



Airborne
Engines Ltd

**ROLLS ROYCE M250
COMPONENT & ENGINE REWORK
CAPABILITIES LISTING**





Airborne
Engines^{Ltd}



**ROLLS ROYCE
M250 ENGINE**

AUTHORIZED MAINTENANCE, REPAIR, & OVERHAUL CENTER (AMROC)

250-C20B Commercial Application Bell 206B, 206B2, 206B3

250-C20R Commercial Application Bell 206LR, MD500, AS355

250-C28 Commercial Application Bell 206L1-4, S-76A, BO-105

250-C30P Commercial Application Bell 206L3, 206L4, MD530

250-C47 Commercial Application Bell 407

250-C20W Commercial Application Enstrom Helicopter

250-C40 Commercial Application Bell 430

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Rolls Royce C20 Capabilities

C20B Compressor Section

Front Support

- ❑ Aft flange restoration
- ❑ Cold work #1 bearing bore and relocate incl. NDT, CMM
- ❑ Exchange
- ❑ Forward flange restoration
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- ❑ Repair minor cracks & dents incl. silver solder, NDT, and pressure test
- ❑ Restore pilot diameter "C" incl. NDT
- ❑ Sermetel paint

Shroud Housing (Front Diffuser)

- ❑ Chemical strip, glass beading to remove coating, NDT, CMM pilot diameters
- ❑ Exchange
- ❑ Metallize and machine flange "S"
- ❑ Metallize and machine and re-contour
- ❑ Metallize and machine aft pilot diameter
- ❑ Metallize and machine forward pilot diameter
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- ❑ Sermetel paint

Diffuser Vane Assembly

- ❑ Blend and dress vanes incl. NDT
- ❑ Exchange
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- ❑ Remove excess braze from throat area
- ❑ Stud replacement - EACH (up to 3 studs only)

Scroll

- ❑ Air tube insert repair - BOTH (Parts extra)
- ❑ Exchange
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- ❑ Restore boss chamfer and threads
- ❑ Sermetel paint
- ❑ Sleeve repair of damaged thread boss and/or helicoil - EACH
- ❑ Stud replacement - EACH (up to 3 studs only)
- ❑ Weld repair, NDT & pressure test (Nickel plate and air tube insert extra)



Rear Support (Rear Diffuser)

- Adding slots for bearing puller - CEB 1088
- Exchange
- Machine mount pad
- Metallize and machine rear pilot incl. NDT
- Metallize and machine seal bores incl. NDT
- Metallize and machine mount pad
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint

Impeller

- Blend and dress vanes incl. NDT
- Glass bead peen per CEB 1325 only
- Machine bore for new spline adapter incl. NDT CEB 1392
- Machine impeller stub shaft incl. glass bead peen, NDT CEB 1325 & 1392
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)

1st, 2nd, 3rd, 4th, 5th, and 6th Stage Wheels

- Blend and dress vanes incl. NDT
- Grind pin per CEB 1321
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)

Tie Bolt

- Overhaul inspect & tag (certify/rework) incl. NDT





C20B Gearbox Section

Gearbox Cover

- ❑ Add bronze shim & machine surface "G"
- ❑ Conversion C20B to C20R
- ❑ Corrosion major repair (METAL SET)
- ❑ Corrosion minor repair (METAL SET)
- ❑ Exchange (Parts extra)
- ❑ Idler gearshaft bore - install insert - EACH (Parts extra)
- ❑ Insert repair helicoil/key insert CEB 1122 & 1166
- ❑ Machine turbine mount surface "G"
- ❑ Metallize and machine cage bore (ALL) - EACH (Parts extra)
- ❑ Metallize and machine seal bore (ALL) - EACH
- ❑ New mag plug insert (Parts extra)
- ❑ Overhaul inspect incl. cleaning, NDT, CMM
- ❑ Repaint
- ❑ Repair alignment dowel pin bores - BOTH
- ❑ Replace bearing cage (ALL) - EACH (Parts extra)
- ❑ Replace torquemeter bushing incl. CMM - EACH (Parts extra) CEB 1105
- ❑ Replace worn 3 & 4 bearing bore - machine for new cage incl. CMM (Parts extra)
- ❑ Replacing 3 & 4 bearing cage (Parts extra) CEB 72-4020 & 1274
- ❑ Restore worn 3 & 4 bearing bore (Pre-machine, metallize and machine)
- ❑ Stud replacement incl. helicoil - EACH (Parts extra)
- ❑ Thread repair stainless steel insert - EACH
- ❑ Throughbolt configuration CEB 1226 (Parts extra)
- ❑ Weld repair lock wire lug





Gearbox Housing

- Add torque meter bore (Bushing)
- Compressor pilot bore - Pre-machine, metallize and machine incl. NDT, plasma spray
- Conversion C20B to C20R
- Corrosion major repair (METAL SET)
- Corrosion minor repair (METAL SET)
- Exchange
- Idler gearshaft bore - install insert - EACH (Parts extra)
- Insert repair helicoil/key insert CEB 1122 & 1166
- Metallize and machine cage bore (ALL) - EACH (Parts extra)
- Metallize and machine seal bore (ALL) - EACH
- Mill oil filter mount surface
- New mag plug insert (Parts extra)
- Overhaul inspect incl. cleaning, NDT, CMM (no paint)
- Repaint
- Repair alignment dowel pin bores - BOTH
- Repair compressor mount pad - remove stud, pre-machine, finish machine (Parts extra)
- Repair compressor mount pad - replace stud - (Parts extra) EACH
- Repair engine mount - install insert - EACH
- Repair RG check valve bore
- Repair torque meter bore (Bushing)
- Replace bearing cage (ALL) - EACH (Parts extra)
- Skim compressor mounting surface incl. CMM
- Stud replacement incl. helicoil - EACH (Parts extra)
- Thread repair stainless steel insert - EACH
- Throughbolt configuration CEB 1226 (Parts extra)
- Weld repair lock wire lug

