



KEYSTONE HELICOPTER SERVICES
1420 PHOENIXVILLE PIKE • WEST CHESTER, PA 19380

ASSEMBLY RECORD

ENGINE ASSEMBLY

Part V
Page No. _____

Engine Serial Number CAE 830278

Engine Model 250-C20B

Nomenclature	Part Number	Serial Number	INSTALLED			REMOVED			Reason
			Date	Engine Total Time	TSO This Item	Date	Engine Total Time	TSO This Item	
Gearbox	6894171	23346	4-29-98	4580.0	0.0				
Compressor	6890550	38718F	4-29-98	4580.0	1673.8				
Turbine	6898735	35461	4-29-98	4580.0	58.0				
Control	23065104	331480	4-29-98	4580.0	0.0	5/7/99	4580	0.0	
Governor	23065123	29288	4-29-98	4580.0	0.0	7/27/22	4622	42	Convenience
Pump	6899253	T103568	4-29-98	4580.0	0.0				
Fuel Nozzle	6890917	2990	4-29-98	4580.0	0.0	3/1/06	4609		0/14 EXCG
Bleed Valve	23053176	FF 22874	4-29-98	4580.0	0.0				
Control	2524644 -30H	302841	5/7/99	4580	1302	3/5/19	4682	1153	
FUEL NOZZLE	23077068	A639719	3/15/06	4609	0				
Fuel Control	2524644-31	GR52248	3/5/19	4724.5	0				
Governor	23065123	14479	7/27/22	4631.7	1750.9	5/10/24	5143.5	272627	



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Page No. _____

Engine Serial Number CAE 830278

Engine Model A250-C20B

Nomenclature	Part Number	Serial Number	INSTALLED			REMOVED			Reason
			Date	Engine Total Time	TSO This Item	Date	Engine Total Time	TSO This Item	
GEARBOX	6894171	33281	12/16/94	4580.0	4562.2	9/26/95	4580.0	4562.2	To Stock
COMPRESSOR	6890550	34202	12/16/94	4580.0	0.0	4/21/95	4580.0	0.0	Transfer
TURBINE	6898735	33281	12/16/94	4580.0	0.0*	4/21/95	4580.0	0.0	Transfer
CONTROL	23057344	327309	12/16/94	4580.0	0.0	9/21/95	4580.0	0.0	To Stock
GOVERNOR	23007505	26277	12/16/94	4580.0	95.5	9/19/95	4580.0	95.5	To Stock
PUMP	6899253	T3769	12/16/94	4580.0	0.0	6/16/95	4580.0	0.0	Transfer
FUEL NOZZLE	6890917	AG 62433	12/16/94	4580.0	2.2	9/19/95	4580.0	2.2	To Stock
BLEED VALVE	23053176	FF 30082	12/16/94	4580.0	0.0	9/19/95	4580.0	0.0	To Stock
* 3rd & 4th stage wheels must be replaced in 1361 hours or 2600 cycles.									

ASSEMBLY RECORD

ENGINE ASSEMBLY

Nomenclature	Part Number	Serial Number	INSTALLED			REMOVED			Reason
			Date	Engine Total Time	TSO This Item	Date	Engine Total Time	TSO This Item	
GOVERNOR	6898854	9268	JUNE 81	1498.2	Ø	OCT 81	1597.6	99.4	ENG 31N 830095 INSTALLED
DOUBLE VALVE	6876557B	37665	JUNE 81	1498.2	Ø	OCT 81	1591.6	99.4	ENG 31N 830095 INST.
TURBINE	6286443	33281	OCT 81	1596.6	Ø	OCT 81	1597.6	1	ENG 31N 830095 INST.
COMPRESSOR	6890550	33099	OCT 25/81	1597.1	Ø	OCT 27/81	1597.6	1597.6	TURBINE - SEIZED
GEAR BOX	6886442	33281	NOV 81	JJK 1611.9	1597.6	26-7-83	1905.4	1891.1	Repair.
COMPRESSOR	6890550	33280	NOV 81	JJK 1611.9	1597.1	26-7-83	1905.4	1890.6	
TURBINE	6886443	33281	NOV 81	JJK 1611.9	1	26-7-83	1905.4	294.5	
GOVERNOR	6896568	9268	NOV 81	JJK 1611.9	99.4	26-7-83	1905.4	392.9	
NOZZLE	6874959	AG-21641	NOV 81	JJK 1611.9	99.4	26-7-83	1905.4	392.9	
BLEED VALVE	6875120	FF12415	NOV 81	JJK 1611.9	99.4	26-7-83	1905.4	392.9	
FUEL PUMP	6876121	PE5346	NOV 81	JJK 1611.9	1591.1	4/85	2273	2252.2	T/X
FUEL CONTACT	6895663	320213	NOV 81	JJK 1611.9	937.6	26-7-83	1905.4	1231.1	
D.C. V.	6876557A	37665	NOV 81	JJK 1611.9	99.4	26-7-83	1905.4	392.9	
FUEL PUMP	6876121	PE5346	4/85	2273	Ø				

