

## T-052 SERVICE BULLETIN

### Installation of E23032283-1, -2, -3 Bearing Cage

<b>Engine Application(s):</b>	Allison 250-C20, C20R, B17, B17F
<b>Subject:</b>	Installation instructions for E23032283-1, -2, -3 Bearing Cages.
<b>Compliance:</b>	Any time the subject part numbers are installed.
<b>Revisions:</b>	N/C Dated: 03/29/00 Initial Release. A Dated: 09/01/09 Updated EXTEX to TIMKEN. B Dated: 2/04/16 Updated Timken to EXTEX Engineered Products.

All dimensions are in inches. Numbers in brackets are in mm.

#### REASON:

To accommodate installation of high capacity roller bearings at the No. 3 and 4 bearing locations.

#### DESCRIPTION:

The instructions contained herein provide the procedures required to properly install the subject part numbers in the eligible engines when used with #3 and 4 roller bearings.

NOTE: Having satisfied all requirements for part interchangeability and TC application date per FAR 21.50 and FAA Order 8110.42, compliance with T-052 is not required if the applicable OEM instructions are used for installation. The applicable OEM publications are as follows:

<u>Engine</u>	<u>Publication</u>
250-C20 Series	CEB 1274
250-C20R Series	CEB 72-4020
250-B17 Series	TP CEB 1235
250-B17F Series	TP CEB 72-2007

#### APPROVAL:

Technical aspects are FAA Approved.

#### ACCOMPLISHMENT INSTRUCTIONS:

1. Comply with all OEM requirements pertaining to the gearbox cover assembly.
2. Select a new pinion bearing cage, P/N E23032283-1, -2 or -3 to provide a line-to-line to .001" tight fit in the bore of the cover. See Table 1 for OD dimensions of the cage.
3. Heat the area around the cage bore to 300°F (149 °C) maximum. Align the holes in the cage flange with the holes in the cover and press the cage into the cover until it is fully seated against the cover.
4. Machine the ID of the installed cage as shown in Figure 1. The depth of the shoulder is referenced for planning purposes only. Axis of machined ID must be square with splitline of cover assembly within .001 TIR and located within .002 of True Position. Coat the exposed (machined) surface of the cage

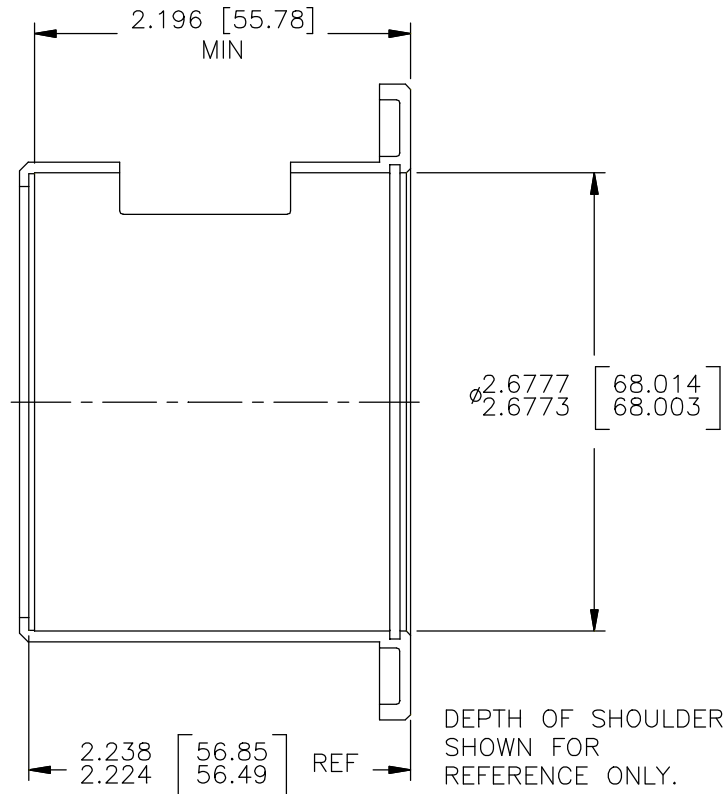
**T-052 SERVICE BULLETIN**

with corrosion inhibiting fingerprint compound (Rust Veto Z-238-G or 77-84-M rust inhibiting oil or Nox-Rust R-431-43 or equivalent).

5. Inspect the machined areas for compliance to Figure 1.
6. Re-identify the reworked gearbox cover assembly per OEM requirements.

Part Number	Dia
E23032283-1	2.801 - 2.802
E23032283-2	2.804 - 2.805
E23032283-3	2.807 - 2.808

**Table 1**



**Figure 1**