Fuel Control Gearshaft, FCU/OP Gearshaft, Generator Gearshaft, Fuel Pump Gearshaft, Tach/Gov. Gearshaft, PTO Gearshaft, Centrifugal Breather Gearshaft,

- Polish journals

Pinion Gear

- Machine to remove contact damage

Pressure Pump Body

- Replace bearing cage (ALL) - EACH (Parts extra)
- Replace flanged inserts



Oil Filter Housing

- Corrosion Repair
- Exchange
- Insert flanged bushing CEB 1241 - EACH (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. cleaning, NDT (no paint)
- Pressure regulator bore - Sleeve repair
- Repaint
- Repair oil filter standpipe
- Replace seat bushing
- Replace studs (Parts extra)

C20B Turbine Section

Exhaust Collector

- Cold work bearing bore
- Exchange (incl. flanges, welding, bore align & chrome)
- Insert scallop on bore face CEB 1095
- Metallize and machine pilot & #4 nozzle mounting face
- Metallize and machine bearing bore, seal bore, and shoulder surface "N"
- Metallize and machine diameter "L" forward, pilot
- Metallize and machine flange "T"
- Metallize and machine surface "S"
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Restore snap ring groove
- Sermetel paint
- Skim bearing, shoulder surface "N"
- Skim flange "T"
- Skim nozzle shroud
- Skim pads, surface "S"
- Weld repair cracks



PT Support

- CEB 1185
- Exchange (incl. cloverleaf & 19-24 seal bore replacement). NOTE: DOES NOT INCLUDE REPLACEMENT OF 25-28 SEAL P/N 23030978-1
- Exchange (No cloverleaf or 19-24 seal bore replacement)
- Finish machine 19-24 & 25-28 seals
- Metallize and machine 19-24 seal
- Metallize and machine 25-28 seal bore incl. NDT, plasma spray (Parts extra)
- Metallize and machine flange "C"
- Metallize and machine flange "N"
- Metallize and machine nozzle mount, face, A/F
- Metallize and machine sump cover mounting face
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Replace 25-28 seal, incl. welding, NDT (Parts extra)
- Restore tang slots
- Sermetel paint
- Skim 25-28 seal only
- Skim flange "C"
- Skim flange "N"
- Skim sump mounting face
- Skim support pilot diameter
- Weld repair bolt holes - EACH
- Weld repair cracks





GP Support

- CEB 1185
- Embody CEB A-1254 (incl. wear pads)
- Exchange - Does not include CEB 1254 (Parts extra)
- Machine fwd pilot diameter
- Machine out cracked strut
- Metallize and machine #1 nozzle face
- Metallize and machine aft flange
- Metallize and machine bearing bore
- Metallize and machine flange "K"
- Metallize and machine sump face (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Replace containment ring pads (CEB 1276)
- Replace off set pin
- Replace oil nozzle pin, CEB 1183 (Parts extra)
- Replace stator seal pin (Parts extra)
- Restore containment ring slots
- Restore nozzle tang slots
- Sermetel paint
- Skim #1 nozzle mounting face
- Skim aft flange
- Skim flange "K"
- Skim sump face (Parts extra)
- Skim support pilot diameter
- Weld and blend struts
- Weld repair bolt holes - EACH
- Weld repair cracks

Containment Ring

- Overhaul inspect & tag (certify/rework) incl. NDT
- Repair tangs

1st and 2nd Stage Turbine Wheel

- Blade tip grinding
- Overhaul inspect & tag (certify/rework) incl. NDT
-

1st Stage Nozzle

- Final clean
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks incl. heat treat





2nd Stage Nozzle

- Exchange - New casting replacement
- Final clean
- Finish machine (install new semi-finished nozzle) - TWO EACH BLADE PATH
- Metallize and machine blade path #1
- Metallize and machine blade path #2
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Modify per CEB A-1253 incl. de-burr, NDT
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Skim blade path #1
- Skim blade path #2
- Skim centre seal
- Weld repair tangs

3rd Stage Nozzle

- Exchange (Enhanced per CEB 1365)
- Exchange (Unenhanced)
- Metallize and machine forward flange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Skim forward flange
- Weld repair casting incl. heat treat, NDT

4th Stage Nozzle

- Exchange (Enhanced per CEB 1365)
- Exchange (Unenhanced)
- Final clean
- Finish machine (install new semi-finished nozzle) - TWO EACH BLADE PATH
- Metallize and machine blade path #3
- Metallize and machine blade path #4
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace centre seal (Parts extra)
- Skim blade path #3
- Skim blade path #4
- Skim centre seal
- Weld repair tangs
- Weld repair vanes





PT Outer Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Polish to remove corrosion pitting
- Retempering

PT Inner Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT

PT Labyrinth Seal

- Skim knives

Sump Covers

- Braze repair
- Exchange (No braze joint repair required)
- Exchange (Replace seal)
- Finish machine 9-12 & 13-18 seals
- Metallize and machine 9-12 & 13-18 seals
- Metallize and machine surface "D" & "F"
- Metallize and machine surface "E"
- Metallize and machine surface "E", "D", & "F"
- Overhaul inspect & tag incl. pre-machine, NDT, pressure test
- Replace seal E.O. A250-001
- Skim surface "E"

#1 Nozzle Shield

- Braze repair
- Exchange (Dome and deflector extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace deflector only
- Restore saddle tabs
- Weld repair cracks



#3 Nozzle Shield

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld build up saddle tabs
- Weld repair cracks

External Sump Can

- Restore mounting flange surface (Lapping only)

Horizontal and Vertical Fireshield

- Cold work and dress welds
- Overhaul inspect & tag (certify/rework) incl. NDT
- Sermetel paint
- Weld cracks

C20B Combustion Section

Outer Combustion Case

- Dent removal & pressure check
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Restore air tube boss - BOTH
- Screen patch repair
- Sermetel paint
- Thread repair
- Weld repair cracks & pressure check

Combustion Liner

- CEB 1299
- Change fuel ferrule and/or ignitor
- Exchange
- Install new details (Parts included)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Re-gap louvers
- Weld repair cracks (incl. burnt louvers)





