GT 2782D-1 (9-83)

SERVICE RECORD
TURBINE ASSEMBLY

Part I
Page No. _____

Turbine Serial Number CAT- 81050 Engine Model 250-B17F/2

INSTALLED					REMOVED			
Date	Owner	A/C or Eng. S/N	Turbine Time Since OH	Turbine Time Total	Date	Turbine Time Since OH	Turbine Time Total	Reason
2-28-94		881223	NEW	0.0	13 OCT 2023	New	2787.9	
13 JAN 2023		881223	0.0	2787.9				

1. SOUTH AFRICAN CIVIL AVIATION AUTHORITY

2.

AUTHORISED RELEASE CERTIFICATE

CA 21- 19 AIRWORTHINESS APPROVAL TAG

3. Form Tracking Number

T01803

4. Organization Name and Address:

nac

National Airways Corporation (Pty) Ltd
Rolls-Royce Turbine Engine Shop
Hanger 39 Rand Airport
Germiston
1404

Tel: +27110452564
Fax: +27118275049
Email: marc.post@nac.co.za
Web: www.nac.co.za

5.Work Order/Contract/Invoice Number:

RE1582

6.Item:	7.Description:	8.Part Number:	9.Eligibility:	10.Quantity:	11. Serial / Reg Number:	12.Status/Work:
Rolls-Royce M250	B17F/2 Turbine Assy	23033383	Yes	1	CAT81050 / N6593W	Overhaul

13.Remarks:

The turbine assembly was overhauled. New 1st and 2nd stage wheels and 2nd stage nozzle fitted. A overhauled 1st stage nozzle was fitted. The GP support and containment ring slots and wear pads were reworked by welding and machining. The PT support and sump cover seals were reworked by plasma spray. New PT outer shaft and coupling shaft fitted due to bulletin. The Inner shaft was recoated with Alseal. New No5 carbon seal and seal plate fitted.
All work carried out IAW Rolls-Royce Overhaul Electronic Publication Manual Pub GTP5243--3
Edition: 1 **Revision:** 24 **Dated:** May 1, 2020 (including up to TR E1R24-72-2 dated August 12, 2022). ATA: 72-50-00
Details pertaining to parts and job under Job No RE1582
All applicable duplicate inspections have been carried out.
All mandatory CEB's complied with up to and including CEB-TP-72-2109.
CEB's EMBODIED:
CEB-TPA-72-2030; CEB-TPA-72-2058; CEB-TPA-72-2069; CEB-TPA-72-2074; CEB-TPA-72-2089; CEB-TPA-72-2091; CEB-TP-72-2033; CEB-TP-72-2065; CEB-TP-72-2090; CEB-TP-72-2096; CEB-TP-72-2099; CEB-TP-72-2102; CEB-TP-72-2104.
All Mandatory AD's complied with up to and including AD 2006-16-04
AD's EMBODIED:
None.
CSL's EMBODIED:
CSL-PT-1120; CSL-TP-1196.

Wheels Removed					Wheels Fitted				
1st Stage Wheel	P/N: 6886407	S/N:X148664	T.T: 1812.78	TC: 3161	1st Stage Wheel	P/N: M250-10223	S/N:X661341	T.T: 0.0	TC: 0
2nd Stage Wheel	P/N: 6898782	S/N:HX129899	T.T: 1812.78	TC: 3161	2nd Stage Wheel	P/N: 23073854	S/N:X676638	T.T: 0.0	TC: 0

Released Untested

Engine hours: 2787.9 **Total Cycles:** 5082 **TSO:** 0.0 **CSO:** 0 **Time Remaining:** 3500

14. Certifies the items identified above were manufactured in conformity to:
□ Approved design data and are in condition for safe operation.
□ Non-approved data specified in block 13.

19. x Part 43 Release to Service □ Other regulation specified in block 13

Certifies that unless otherwise specified in Bloc k 13, and the work identified in Block 12 and described in Block 13 was accomplished in accordance with Civil aviation Regulations, part 43 and in respect to that work, the items are approved for return to service.

