



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

# INSPECTION — MAINTENANCE OVERHAUL RECORD TURBINE ASSEMBLY

Part IV 4  
Page No. \_\_\_\_\_

CAT - 35461

250 - C20B

Date	Turbine Time		Remarks	Signature	Organization
	Since OH	Total			
11-25-97	52.2	3406.3	Inspected externally and hot end for time - continued operation, after return from Rental. Tested per the Manufacturer's Specifications.		
Cycles	75	3299			

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

W.O. No. A00613 Date 11-26-97  
Signed Timothy J. Wald for \_\_\_\_\_

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

**CRS # YKER025K**

12/16/97	58.0	3412.1	Inspected the hot end and exterior of the turbine and functionally tested per the manufacturer's specifications.		
Cycles	81	3305			

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

W.O. No. A00637 Date 12/16/97  
Signed Timothy J. Wald for \_\_\_\_\_

KEYSTONE ENGINE SERVICES  
1420 PHOENIXVILLE PIKE  
WEST CHESTER, PA 19380  
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**CRS # YKER025K**



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

# INSPECTION — MAINTENANCE OVERHAUL RECORD TURBINE ASSEMBLY

Part IV 3  
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Turbine Serial Number CAT 35461

Engine Model 250-C20B

Date	Turbine Time		Remarks	Signature	Organization
	Since OH	Total			
4/18/97	0.0	3354.1	Overhauled, modified and tested per the manufacturer's specifications. S/N DJ71381 tiebolt free length was 6.8825";		
Cycles	0	3224	stretched length is 6.8970".		

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

W.O. No. A00244 Date 4/18/97

Signed Timothy J. Wall for \_\_\_\_\_

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9-15-97	29.3	3383.4	Inspected externally after return from rental and tested per the manufacturer's specifications.		
Cycles	62	3286			

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

W.O. No. A00508 Date 9-15-97

Signed Timothy J. Wall for \_\_\_\_\_

KEYSTONE ENGINE SERVICES  
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**CRS # YKER025K**

# INSPECTION — MAINTENANCE — OVERHAUL RECORD

## TURBINE ASSEMBLY

FORM 2784 D (BACK)

Date	Turbine Time		Remarks	Signature	Organization
	Since OH	Total			
8-3-95	T.S-N	3202.6	Repaired ducts #5 CRS/Adm	<i>[Signature]</i>	Metro Aviation CRS HDNR610E
	T.CYC	2883	All work done I/A/W O/H Manual 10W3 VOL I,		
<p>The item identified above was repaired and inspected in accordance with current Regulations of the Federal Aviation Administration and is approved for return to service. Pertinent details of the repair are on file at this repair station under order No. <u>832429030795</u> Date <u>8-3-95</u> Signed <u><i>[Signature]</i></u> for</p> <p>Metro Aviation, Inc. CRS # HDNR610E Airport Rd. Downtown Airport #120 Shreveport, La. 71107</p>					

# INSPECTION — MAINTENANCE — OVERHAUL RECORD

## TURBINE ASSEMBLY

FORM 2784 D

Turbine Serial Number CAT-35461 Engine Model 250-C20B

Date	Turbine Time		Remarks	Signature	Organization
	Since OH	Total			
26Jan84	1752.0	1752.0	Heavy maintenance inspection W01687T	<i>C. P. Montgomery</i>	HELIPOWER 401-94
8-8-94	NEW	2938.1	Comply with repair order to burn		Metro
	T.C.O.	2808.	#1 NOZZLE + G/W Sudden Stoppage		Aviation
			Inspection. All work done I/A/W		INC.
			OPS + maint manual 10W2 + O/H manual		CRS.
			10W3 V&I.	<i>J. Johnson</i>	HDNR610E
<p>The item identified above was repaired and inspected in accordance with current Regulations of the Federal Aviation Administration and is approved for return to service. Pertinent details of the repair are on file at this repair station under order No. <u>832429063094</u> Date <u>8-8-94</u> Signed <u><i>J. Johnson</i></u> for Metro Aviation, Inc. CRS # HDNR610E Airport Rd. Downtown Airport #120 Shreveport, La. 71107</p>					

# MODIFICATION RECORD

## TURBINE ASSEMBLY

FORM 2783 D (BACK)

CAT 35461

250-C20B

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
4/7/97	CEB 1223 R1	Nozzle shield positioning plugs mod	<i>T. Wahl</i>	Keystone
4/7/97	CEB 1267	#2 wheel w/reduced dia. knives		Engine
4/7/97	CEB A-1341	Visual insp of nozzle shield dome	<i>T. Wahl</i>	Services
4/7/97	CEB A-1342 R1	Chemical insp of nozzle shield dome		
4/7/97	AD 96-19-01	N/A by part no of #5 & #8 bearings	<i>T. Wahl</i>	YKER025K
9-15-97	AD79-21-01 R1	N/A by P/N of 3rd stg wheel		Keystone Engine
9-15-97	AD83-03-02 R1	N/A by P/N of 3rd stg wheel	<i>T. Wahl</i>	Services YKER025K
04JAN11	AD2006-13-06	(CEB-A-1371) Replace turbine tiebolt		CRS# TU3R880L
04JAN11	AD2005-10-13	(CEB-A-1255) Energy absorbing ring	<i>[Large Signature]</i>	
04JAN11	CEB A-1253	Modify 1st/2nd stage nozzle		
04JAN11	CEB 1254	Modify gas producer support		
04JAN11	CEB 1399	Inspect oil sump		
04JAN11	CEB 1370	Nozzle shield P/N 6890040, S/N 8-80-1B3		ASI Services