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Air Discharge Tube

- ❑ Add braze patch
- ❑ Dent removal & pressure check
- ❑ Metallize and machine seal ring grooves
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- ❑ Sermetel paint

Fuel Nozzle

- ❑ 300 hour inspection (clean and flow)



Rolls Royce C20R Capabilities

C20R Compressor Section

Front Support

- Aft flange restoration
- Aft pilot plasma spray
- Cold work #1 bearing bore and relocate incl. NDT, CMM
- Exchange
- Forward flange restoration
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Repair minor cracks & dents incl. silver solder, NDT, and pressure test
- Sermetel paint

Shroud Housing (Front Diffuser)

- Exchange
- Metallize and machine and machine aft flange
- Metallize and machine and re-contour
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint

Diffuser Vane Assembly

- Blend and dress vanes incl. NDT
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Remove excess braze from throat area
- Stud replacement - EACH (up to 3 studs only)

Scroll

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Restore boss chamfer and threads
- Sermetel paint
- Sleeve repair of damaged thread boss and/or helicoil - EACH
- Stud replacement - EACH (up to 3 studs only)
- Weld repair, NDT & pressure test (Nickel plate)



Rear Support (Rear Diffuser)

- Adding slots for bearing puller - CEB 72-4047
- Exchange
- Machine mount pad
- Metallize and machine rear pilot incl. NDT
- Metallize and machine seal bores incl. NDT
- Metallize and machine mount pad
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint

Impeller

- Blend and dress vanes incl. NDT
- Glass bead peen (FOD repair)
- Machine bore for new spline adapter incl. NDT
- Machine impeller stub shaft incl. glass bead peen, NDT
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)

1st, 2nd, 3rd, and 4th Stage Wheels

- Blend and dress vanes incl. NDT
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)

Tie Bolt

- Overhaul inspect & tag (certify/rework) incl. NDT

Case Halves

- Exchange
- Overhaul inspect & tag incl. strip and repaint (stators parts extra)
- Restore aft and flange pilot diameter
- Restore blade tracks
- Restore forward and flange pilot diameter
- Restore stators
- Skim aft flange
- Skim blade tracks
- Skim forward flange
- Skim stators





C20R Gearbox Section

Gearbox Cover

- ❑ Add bronze shim & machine surface "G"
- ❑ Corrosion major repair (METAL SET)
- ❑ Corrosion minor repair (METAL SET)
- ❑ Exchange (Parts extra)
- ❑ Idler gearshaft bore - install insert - EACH (Parts extra)
- ❑ Insert repair helicoil/key insert
- ❑ Machine turbine mount surface "G"
- ❑ Metallize and machine cage bore (ALL) - EACH (Parts extra)
- ❑ Metallize and machine seal bore (ALL) - EACH
- ❑ New mag plug insert (Parts extra)
- ❑ Overhaul inspect incl. cleaning, NDT, CMM
- ❑ Repaint
- ❑ Repair alignment dowel pin bores - BOTH
- ❑ Replace bearing cage (ALL) - EACH (Parts extra)
- ❑ Replace torquemeter bushing incl. CMM - EACH (Parts extra)
- ❑ Replace worn 3 & 4 bearing bore - machine for new cage incl. CMM (Parts extra)
- ❑ Replacing 3 & 4 bearing cage
- ❑ Restore worn 3 & 4 bearing bore (Pre-machine, metallize and machine)
- ❑ Stud replacement incl. helicoil - EACH (Parts extra)
- ❑ Thread repair stainless steel insert - EACH
- ❑ Throughbolt configuration (Parts extra)
- ❑ Weld repair lock wire lug





Gearbox Housing

- Add torque meter bore (Bushing)
- Compressor pilot bore - Pre-machine, metallize and machine incl. NDT, plasma spray
- Corrosion major repair (METAL SET)
- Corrosion minor repair (METAL SET)
- Exchange
- Idler gearshaft bore - install insert - EACH (Parts extra)
- Insert repair helicoil/key insert
- Metallize and machine cage bore (ALL) - EACH (Parts extra)
- Metallize and machine seal bore (ALL) - EACH
- Mill oil filter mount surface
- New mag plug insert (Parts extra)
- Overhaul inspect incl. cleaning, NDT, CMM (no paint)
- Repaint
- Repair alignment dowel pin bores - BOTH
- Repair compressor mount pad - remove stud, pre machine, finish machine (Parts extra)
- Repair compressor mount pad - replace stud - EACH (Parts extra)
- Repair engine mount - install insert - EACH
- Repair RG check valve bore
- Repair torque meter bore (Bushing)
- Replace bearing cage (ALL) - EACH (Parts extra)
- Skim compressor mounting surface incl. CMM
- Stud replacement incl. helicoil - EACH (Parts extra)
- Thread repair stainless steel insert - EACH
- Weld repair lock wire lug

Fuel Control Gearshaft, FCU/OP Gearshaft, Generator Gearshaft, Fuel Pump Gearshaft, Tach/Gov. Gearshaft, PTO Gearshaft, Centrifugal Breather Gearshaft,

- Polish journals

Pinion Gear

- Machine to remove contact damage

Pressure Pump Body

- Replace bearing cage (ALL) - EACH (Parts extra)
- Replace flanged inserts



Oil Filter Housing

- Corrosion repair
- Exchange
- Insert flanged bushing - EACH (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. cleaning, NDT (no paint)
- Pressure regulator bore - Sleeve repair
- Repaint
- Repair oil filter standpipe
- Replace seat bushing
- Replace studs (Parts extra)

C20R Turbine Section

Exhaust Collector

- Cold work bearing bore
- Exchange (incl. flanges, welding, bore align & chrome)
- Insert scallop on bore face
- Metallize and machine pilot & #4 nozzle mounting face
- Metallize and machine bearing bore, seal bore, and shoulder surface "N"
- Metallize and machine diameter "L" forward, pilot
- Metallize and machine flange "T"
- Metallize and machine surface "S"
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Restore snap ring groove
- Sermetel paint
- Skim bearing, shoulder surface "N"
- Skim flange "T"
- Skim nozzle shroud
- Skim pads, surface "S"
- Weld repair cracks and baffel



