

**T-053 SERVICE BULLETIN**

**Rework of E6898785 Helical PTO Gearshaft**

<b>Engine Application(s):</b>	Allison 250-C28B, C28C, C30, C30L, C30M, C30P, C30R, C30R/1, C30R/3, C30S, C30U, C47B, C47M Series
<b>Subject:</b>	Rework instructions for E6898785 Helical PTO Gearshaft
<b>Compliance:</b>	Customer Option.
<b>Revisions:</b>	N/C Dated: 07/10/00 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.

**REASON:**

To reduce the tendency of the power take-off (PTO) gearshaft bearings to work off their journals.

**DESCRIPTION:**

A groove is added forward of the roller bearing journal for a retaining ring. The retaining ring will secure the roller bearing inner ring to prevent it from moving axially off the journal during engine operation.

NOTE: Having satisfied all conditions for part interchangeability and TC application date per FAR 21.50 and FAA Order 8110.42, compliance with T-053 is not required if the applicable OEM instructions are used for rework. The applicable OEM publications are as follows:

<u>Engine</u>	<u>Publication</u>
250-C28 Series	CEB 72-2184
250-C30 Series	CEB 72-3226
250-C47 Series	CEB 72-6014

**APPROVAL:**

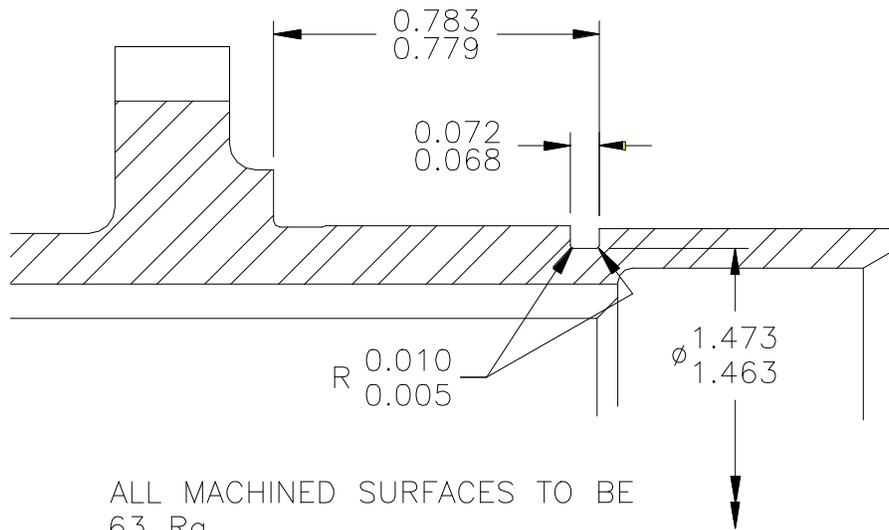
Technical aspects are FAA Approved.

**ACCOMPLISHMENT INSTRUCTIONS:**

1. Comply with all OEM instructions pertaining to gearbox disassembly and Helical PTO Gearshaft removal.
2. Inspect Helical PTO Gearshaft per the applicable OEM Operation and Maintenance Manual to ensure suitability for rework.
3. Machine a groove in the bearing journal as shown in Figure 1. Upon completion of machining, it is optional to reapply black oxide to the newly exposed bare-metal surfaces; however, for parts that are not to be immediately installed in an engine, application of a corrosion inhibiting substance is recommended.
4. MPI the gearshaft per the applicable OEM Overhaul Manual.

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5. Re-identify the reworked gearshaft P/N E6898785 to P/N E23068295 per AS478-2D1.
6. Install bearing inner race as required per OEM instructions. Install AS3216-124 retaining ring into the new groove forward of roller bearing inner race.
7. Install all components and reassemble gearbox per the appropriate OEM instructions.



**Figure 1**