

T-045 Inspection Limits and Repair

Subject:	Installation Procedure for the E6888547-UC Power Turbine Support Oil Sump Cover Assembly.
EEP Part Numbers:	E6888547-UC
Installations:	Rolls-Royce (250-B17, B17B, B17C, B17D, B17E; C18, C18A, C18B, C18C; C20, C20B, C20F, C20J, C20R, C20R/1, C20R/2, C20R/4, C20S, C20W)
Revision History:	N/C Dated: 06/22/98 Original Issue. A Dated: 09/03/09 Updated EXTEX to TIMKEN. B Dated: 10/30/13 Added instructions to update the part marking revision letter. Updated format. C Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.
Reason:	To provide Supplemental Instruction for Continued Airworthiness (ICA)
Description:	The E6888547-UC Oil Sump Cover Assemblies are manufactured with .015" machining stock remaining on the abradable seal diameters. This allows the overhaul facility to custom machine the cover for specific labyrinth seals to optimize performance. Refer to Type Certificate Holder's published data for installation, engine operation, and disassembly.
Applicability:	E6888547-UC
Accomplishment Instructions:	See 'Installation Procedures' below.
Approval:	This document is FAA approved.
Notes:	Refer to Type Certificate Holder's published data for assembly, disassembly, and engine operation. Please contact your EEP representative with any questions.

Installation Procedures

Accomplishment: Before installation of the Power Turbine Support Oil Sump Cover Assembly, machine the seal surfaces to allow the desired rotating lab seal clearances. Cover Assy is shown in Figure 1. Dimensions of seal surfaces are not to exceed the following:

Largest Allowable Dimensions	
Diameter F	Diameter G
2.724	2.226

Part Marking: Re-identify the part as 'E6888547' by removing the '-UC' and revision letter from the part number marking. If the '-UC' and/or revision letter is ink stamped, remove with MEK. If '-UC' and/or revision letter is permanently marked, remove by vibro-peening an "X" over the '-UC' and over the revision letter. Vibro-peen the current E6888547 revision letter adjacent to the removed revision letter.

At time of overhaul, inspect cover using Inspection Limits & Repair T-023.

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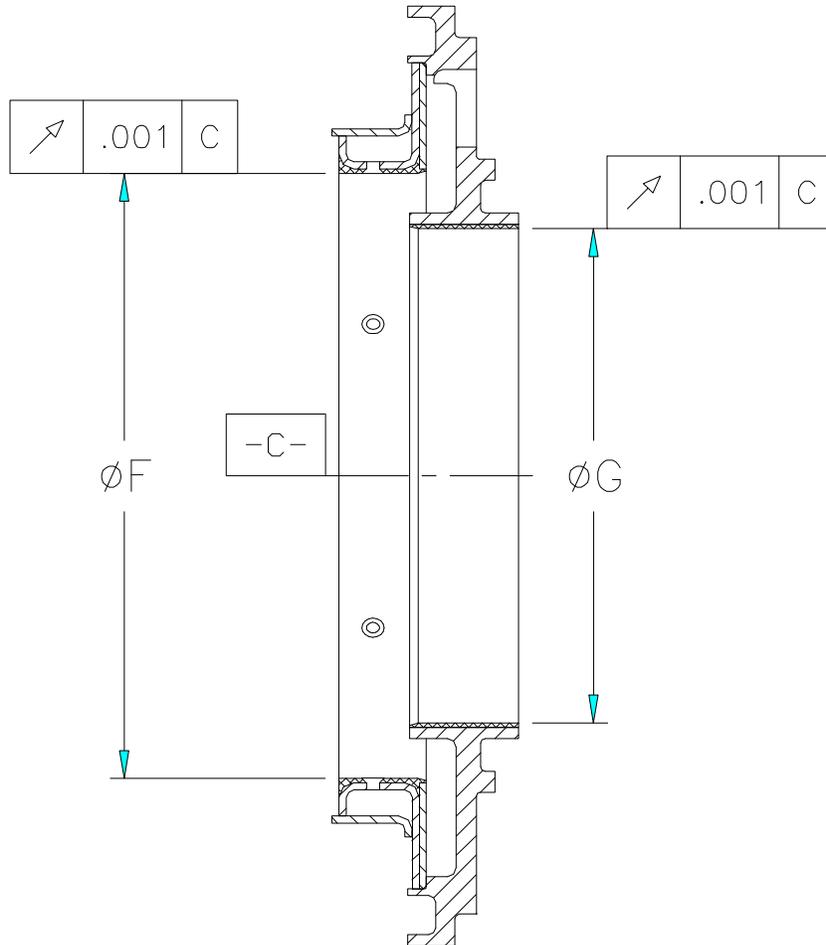


FIGURE 1