

T-301 Inspection Limits and Repair

E3611904-1 Turbine Shroud

Engine Application(s):	Allied Signal 85 Series Auxiliary Power Unit.	
Subject:	Inspection and Repair Limits	
Compliance:	On condition.	
Revisions:	N/C A B	Dated 9/27/99 Original issue. Dated 8/04/09 Updated from EXTEX to TIMKEN. Dated 2/08/16 Updated from Timken to EXTEX Engineered Products.

1.0 INSPECTION PROCEDURES:

Feature	Service Limit	Repair Limit	Corrective Action
Surface M	Cracks which do not extend below the bolt hole are acceptable.	Cracks which extend beyond bolt hole or are progressing toward one another are not acceptable.	Replace
Surface M	Fretting by spacers not more than .015 deep on three locations.	Flange thickness must be .250 minimum after clean-up.	Machine per Figure 1.
Surface T	Cracks which do not extend below the bolt hole are acceptable.		Replace
Surface H	Rub marks up to .030" deep are acceptable.	Positives such as ridges or metal build-up are not acceptable.	Blend as necessary to remove positives.
Threads	7.487- 7.489" Diameter 7 1/2 - 12NS-2A-LH threads 7.437 - 7.444" Pitch Diameter .003 - .009 " radius on crest	Inspect for worn, crossed, stripped, peened, burred, nicked or dented threads.	Chase threads per Figure 1.

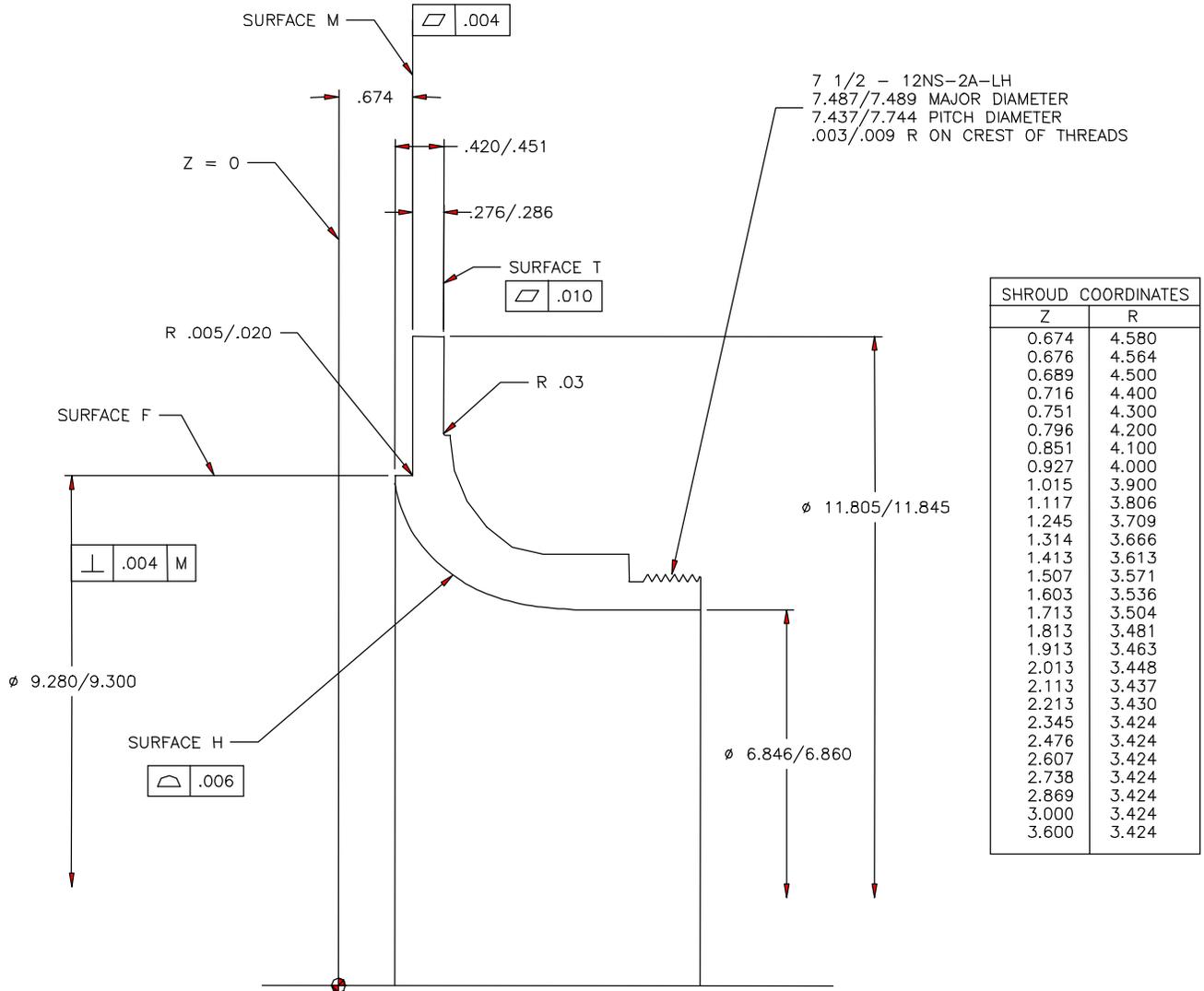
Fluorescent Penetrant Inspection - per ASTM E 1417, Method D Level 3 or equivalent.

Accept per Mil-Std-1907 - Surface H and threads Table I, Class A; balance of part Table I, Class B.

2.0 DIMENSIONAL INSPECTION & REPAIR

- All parts returned to service must meet the dimensions in Figure 1.
- A minimum amount of material is to be removed if machining is necessary to comply with any of the dimensions.
- For feature control limits on surfaces which have been distorted, 90% compliance of the surface to the feature tolerance is required.
- 9.280/9.300 diameter may be dimensionally restored using Metco 450 or equivalent metal spray, applied per manufacturer's instructions.

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REPAIRED LIMITS

FIGURE 1

All dimensions are in inches.