

COMMERCIAL ENGINE BULLETIN



Detroit Diesel Allison

Indianapolis, Indiana 46206

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November 30, 1980

ENGINE, TURBINE EXHAUST COLLECTOR INNER CONE--MODIFY

PLANNING INFORMATION:

EFFECTIVITY: All Model 250-C30 engines and turbine assemblies should be inspected for applicability.

NOTE: Turbine Support and Exhaust Collector Assemblies identified by the following or subsequent change letters will comply:

<u>PART NUMBER</u>	<u>CHANGE LETTER</u>
6893075	"W"
23001996	"E"
23004240	"B"
23004509	"B"

REASON: It is possible for the fourth stage wheel to contact the upstream edge of the -7 detail sheet metal inner cone of the exhaust collector under adverse tolerance stack conditions.

DESCRIPTION: The upstream edge of the -7 detail sheet metal inner cone of the exhaust collector is machined to obtain an increased minimum locating dimension from the power turbine support mounting flange.

INTERCHANGEABILITY:
Not affected.

COMPLIANCE: Compliance is recommended whenever access to exhaust collector is next achieved, but no later than next overhaul.

APPROVAL: FAA-DER Approved.

MATERIAL AVAILABILITY:
None.

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TOOLING: None.

WEIGHT AND BALANCE:
 None.

REFERENCE: CW 3033

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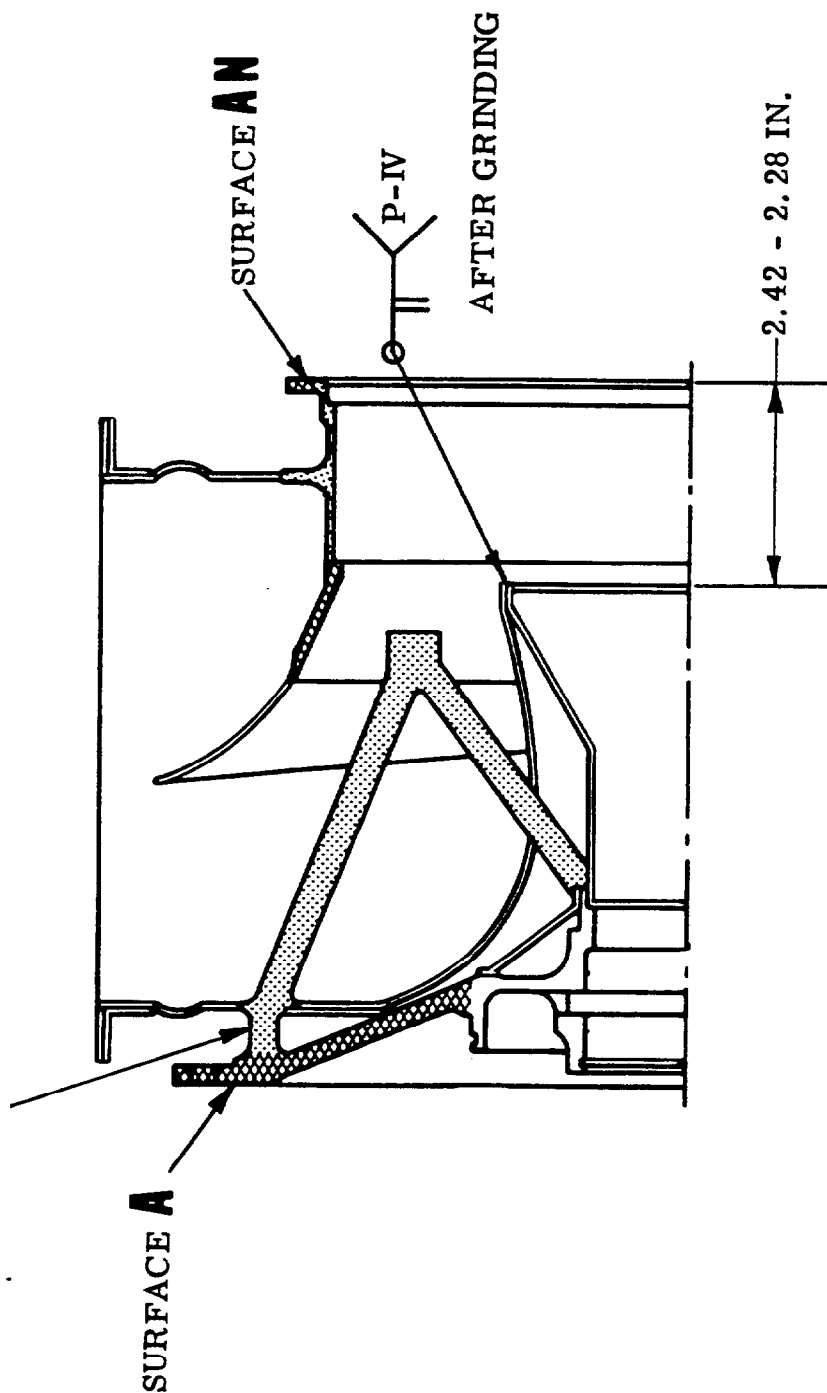
ACCOMPLISHMENT INSTRUCTIONS:

- 1.0 Modify and reidentify affected P/N 6893075, 23001996, 23004240 or 23004509 Support Assemblies, Turbine and Exhaust Collectors.
Refer to Figure 1.
- 1.1 Ensure that support assembly, turbine and exhaust collector to be modified has passed the inspection criteria in the Overhaul Manual and is in fit condition for further service and to be modified.
- 1.2 Machine or hand grind the upstream edge of the -7 detail sheet metal inner cone to obtain the increased minimum locating dimension as shown in Figure 1. Reweld using inert gas arc, without filler rod.
- 1.3 Reidentify modified Support Assemblies, Turbine and Exhaust Collector by adding the suffix "CEB 72-3044" to the part number and any existing suffixes per AS478-2D1.
- 2.0 Record compliance with 250-C30 CEB 72-3044 in the Engine Log Book, Turbine Assembly (pink pages), Modification Record, Part III.

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REIDENTIFY MODIFIED EXHAUST COLLECTOR
BY ADDING "CEB 72-3044" SUFFIX TO PART
NUMBER AND ANY EXISTING SUFFIX PER
AS478-2D1



PARTIAL SECTION VIEW
TURBINE AND EXHAUST COLLECTOR SUPPORT

FIGURE 1

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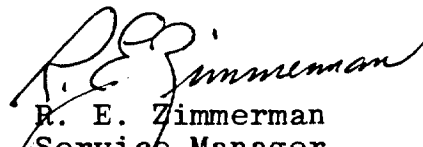
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MATERIAL INFORMATION:

<u>NEW P/N</u>	<u>QTY.</u>	<u>NOMENCLATURE</u>	<u>OLD P/N</u>	<u>QTY.</u>	<u>DIS- POSITION</u>
6893075 "CEB 72-3044"	1	Support Assembly, Turbine and Exhaust Collector	6893075	1	1
23001996 "CEB 72-3044"	alt.	Support Assembly, Turbine and Exhaust Collector	23001996	alt.	1
23004240 "CEB 72-3044"	alt.	Support Assembly, Turbine and Exhaust Collector	23004240	alt.	1
23004509 "CEB 72-3044"	alt.	Support Assembly, Turbine and Exhaust Collector	23004509	alt.	1

STOCK DISPOSITION NOTES:

1. Modify and reidentify.


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Allison Engine Company

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