ASSEMBLY RECORD

ENGINE ASSEMBLY

Part V
Page No. _____

FORM 2785 A

Engine Serial Number CAE - 830278 Engine Model 250-C20B

Nomenclature	Part Number	Serial Number	INSTALLED			REMOVED			Reason
			Date	Engine Total Time	TSO This Item	Date	Engine Total Time	TSO This Item	
GEARBOX	6886442	33281	6-30-76	0.0	New	OCT 81	1597.6	1597.6	ENG S/N 830095 INSTALLED.
COMPRESSOR	6890550	33280	"	"	"	7/79	961.9	TSN	repair
TURBINE	6886443	33281	"	"	"	"	"	"	"
CONTROL	6887755	320054	"	"	"	9-20-78			DIRTY, SLOW ACCEL.
GOVERNOR	6876568	17665	"	"	"	JUNE 81	1498.2	1498.2	TX.
PUMP	6876721	PE5346	"	"	"	OCT 81	1597.6	1591.1	ENG S/N 830095 TEST.
FUEL NOZZLE	6890917	AG31400	"	"	"	JUNE 81	1498.2	1498.2	TX
BLEED VALVE	6889815	FF18161	"	"	"	JUNE 81	1498.2	1498.2	TX
CONTROL	6895663	320213	9-20-78	660	0.0	OCT 81	1597.6	937.6	ENG S/N 830095 INSTALLED.
COMPRESSOR	6890550	33280	8/79	961.9	TSN	Oct 81	1597.1	1597.1	#1 BEARING LEAKING.
TURBINE	6886443	33281	"	"	"	Aug 81	1596.6	1596.6	CE 31174 SIZED.
BLEED VALVE	6899115	FF12415	JUNE 81	1498.2	Ø	OCT 81	1597.6	99.4	ENG Assy S/N 830095 TEST.
FUEL NOZZLE	6833333	AG27641	JUNE 81	1498.2	Ø	OCT 81	1597.6	99.4	ENG S/N 830095 INSTALLED.



KEYSTONE HELICOPTER SERVICES
1420 PHOENIXVILLE PIKE • WEST CHESTER PA 19380

INSPECTION — MAINTENANCE OVERHAUL RECORD ENGINE ASSEMBLY

Part IV
Page No. _____

Engine Serial Number CAE 830278

Engine Model A250-C20B

ALBE 681-3

Date	Engine Time		Remarks	Signature	Organization
	Since OH	Total			
12/16/94	TSN	4580.0	Overhauled the compressor and repaired and updated the turbine, complied with all scheduled inspections through the 1750 hour, and tested per the manufacturer's specifications.		
Cycle Counter	0001				

The powerplant and/or component identified herein was repaired and inspected in accordance with current Federal Aviation Administration Regulations, and was found airworthy for return to service. Pertinent details of the repairs are on file at this agency under:

W.O. No. E4090 Date 12/28/94
Signed Timothy J. Wabl for

KEYSTONE ENGINE SERVICES
1420 PHOENIXVILLE PIKE
WEST CHESTER, PA 19380
A Division of Keystone Helicopter Corp.

CRS # YKER025K

INSPECTION — MAINTENANCE — OVERHAUL RECORD

ENGINE ASSEMBLY

FORM 2784 A

Engine Serial Number CAE - 830278 Engine Model 250-C20B

Date	Engine Time		Remarks	Signature	Organization
	Since OH	Total			
6-30-76	New	0.0	Fuel System Preserved with MIL-0-6081 OIL	<i>Stevenson</i>	DDA-GMC
10-21-76	NEW	0.0	Gov #N17665 INSPECTED PER CERS-1106	<i>J. J. Jett</i>	DDA - G.M.C.
8/7/79	TSN	961.9	Inspected, repaired, and tested in accordance with manufacturer's specifications.	<i>Schomaker</i>	Airwork

This certifies that only the work requested by the customer and described on our work order listed below, was accomplished and inspected in accordance with manufacturer's specifications and with current Federal Aviation Administration regulations, and is approved for return to service. Pertinent details of this repair are on file at this agency under:

Job No. X-77275 Date August 7, 1979
Signed *Arthur A. Schomaker* for 2203052

Airwork Service Division - (C.R.S - 3507)
Millville Municipal Airport
Millville, New Jersey 08332