15.Authorised Signature	16 Approval/Authorization No.	20. Authorized Signature	21. Certificate/Approval Ref No.
		NAC HELICOPTER DIV 23 AMO 27	AMO 27
17.Name	**18.Date: (YY/MM/DD)**	**22. Name**	**Date: (YY/MM/DD)**
		Marc. Post	2023-01-13

CA 21- 19 *Installer must cross-check eligibility with applicable technical data.

User /Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the part/component/assembly.

Where the user/ installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1, it is essential that the user/ installer ensures that his/her airworthiness authority accepts parts/components/assemblies from the airworthiness authority of the country specified in Block 1.

Statements in Block 14 and 19 do not constitute installation certificate. In all cases, aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.

CA 21- 19 *Installer must cross-check eligibility with applicable technical Data.

AUTHORISED RELEASE CERTIFICATE-SACAA FORM CA 21-19

COMPLETION INSTRUCTIONS

These instructions relate to the use of SACAA Form 21-19 for manufacturing/maintenance purposes.

Purpose and Scope

The primary purpose of the certificate is to release products, parts, appliances (hereafter referred to as item(s) and/or materials as identified in block 7 through 11 as applicable after manufacture, or to release maintenance work carried out on items in accordance with the privileges conferred to the organization.

The certificate is to be used for export purposes, as well as for domestic and inter-production organization purposes, and serves as an official certificate for the delivery of items from the manufacturer to users.

It may only be used by organizations certified by the Authority under Part 21, 145 or 148, within the scope of such an approval.

A mixture of "New" and "Used" is not permitted on the same Certificate.

A mixture of items certified in conformity with "approved data" and to "non-approved data" is not permitted on the same certificate, and consequently only one statement on block 14 may be ticked.

A mixture of parts released under Part 21, 145 or 148 is not permitted on the same Certificate.

GENERAL

The Certificate must comply with the format attached including block numbers and the location of each block. The size of each block may however be varied to suit the individual application, but not to the extent that would make the Certificate unrecognizable. The overall size of the Certificate may be significantly increased or decreased so long as the Certificate remains recognizable and legible. If in doubt consult the Authority.

All printing must be clear and legible to permit easy reading.

The Certificate may either be pre-printed, or computer generated but in either case the printing of lines and characters must be clear and legible. Pre-printed wording is permitted in accordance with the attached model, but no other certification statements are permitted.

The details to be entered on the Certificate may be either machine or computer printed or hand-written using block letters and must permit easy reading. Abbreviations must be restricted to a minimum.

The original Certificate must accompany the items and correlation must be established between the Certificate and the item(s). A Copy of the Certificate must be retained by the organization that manufactured/maintained the item(s). Where the Certificate format and data is entirely computer generated, subject to acceptance by the Authority it is permissible to retain the Certificate format and data on a secure database.

National Airways Corporation (Pty) Ltd

Alert CEB /AD COMPLIANCE

B17 TURBINE S/No: CAT-81050 **P/No:** 2303383

REASON FOR SHOP VISIT: Overhaul **Job No:** RE1582

AD	B17F/2	C20	DESCRIPTION	Bulletin Status		
	CEB No:	CEB No:		Complied With	Previously Complied With	N/A
	TPA-72-2023	A-1283	PT shafts Alseal coating		X	
	TPA-72-2030	A-1292	Replace suspect splined adapters	X		N/A TO SERIAL NUMBER
	TPA-72-2032		Multi engine exhaust collector horizontal support repetitive inspection and modification		X	
	TPA-72-2051	A-1327	Fire shield retaining nut torque.		X	
	TPA-72-2058	A-1342	Inspection of 1st stage nozzle shield dome detail for HMI overhaul	X		
	TPA-72-2069	A-1370	Inspection of 1st stage nozzle shield dome	X		1000 CYCLE INTERVALES
AD2006-13-06	TPA-72-2070	A-1371	Replace turbine tie bolt		X	
	TPA-72-2074	A-1375	Replacement of 2nd stage nozzle	X		
	TPA-72-2089	A-1398	PT outer shaft, Certain Serial Numbers	X		
	TPA-72-2091	A-1400	Steady state operation avoidance range	X		

