

T-068 SERVICE BULLETIN

Two Piece Diffuser Installation Rework Instructions

Engine Application(s):	Rolls - Royce Allison 250-C40B, C47B, C47M
Subject:	Rework of Compressor Rear Mount for Installation of PMA Part
Compliance:	Customer option.
Revisions:	N/C Dated: 3/25/04 Initial release
	A Dated: 9/22/04 Removed rework of support
	B Dated: 9/24/04 Updated subject line, part numbers 23055455 or 23064593 in Figure 2 were 23007196.
	C Dated: 8/25/09 Updated EXTEX to TIMKEN.
	D Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.

REASON:

Provide instruction to rework mating hardware **REQUIRED** for installation of a Two Piece Diffuser Assembly P/N E23064637-2P as a customer option for the Model A250-C40/47 engines. The E23064637-2P replaces either E23064637 or 23064637 one-piece diffuser.

DESCRIPTION:

Obtain P/N 23007217 Rear Compressor Mount for rework as follows:

- Rework Rear Mount as shown in Figure 1 and re-identify with "reworked per Extex T-068" vibropeened immediately following P/N.

APPROVAL:

Technical aspects are FAA Approved.

WEIGHT AND BALANCE:

Not Affected

PREREQUISITES:

None

ACCOMPLISHMENT INSTRUCTIONS:

Install per OEM procedures substituting the reworked part above for its non-reworked equivalent and substituting the P/N E23064637-2P Diffuser and P/N E23051099 Cover for the one-piece diffuser. Reference Figure 2 for assembly.

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MATERIAL INFORMATION:

NAME	OLD P/N	DISPOSITION
Mount , Compressor, Rear	23007217	Rework
Diffuser	E23064637-2P	Install
Cover, Diffuser	E23051099	Install

