

T-065 Instructions for Continued Airworthiness

Instructions for Continued Airworthiness EXTEX Replacement Parts for RR250

Engine Application(s):	All Rolls Royce / Allison 250 engine models.
Compliance:	As required.
Notes:	Refer to OEM's published data for installation, engine operation, and disassembly.
Revisions:	<p>A Dated: 7/02/08 Initial Release.</p> <p>B Dated: 8/27/09 Updated EXTEX to TIMKEN.</p> <p>C Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.</p> <p>D Dated: 2023/8/02 Updated to indicate superseded T-documents.</p>

As part of the FAA approval process, EXTEX demonstrated that the OEM's published Instructions for Continued Airworthiness (ICA) is applicable to and may be used for all EXTEX replacement parts except as noted in Section 2. EXTEX Supplemental ICA is also available for product listed in Section 3.

Section 1: General Instructions:

1. Refer to the OEM's published data for instructions for engine disassembly, cleaning, inspection, rework, Ass'y, operation, and testing.
2. All work must be performed at an FAA-approved repair facility.
3. Except as noted in Section 2B, you may use the OEM ICA for the equivalent OEM part to inspect, repair, and overhaul the EXTEX Product.
4. EXTEX recommends that, whenever applicable, you comply with the Supplemental EXTEX ICA listed in Section 3.
5. Products inspected or repaired/reworked in accordance the Supplemental EXTEX ICA may be classified as serviceable, repaired, or overhauled at the discretion of the certifying entity.

Section 2: Required EXTEX Instructions for Continued Airworthiness:

- A) Use the following EXTEX ICA for the product listed below whenever applicable to your situation:

Part Number	Nomenclature	Service Document	Topic
E23031938-C, E6878426-C	2 nd Stage Turbine Nozzle Ass'y	T-009	Inspection limits and repair for coated nozzles.
E23031938-UC, E6878426-UC	2 nd Stage Turbine Nozzle Ass'y	T-012	Installation Procedure for 'uncut' blade paths.
E23032335-UC, E23055438-UC	Un-Cut 2 nd Stage Turbine Nozzle	T-026	Installation Procedure for 'uncut' blade paths.
E23038218-C505	1 st Stage Turbine Nozzle Ass'y	T-013	Inspection limits and repair for coated nozzles.
E23039791-1	Compressor Adapter Couplings	T-061 Superseded. Contact EXTEX Customer Service	Remove From Service
E23053330	C47 2nd Stage Turbine Nozzle Assembly	T-071	Installation Procedure for 'uncut' blade paths.
E23064637-2P	Two Piece Diffuser	T-068	Installation Rework Instructions

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GENERAL

P/N(s): Various – See Tables

Revision: D Issued: 2023/08/02

Part Number	Nomenclature	Service Document	Topic
E6878426	2 nd Stage Nozzle	T-049	Rework For C20B Installation
E6888529	Starter Generator Gearshaft	T-050	Installation Instructions
E6888547-UC	Un-Cut Power Turbine Oil Sump Cover Ass'y	T-045	Installation Procedure for 'uncut' seal diameters.
E6898977	Turbine to Compressor Couplings	T-062	Remove certain serial numbers from service.
E6898785	PTO Gear	T-075	Remove certain serial numbers from service.
E6893673	Torquemeter Gear	T-076	Inspection of certain serial numbers
E23039791, E23039791-1,-2,-3; EH23039791, EH23039791-1,-2,-3	Compressor Splined Adapter Coupling	T-081 Superseded. Contact EXTEX Customer Service	Remove from Service
E23008020	Turbine Tie Bolt	T-090	Remove from Service
E23057111, E23057112, E23057114, E23057115, E23057116	Compressor Wheels	T-099	Corrosion Inspection
E23075442	Gearshaft Ass'y, Helical Torquemeter Gear	T-100	Re-identification of certain serial numbers.

B) You cannot use OEM ICA and must use only EXTEX ICA for the product listed below:

None Listed.

Section 3: Supplemental EXTEX Instructions for Continued Airworthiness:

EXTEX has issued supplemental ICA for certain products. [See the Model 250 Tech Manual Table of Contents for the complete listing.](#)