NAME: Marc Post **SIGN:** _____ **STAMP:** NAC HELICOPTER DIV 23 AMO 27 **DATE:** 2023-01-13

National Airways Corporation (Pty) Ltd

CEB/AD COMPLIANCE

B17 TURBINE S/No: CAT-81050 **P/No:** 2303383

REASON FOR SHOP VISIT: Overhaul **Job No:** RE1582

AD	B17	C20	DESCRIPTION	Bulletin Status		
	CEB No:	CEB No:		Complied With	Previously Complied With	N/A
	PT 72-2005	1267	2nd stage turbine wheel, reduced diameter balance piston seal knife		X	
	PT 72-2011	1276	Gas producer support, addition of brazed wear pads		X	
	PT 72-2038	1299	Rework combustion liner		X	
	PT 72-2029		Turbine assembly, First stage nozzle , Modify		X	
	PT 72-2048	1324	Release of new horizontal fire shield & access panel			Per Customer option
	PT 72-2049	1326	Release of new # 8 bearing & retaining plate		X	
	PT 72-2033	1333	Authorization to re-identify semi-finished 2nd stage nozzle	X		
	PT 72-2065	1360	Recoating of inner power turbine shaft	X		
	PT 72-2093	1365	Power turbine with improved airflow characteristics			PER CUSTOMER OPION
	PT 72-2090	1399	Inspection of sump nut	X		
	PT 72-2096	1406	Replacement of turbine GP forward labyrinth seal.	X		
	PT 72-2099	1414	N2 Shafting Replacement	X		NOT STRIPPED
	PT 72-2102	1417	NO. 5 Bearing Retaining ring replacement	X		
	PT 72-2104	1421	NO. 8 Bearing Manufactured by NHBB	X		N/A TO PART NUMBER
	PT 72-2108	1429	2ND Stage turbine wheel replacement.			N/A TO SERIAL NUMBER

NAME: Marc Post **SIGN:** _____ **STAMP:** NAC HELICOPTER DIV 23 AMO 27 **DATE:** 2023-01-13

National Airways Corporation (Pty) Ltd

CSL COMPLIANCE

B17 TURBINE S/No: CAT-81050 **P/No:** 2303383

REASON FOR SHOP VISIT: Overhaul **Job No:** RE1582

AD	B17	C20	DESCRIPTION	Bulletin Status		
	CEB No:	CEB No:		Complied With	Previously Complied With	N/A
		1026	Model 250 engine logbook	X		
		1036	Model 250 report	X		
		1125	Alignment build procedure	X		
	PT-1120	1165	Heavy maintenance inspection (H.M.I.) compliance option (A)	X		
	PT-1196	1244	Power turbine rotor clamping	X		

NAME: Marc Post **SIGN:** _____ **STAMP:** _____ **DATE:** 2023-01-13

1. SOUTH AFRICAN CIVIL AVIATION AUTHORITY

2.

AUTHORISED RELEASE CERTIFICATE

CA 21- 19 AIRWORTHINESS APPROVAL TAG

3. Form Tracking Number

T01803

4. Organization Name and Address:

National Airways Corporation (Pty) Ltd
Rolls-Royce Turbine Engine Shop
Hanger 39 Rand Airport
Germiston
1404

Tel: +27110452564
Fax: +27118275049
Email: marc.post@nac.co.za
Web: www.nac.co.za

5.Work Order/Contract/Invoice Number:

RE1582

6.Item:	7.Description:	8.Part Number:	9.Eligibility:	10.Quantity:	11. Serial / Reg Number:	12.Status/Work:
Rolls-Royce M250	B17F/2 Turbine Assy	23033383	Yes	1	CAT81050 / N6593W	Overhaul

13.Remarks:

The turbine assembly was overhauled. New 1st and 2nd stage wheels and 2nd stage nozzle fitted. A overhauled 1st stage nozzle was fitted. The GP support and containment ring slots and wear pads were reworked by welding and machining. The PT support and sump cover seals were reworked by plasma spray. New PT outer shaft and coupling shaft fitted due to bulletin. The Inner shaft was recoated with Alseal. New No5 carbon seal and seal plate fitted.