KEYSTONE HELICOPTER SERVICES
1420 PHOENIXVILLE PIKE • WEST CHESTER, PA 19380

MODIFICATION RECORD

ENGINE ASSEMBLY

Part III
Page No. 3

Engine Serial Number CAE 830278

Engine Model A250-C20B

ALBE 681-2

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
12/16/94	CEB 1156	Bleed valve gasket - replace	<i>T. Wahl</i>	Keystone
	CEB 1198 R2	Fuel tubes - add clamps		Engine
	CEB A-1233	Improved PC filter housing		Services
	CEB A-1234R3	PC tube and fittings - inspect		
	CEB A-1281R2	Governor - inspect port casting		
	CEB A-1289	Governor - remove accumulator		
12/16/94	CEB A-1294	PC tube - replace	<i>T. Wahl</i>	YKER025K
4-29-98	CEB A-1349	Proper clamping of oil check valve	<i>Kevin ...</i>	K.E.S. YKER025K
3/7/01	CEB 1374	Comp. Scroll Pres Probe	<i>2005 Apr 27 4-5745</i>	<i>Signature H-11</i>

MODIFICATION RECORD

ENGINE ASSEMBLY

FORM 2783 A (BACK)

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
	CEB 1128	REPLACE NO 5 TURBINE OIL BELLOW SERT AT OVERTHULL		
NA	CEB 1129	BENDIX GOV PNEUMATIC CIRCUIT CLEANING - NA - MORE THAN 100 HRS	NA	NA
NA	AD 78-14-08 CEB 1051, CS 41 (W)	DUAL ELEMENT PUMP NA - SINGLE ELEMENT	NA	NA
NA	CEB 1125	NEW PIN BENDIX GOV FOR MULTI APPLIC. NA - SINGLE ENGINE	NA	NA
NA	CEB 1104	HIGH PRESS FUEL FILTER INSP NA - BENDIX	NA	NA
NA	CEB 1130	BENDIX GOV DRIVE SPLINE COMPL - P/INE NA - PIN	NA	NA
8/7/79	AD 73-19-7	not applicable Bendix System installed	<i>[Signature]</i>	Airwork
"	AD 77-09-08	complied with previously		"
"	AD 78-14-08	not applicable P/N 6876721 pump installed		Airwork
1-5-80	AD 79-21-01	N/A BY P/N	<i>[Signature]</i>	AMERICAN JET SERVICE
Oct 21 '81	CEB-1174	3 RD STG TURBINE INSP DONE (15966) ^{TJIS}	TURBINE #/N 33221 TSN 15966	
		TSO & SAE w/p 34270	HELI VOYAGEUR LTÉE	
Oct 81	CEB-1177	^{TJK HVW/O} (15966) 3150 INSP of OIL DELIVERY	HELI VOYAGEUR LTÉE	
		G/B #/N 33221 TUBE (PICCOLO) FOR BURAS.	HELI VOYAGEUR LTÉE	

MODIFICATION RECORD

ENGINE ASSEMBLY

FORM 2783 A

Engine Serial Number CAE - 830278

Engine Model 250-C20B

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
10-21-76	CEB-1092	INSTALL A 5 MICRON FUEL FILTER	J. J. Jett	DDA-G.M.C.
5-19-77	AD77-09-08	(CEB#1116) ADD BLEED VALVE STRAINER	M. Johnson	CRESCENT
NA	CEB 1042	FUEL PUMP TO CONTROL + FIC TO PUMP BYPASS CLAMPS - REPLACE - NA SERIAL NO	NA	NA
NA	CEB 1055	CECO PIC VALVE SPRING - REPLACE NA - BENDIX	NA	NA
	CEB 1082	INSTALL NET SPLINE STARTER SHAFT OPTIONAL		
NA	CEB 1085	NO 1 BEARING + ANTI-ICE TUBE CLAMP REPLACE - NA SERIAL NO.	NA	NA
9-21-78	CEB 1079 CEB 1089	REPLACE BENDIX FUEL INLET FILTER REPLACE FIC THROTTLE SHAFT ASSEMBLY	H. B. WATSON J. Johnson	OTI/ME GOV. INST. CRESCENT
NA	CEB 1093	REPLACE CECC GOV. BYPASS VALVE NA - BENDIX	NA	NA
6-27-78	CEB 1101	ADD CHECK VALVE ASSEMBLY	M. Johnson	CRESCENT
10-21-76	CEB 1106	INSPECT GOVERNOR THROTTLE SHAFT	STEVENSON	DDA-G.M.C.
NA	CEB 1112	ADD SINGLE ELEMENT FUEL PUMP DRIVE SHAFT STOP NA - PART NO	NA	NA
6-27-78	CEB 1115	ANTI ICE VALVE ROCKET SEAT SCREW INSPECT	M. Johnson	CRESCENT
	CEB 1120	REPLACE POWER TURBINE COUPLING NUT - AT-OVERHAUL		
	CEB 1126	AUTO RELIGNMENT CONTROL MODIFICATION		

