

## T-046 SERVICE BULLETIN

### Rework of E6899081 Combustion Liner for C28 Installation

<b>Engine Application(s):</b>	Allison 250-C28B, C28C
<b>Subject:</b>	Rework procedures for E6899081 Combustion Liner to improve part durability and improved burner outlet temperature in Series III applications only.
<b>Compliance:</b>	Customer option.
<b>Revisions:</b>	N/C Dated: 9/18/98 Original issue. A Dated: 1/07/99 Page 2: .63 was .600. Page 3: Added "Dilution Chamber" to Figure 2 and 1.95±.06 was 1.50±.06. B Dated: 9/03/09 Updated EXTEX to TIMKEN. C Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.

#### REASON:

To provide additional cooling of the -10 detail and to improve the burner outlet temperature.

#### DESCRIPTION:

This rework procedure describes the following:

1. Addition of 120 holes, 0.125" diameter, to the -17 detail for improved cooling of the -10 detail.
2. Modification of size and location of dilution trimmer holes for improved burner outlet temperature.
3. Re-identification requirements.

#### APPROVAL:

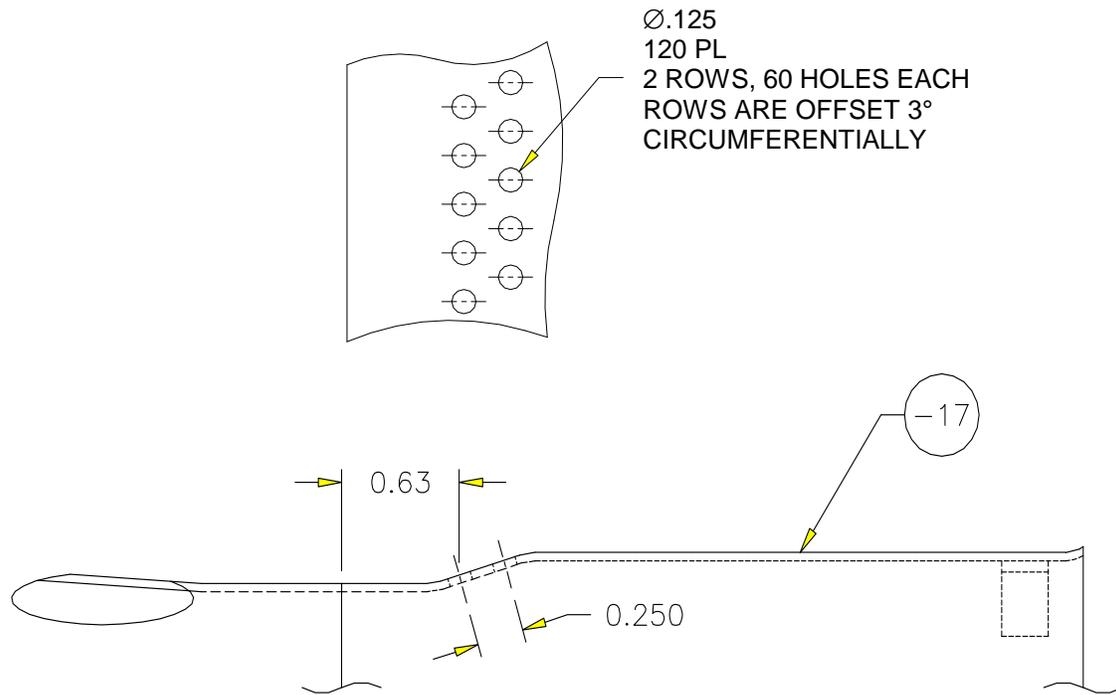
Technical aspects are FAA Approved.

#### ACCOMPLISHMENT INSTRUCTIONS:

1. Rework Combustion Liner Assembly, P/N E6899081.
  - 1.1 If part is new, no inspection is required. If the part has been in service, inspect and repair as necessary per ILR T-041 prior to modification.
  - 1.2 Add 120 holes, 0.125" diameter, located as shown in Figure 1.
    - 1.2.1 Any suitable method may be used to add the holes provided deformation of the -17 detail is kept to a minimum and the -10 detail is not punctured or otherwise damaged.
  - 1.3 Fabricate seven 0.250" diameter disks, 0.038 - 0.046" thick using AMS 5536.
    - 1.3.1 Use the disks to plug the holes as shown in Figure 2. GTAW Class II plugs in place all around per MIL-STD-2219 using AMS 5786 or AMS 5798 weld rod. Grind excess weld flush on both sides. Maximum reduction of parent material thickness after grinding: 0.005".
    - 1.3.2 Enlarge the three holes from 0.245 - 0.255" to 0.310 - 0.319" diameter as shown in Figure 2.