All work carried out IAW Rolls-Royce Overhaul Electronic Publication Manual Pub GTP5243--3

Edition: 1 **Revision:** 24 **Dated:** May 1, 2020 (including up to TR E1R24-72-2 dated August 12, 2022). ATA: 72-50-00

Details pertaining to parts and job under Job No RE1582

All applicable duplicate inspections have been carried out.

All mandatory CEB's complied with up to and including CEB-TP-72-2109.

CEB's EMBODIED:

CEB-TPA-72-2030; CEB-TPA-72-2058; CEB-TPA-72-2069; CEB-TPA-72-2074; CEB-TPA-72-2089; CEB-TPA-72-2091; CEB-TP-72-2033; CEB-TP-72-2065; CEB-TP-72-2090; CEB-TP-72-2096; CEB-TP-72-2099; CEB-TP-72-2102; CEB-TP-72-2104.

All Mandatory AD's complied with up to and including AD 2006-16-04

AD's EMBODIED:

None.

CSL's EMBODIED:

CSL-PT-1120; CSL-TP-1196.

Wheels Removed					Wheels Fitted				
1st Stage Wheel	P/N: 6886407	S/N:X148664	T.T: 1812.78	TC: 3161	1st Stage Wheel	P/N: M250-10223	S/N:X661341	T.T: 0.0	TC: 0
2nd Stage Wheel	P/N: 6898782	S/N:HX129899	T.T: 1812.78	TC: 3161	2nd Stage Wheel	P/N: 23073854	S/N:X676638	T.T: 0.0	TC: 0

Released Untested

Engine hours: 2787.9 **Total Cycles:** 5082 **TSO:** 0.0 **CSO:** 0 **Time Remaining:** 3500

14. Certifies the items identified above were manufactured in conformity to:
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19. ☒ Part 43 Release to Service □ Other regulation specified in block 13

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17.Name	**18.Date: (YY/MM/DD)**	**22. Name**	**Date: (YY/MM/DD)**
		Marc. Post	2023-01-13

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TURBINE ASSY STATUS SHEET
OUTBOUND

JOB RE1582 **P/N:** 23033383 **S/N CAT:** 81050 **REG:** N6593W

TT: 2787.9 **TSO:** 0.0 **TC:** 5082 **CSO:** 0

					TT	TC	TR	CR
1st STAGE WHEEL	P/N	M250-10223	S/N:	X661341	0.0	0	1775	3000
2nd STAGE WHEEL	P/N	23073854	S/N:	X676638	0.0	0	1775	3000
3rd STAGE WHEEL	P/N	23001967	S/N:	HX80050	2787.9	5082	1762.1	918
4th STAGE WHEEL	P/N	6853278	S/N:	HX68024	2787.9	5082	1762.1	918
1st STAGE NOZZLE	P/N	23075928	S/N	KD514758	Overhauled	0	ON CONDITION	ON CONDITION
2nd STAGE NOZZLE	P/N	M250-10577	S/N	513581	0.0	0	ON CONDITION	ON CONDITION
1st stg NOZZLE SHIELD	P/N	23084382	S/N	Unknown	2787.9	5082	ON CONDITION	ON CONDITION
TIE BOLT	P/N	23068265	S/N	NM85771	1812.78	NEW	ON CONDITION	6825
SPLINE ADAPTER	P/N	6898784	S/N	H1070017	2787.9	5082	ON CONDITION	ON CONDITION
N1SHAFTING	P/N	6898977	S/N	AE71002	2787.9	5082	ON CONDITION	ON CONDITION
N2 SHAFTING	P/N	M250-10416	S/N	WN62136	0.0	0	ON CONDITION	ON CONDITION