PT Support

- Exchange (incl. cloverleaf & 19-24 seal bore replacement). NOTE: DOES NOT INCLUDE REPLACEMENT OF 25-28 SEAL P/N 23030978-1
- Exchange (No cloverleaf or 19-24 seal bore replacement)
- Finish machine 19-24 & 25-28 seals
- Metallize and machine 19-24 seal
- Metallize and machine 25-28 seal bore incl. NDT, plasma spray (Parts extra)
- Metallize and machine flange "C"
- Metallize and machine flange "N"
- Metallize and machine nozzle mount, face, A/F
- Metallize and machine sump cover mounting face
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Replace 25-28 seal, incl. welding, NDT (Parts extra)
- Restore tang slots
- Sermetel paint
- Skim 25-28 seal only
- Skim flange "C"
- Skim flange "N"
- Skim sump mounting face
- Skim support pilot diameter
- Weld repair bolt holes - EACH
- Weld repair cracks





GP Support

- Exchange (Parts extra)
- Machine FWD pilot diameter
- Machine out cracked strut
- Metallize and machine #1 nozzle face
- Metallize and machine aft flange
- Metallize and machine Bearing bore
- Metallize and machine flange "K"
- Metallize and machine sump face (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Replace containment ring pads
- Replace off set pin
- Replace oil nozzle pin (Parts extra)
- Replace stator seal pin (Parts extra)
- Restore containment ring slots
- Restore nozzle tang slots
- Sermetel paint
- Skim #1 nozzle mounting face
- Skim aft flange
- Skim flange "K"
- Skim sump face (Parts extra)
- Skim support pilot diameter
- Weld and blend struts
- Weld repair bolt holes - EACH
- Weld repair cracks

Containment Ring

- Overhaul inspect & tag (certify/rework) incl. NDT
- Repair tangs

1st and 2nd Stage Turbine Wheel

- Blade tip grinding
- Overhaul inspect & tag (certify/rework) incl. NDT

1st Stage Nozzle

- Final clean
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks incl. heat treat





2nd Stage Nozzle

- Exchange
- Exchange - New casting replacement
- Final clean
- Finish machine (install new semi-finished nozzle) TWO EACH BLADE PATH
- Metallize and machine blade path #1
- Metallize and machine blade path #2
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Skim blade path #1
- Skim blade path #2
- Skim centre seal
- Weld repair tangs

3rd Stage Nozzle

- Exchange (Enhanced)
- Exchange (Unenhanced)
- Metallize and machine forward flange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Skim forward flange
- Weld repair casting incl. heat treat, NDT

4th Stage Nozzle

- Exchange (Enhanced per CEB 72-4078)
- Exchange (Unenhanced)
- Final clean
- Finish machine (install new semi-finished nozzle) TWO EACH BLADE PATH
- Metallize and machine blade path #3
- Metallize and machine blade path #4
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace centre seal (Parts extra)
- Skim blade path #3
- Skim blade path #4
- Skim centre seal
- Weld repair tangs
- Weld repair vanes





PT Outer Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Polish to remove corrosion pitting
- Retempering

PT Inner Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT

PT Labyrinth Seal

- Skim knives

Sump Covers

- Braze repair
- Exchange (No braze joint repair required)
- Exchange (Replace seal)
- Finish machine 9-12 & 13-18 seals
- Metallize and machine 9-12 & 13-18 seals
- Metallize and machine surface "D" & "F"
- Metallize and machine surface "E"
- Metallize and machine surface "E", "D", & "F"
- Overhaul inspect & tag incl. pre-machine, NDT, pressure test
- Replace seal E.O. A250-001
- Skim surface "E"

#1 Nozzle Shield

- Braze repair
- Exchange (Dome and deflector extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace deflector only
- Restore saddle tabs
- Weld repair cracks



#3 Nozzle Shield

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld build up saddle tabs
- Weld repair cracks

External Sump Can

- Restore mounting flange surface (Lapping only)

Horizontal and Vertical Fireshield

- Cold work and dress welds
- Overhaul inspect & tag (certify/rework) incl. NDT
- Sermetel paint
- Weld cracks

C20R Combustion Section

Outer Combustion Case

- Dent removal & pressure check
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Restore air tube boss - BOTH
- Screen patch repair
- Sermetel paint
- Thread repair
- Weld repair cracks & pressure check

Combustion Liner

- CEB A72-4050
- Change fuel ferrule and/or ignitor
- Exchange (NOTE: ensure new prices of fuel nozzle ferrule or louvers or sections are included in NEW PARTS portion of quote if required)
- Install new details (Parts included)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Re-gap louvers
- Weld repair cracks (incl. burnt louvers)





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Air Discharge Tube

- ❑ Add braze patch
- ❑ Dent removal & pressure check
- ❑ Metallize and machine seal ring grooves
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- ❑ Sermetel paint

Fuel Nozzle

- ❑ 300 hour inspection (clean and flow)



Rolls Royce C30 Capabilities

C30 Compressor Section

Front Support

- Aft flange restoration
- Aft pilot plasma spray
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint
- Weld cracks and dents

Bleed Manifold

- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Weld repair cracks (Nickel plate external)
- Sermetel paint

Shroud Housing (Front Diffuser)

- Aseal coat
- Bleed slot CEB 72-3200
- CEB 72-3176
- Custom profile (incl. restore shroud contour)
- Exchange
- Metallize and machine aft flange incl. pilot diameter
- Metallize and machine forward flange incl. pilot diameter
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Pre-machine (for inspection)
- Restore shroud contour with Aluminium graphite, Metco 480, Metco 301
- Restore shroud contour with Aluminium polyester, Metco 444, and Aseal
- Restore shroud contour with XPT 268
- Skim aft flange
- Skim forward flange

