

**T-089 Inspection Limits and Repair**

**#8 Bearing Stationary Labyrinth Seal**

**Engine Application(s):** 250-C30, C30D, C30G, C30G/2, C30L, C30M, C30R, C30R/1, C30R/3, C30S, C30U  
250-C40, C47B, C47M

**Subject:** Inspection and Rework Procedure for the E23031494 Stationary Labyrinth Seal.

**Compliance:** Any time the Stationary Labyrinth Seal is accessed or removed.  
Refer to Table 1 and Figure 1 for Inspection and Rework Procedures.

**Notes:** Refer to OEM's published data for installation, engine operation and disassembly.

**Revisions:** N/C Dated 5/13/05 Initial Release  
A Dated 8/12/09 Updated EXTEX to TIMKEN.  
B Dated: 2/05/16 Updated Timken to EXTEX Engineered Products.

**E23031494**

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Inspection and Rework Limits**

**TABLE 1**

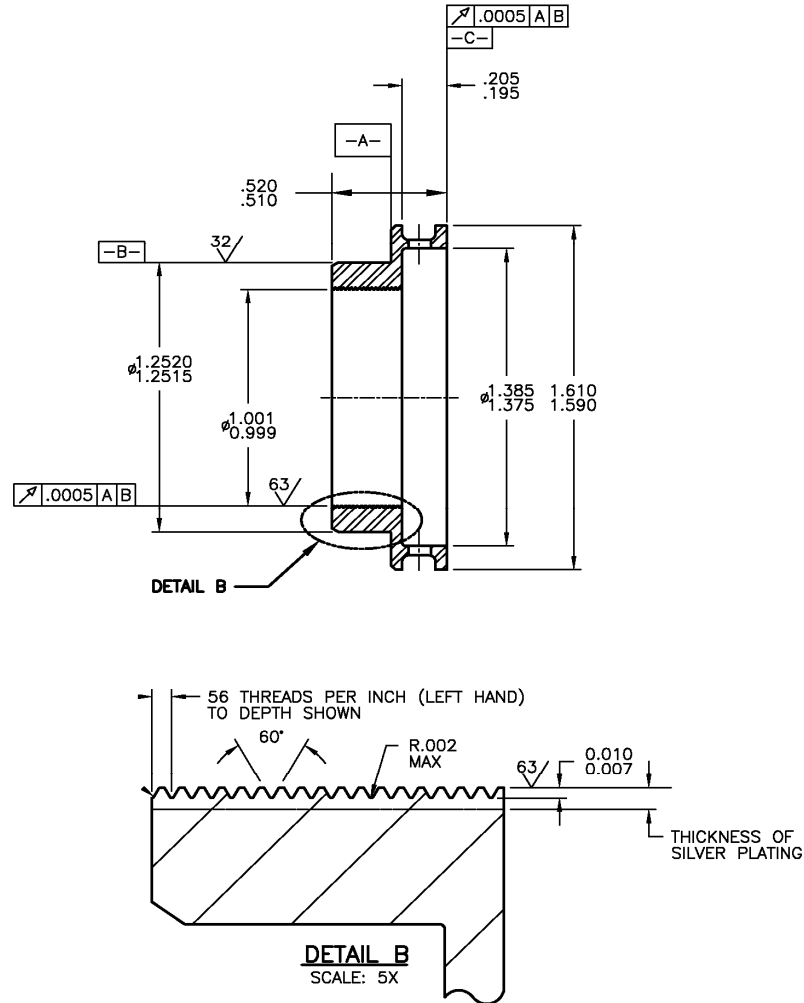
Condition	Service Limit	Repair Limit	Corrective Action
<b>Crack Indications, Visual and FPI*</b>	Cracks are not acceptable.	No Repair.	Replace Labyrinth Seal.
<b>Nicks, Scratches, or Damage to silver seal surface</b>	Desired radial clearance with Rotating Labyrinth Seal	Damage to Parent Metal	Replace Silver Coating on inner diameter in accordance with Fig. 1
<b>Fit of Seal in Bore</b>	.0005 to .002 inch. "tight fit"	Same as Service Limit	Repair bore or replace seal.

**NOTE:**

- FPI per ASTM E 1417 Method A.  
Acceptance per MIL-STD-1907, Grade B.

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- NICKEL PLATE SURFACE -C- PER AMS 2405 TO .0005-.0010 THICK. AFTER PLATE, BAKE AT 600°F +/- 10°F FOR 2 HOURS. OPTIONAL TO PLATE OTHER SURFACES.
- FINISH ALL OVER Ra 63 UOS (BEFORE PLATING)
- BREAK SHARP EDGES 0.010 IN.
- ALL DIMENSIONS TO BE MET AFTER PLATING.
- NICKEL STRIKE AND SILVER PLATE THIS DIA THIS DISTANCE PER AMS 2410. PLATING TO BE 0.015-0.025 IN. THICK AFTER MACHINING.
- DIMENSIONS ARE IN INCHES

**FIGURE 1**