TIME REMAINING HOURS 1762.1 CYCLES 918

INSPECTOR: Marc Post **SIGNED:** _____ **STAMP:** NAC HELICOPTER DIV 23 AMO 27 **DATE:** 13-Jan-23

AD Compliance

CAT81050 RE1582 Skycare Aviation Turbine Overhaul 2023-01-13

AD Number	Subject	Status	Effective Dat	Model
2006-16-04 PCW	Inspection of the fuel nozzle screen	Current	09/07/2006	250-B15A | 250-B15E | 250-B15G | 250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C10 (T63-A-5) | 250-C10B (T63-A-5A) | 250-C10D (T63-A-700) | 250-C18 | 250-C18A | 250-C18B | 250-C18C | 250-C20 | 250-C20B | 250-C20C (T63-A-720) | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W | 250-C28 | 250-C28B | 250-C28C | 250-C30 | 250-C30G | 250-C30G/2 | 250-C30M | 250-C30P | 250-C30R (T703-AD-700) | 250-C30R/1 (T703-AD-700B) | 250-C30R/3 | 250-C30R/3M | 250-C30S | 250-C30U | 250-C40B | 250-C47B | 250-C47M
2006-13-06 PCW	Gas producer rotor assembly tie bolts	Current	07/26/2006	250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C18 | 250-C20 | 250-C20B | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W
2001-24-12 PCW	Helical Torquemeter Gearshaft Assembly	Current	12/19/2001	250-B17 | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C20 | 250-C20B | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20S | 250-C20W
98-24-28 PCW	Main Fuel Control Bellows	Current	01/07/1999	250-B15A | 250-B15E | 250-B15G | 250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C18 | 250-C18A | 250-C18B | 250-C18C | 250-C20 | 250-C20B | 250-C20C (T63-A-720) | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W | 250-C28 | 250-C28B | 250-C28C | 250-C30 | 250-C30G | 250-C30G/2 | 250-C30M | 250-C30P | 250-C30R (T703-AD-700) | 250-C30R/1 (T703-AD-700B) | 250-C30R/3 | 250-C30S | 250-C30U
96-19-01 PCW	Superior Air Parts Manufacture Approval (PMA) Bearings	Current	09/26/1996	250-B15G | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C20 | 250-C20B | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W | 250-C28B | 250-C28C | 250-C30 | 250-C30G | 250-C30M | 250-C30P
77-15-12 PCW	Power Turbine Coupling Nut	Current	09/23/1977	250-B15A | 250-B15E | 250-B15G | 250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C18 | 250-C18A | 250-C18B | 250-C18C | 250-C20 | 250-C20B | 250-C20C (T63-A-720) | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W

13 JAN 2023

23 AUG 27 MAC HELICOPTER DIV

88-17-01 PCW	Fuel Controls	Current	03/01/1989	250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C20 | 250-C20B | 250-C20C (T63-A-720) | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W | 250-C30 | 250-C30G | 250-C30G/2 | 250-C30M | 250-C30P | 250-C30R (T703-AD-700) | 250-C30R/1 (T703-AD-700B) | 250-C30R/3 | 250-C30S | 250-C30U
82-24-05 PCW	Control Assembly and Power Turbine Governor Assembly	Current	11/26/1982	250-B15A | 250-B15E | 250-B15G | 250-B17 | 250-B17B | 250-B17C | 250-B17D | 250-B17E | 250-B17F | 250-B17F/1 | 250-B17F/2 | 250-C10 (T63-A-5) | 250-C10B (T63-A-5A) | 250-C10D (T63-A-700) | 250-C18 | 250-C18A | 250-C18B | 250-C18C | 250-C19 | 250-C20 | 250-C20B | 250-C20C (T63-A-720) | 250-C20F | 250-C20J | 250-C20R | 250-C20R/1 | 250-C20R/2 | 250-C20R/4 | 250-C20S | 250-C20W | 250-C28 | 250-C28B | 250-C28C | 250-C30 | 250-C30G | 250-C30G/2 | 250-C30M | 250-C30P | 250-C30R (T703-AD-700) | 250-C30R/1 (T703-AD-700B) | 250-C30R/3 | 250-C30S | 250-C30U | 250-C40B | 250-C47B | 250-C47M

NAC HELICOPTER DIV
23
AMO 27
13 JAN 2023

GT 2782D-1 (9-83)