Diffuser Vane Assembly

- Blend and dress vanes
- Exchange (Enhanced P/N 23066669)
- Exchange (Standard)
- Exchange (Two piece 23051119 enhanced)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Stud replacement - EACH (up to 3 studs only)



Scroll

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Remove broken bolt - EACH
- Remove patches - BOTH
- Replace PC fitting
- Sermetel paint
- Stud replacement - EACH (up to 3 studs only)
- Weld repair cracks (Plating extra)

Rear Support (Rear Diffuser)

- Add XPT seals CEB 72-3240
- CEB 72-3176
- Exchange
- Index pin CEB 72-3078
- Metallize and machine flange
- Metallize and machine rear pilot
- Metallize and machine seal bores
- Modify slot radius CEB 72-3273
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Sermetel paint

Impeller

- Blade straightening
- Blend and dress vanes incl. glass bead peen, NDT
- Machine bore new spline adapter (per CEB 72-3264 & PMI B00015)
- Overhaul inspect & tag (certify/rework) incl. NDT (excl. blade straightening)
- Restore damaged shaft internal splines IAW PRPL

Rear Mount

- CEB 72-3176
- Mount pads (skim surface only)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks (Nickel plating external)





C30 Gearbox Section

Gearbox Cover

- ❑ Bearing stud replacement - ALL (Parts extra) CEB 72-3073/2074 2&1/2
- ❑ Corrosion major repair (METAL SET)
- ❑ Corrosion minor repair (METAL SET)
- ❑ Exchange (Parts extra)
- ❑ Helicoil CEB 72-3033/2042
- ❑ Helicoil replacement CEB 72-3016/2021
- ❑ Insert repair helicoil/key insert - EACH (Parts extra)
- ❑ Install new 3 & 4 bearing cage (Parts extra) - ADD EXTERNAL FINISH GRIND ABOVE
- ❑ Install new 3 & 4 bearing cage (Parts extra) CEB 72-3206/2174 & 72-2169/3193 - ADD EXTERNAL FINISH GRIND ABOVE
- ❑ Install transfer tube flange bushing (Parts extra) CEB 72-3123/2119
- ❑ Metallize and machine cage bore (ALL) - EACH (Parts extra)
- ❑ Metallize and machine seal bore (ALL) - EACH
- ❑ Modify for new improved piccolo tube CEB 72-3212/2177
- ❑ New FCU oil pump gear slot CEB 72-3145/2131
- ❑ New mag plug insert CEB 72-3083/2008 (Parts extra)
- ❑ New scavenge pickup tube (Parts extra) CEB 72-3182/2163
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- ❑ Repaint
- ❑ Repair alignment dowel pin bores - BOTH (EO A-250-003)
- ❑ Repair turbine mount pad - replace stud (Parts extra) CEB 72-3017
- ❑ Repair turbine mount pads - shim and skim to print limits - EACH
- ❑ Repair turbine mount pads - skim all studs to print limits
- ❑ Replace bearing cage (ALL) - EACH (Parts extra)
- ❑ Replace stud on turbine mount pad - EACH
- ❑ Restore worn 3 & 4 bearing bore (Pre-machine, metallize and machine)
- ❑ Stud replacement incl. helicoil - EACH (Parts extra)
- ❑ Thermal spray torqueometer bore and face (EO 0027)



Gearbox Housing

- Compressor pilot bore - Pre-machine, metallize and machine
- Corrosion major repair (METAL SET)
- Corrosion minor repair (METAL SET)
- Enhance oil pump CEB 72-3152/2139
- Exchange (Parts extra)
- Helicoil CEB 72-3033/2042
- Helicoil replacement CEB 72-3016/2021
- Idler gearshaft bore - install insert - EACH (Parts extra)
- Install new flanged compressor mount studs (Parts extra) CEB 72-3126/2120
- Install transfer tube flange bushing (Parts extra) CEB 72-3123/2119
- Metallize and machine cage bore (ALL) - EACH (Parts extra)
- Mill oil filter mount surface
- Modify for new improved piccolo tube (Parts extra) CEB 72-3212/2177
- New bushing for oil check valve CEB 72-3089/2089
- New mag plug insert CEB 72-3083/2008 (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Repaint
- Repair alignment dowel pin bores - BOTH (EO A-250-002)
- Repair compressor mount pad - replace stud - EACH (Parts extra)
- Repair compressor mount pad - skim cut all studs
- Repair oil In, oil out, tank vent, and scavenge port - install insert - EACH (Parts extra)
- Replace bearing cage (ALL) - EACH (Parts extra)
- Stud replacement incl. helicoil - EACH (Parts extra)
- Torquemeter gearshaft bore - add chamfer CEB 72-3167/2151

Fuel Control Gearshaft, FCU/OP Gearshaft, Generator Gearshaft, Fuel Pump Gearshaft, Tach/Gov. Gearshaft, PTO Gearshaft, Centrifugal Breather Gearshaft,

- Polish journals

Pinion Gear

- Machine to remove contact damage

Pressure Pump Body

- Replace bearing cage - EACH (Parts extra)

Scavenge Pump Body

- Install transfer tube flange bushing (Parts extra) CEB 72-3123/2119





Oil Filter Housing

- Corrosion repair
- Exchange (Parts extra)
- Insert flanged bushing CEB 72-3154 (Parts extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Pressure regulator bore - sleeve repair
- Repaint
- Replace studs (Parts extra)
- Replace valve seat (Parts extra)

C30 Turbine Section

Exhaust Collector

- Add gearbox port vent (Parts extra) CEB 72-2096/3068
- Exchange
- Flow splitter modify (Parts extra) CEB 72-2049/3040
- Metallize and machine #5 bearing bore, surface "D", and labyrinth seal bore
- Metallize and machine pilot & #4 nozzle mounting face
- Metallize and machine forward pilot diameter "B"
- Metallize and machine rear flange surface "AN" (split-line flange)
- Metallize and machine turbine mount pad surface "A"
- Modify exhaust collector (Parts extra) CEB 72-2099/3096
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Restore snap ring groove
- Sermetel paint
- Skim rear flange surface "AN" (split-line flange)
- Skim turbine mount pad surface "A"
- Vent tube doublers (Parts extra) CEB 72-2111/2110/3111
- Weld repair #5 labyrinth seal air tube (incl. metallizing bearing bore, surface "D", and labyrinth seal bore)
- Weld repair cracks





