



627 Ruberta Avenue
Phone: (818) 291-0338
Email: armen@hyetechllc.com

IFCA-G-007
Glendale, CA 91201
Fax: (818) 291-0339
Web: www.hyetechllc.com

6853446HT & 6844007HT Oil Pump Gear Shafts

For Warranty & Model Eligibility, Please visit us at www.hyetechllc.com

Subject: Removal, cleaning, inspection, rework, repair, and installation procedures for 6853446HT & 6844007HT – Oil Pump Gear Shafts.

Compliance: Any time oil pump is disassembled.

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 Remove the gearbox assembly in accordance with the manufacturer's instructions.
- 1.2 Disassemble gearbox assembly in accordance with the manufacturer's instructions.
- 1.3 Remove & disassemble Lube Oil Pump in accordance with the manufacturer's instructions.
- 1.4 Do not remove three pinned oil pump gear shafts unless replacement is necessary. If necessary, drive out shafts in accordance with the manufacturer's instructions.

2.0 CLEANING

- 2.1 Clean parts by vapor degreasing.

3.0 INSPECTION

- 3.1 No wear steps allowed.

4.0 REPAIR

- 4.1 None

5.0 INSTALLATION *(Reference 250-C20 Series CEB-1218)*

- 5.1 Prior to installation, clean both the gear shafts & bores using cleaning agents recommended by the Loctite® Corporation. Apply Loctite® 290 to the OD of the shafts ONLY. Align the slot on the shaft with the anti-rotation pin & ensure that it bottoms in the cover assembly bore. Clean any Loctite® on the shaft OD & cover assembly immediately.