TRANSFER RECORD

Part II
Page No. _____

Turbine Serial Number CAT- 81050 Engine Model 250- B17F/2

SHIPPED					RECEIVED	
			Turbine Time			
Date	From	To	Since OH	Total	Date	By
2-28-94	AGT-GMC	O+N	NEW	0.0		

GT 2783D-1 (9-83)

MODIFICATION RECORD
TURBINE ASSEMBLY

Part III
Page No. _____

Turbine Serial Number CAT- 81050 Engine Model 250- B17F/2

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
6 July 2000	AD 96-19-01	Rolls Royce No 5+8 Bearings found		H+S
		fitted and refitted		Aviation
—"—	CEB ATP72-2069 Ro	Inspection of 1st stage nozzle shield.		
16-9-03	CEB ATP-72-2069R1	Inspection of 1st stage nozzle shield.		
		23062750 fitted repeat at 1000 cycles		H+S
—"—	CEB TP 2070 Ro	Replace Trabolt.		Aviation.
—"—	CEB ATP-72-2074B	2nd stg nozzle replace diaphragm.	H+S 1003	
		Note NOT ONLY THIS REPAIR		
24 July 07	CEB ATP 72-2069R3.	1st stg nozzle shield 23084382		
		fitted.		H+S
—"—	ATP 72-2089R2	Not applicable		Aviation
—"—	ATP 72-2091 Ro	Not applicable	H+S 1003	

GT 2783D-1 (9-83)

MODIFICATION RECORD
TURBINE ASSEMBLY

Part III
Page No. _____

Turbine Serial Number CAT- 81050 Engine Model 250- B17F/2

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
15 Jan 2023	CEB-TPA-72-2030	PT shaft Hseal coating		
	TPA-72-2058	Insp 1st stg Nozzle shield dome		
	TPA-72-2069	Insp 1st stg Nozzle shield dome		
	TPA-72 2074	Replacement of 2ND stg Nozzle		
	TPA-72-2089	PT outer shaft S/N		
	TPA-72-2091	Steady state operation avoidance		NAC
	TP-72 2033	Autorization to re-identify 2ND stg Nozzle		
	TP-72-2065	Recoating of Inner turbine shaft		
	TP-72-2090	Inspection of sump nut		
	TP-72-2096	Replacement of turbine GP ladyrinth seal		
	TP-72-2099	N2 shafting Replacement		
	TP-72-2102	No 5 Bearing Retaining ring Rep.		
	TP-72-2104	No 8 Bearing mach by NTFBB		

NACHI COPTER DIV 23 MAY 21

INSPECTION — MAINTENANCE — OVERHAUL RECORD

TURBINE ASSEMBLY

GT 2784D-1 (9-83)

Turbine Serial Number CAT- 81050 Engine Model 250-B17F/2

Date	Turbine Time Since OH	Turbine Time Total	Remarks	Signature	Organization
6 JULY 2000	NEW	975:12	TURBINE REPAIRED AND TESTED.		
			H.M.1 CARRIED OUT IAW AMCIL		
			155. TIEBOLT P/N° 23008020 S/N°		
			DJ 71070. FREE STATE LENGTH 6.878"		H+S
			P/N° 23062750 1ST STG NOZZLE		AVIATION
			SHIELD FITTED NEW THIS VISIT.		
			1000 CYCLES AVAILABLE. H+S AVIATION		
			PROJECT 4174601 REFERS.		
16-9-03	New	1322:42.	Propeller strike inspection, repaired &		
		2210 cycles	tested. Tiebolt S/N NM 85771 free length		H+S
			6.880" 23062750 1st stg nozzle shield restricted		Aviation
			to 1000 cycles. H+S Aviation project	H+S 1003	
			6122836 refers		

INSPECTION — MAINTENANCE — OVERHAUL RECORD

TURBINE ASSEMBLY

GT 2784D-1 (9-83)

Turbine Serial Number CAT- 81050 Engine Model 250-B17F/2

Date	Turbine Time Since OH	Turbine Time Total	Remarks	Signature	Organization
24 July 07	New	2069:00	Turbine repaired (exhaust		
		2865cyc	collector changed) not tested.		
			1+2 wheels 6681:12 hours 2056		
			cycles available. 3+4 wheels		H+S
			2481:00 hours 3135 cycles		Aviation
			available. Turbot 8056 cycles	H+S 1003	
			available. H+S Aviation project		
			6298958 miles		

