



# REWORK & INSTALLATION INSTRUCTIONS

R.I.I. # 250-201  
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Reference Rolls Royce Publications: 5W3, 10W3, 11W3, 16W3, 14W3, GTP 5232-3 Revision: B

The following procedures provide descriptive information for installation of HYE-Tech Manufacturing Bearing Cages for the Rolls Royce 250 Series engines.

The following procedures shall be used in the installation of the following HYE-Tech Manufacturing bearing cages:

23059568HT 23032283HT 6843356HT 6843357HT 6843358HT 6843360HT 6843361HT  
6889316HT 6892287HT

### Caged Bearing Bore Repair

- (A) Replace bearing cages which are damaged or worn beyond acceptable fit limits using standard shop practices.
- (B) The following specific conditions are applicable to cage replacement.
  - (1) All cages shall be selected to obtain the bearing cage-to-housing fit as well as the specified bearing-to-cage fit. Oversized cages may be used where applicable. Machine the bore as necessary to maintain assembly fit limits with the oversized cages. All cages shall fit line-to-line to .001 in. tight in machined or restored bores.
  - (2) Before installing the new cage, be sure that the bore of the housing is clean & free from debris.
  - (3) The new lockpin shall be at least 3/16 in. (5 mm) removed from the old position & not close to an oil passage. Select the pin for a drive fit. Install pins flush to .005 in. (0.25 mm) below cage ID.
  - (4) A gap of .002 in (0.03 mm) (maximum) is acceptable between the bearing cage flange & its mated seating surface.
  - (5) Heat the area around the cage bore before installing the cage to ensure seating & avoid galling & wear on the cage & its mating bore. Do not exceed 300° F (149° C). Do not use galley type ovens with direct gas-flame heating. Apply a light coat of Loctite® 271 to the OD of the cage just prior to installation.
  - (6) After installation, verify the installed cage ID by measurement & sample bearing. Slight jig grinding is allowed to obtain desired ID of the installed cage.

**NOTE: For bearing cages 23032283HT & 23059568HT, Jig grinding is required after installation in order to achieve final bearing cage ID.**

Quality Assurance Armen M. Kajberouni	Date 9-Feb-05	Quality Control Heros P. Kajberouni	Date 9-Feb-05
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