PT Support

- ❑ CEB 72-2064/3061
- ❑ CEB 72-3151
- ❑ Exchange - Does not include 19-24 seal P/N 23004203 & cloverleaf P/N 23004205 (Parts extra)
- ❑ Finish machine 19-24 & 25-28 seals
- ❑ Metallize and machine aft pilot diameter
- ❑ Metallize and machine 19-24 seal
- ❑ Metallize and machine aft flange
- ❑ Metallize and machine fwd flange
- ❑ Metallize and machine sump cover mounting face
- ❑ Metallize 25-28 seal bore incl. NDT, plasma spray (Parts extra)
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- ❑ Remove broken bolt - EACH
- ❑ Replace 25-28 seal, incl. welding, NDT (Parts extra)
- ❑ Restore tang slots
- ❑ Sermetel paint
- ❑ Skim 25-28 seal only
- ❑ Skim aft flange
- ❑ Skim fwd flange
- ❑ Skim fwd pilot diameter
- ❑ Skim sump cover mounting face
- ❑ Weld repair bolt holes - EACH
- ❑ Weld repair cracks





GP Support

- #8 Oil dampened bearing (Parts extra) CEB 72-3199
- Add four additional containment ring slots CEB 72-3221
- Blend fretted struts
- Break edge hole CEB 72-2064/3061
- Exchange (Parts extra)
- Metallize and machine #1 nozzle face
- Metallize and machine aft flange
- Metallize and machine fwd flange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Restore containment ring pads
- Restore containment ring slots
- Restore nozzle tang slots
- Sermetel paint
- Skim 35 - 38 steel mating surface
- Skim fwd pilot diameter
- Weld repair bolt holes - EACH
- Weld repair cracks
- Weld repair struts

Containment Ring

- Overhaul inspect & tag (certify/rework) incl. NDT
- Repair tangs

1st and 2nd Stage Turbine Wheel

- Blade tip grinding
- Overhaul inspect & tag (certify/rework) incl. NDT

1st Stage Nozzle

- Exchange - New casting replacement (Parts extra)
- Exchange (Parts extra)
- Metallize and machine mounting face to restore overall height
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace diaphragm and keys
- Weld repair and/or replace keys (Parts extra)
- Weld repair casting - < 50% vanes
- Weld repair casting - > 50% vanes
- Weld repair casting - Up to 2 vanes





2nd Stage Nozzle

- Exchange (Casting replacement P/N 23075935)
- Exchange (Parts extra)
- Metallize and machine blade path #1
- Metallize and machine blade path #2
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace diaphragm only and ultrasonic inspection (Parts extra)
- Replace keys and ultrasonic inspection (Parts extra)
- Skim blade path #1
- Skim blade path #2
- Skim centre seal
- Weld repair tangs

3rd Stage Nozzle

- Exchange
- Metallize and machine forward flange
- Metallize and machine inner flange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair casting incl. heat treat, NDT

4th Stage Nozzle

- Exchange (Parts extra)
- Metallize and machine blade path #3
- Metallize and machine blade path #4
- Metallize and machine centre seal
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace diaphragm only and ultrasonic inspection (Parts extra)
- Replace keys and ultrasonic inspection (Parts extra)
- Skim blade path #3
- Skim blade path #4
- Skim centre seal
- Weld repair casting
- Weld repair tangs





PT Outer Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Polish to remove corrosion pitting
- Retempering

PT Inner Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT

PT Labyrinth Seal

- Skim knives

Sump Covers

- Exchange
- Finish machine 9-12 & 13-18 seals
- Metallize and machine 9-12 & 13-18 seals
- Metallize and machine mating surface and pilot diameter
- Overhaul inspect & tag incl. pre-machine, NDT, pressure test (restore seals extra)
- Skim mating surface

#1 Nozzle Shield

- Braze repair
- Exchange (Dome and deflector extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace deflector only
- Restore saddle tabs
- Weld repair cracks

#3 Nozzle Shield

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld build up saddle tabs
- Weld repair cracks



External Sump Can

- ❑ Restore mounting flange surface (Machining only)

Horizontal Fireshield

- ❑ Add scallop CEB 72-3219
- ❑ Cold work and dress welds
- ❑ Modify for new anti-ice CEB 72-3209
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT
- ❑ Replace broken access panel stud
- ❑ Sermetel paint
- ❑ Weld cracks

Vertical Fireshield

- ❑ #5 Air labyrinth seal install (Parts extra) CEB 72-3158
- ❑ Cold work and dress welds
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT
- ❑ Replace four to six mount pads (Parts extra) CEB 72-3110
- ❑ Replace mount pad - EACH (Parts extra)
- ❑ Sermetel paint
- ❑ Weld cracks

#5 Bearing Rotating Seal

- ❑ Skim seal knives (Labyrinth seal)

#5 Bearing Stationary Seal

- ❑ Metallize and machine seal (Labyrinth seal)





C30 Combustion Section

Outer Combustion Case

- Dent removal and pressure check
- Exchange (Does not include flange repair)
- Install braze patch repair - EACH
- Install braze patch repair per CEB 72-3010
- Metallize and machine rear mount flange and pilot
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Replace one lock wire tab (Parts extra)
- Sermetel paint
- Thread repair either drain fitting or exciter boss
- Weld repair cracks and pressure check

Combustion Liner

- Exchange - Low smoke liner P/N's 23066675, 23064570, 23063404 & 23066685
- Exchange - Standard liner for low smoke liner
- Exchange - Standard liner p/n 6899081
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks

Air Discharge Tube

- Add braze patch
- Dent removal & pressure check
- Metallize and machine aft flange
- Metallize and machine seal ring grooves
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Sermetel paint

