

P/N(s): E23032335-UC,
E23055438-UC,
E23053330
E23064622

Revision: F Issued: 2/02/16

T-026 SERVICE BULLETIN

Un-Cut 2nd Stage Turbine Nozzle Assembly

Engine Application(s): 250-C30, C30G, C30G/2, C30L, C30M, C30P, C30R, C30S, C30U.
250-C40B, C47B, C47M

Subject: Installation Procedure for the E23032335-UC, E23055438-UC, E23053330 & E23064622 2nd Stage Turbine Nozzle Assembly.

Compliance: The E23032335-UC, E23055438-UC & E23053330 nozzles are manufactured with .010" machining stock remaining on the 1st and 2nd turbine wheel blade path diameters. This allows an overhaul facility to custom machine the nozzle for specific turbine wheels to optimize performance.

Before installation of the nozzle assembly, machine the blade paths, per approved procedures, to allow the desired radial blade tip clearances for the appropriate engine model being assembled.

For P/N E23032335-UC and E23055438-UC, re-identify the part as 'E23032335' & 'E23055438' by removing the '-UC' from the part number marking. If the '-UC' is ink stamped, remove with MEK. If '-UC' is permanently marked, remove by vibro-peening an "X" over the '-UC'.

For P/N E23053330, on C30, C40 & C47 series installations, re-identify the part as E23064622 per AS478-2D1 (vibropeen).

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

Revisions:

N/C	Dated: 01/30/97	Initial Release.
A	Dated: 08/08/97	Updated format.
B	Dated: 01/01/01	Added P/N E23055438-UC.
C	Dated: 11/10/03	Added P/N E23053330.
D	Dated: 09/08/09	Updated EXTEX to TIMKEN.
E	Dated: 03/17/10	(1) Added part number designations for re-identification of nozzles used in C30 and C40 & C47 engine models. (2) Added 250-C40B, C47B, C47M to engine applications. (3) Added wording to Compliance to ensure blade tip path clearances are appropriate for the engine model being assembled.
F	Dated: 2/02/16	Updated Timken to EXTEX Engineered Products.