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23032283HT Pinion Bearing Cage

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Subject: Removal, cleaning, inspection, rework, repair, and installation procedures for 23032283-1HT, 23032283-2HT & 23032283-3HT – Pinion Bearing Cages.

Compliance: Any time bearing cage is accessible.

Notes: Refer to OEM's published engine operation data.

Technical aspects are FAA approved

Standard shop practices may be substituted for materials and procedures referenced herein provided they have been demonstrated as effective and safe for use with these parts or their OEM and other FAA approved equivalents.

1.0 REMOVAL

1.1 Do not remove the cage unless obviously damaged or worn. The cage may be pressed or driven out of the cover using an arbor press & suitable drift. The cover may be heated to facilitate removal of the bearing cage. Do not exceed 300°F (149°C).

2.1 CLEANING

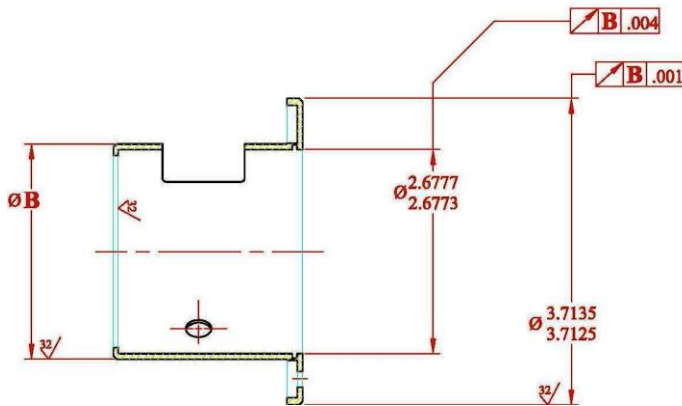
2.2 Agitate in petroleum solvent, P-D-680, Type 2 dry cleaning petroleum solvent or equivalent. Drain parts; blow petroleum solvent out of parts with dry filtered air.

3.1 INSPECTION

3.2 Bearing Cage Inspection. Inspect the installed bearing cages per Table 1:

Table 1

| Condition | Service Limit | Repair Limit | Corrective Action |
|--|-----------------|--------------|---|
| Bearing Bore Wear | 2.6777 – 2.6773 | None | Replace Cage |
| Bearing Bore Location (Reference Rolls Royce CSL-1238) | 0.004 in. TIR | None | Replace cage. Repair bearing cage bore in accordance with OEM published data. |
| Squareness to cover splitline | .0015 TIR max | None | Replace Cage |



| Part Number | Dia B | Oversize Mark |
|--------------|---------------|---------------|
| 23032283-1HT | 2.801 - 2.802 | ----- |
| 23032283-2HT | 2.804 - 2.805 | + .003 |
| 23032283-3HT | 2.807 - 2.808 | + .006 |

4.0 REPAIR

4.1 None

5.0 INSTALLATION (Refer to RRI# 250-201)

5.1 Assemble gearbox assembly in accordance with the manufacturer's instructions.

Oversized cages may be used where applicable and when available. However, new oversized cages shall be used only as required. When an oversized cage is necessary, machine the bore for the cage as required to maintain assembly fit specified in the table above. Chrome pickle the machined bore in accordance with MIL-M-3171.