Rear Engine Mount

- Exchange (With compliance of CEB's)
- Exchange (Without compliance of CEB's)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace bearing (Bearing p/n 23071966) CEB 72-3245/5025/6029 (Parts extra)
- Weld cracks

Fuel Nozzle

- 300 hour inspection (clean and flow)



Rolls Royce C47B Capabilities

C47B Compressor Section

Front Support

- Aft flange restoration
- Aft pilot plasma spray
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint
- Weld cracks and dents

Bleed Manifold

- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Sermetel paint
- Weld repair cracks (Nickel plate external)

Shroud Housing (Front Diffuser)

- Custom profile (incl. restore shroud contour)
- Exchange
- Metallize and machine aft flange incl. pilot diameter
- Metallize and machine forward flange incl. pilot diameter
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM (if required)
- Pre-machine (for inspection)
- Restore shroud contour with XPT 268
- Skim aft flange
- Skim forward flange

Diffuser Vane Assembly

- Blend and dress vanes
- Exchange (Standard)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Stud replacement - EACH (up to 3 studs only)





Scroll

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Remove broken bolt - EACH
- Remove patches - BOTH
- Replace PC fitting
- Sermetel paint
- Stud replacement - EACH (up to 3 studs only)
- Weld repair cracks (Plating extra)

Rear Support (Rear Diffuser)

- CEB 72-5008/72-6011 (PER PMI B0002)
- Exchange
- Metallize and machine flange
- Metallize and machine rear pilot
- Metallize and machine seal bores
- Modify slot radius CEB 72-5049/72-6055
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Sermetel paint

Impeller

- Blade straightening
- Blend and dress vanes incl. glass bead peen, NDT
- Overhaul inspect & tag (certify/rework) incl. NDT (excl. blade straightening)
- Restore damaged shaft internal splines IAW PRPL

Rear Mount

- Mount pads (skim surface only)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks (Nickel plating external)



C47B Gearbox Section

Gearbox Cover

- Bearing stud replacement - ALL (Parts extra)
- Corrosion major repair (METAL SET)
- Corrosion minor repair (METAL SET)
- Exchange (Parts extra)
- Insert repair helicoil/key insert - EACH (Parts extra)
- Install new 3 & 4 bearing cage & finish grind (Parts extra) - ADD EXTERNAL FINISH GRIND ABOVE
- Metallize and machine cage bore (ALL) - EACH (Parts extra)
- Metallize and machine seal bore (ALL) - EACH
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Repaint
- Repair alignment dowel pin bores - BOTH (EO A-250-003)
- Repair turbine mount pads - shim and skim to print limits - EACH
- Repair turbine mount pads - skim all studs to print limits
- Replace bearing cage (ALL) - EACH (Parts extra)
- Replace mag plug insert (Parts extra)
- Replace stud on turbine mount pad - EACH
- Replace transfer tube flange bushing (Parts extra)
- Restore worn 3 & 4 bearing bore (Pre-machine, metallize and machine)
- Splitline flange clearance cut CEB 75-6005 (PMI C0004)
- Stud replacement incl. helicoil - EACH (Parts extra)
- Thermal spray torqueometer bore and face (EO 0027)





Gearbox Housing

- Compressor pilot bore - Pre-machine, metallize and machine
- Corrosion major repair (METAL SET)
- Corrosion minor repair (METAL SET)
- Exchange (Parts extra)
- Helicoil replacement - EACH
- Idler gearshaft bore - install insert - EACH (Parts extra)
- Install new flanged compressor mount studs (Parts extra)
- Metallize and machine cage bore (ALL) - EACH (Parts extra)
- Mill oil filter mount surface
- Overhaul inspect & tag (certify/rework) incl. NDT
- Repaint
- Repair alignment dowel pin bores - BOTH (EO A-250-002)
- Repair compressor mount pad - replace stud - EACH (Parts extra)
- Repair compressor mount pad - skim cut all studs
- Repair oil In, oil out, tank vent, and scavenge port - install insert - EACH (Parts extra)
- Replace bearing cage (ALL) - EACH (Parts extra)
- Replace bushing for oil check valve
- Replace mag plug insert (Parts extra)
- Replace transfer tube flange bushing (Parts extra)
- Stud replacement incl. helicoil - EACH (Parts extra)

Fuel Control Gearshaft, FCU/OP Gearshaft, Generator Gearshaft, Fuel Pump Gearshaft, Tach/Gov. Gearshaft, PTO Gearshaft, Centrifugal Breather Gearshaft,

- Polish journals

Pinion Gear

- Machine to remove contact damage

Pressure Pump Body

- Replace bearing cage - EACH (Parts extra)

Scavenge Pump Body

- Replace transfer tube flange bushing (Parts extra)





Oil Filter Housing

- ❑ Corrosion repair
- ❑ Exchange (Parts extra)
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT
- ❑ Pressure regulator bore - sleeve repair
- ❑ Repaint
- ❑ Replace flanged bushing (Parts extra)
- ❑ Replace studs (Parts extra)
- ❑ Replace valve seat (Parts extra)

C47B Turbine Section

Exhaust Collector

- ❑ Exchange
- ❑ Metallize and machine #5 bearing bore, surface "D", and labyrinth seal bore
- ❑ Metallize and machine pilot & #4 nozzle mounting face
- ❑ Metallize and machine forward pilot diameter "B"
- ❑ Metallize and machine rear flange surface "AN" (split-line flange)
- ❑ Metallize and machine turbine mount pad surface "A"
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- ❑ Restore snap ring groove
- ❑ Sermetel paint
- ❑ Skim rear flange surface "AN" (split-line flange)
- ❑ Skim turbine mount pad surface "A"
- ❑ Weld repair #5 labyrinth seal air tube (incl. metallizing bearing bore, surface "D", and labyrinth seal bore)
- ❑ Weld repair cracks





