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6853455HT & 6840117HT Oil Transfer Tubes

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

Subject: Removal, cleaning, inspection, rework, repair, and installation procedures for 6853455HT and 6840117HT – Oil Transfer Tubes.

Compliance: Any time the gearbox is disassembled, remove the transfer tubes & inspect as follows.

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 oil transfer tubes, discarding two preformed packings from each tube.

2.1 CLEANING

- 2.2 Agitate in petroleum solvent, P-D-680 or equivalent, 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 Inspect and repair or replace the oil tube per Table 1:



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Table 1

Tube assembly is a critical flight safety part. Critical characteristics are: Crack limits

Condition	Service Limit	Repair Limit	Corrective Action
Cracks (Visual & FPI)	None permitted.	No Repair.	Replace part
Preformed packing grooves for nicks and dents. (Visual)	None permitted.	Sealing capability is not affected.	Blend out protrusions using a fine file or Arkansas stone, FED-SS-S-736, Type 1 or equivalent.

4.1 REPAIR

4.2 None

5.1 INSTALLATION

5.2 Assemble gearbox in accordance with the manufacturer's instructions.

With gearbox housing mounted in stand and in a horizontal position, carefully assemble gearbox cover to the gearbox housing utilizing 6895957 or equivalent alignment tool to hold the oil transfer tubes. Align the oil delivery tube, scavenge oil pickup tube, and fuel control and oil pump flex shaft coupling.

Insert adapter 6799790 or equivalent in the tachometer and governor power train spur gearshaft. This may be used to turn the gear train to assist assembly. The 6799790 or equivalent adapter may also be used to assure proper engagement of fuel control spur gearshaft with flex shaft coupling.