

T-030 Inspection Limits and Repair

1st Stage Turbine Nozzle Shield Assembly

Engine Application(s):	Allison 250-C30, C40, C47 Series
Subject:	Inspection and Rework Procedure for the E6892828, E23062752, & E23073566 1 st Stage Turbine Nozzle Shield Assembly.
Compliance:	Any time the Nozzle Shield is removed during overhaul. Refer to the following Table for Inspection and Rework Procedures. Table 1: Inspection and Rework Limits
Notes:	Refer to OEM's published data for installation, engine operation, and disassembly.
Revisions:	N/C Dated: 06/16/97 Initial release. A Dated: 11/13/00 Added P/N E23062752 and updated format. B Dated: 01/31/03 Added P/N E23073566. C Dated: 09/04/09 Updated EXTEX to TIMKEN. D Dated: 2/02/16 Updated Timken to EXTEX Engineered Products.

REASON:

To provide instructions for continued airworthiness

DESCRIPTION:

Instructions for continued airworthiness.

APPROVAL:

Technical aspects are FAA Approved

WEIGHT AND BALANCE:

Not Affected

PREREQUISITES:

None

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ACCOMPLISHMENT INSTRUCTIONS:

Inspect as follows:

Condition	Service Limit	Repair Limit	Corrective Action
Cracks, Visual and FPI*, around braze attach points on heat shield.	Crack(s) less than 50% of distance around spot weld are acceptable.	Crack(s) up to 100% of braze joint.	Re-braze or replace Assembly.
Cracks, Visual and FPI*, in areas other than braze attach points.	No cracks are acceptable.	Any amount.	Weld repair or replace cracked detail(s) or Assembly.
FPI* indications (line type) in braze area joining saddles to inner or outer band.	Line type indications in the braze are acceptable at the open end of the saddle up to 0.12 in. max length providing they are not in saddle or band material adjacent to the braze.	Line indications in braze only.	Replace Saddle(s) or replace assembly.
Saddle Wear (outer side)	Minimum distance across saddle 0.339 inch. AND Minimum lip thickness: 0.010 inch.	No repair.	Replace Saddle(s) or replace Assembly.

NOTES:

* FPI per approved Water Washable technique.

P/N's	MATERIAL	WELD	BRAZE ALLOY
E6892828	Hast X	Hast X or W	AMS 4783
E23062752	Haynes 230	Haynes230	BNi -10 or N99622 (UNS)
E23073566	Haynes 230	Haynes230	BNi -10 or N99622 (UNS)

TABLE 1

Parts meeting the above criteria are eligible for return to service.

MATERIAL INFORMATION:

N/A