# MODIFICATION RECORD

## TURBINE ASSEMBLY

Turbine Serial Number CAT-35461Engine Model 250-C20B

Compliance Date	Bulletin or Directive No.	Title	Signature	Organization
26 Jan 84	CEB 1158	PT Outer coupling nut drilled	<i>C. M. McGowan</i>	HELIPOWER 491-94
26 Jan 84	CEB 1161	New 6 & 7 Oil Jet	<i>C. M. McGowan</i>	HELIPOWER 491-94
26 Jan 84	CEB 1197	New GP Tie Bolt A.C.W.	<i>C. M. McGowan</i>	HELIPOWER 491-94
26 Jan 84	DIL 155	Heavy Maintenance Inspection	<i>C. M. McGowan</i>	HELIPOWER 491-94
8-8-94	CEB 1212 R3	Replace Tie Bolt	<i>J. Wilson</i>	METRO-
8-8-94	CEB A-1224 R2	INNER + Outer P.T. Shaft thicker nickel	<i>J. Wilson</i>	AVIATION
8-8-94	CEB 1262	1 <sup>st</sup> stage NOZZLE Key welds	<i>J. Wilson</i>	INC.
8-8-94	CEB-A-1283	ALSEAL Coating on P.T. Shafts	<i>J. Wilson</i>	CRS.
8-8-94	CEB-A-1292	N/A per Part S/n.	<i>J. Wilson</i>	HONR610E
4/7/97	CEB 1155 R1	PT support-rework scavenge strut		Keystone
4/7/97	CEB 1178 R2	PT inner shaft w/increased pilot	<i>T. Walsh</i>	Engine
4/7/97	CEB 1183 R1	GP support - repl anti-rotation pin		Services
4/7/97	CEB 1185	GP & PT supports-break edge hole		
4/7/97	CEB 1221 R5	PT sump cover - modify previous compliance verified	<i>T. Walsh</i>	YKER025K



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# INSPECTION — MAINTENANCE OVERHAUL RECORD TURBINE ASSEMBLY

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Turbine Serial Number CAT 35461

Engine Model 250-C20B

Date	Turbine Time		Remarks	Signature	Organization
	Since OH	Total			
4-29-98	58.0	3412.1	Replaced the 3rd and 4th stage wheels with used-serviceable		
Cycles:	81	3305	and tested per the manufacturer's specifications.		
Cycle Counter:		0005			
<div style="border: 1px solid black; padding: 5px;"> <p>The powerplant or component identified herein was repaired and inspected in accordance with current Federal Aviation Regulations, and was found airworthy for return to service. Pertinent details of the repairs are on file at this agency under:            W.O. No. <u>A00772</u> Date <u>4-29-98</u>            Signed <u><i>Neal Barlett</i></u> for            KEYSTONE ENGINE SERVICES CRS # YKER025K            1412 PHOENIXVILLE PIKE            WEST CHESTER, PA 19380            A Division of Keystone Helicopter Corp.</p> </div>					
04JAN11	95.0	3449.1	Installed an energy absorbing ring	CRS#	TU3R880L
	CSO: 176	TC: 3405	(AD2005-10-13) and reidentified to P/N		
			23038241. Not tested. Tiebolt P/N 23068265,		
			S/N NC85418, length 6.883", stretch .013".		
			All work accomplished in accordance with		
			Rolis Royce manual 10W3, 4th ed., temp.		
			rev. E4R6-72-1. ASI work order E65375.	ASI	Services













# ASSEMBLY RECORD

## TURBINE ASSEMBLY

Part V 1  
Page No. 1

FORM 2785 D(FRONT)  
REV. 12/70

Turbine Serial Number CAT-35461

Engine Model 250-C20B

Nomenclature	Part Number	Serial Number	INSTALLED			REMOVED			Reason
			Date	Turbine Total Time	This Item TT Cycles	Date	Turbine Total Time	This Item TT Cycles	
1st Stg Whl	6886407	x59691	9-12-79	0.0	0.0	26Jan84	1752.0	1752.0 2348	Time
2nd Stg Whl	6898782	HX49184		0.0	0.0	26Jan84	1752.0	1752.0 2348	Time
3rd Stg Whl	6899373	HX46077		0.0	0.0	12/13/96	3354.1	3354.1 3224	Cracks
4th Stg Whl	6853279	HX38343		0.0	0.0	8-8-94	2938.1	2938.1 3192	Cracked Shaft Knife Seal
1st Stg Whl	6886407	X83212	26Jan84	1752.0	0.0 0	12/13/96	3354.1	1602.1 876	Life Limit
2nd Stg Whl	6898782	X68185	26Jan84	1752.0	0.0 0	12/13/96	3354.1	1602.1 876	Life Limit
#4 Whl.	6853279	HX- 30167	8-8-94	2938.1	3312.7 3487	12/13/96	3354.1	3728.7 3903	Overhaul
1st Stg Whl	6886407	X 136750	4/7/97	3354.1	0.0 0				
2nd Stg Whl	6898782	HX 119110	4/7/97	3354.1	0.0 0				