Inspection - Maintenance - Overhaul Record
TURBINE ASSEMBLY

Rolls-Royce

Part IV
Page No. 3

Turbine Serial Number CAT-81050 Engine Model 250- B17F/2

Date	Turbine Time		Remarks	Signature and Certificate No.	Organization
	Since OH	Total			
13 JAN 2023	0.0	2787.9	The turbine Assy was	ARC-T01803	NAC
	cycles	~~3345~~ NP	overhauled. 1+2 stage		
		5082	wheels replaced.		
			Details of work under		
			NAC job NO RE1582		
			Tie bolt Free length		
			6.881		

NAC HELICOPTER DIV 23 MAR 77

F-2784D (8/99)

ASSEMBLY RECORD
TURBINE ASSEMBLY

Part V
Page No. _____

GT 2785D-1 (9-83)

Turbine Serial Number CAT - 81050 Engine Model 250-B17F/2

Nomenclature	Part Number	Serial Number	INSTALLED Date	INSTALLED Turbine Total Time	INSTALLED This Item TT / Cycles	REMOVED Date	REMOVED Turbine Total Time	REMOVED This Item TT / Cycles	Reason
1ST STG.WHL.	6886407	X129449	2-28-94	0.0	0.0	6 JULY 00	975:12	975:12 / 1921	CRACKED.
2ND STG.WHL.	6898782	HX112520	"	0.0	0.0	—"—	—"—	975:12 / 1921	—"—
3RD STG.WHL.	23001967	HX80050	"	0.0	0.0				
4TH STG.WHL.	6853279	HX68024	"	0.0	0.0				
1ST STG WHL	6886407	X148664	6 JULY 00	975:12	0.0 / NIL				
2ND STG WHL	6898782	HX129899	6 JULY 00	975:12	0.0 / NIL				
Tiebolt	23068265	NM 85771	16-9-03	1322:42	N/A / 00				

Assembly Record
Turbine Assembly

Rolls-Royce

nac

Part V
Page No. 2

Turbine Serial Number CAT- 81050

Engine Model 250- B17/2

Nomenclature	Part Number / Serial Number	Installed Date	Installed Turbine TT Cycles	Installed Component TT Cycles	Removed Date	Removed Turbine TT Cycles	Removed Component TT Cycles
1st stage wheel	M250-10223 / X661341	13 JAN 2023	2787.9 / 5082	0.0 / 0			
2ND stage wheel	23073854 / X676638	13 JAN 2023	2787.9 / 5082	0.0 / 0			
1st stg Nozzle	23075928 / KD514758	13 JAN 2023	2787.9 / 5082	(O/H) 0.0 / 0			
2ND stg Nozzle	M250-10577 / 513581	13 JAN 2023	2787.9 / 5082	0.0 / 0			
N2 outer shaft	M250-10415 / GK578364	13 JAN 2023	2787.9 / 5082	0.0 / 0			
N2 coupling	M250-10416 / WN62136	13 JAN 2023	2787.9 / 5082	0.0 / 0			
Spline Adapter	6898784 / H1070017	13 JAN 2023	2787.9 / 5082	2787.9 / 5082			
1st stg Nozzle Shield	23084382 / UNK	13 JAN 2023	2787.9 / 5082	2787.9 / 5082			

F-2785D (12/98)

GT 9386-1 (9-83)

CYCLE RECORD
TURBINE ASSEMBLY

(Refer to Life Limiting CSL)

Part VI
Page No._____

Turbine Serial Number CAT - 81050 Engine Model 250- B17F/2

Installed				Do Not Exceed Cycle Counter Reading	Removed		Cycles This Installation
Date	Owner	Eng S/N	Cycle Counter Reading		Date	Cycle Counter Reading	
2-28-94		881223	0	3000	6 July 00	1921	1921
6 July		881223	1921	2921			