

T-040 Inspection Limits and Repair

P.T. Oil Sump Cover

Engine Application(s):	250-C28B, C28C 250-C30, C30G, C30G/2, C30M, C30P, C30S
Subject:	Inspection and Rework Procedures for the E23034608 Power Turbine Support Oil Sump Cover.
Compliance:	At access during repair or overhaul.
Notes:	Refer to OEM's published data for installation, engine operation and disassembly.
Revisions:	N/C Dated: 9/21/97 Initial release. A Dated: 1/29/01 Updated format. B Dated: 9/03/09 Updated EXTEX to TIMKEN. C Dated: 2/03/16 Updated Timken to EXTEX Engineered Products.

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E23034608 Power Turbine Support Oil Sump Cover

I. Cleaning Method

Part	Cleaning Method	Remarks
PT Support Oil sump cover	Alkaline Liquid Bath	Per approved standard practices.

II. NDT Method

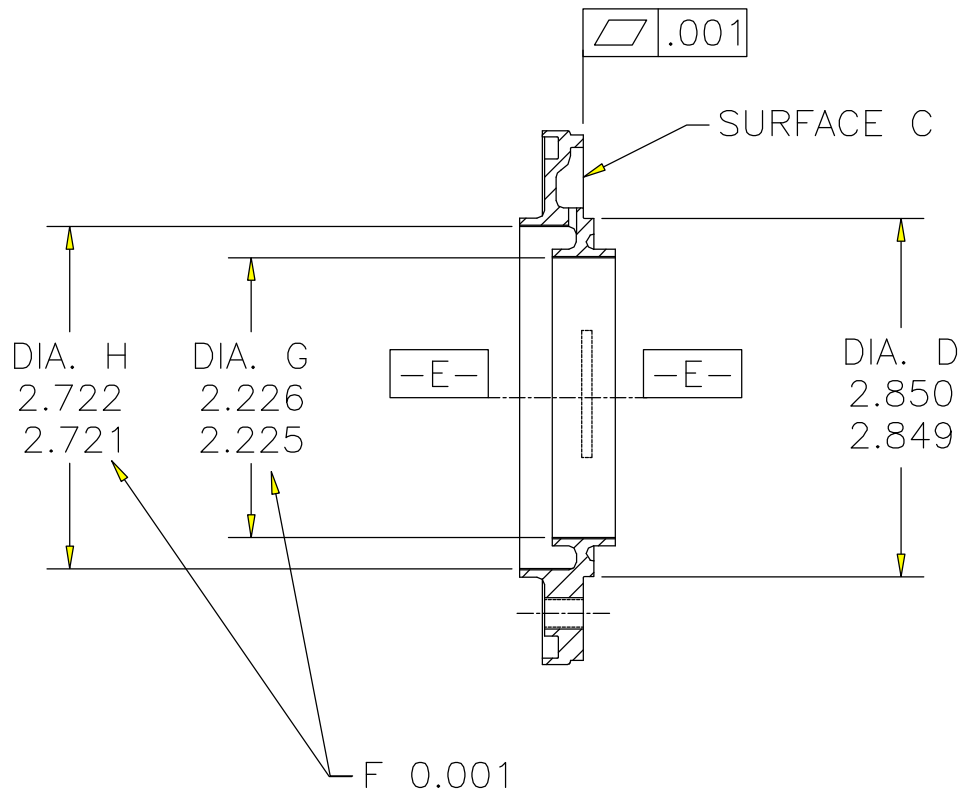
Part	Inspection Method	Remarks
PT Support Oil Sump cover	FPI	Per approved water-washable technique.

III. Inspection and Repair

Condition	Service Limit	Repair Limit	Corrective Action
Damage to abradable seal	Chipped coating that does not extend into hub groove. Desired radial seal clearance with mating part.	Dia. G 2.255 inch. Dia. H 2.775 inch.	Apply new seal. Finish per Fig. 1.
Abradable seal loose bond	N/A	N/A	Apply new seal.
Pilot dia.	2.8485	2.8285 inch before metalizing.	Metalize.

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**E23034608
Power Turbine Support - Oil Sump Cover
Abradable Seal Repair**



AXIS E-E ESTABLISHED BY DIA D AND SURFACE C.

*DIA G AND H CAN BE DIMENSIONED SMALLER THAN PRINT SIZE TO OBTAIN LABYRINTH SEAL DESIRED CLEARANCE.

FEATURES SHALL BE WITHIN THE TOTAL RUNOUT SPECIFIED BY F. ALL UNSPECIFIED DIA TO BE WITHIN 0.010 TOTAL RUNOUT.

COAT SURFACES OF DIAMETERS G AND H WITH 85-15 NICKEL GRAPHITE. NICKEL GRAPHITE TO BE 0.015-0.025 THICK AFTER MACHINING.

DIMENSIONS ARE IN INCHES.

FIGURE 1