PT Support

- ❑ CEB 72-2064/3061
- ❑ CEB 72-3151
- ❑ Exchange - Does not include 19-24 seal P/N 23004203 & cloverleaf P/N 23004205 (Parts extra)
- ❑ Finish machine 19-24 & 25-28 seals
- ❑ Metallize and machine aft pilot diameter
- ❑ Metallize and machine 19-24 seal
- ❑ Metallize and machine aft flange
- ❑ Metallize and machine fwd flange
- ❑ Metallize and machine sump cover mounting face
- ❑ Metallize 25-28 seal bore incl. NDT, plasma spray (Parts extra)
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- ❑ Remove broken bolt - EACH
- ❑ Replace 25-28 seal, incl. welding, NDT (Parts extra)
- ❑ Restore tang slots
- ❑ Sermetel paint
- ❑ Skim 25-28 seal only
- ❑ Skim aft flange
- ❑ Skim fwd flange
- ❑ Skim fwd pilot diameter
- ❑ Skim sump cover mounting face
- ❑ Weld repair bolt holes - EACH
- ❑ Weld repair cracks





GP Support

- Add four additional containment ring slots CEB 72-5016/6020
- Blend fretted struts
- Exchange (Parts extra)
- Metallize and machine #1 nozzle face
- Metallize and machine aft flange
- Metallize and machine fwd flange
- Overhaul inspect & tag (certify/rework) incl. NDT, CMM
- Restore containment ring pads
- Restore containment ring slots
- Restore nozzle tang slots
- Sermetel paint
- Skim 35 - 38 steel mating surface
- Skim fwd pilot diameter
- Weld repair bolt holes - EACH
- Weld repair cracks
- Weld repair struts

Containment Ring

- Overhaul inspect & tag (certify/rework) incl. NDT
- Repair tangs

1st and 2nd Stage Turbine Wheel

- Blade tip grinding
- Overhaul inspect & tag (certify/rework) incl. NDT

1st Stage Nozzle

- Exchange - New casting replacement (Parts extra)
- Exchange (Parts extra)
- Metallize and machine mounting face to restore overall height
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace diaphragm and keys
- Weld repair and/or replace keys (Parts extra)
- Weld repair casting - < 50% vanes
- Weld repair casting - > 50% vanes
- Weld repair casting - Up to 2 vanes





2nd Stage Nozzle

- Exchange (Casting replacement)
- Exchange (Parts extra)
- Metallize and machine blade path #1
- Metallize and machine blade path #2
- Metallize and machine centre seal
- Metallize and machine flange incl. pre-machine
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace diaphragm only and ultrasonic inspection (Parts extra)
- Replace keys and ultrasonic inspection (Parts extra)
- Skim blade path #1
- Skim blade path #2
- Skim centre seal
- Weld repair tangs

3rd Stage Nozzle

- Exchange
- Metallize and machine forward flange
- Metallize and machine inner flange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair casting incl. heat treat, NDT

4th Stage Nozzle

- Exchange (Parts extra)
- Metallize and machine blade path #3
- Metallize and machine blade path #4
- Metallize and machine centre seal
- Overhaul inspect & tag (certify/rework) incl. pre-machine, NDT
- Replace diaphragm only and ultrasonic inspection (Parts extra)
- Replace keys and ultrasonic inspection (Parts extra)
- Skim blade path #3
- Skim blade path #4
- Skim centre seal
- Weld repair casting
- Weld repair tangs





PT Outer Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Polish to remove corrosion pitting
- Retempering

PT Inner Shaft

- Alseal coat
- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT

PT Labyrinth Seal

- Skim knives

Sump Covers

- Exchange
- Finish machine 9-12 & 13-18 seals
- Metallize and machine 9-12 & 13-18 seals
- Metallize and machine mating surface and pilot diameter
- Overhaul inspect & tag incl. pre-machine, NDT, pressure test (restore seals extra)
- Skim mating surface

#1 Nozzle Shield

- Braze repair
- Exchange (Dome and deflector extra)
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace deflector only
- Restore saddle tabs
- Weld repair cracks

#3 Nozzle Shield

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld build up saddle tabs
- Weld repair cracks





External Sump Can

- ❑ Restore mounting flange surface (Machining only)

Horizontal Fireshield

- ❑ Add scallop CEB 72-3219
- ❑ Cold work and dress welds
- ❑ Modify for new anti-ice CEB 72-3209
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT
- ❑ Replace broken access panel stud
- ❑ Sermetel paint
- ❑ Weld cracks

Vertical Fireshield

- ❑ Cold work and dress welds
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT
- ❑ Replace mount pad - EACH (Parts extra)
- ❑ Sermetel paint
- ❑ Weld cracks

#5 Bearing Rotating Seal

- ❑ Skim seal knives (Labyrinth seal)

#5 Bearing Stationary Seal

- ❑ Metallize and machine seal (Labyrinth seal)

C47B Combustion Section

Outer Combustion Case

- ❑ Dent removal and pressure check
- ❑ Exchange (Does not include flange repair)
- ❑ Install braze patch repair - EACH
- ❑ Metallize and machine rear mount flange and pilot
- ❑ Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- ❑ Replace one lock wire tab (Parts extra)
- ❑ Sermetel paint
- ❑ Thread repair either drain fitting or exciter boss
- ❑ Weld repair cracks and pressure check





Combustion Liner

- Exchange - Low smoke liner
- Exchange - Standard liner
- Exchange - Standard liner for low smoke liner
- Overhaul inspect & tag (certify/rework) incl. NDT
- Weld repair cracks

Air Discharge Tube

- Add braze patch
- Dent removal & pressure check
- Metallize and machine aft flange
- Metallize and machine seal ring grooves
- Overhaul inspect & tag (certify/rework) incl. NDT, pressure test
- Sermetel paint

Rear Engine Mount

- Exchange
- Overhaul inspect & tag (certify/rework) incl. NDT
- Replace bearing (Bearing p/n 23071966) CEB 72-3245/5025/6029 (Parts extra)
- Weld cracks

Fuel Nozzle

- 300 hour inspection (clean and flow)





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