

SERVICE INSTRUCTION

DATE: December 20, 2000 Service Instruction No. 1503
Engineering Aspects are
FAA Approved

SUBJECT: Accessory Drive Gear and Shaft Dowel Replacement

MODELS AFFECTED: Textron Lycoming VO-435-B1A model engines.

TIME OF COMPLIANCE: At overhaul or whenever the accessory drive gear and shaft assembly P/N 76327 is disassembled.

Any time the accessory drive gear and shaft assembly, P/N 76327, is disassembled, replace the three standard dowels, P/N 76323, connecting the gear and shaft with oversize dowels P/N 76323-P15.

1. Mark the gear and shaft to allow the parts to be reassembled in the same orientation.
2. To remove the existing dowels from the assembly, remove the bolts securing the three lock tabs to the shaft flange and remove the lock tabs P/N 76324. Drive the dowels out of the assembly. (See Figure.)
3. Install the oversize dowels.
 - a. Reassemble the gear to the shaft, align dowel holes and reinstall the six bolts, but do not install the tabs.
 - b. Ream the three aligned dowel holes through the gear and the shaft flange to .2635-.2645. Be sure to remove material around the entire diameter on both pieces.
 - c. Press the oversize dowels P/N 76323-P15 into the holes until they are flush with the shaft flange. Mark P15 next to the dowel holes to show that oversize dowels have been installed.
 - d. Remove the six bolts and install the three new P/N 76324 lock tabs and torque the bolts to 100-120 in.-lbs. and lock the tabs.

