

TEMPORARY REVISION

OHMG-TR-MDC-E4-385

Bonding of Gearbox-inner bearing rings

This Temporary Revision OHMG-TR-MDC-E4-385 is approved in conjunction with the Design Change Advisory MDC-E4-385 and is valid in conjunction with the latest revision of the Overhaul Manual-Gearbox (OHMG) until this Temporary Revision has been incorporated into the OHMG.

The limitations and information contained herein either supplement or, in the case of conflict, override those in the OHMG.

The technical information contained in this document has been approved under the authority of DOA ref. EASA.21J.0399.

Doc. Nr.	Affected Section(s)	Affected Page(s)s
E4.12.02	5	11a

Instruction:

- Print this document on yellow paper (single-sided)
- Insert this cover page as the first page of the OHMG
- Insert the other pages of this Temporary Revision adjacent to or in front of the corresponding OHMG pages

5. Gearbox assembly

5.2 Mounting preparations

5.2.2 Pre-assembly intermediate shaft

5.2.2.1 Material and securing

The existing table is amended to read:

Pos	Part number	Description	Qty	Torque	Tool	Securing	Mandatory replacement
02	NJ 2207E-TVP2 C3 *)	Roller bearing	2		W103.0002	Loctite 620	X

5.2.2.2 Mounting bearing inner rings

The existing text is replaced as follows:

- Heat up inner ring of roller bearings FAG NJ 2207E.TVP2 C3 (5.2.2.1-02) to 130°C
- Join/bond inner rings to intermediate shaft (5.2.2.1-01). Use Loctite 620. Use tool W103.0002 if necessary



Coat bearing seats of intermediate shaft evenly with Loctite 620 and press inner bearing ring on shaft until dead stop.



Check position of inner rings! No gap must be visible!

- Mount circlips 35x1,5 (5.2.2.1-03) on intermediate shaft