

T-083 Inspection Limits and Repair

Stationary/Rotating No. 5 Labyrinth Seals

Engine Application(s):	250-C28B, C28C 250-C30, C30L, C30M, C30P, C30S 250-C30R, C30R/3, C30U, C30G 250-C30G/2, C30R/1 250-C40B 250-C47B, C47M		
Subject:	Inspection and Rework Procedure for No. 5 Labyrinth Seals: E23032327 & E23032328.		
Compliance:	Any time the No. 5 Labyrinth Seal is removed. Refer to the Table for Inspection and Rework Limits.		
Notes:	Refer to OEM's published data for installation, engine operation and disassembly.		
Revisions:	N/C	Dated: 2/15/05	Initial Release.
	A	Dated: 8/13/09	Updated EXTEX to TIMKEN.
	B	Dated: 2/05/16	Updated Timken to EXTEX Engineered Products.

Stationary Labyrinth Seal – E23032327

Condition	Service Limit	Repair Limit	Corrective Action
Nicks, scratches, or damage to silver seal surface	Desired radial seal clearance with mating part	Damage to parent metal	Replace aluminum graphite in accordance with Figure 1.
Fit of seal in bore	.0005-.002 in. tight		Repair or replace.

Rotating Labyrinth Seal – E23032328

Condition	Service Limit	Repair Limit	Corrective Action
Cracks (MPI)	None.		Replace.
Nicks or gouges	None.		Repair or replace.

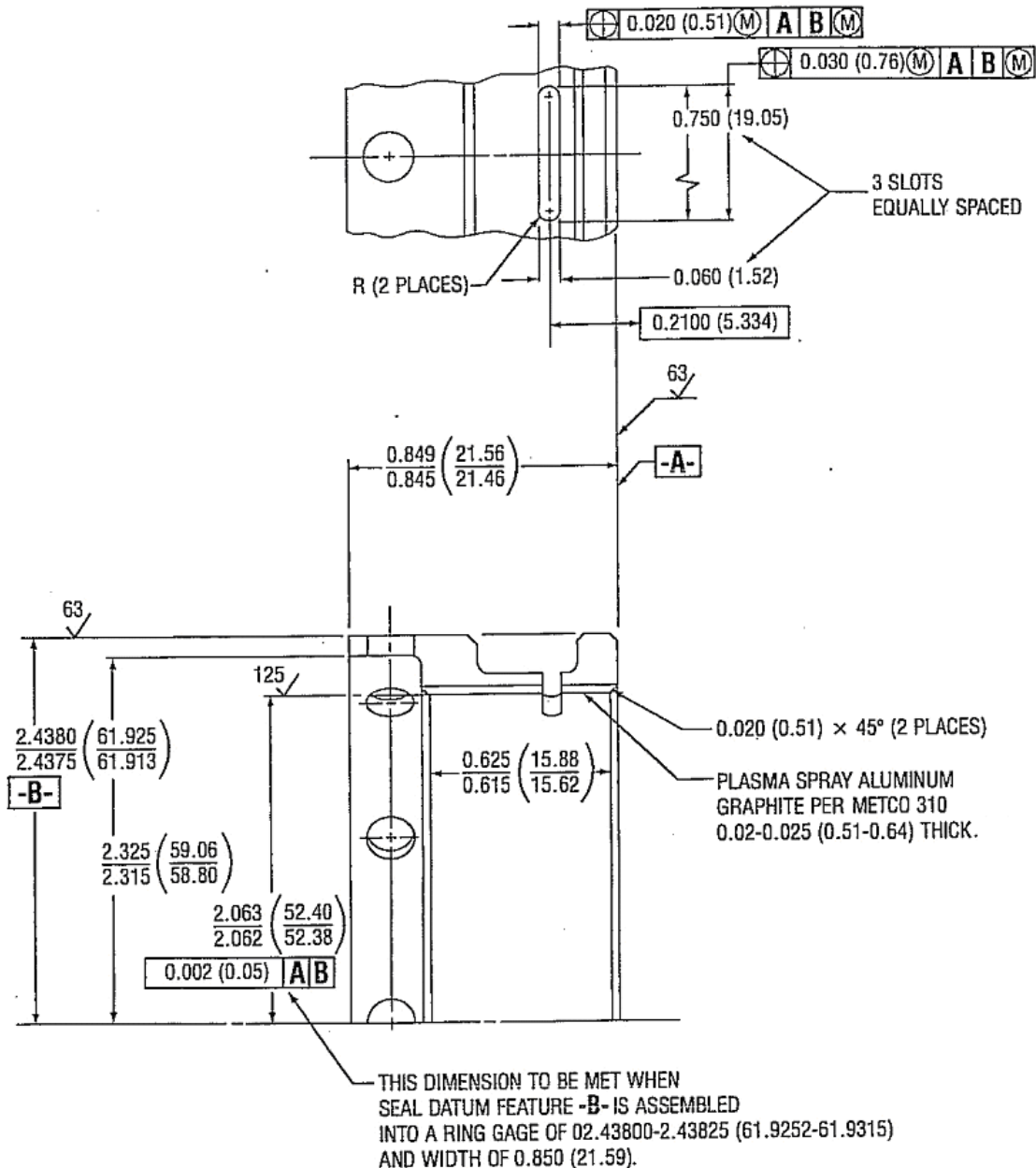
Seal No.	Minimum After Metal Removal	Acceptable Rework
NO. 5 Bearing	2.052 in Dia.	All seal knives must meet the desired clearance.

NOTES:

- * Maintain .001 in. FIR concentricity about center axis of wheel blade tip or seal knife edge features if reworked.
- ** Remove burrs on wheel blade tip or seal knife edge but do not break sharp edges if reworked.

TABLE 1

T-083 Inspection Limits and Repair



DIMENSIONS ARE IN INCHES (MILLIMETERS)

FIGURE 1