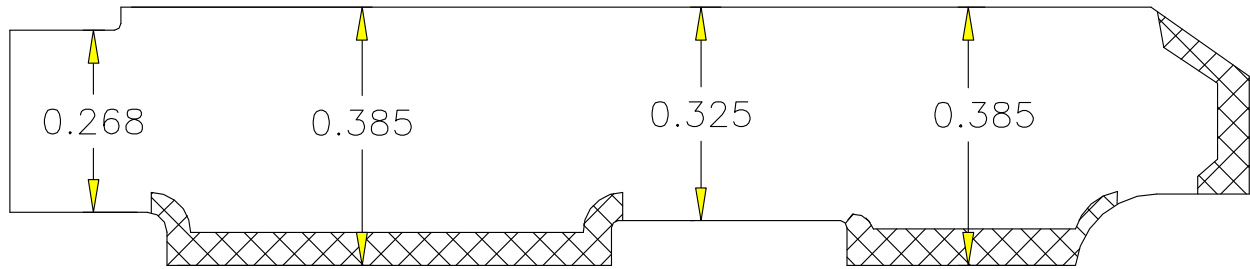
**E23032263 and E23054648 Energy Absorbing Rings  
Inspection and Rework Limits**

Condition	Service Limit	Repair Limit	Corrective Action
<b>Wear on OD</b>	Minimum thickness 0.268 inch or 0.385 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 (shaded areas on Fig. 1)</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 (shaded area on Fig. 1)</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 Max.	0.254 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**

**T-034 Inspection Limits and Repair**

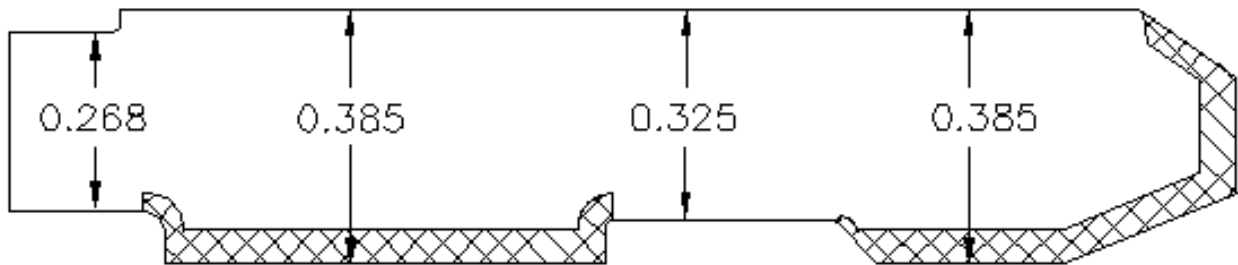
E23032263  
Energy Absorbing Ring



**Figure 1**

DIMENSIONS ARE IN INCHES

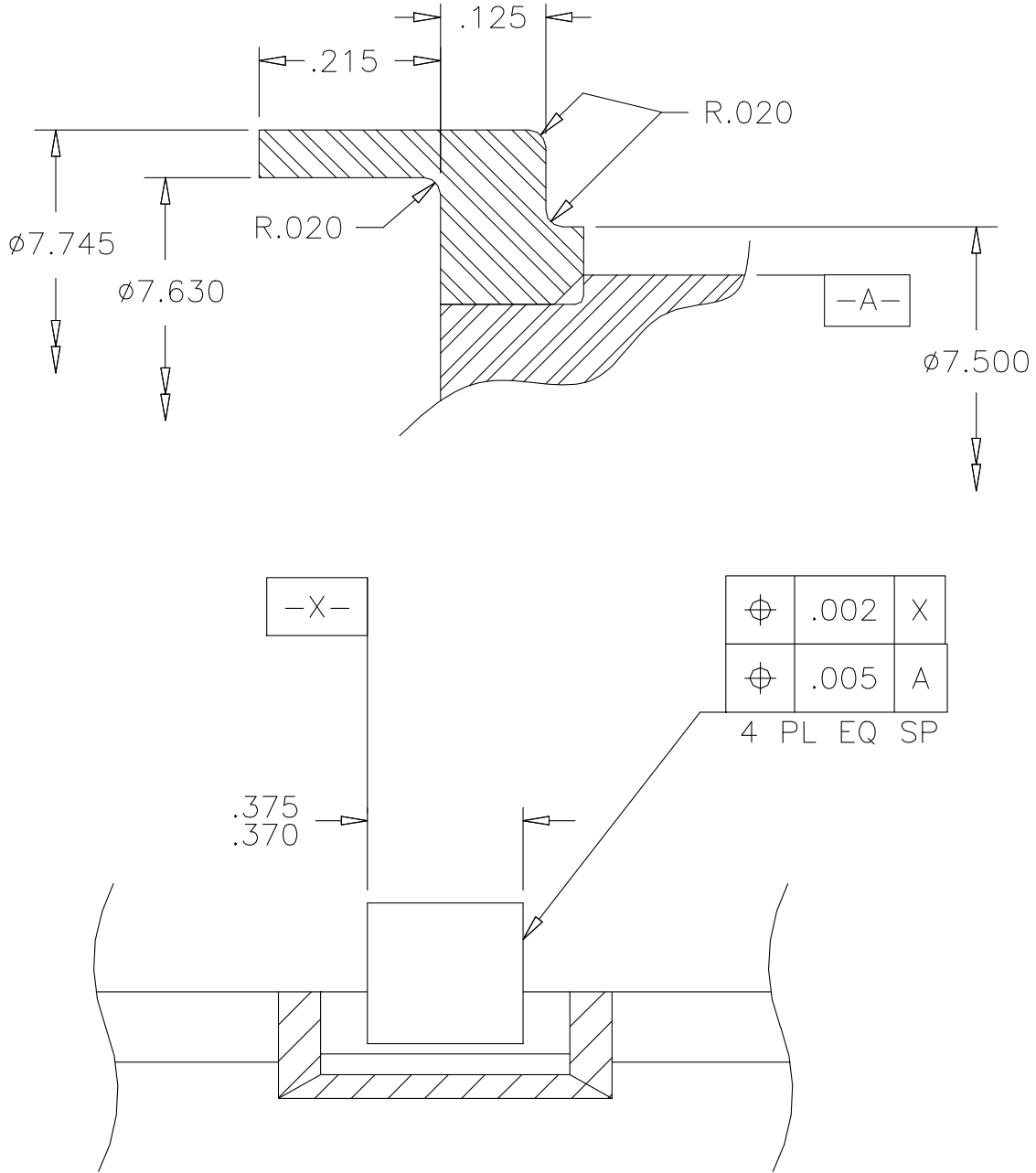
E23054648  
Energy Absorbing Ring



**Figure 1A**

ANGULAR DIMENSIONS: +/- 1 DEG.

**T-034 Inspection Limits and Repair**



**Figure 2**