

T-082 SERVICE BULLETIN

MODIFICATION

P/N(s): E6878498

Revision: C

Issued: 2/05/16

Rework of E6878498 2nd Stage Nozzle

Engine Application(s):	Allison 250-C20, C20B, C20F, C20J, C20S, B17B, B17C, B17D, B17E
Subject:	Second Stage Turbine Nozzles – Modify for Incorporation of an Internal Energy Absorbing Ring.
Compliance:	Customer option.
Revisions:	N/C Dated: 6/16/04 Original issue. A Dated: 6/22/04 Corrected typographical error in Figure 1. B Dated: 8/13/09 Updated EXTEX to TIMKEN. C Dated: 2/05/16 Updated Timken to EXTEX Engineered Products.

REASON:

Turbine Nozzle modification allows clearance for installation of an internal energy absorbing ring.

DESCRIPTION:

The second stage nozzle is modified to allow for installation of an internal energy absorbing ring. These instructions apply to parts modified in accordance with T-049 or Extex parts modified in accordance with CEB-1054.

APPROVAL:

Technical aspects are FAA Approved.

ACCOMPLISHMENT INSTRUCTIONS:

1. Rework Nozzle Assembly.
 - 1.1 No inspection or airflow adjustment is required when performing this work on a new nozzle. If nozzle has been in service, inspect per T-009.
 - 1.2 Machine a groove in the upstream (leading edge) face of the eight lugs on the outer band of the nozzle assembly (Ref. Fig. 1). (Ref. Dia. 7.070/7.060 inches and 6.545/6.535 inches).
 - 1.3 Machine the OD of the seal lip at the leading edge of the outer band to 6.525-6.515 inches.
 - 1.4 Obliterate old P/N E6878498 and re-identify as E23031938.

NOTE: These instructions are equivalent to OEM instructions in CEB-1253. Extex nozzles processed in accordance with CEB-1253 and marked per 1.4 meet the requirements of this document.

T-082 SERVICE BULLETIN

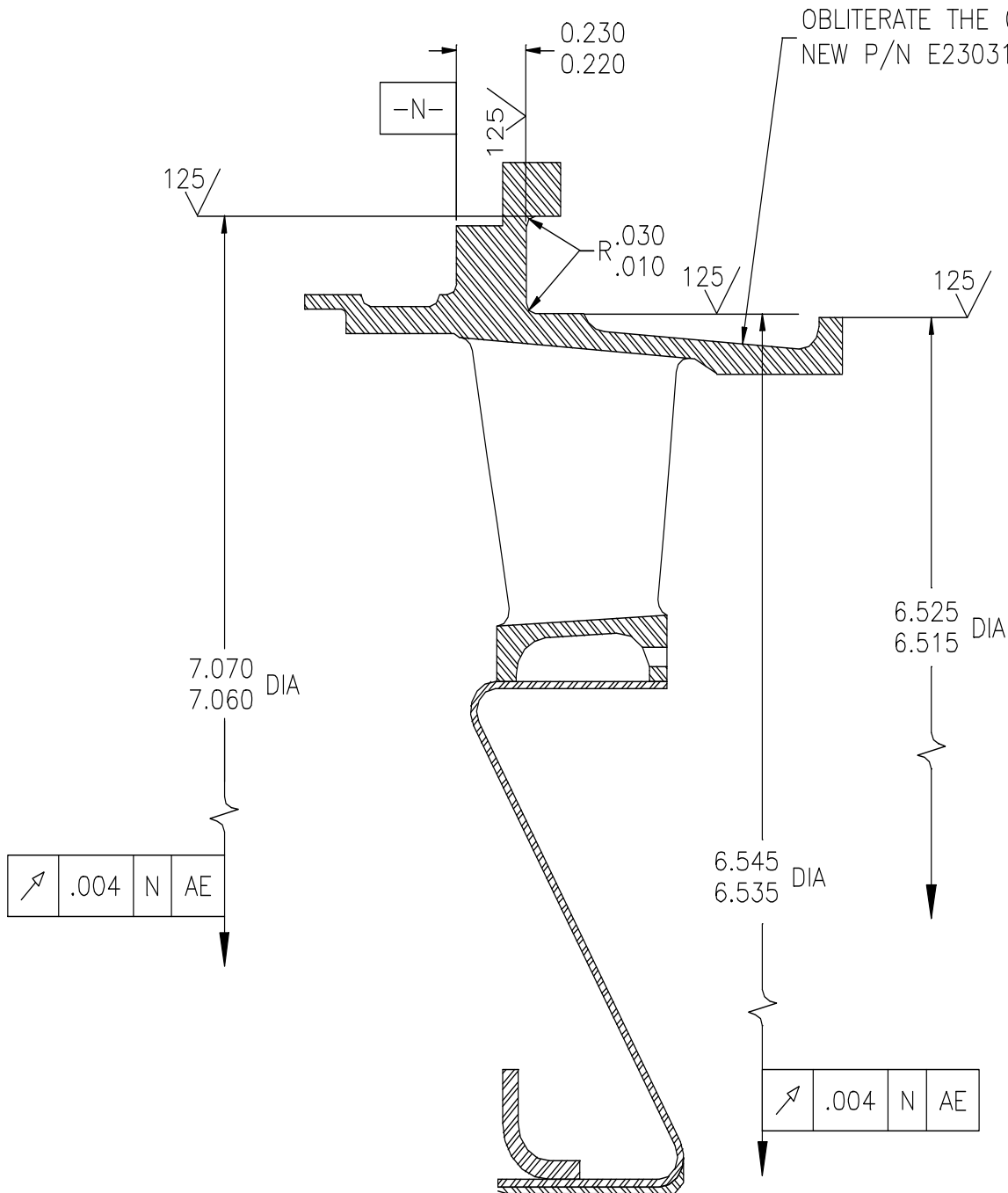
MODIFICATION

P/N(s): **E6878498**

Revision: **C**

Issued: **2/05/16**

OBLITERATE THE OLD P/N AND MARK
NEW P/N E23031938 PER AS478-2D1.



DATUM AE IS FORMED BY 8 EQUALLY SPACED TANGS.

FIGURE 1.