



REWORK & INSTALLATION INSTRUCTIONS

R.I.I. # 250-202

Date 19-Dec-08

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Reference Rolls Royce Publications:

CEB-231, CEB-1105, CEB-101 & CEB-1083

Revision: Initial Release

The following procedures provide descriptive information for installation of HYE-Tech Manufacturing torque meter bushings 6898577HT for the Rolls Royce 250 Series engines.

Technical Aspects are FAA Approved

The following procedures shall be used in the installation of the following HYE-Tech Manufacturing torque meter bushings:

6898577-1HT, 6898577-2HT, 6898577-3HT, 6898577-4HT, 6898577-5HT, 6898577-6HT

Torquemeter Bore Preparation

NOTE:

When replacing the torquemeter bushing, a .001 - .0025 inch interference fit between the bushing pilot diameter & the bore in the gearbox cover. Select the bushing below & match the bore accordingly.

<u>Part Number</u>	<u>Pilot Diameter</u>	<u>Angle -E-</u>
6898577-1HT	1.2800 - 1.2805 Inch	45°
6898577-2HT	1.2830 - 1.2835 Inch	35°
6898577-3HT	1.2860 - 1.2865 Inch	55°
6898577-4HT	1.2925 - 1.2930 Inch	125°
6898577-5HT	1.2955 - 1.2960 Inch	135°
6898577-6HT	1.2985 - 1.2990 Inch	145°

Enlarge the torquemeter shaft bore to accommodate the selected dash number bushing. Follow the manufacturers recommended installation instructions found in the applicable engine series engine bulletin.

Quality Assurance Armen M. Kajberouni	Date 19-Dec-08	FAA-DER Approved
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