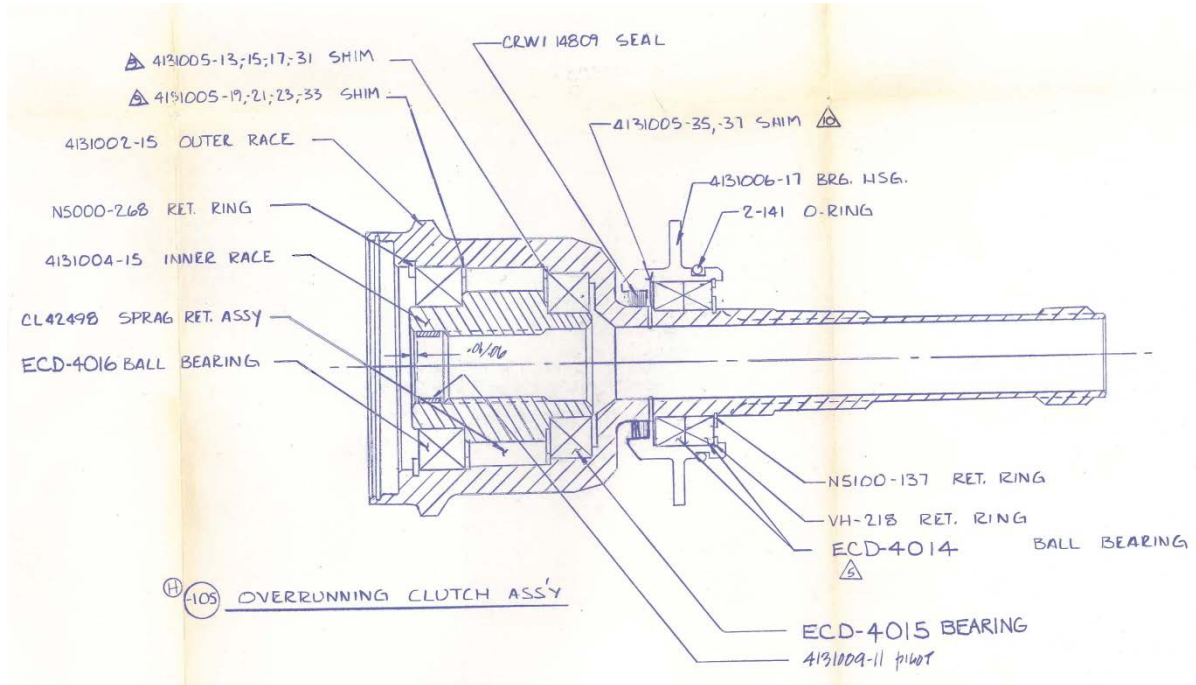




# ENSTROM HELICOPTER CORPORATION

## Work Aid Document: Over Running Clutch



### I. Disassembly

- A. Remove large retaining ring. (N5000-268)
- B. Tap housing lightly on a hard surface to dislodge bearings and sprag assemblies.



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- C. Do not remove the shim that is pressed into the bottom of the clutch housing.



- D. Remove the top bearing (ECD4016) and the (4151005-( )) shims from the bearing and sprag assembly.



- E. Remove the sprag assembly (CL42498) and the (4131005-( )) shims from the inner race assembly.

- F. Do not remove smaller or bottom bearing from inner race.



F. Flush all bearings, sprag and small oil holes in clutch housing with solvent.

G. Lubricate all parts during assembly with turbine engine oil.



H. Install the inner race and bottom bearing assembly into the clutch housing. All parts should be a slip fit although it might be necessary to tap the inner race and bearing assembly gently with a plastic hammer to get it to drop into place.

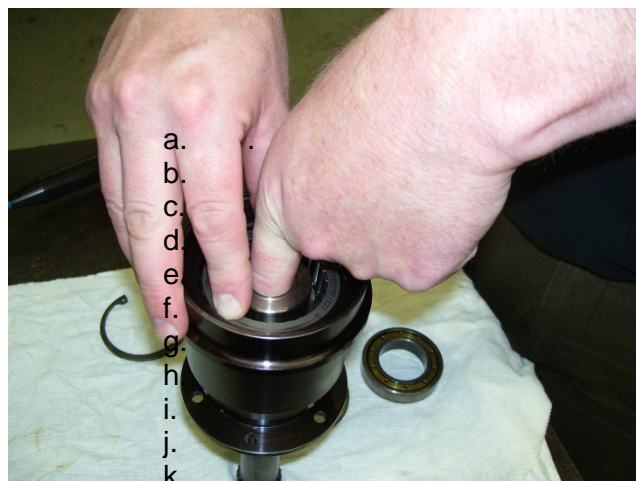
I. Place (4131005-( ))shims over the bearing race assembly.



J. Wrap the sprag assembly with a small rubber band and slide it over to the edge of the assembly closest to the arrow etched on the end race.







- K. Insert the sprag assembly over the inner race and into the clutch housing with the arrow down.
- L. Gently press down on the sprag assembly while turning the inside race with a finger. The sprag assembly should press down into the bell housing and push the rubber band off of the sprag assembly as it goes into place.
- M. Fish the rubber band out of the clutch assembly with a pick.
- N. Set the (4151005-( )) shims over the inner race assembly.





Q. Install the large bearing into the clutch housing, over the inner race.

R. Install the retaining ring.

