

T-049 SERVICE BULLETIN

Rework of E6878426 2nd Stage Nozzle for C20B Installation

Engine Application(s):	Allison 250-C20B
Subject:	Rework procedures for E6878426 2 nd Stage Nozzle Assy to allow for installation in 250-C20B and B17B model engines.
Compliance:	Customer option.
Revisions:	N/C Dated: 6/10/99 Original issue. A Dated: 9/03/09 Updated EXTEX to TIMKEN. B Dated: 2/04/16 Updated TIMKEN to EXTEX Engineered Products.

REASON:

To modify the OD of 2nd stage turbine nozzles to allow installation in 250-C20B and 250-B17B engines.

DESCRIPTION:

This rework procedure describes the following:

1. Machining or grinding a balance air annulus in the nozzle OD.
2. Machining or grinding to remove the relief between the wheel shroud and tang.
3. Re-identification requirements.

APPROVAL:

Technical aspects are FAA Approved.

ACCOMPLISHMENT INSTRUCTIONS:

1. Rework Nozzle Assembly, P/N E6878426.
 - 1.1 No inspection is required when performing this work on a new nozzle.
 - 1.2 Machine or grind per Figure 1.
 - 1.3 Obliterate old P/N E6878426 and re-identify as E6878498.

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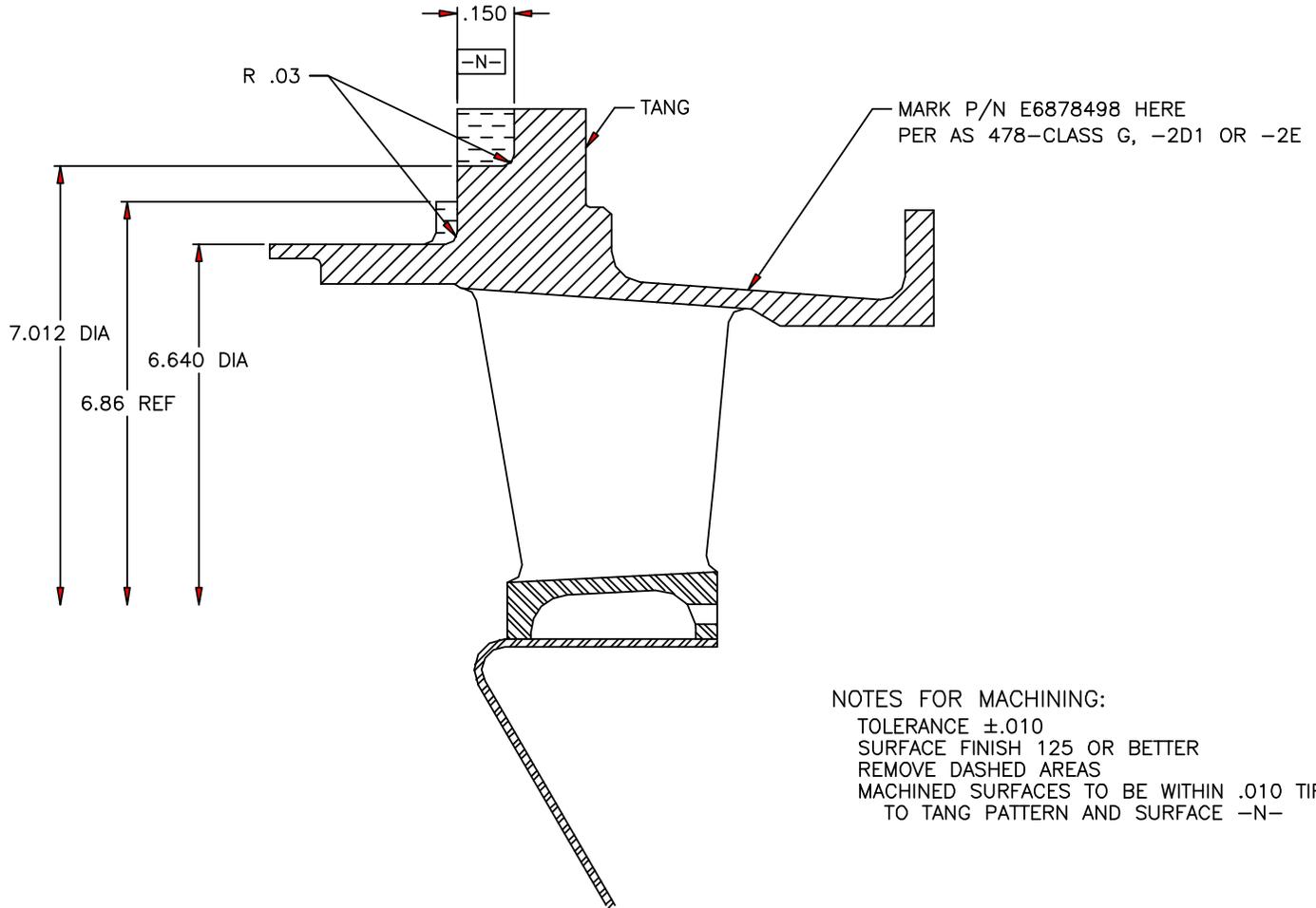


FIGURE 1