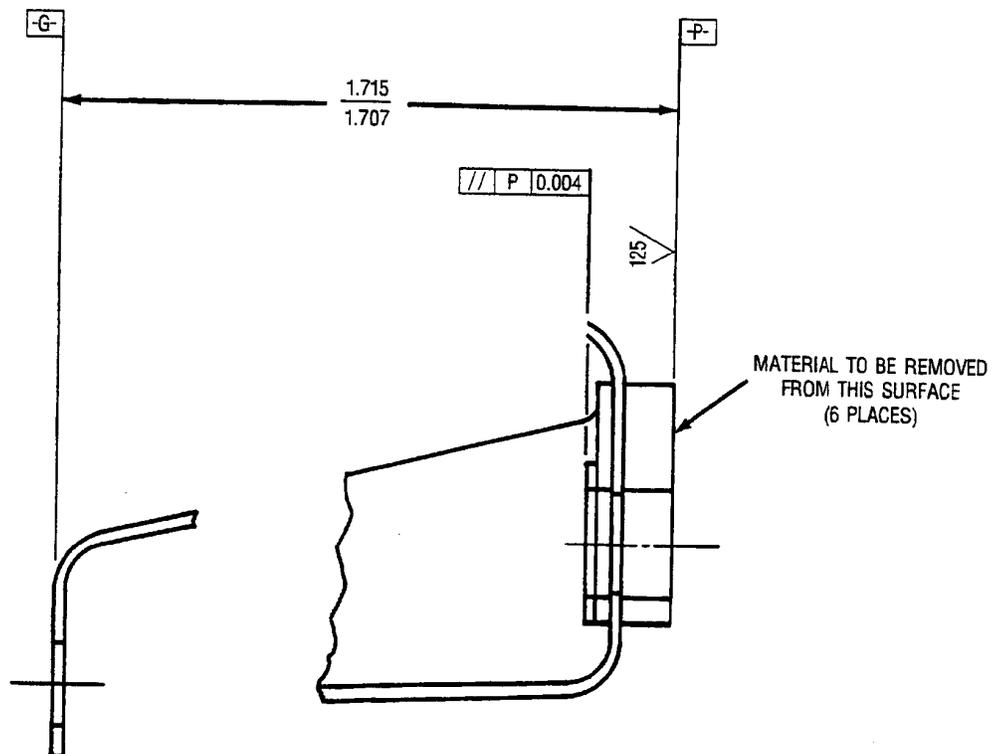
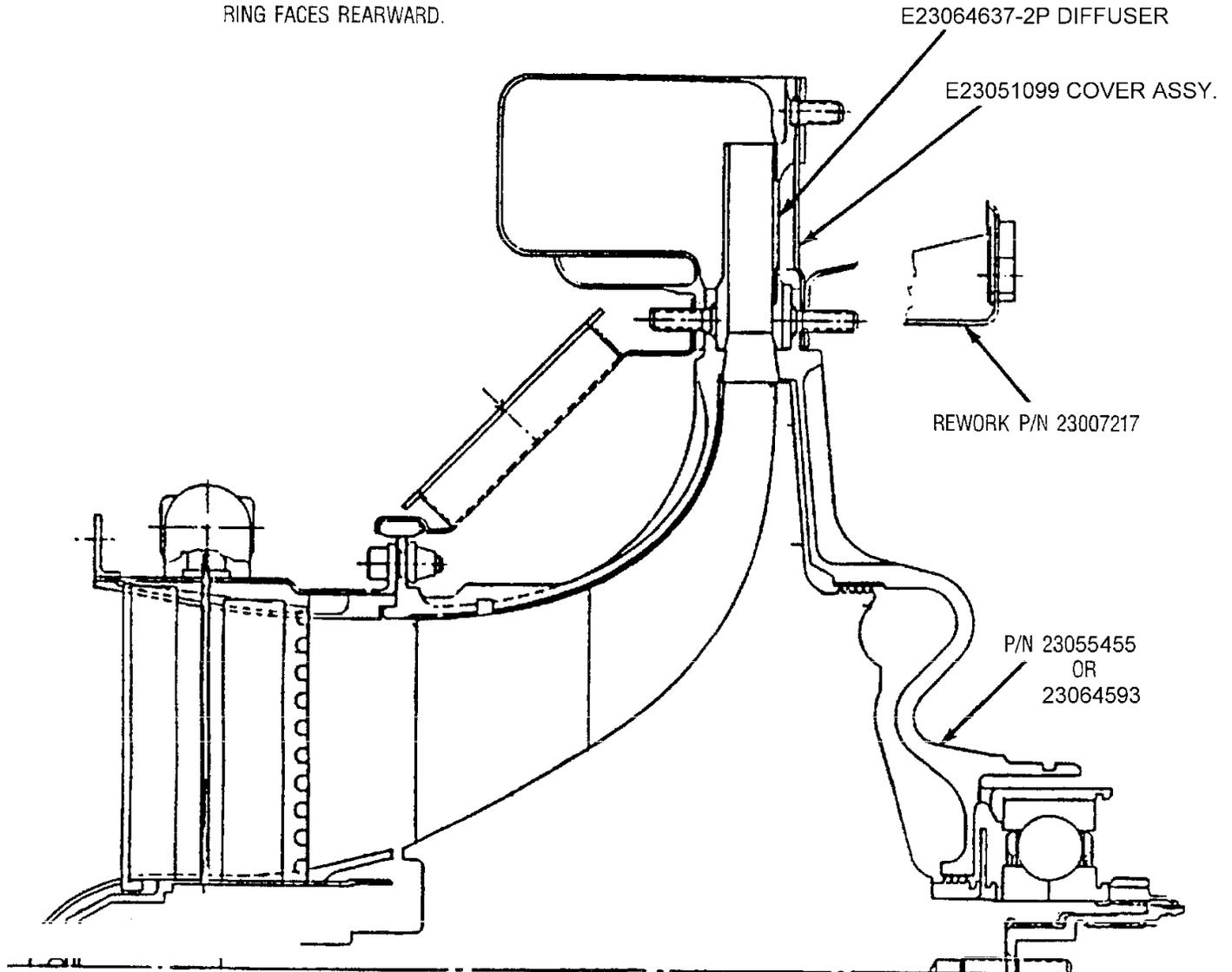


FIGURE 1

REAR COMPRESSOR MOUNT

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* NOTE:
ORIENTATION OF COVER, STIFFENING
RING FACES REARWARD.



**FIGURE 2
COMPRESSOR CROSS SECTION**