

P/N(s): A23031938-UC,
E23031938-UC,
E6878426-UC, &
E23072654-UC

SERVICE BULLETIN T-012

Revision: G

Issued: 9/24/18

Un-Cut 2nd Stage Turbine Nozzle Assembly

Engine Application(s):	250-B17F, B17F/1, B17F/2 250-C20, C20B, C20F, C20J, C20S, C20W 250-C20R, C20R/1, C20R/2, C20R/4, C20R/1(RS), C20R(ST), C20R/2(SP)
Subject:	Installation Procedure for the A23031938-UC, E23031938-UC, E6878426-UC & E23072654-UC 2 nd Stage Turbine Nozzle Assembly.
Compliance:	<p>The A23031938-UC, E23031938-UC, E6878426-UC & E23072654-UC nozzles are manufactured with additional machining stock remaining on the 1st and 2nd turbine wheel blade path diameters and the seal bore. This allows the overhaul facility to custom machine the nozzle for specific turbine wheels and seal clearance to optimize performance.</p> <p>Before installation of the nozzle assembly, machine the blade paths per approved procedures to allow the desired radial blade tip clearance. Machine seal bore per approved procedures to achieve desired seal clearance.</p> <p>Re-identify the part as 'A23031938', 'E23031938', "E23072654", or 'E6878426' by removing the '-UC' from the part number marking. If the '-UC' is ink stamped, remove with MEK. If '-UC' is permanently marked, remove by vibro-peening an "X" over the '-UC'.</p> <p>Inspect Nozzle at time of O/H using Inspection Limits and Repair T-009.</p>
Notes:	Replaces Service Letter T94-021 issued by Superior Turbine on September 26, 1994. Refer to the OEM's published data for installation, engine operation and disassembly.
Revisions:	N/C Dated: 01/30/97 Initial Release. A Dated: 12/01/97 Updated format. Added P/N E6878426. B Dated: 01/23/01 Updated format. C Dated: 07/26/02 Added P/N E23072654-UC. D Dated: 07/06/06 Changed ".010" to "additional". E Dated: 09/09/09 Updated EXTEX to TIMKEN. F Dated: 2/02/16 Updated Timken to EXTEX Engineered Products. G Dated: 9/24/18 Added requirement to machine seal bore diameter.