

**A723-18 Oil Line Assembly Retrofit Kit Instructions**

*Kit replaces superseded A723-15 oil line assembly with A723-18 oil line assembly. Applicable to R44 S/N 2613 & prior, R44 II S/N 14391 & prior, and Cadet S/N 30068 & prior, with original engine. Removal of MS20823-8 elbow may be difficult; RHC recommends kit be installed when engine is out of helicopter for other maintenance. KI-286-2 is optional, and includes new bead clamps with liners, eliminating the need for CRES tape.*

**NOTE**

Visit [www.robinsonheli.com](http://www.robinsonheli.com) to verify kit instructions are current revision. Review instructions before installation; contact RHC Technical Support with questions. Verify kit contents match list; contact RHC Customer Service if parts are missing or damaged.

ITEM	PART NUMBER	KIT CONTENTS	QTY PER KI-286-1	QTY PER KI-286-2
1	KI-286Instr.	Kit Instructions .....	1	1
2	A169-14	Bead Clamp (with liner) .....	0	12
3	A457-21	Elbow .....	1	1
4	A723-18	Line Assembly – Oil .....	1	1
5	77611	Gasket .....	3	3

**Consumables**

Refer to R44 Maintenance Manual (MM) § 23-70 for approved materials list.

- A701-10 Tape – CRES, 1-inch wide (not required if installing KI-286-2)
- B270-6 Sealant

**Kit Instructions**

1. Refer to R44 Illustrated Parts Catalog (IPC) Figures 53-1 and 53-5. Remove D040-1, C377 (LH), and C378 (RH) cowling assemblies.
2. **R44 II only:** Remove airbox assembly per MM § 6.470
3. Remove C169 muffler assembly by removing bead clamps to risers/collectors and clamps. **On engine-left (helicopter-right) side only:** remove risers connected to cylinders.
4. Remove breather tube or air/oil separator. Cover exposed connection on engine.
5. Refer to IPC Figure 79-7. Remove A723-15 oil line (outboard, helicopter-right) and MS20823-8 elbow. Discard oil line and elbow; retain hardware.
6. Apply light coat B270-6 sealant to threads on A457-21 elbow; do not apply sealant to first thread. Install elbow and standard torque per MM § 23-32.
7. Install A723-18 oil line assembly, aligning elbow as required by rotating in a clockwise (tightening) direction only. Special torque oil line end nuts to 40 ft–lb. Torque stripe per MM Figure 2-1.

**Kit Instructions (continued)**

8. Attach retained MS21919WDG clamps to oil line per applicable IPC § 79 Figure.
9. Install breather tube or air/oil separator.
10. Install new 77611 gaskets on engine-left side risers to cylinders; special torque nuts per MM § 23-33. Position muffler on risers/collectors and wrap joints under bead clamps with A701-10 tape as required. Install hardware securing bead clamps. Standard torque bead clamp bolts per R44 MM § 23-32. Verify security.
11. **R44 II only:** Install airbox assembly per R44 MM § 6.480.
12. Install D040-1, C377 (LH), and C378 (RH) cowling assemblies.
13. With an appropriately rated person at controls, perform starting engine and run-up followed by shutdown checklists per Section 4 of Pilot's Operating Handbook.
14. Verify no oil leaks; correct as required.
15. Make appropriate maintenance record entries. Weight and Balance change is negligible.