

T-402 Inspection Limits and Repair

**E3826099 Inlet Guide Vane
EN3826099 Inlet Guide Vane, Nickel**

Engine Application(s):	Allied Signal 331-200 and -250 Series Auxiliary Power Unit.	
Subject:	Inspection and Repair Limits	
Compliance:	On condition.	
Revisions:	N/C A B	Dated 11/8/99 Original issue. Dated 8/04/09 Updated EXTEX to TIMKEN. Dated 2/08/16 Updated Timken to EXTEX Engineered Products.

1.0 Inspection Procedures:

Feature	Service Limit	Repair Limit	Corrective Action
Coating integrity E3826099 only	Wear or corrosion through the hard anodize is not permitted.	None.	Replace
Plating integrity EN3826099 only	Wear or locally missing areas of plating are not to be re-installed.	Worn or locally missing areas of plating may be repaired provided base material of vane is not compromised.	Strip nickel plate and re-plate per AMS 2405. Repaired dimensions in Figure 1 must be maintained after plating.
Vane stem and sector gear flats	Nicks or gouges are not permitted.	None	Replace
All other areas of vane – airfoil, machined slots	Nicks or gouges up to .005 deep may be returned to service after dressing any positive material to flush.	Nicks or gouges up to .015 deep may be blended after stripping of nickel plate.	Re-plate per AMS 2405. Repaired dimensions in Figure 1 must be maintained after plating.

2.0 Repair by Hand finishing

- Surface finish of 63 micro-inches or better required
- No undercutting allowed
- All transitions between blended areas and original material surface shall be smooth and continuous.

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3.0 Dimensional Repaired Limits

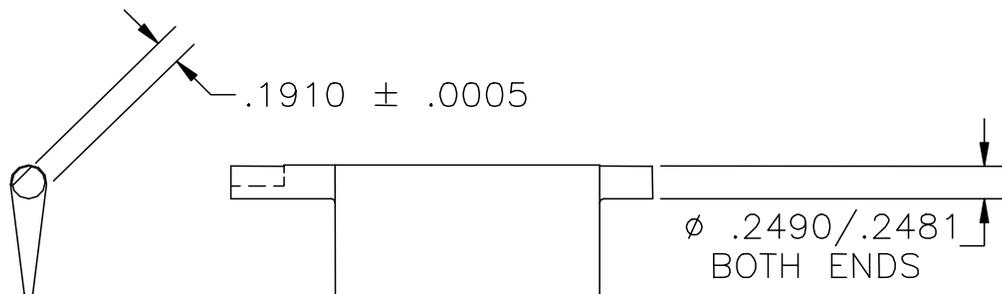


Figure 1

Note: Plating thickness to be .0007" minimum, .0025" maximum