T-020 Inspection Limits and Repair

Oil Bellows Seal

Engine Application(s):		250-B15G 250-B17F, B17F/1, B17F/2 250-C18, C18A, C18B, C18C 250-C20, C20B, C20F, C20J, C20S, C20W 250-C20R, C20R/1, C20R/2, C20R/4 250-C28B, C28C 250-C30, C30G, C30M, C30P, C30S
Subject:		Inspection and Rework Procedures for A6898764 & E6898764 Oil Bellows Seal.
Compliance:		Any time the Oil Bellows Seal is removed from exhaust collector support. Refer to the Table for Inspection and Rework Limits.
Notes:		Replaces Service Letter T95-008 issued by Superior Turbine on June 14, 1995. Refer to OEM's published data for installation, engine operation and disassembly.
Revisions:	N/C	Dated: 01/30/97 Initial release.
	A	Dated: 12/03/97 Updated format.
	B	Dated: 01/26/01 Updated format.
	C	Dated: 09/09/09 Updated EXTEX to TIMKEN.
	D	Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.

A6898764/E6898764 Oil Bellows Seal
Inspection and Rework Limits

Condition	Service Limit	Repair Limit	Corrective Action
Chips, Nicks, Scratches, Gouges across carbon face	Leak check by following the 4-step procedure below. Leakage limits: 0.5 inch Hg (1.69 Kpa) maximum with 25 inch Hg (84 kPa) pressure differential (check for 15 seconds).	Not to exceed 0.010 inch in length. Edge of carbon face cannot be damaged.	Lap carbon seal face to a three helium light band finish and retest per procedure below **OR** Replace oil bellows seal.

Leak Check Procedure:

1. Lubricate the surface plate of vacuum tool with light-weight oil.
2. Seat the seal over the exhaust port of the vacuum tool.
3. Seat the vacuum tool over the seal and apply vacuum.

If carbon seal fails leak check, refer to repair procedure, and then repeat steps 1 thru 3.

Table