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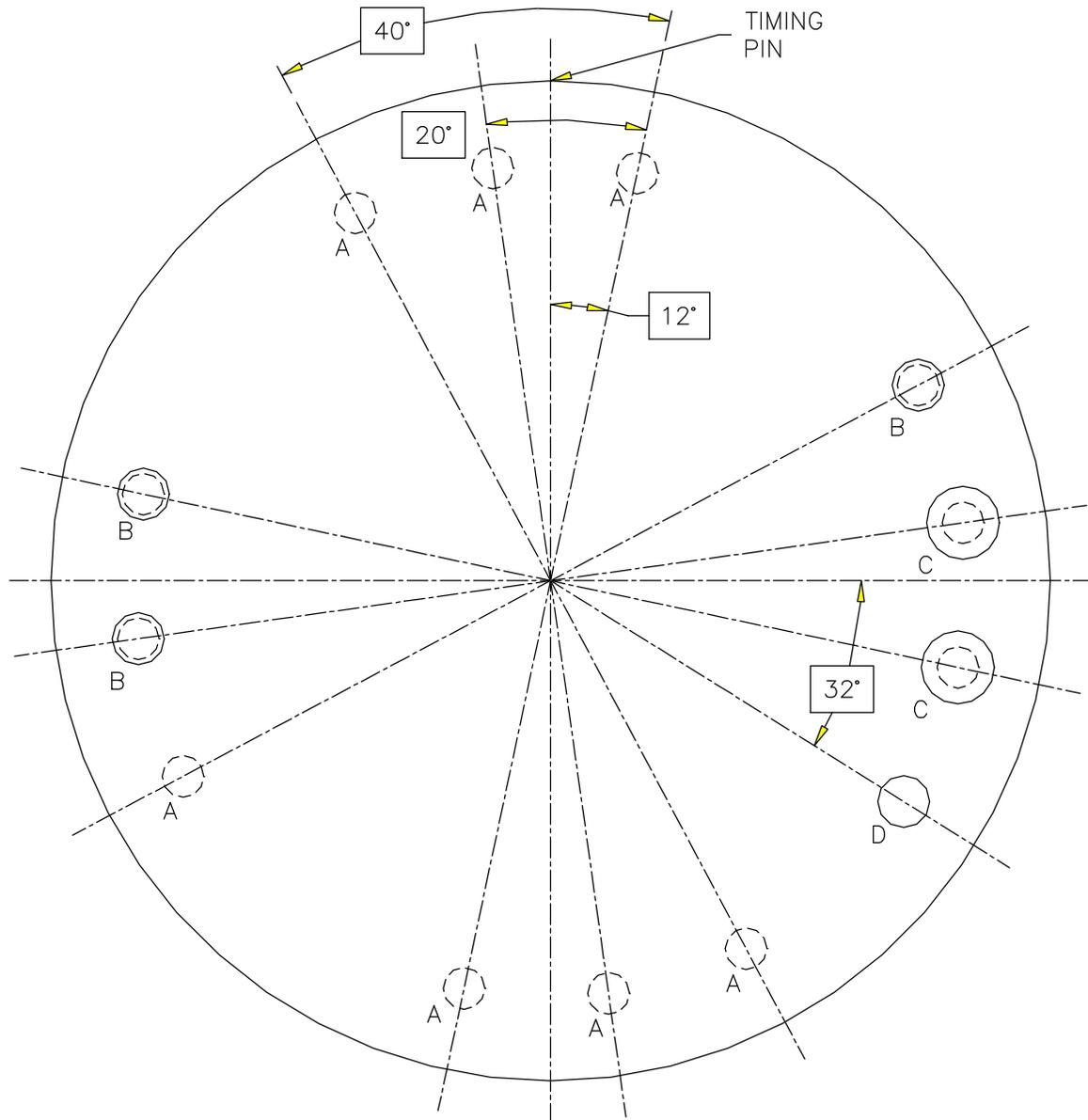
- 1.3.3 Enlarge the two holes from 0.245 - 0.255" to 0.436 - 0.446" diameter as shown in Figure 2.
- 1.3.4 Add one 0.310 - 0.319" diameter hole as shown in Figure 2.
- 1.3.5 FPI welded plugs per AMS 3155, Method B.
- 1.4 Obliterate old P/N E6899081 and re-identify as E23008614 per AS478-3B1 (manual vibropeen).



**FIGURE 1**

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**DILUTION CHAMBER**



- A -** Plugged holes
- B -** Holes enlarged to  $\text{Ø}.310 - .319$
- C -** Holes enlarged to  $\text{Ø}.436 - .446$
- D -** New hole,  $\text{Ø}.310 - .319$

**NOTE:** Centers of all holes must be .06 OTP of basic angular locations and  $1.95 \pm .06$  from aft end of detail.

**FIGURE 2**