

OVERHAUL CHANGE NO. 8

CONNECTING ROD MODIFICATION

REFERENCE:

This change reflects all data and instruction in Franklin Service Bulletin No.99; consequently, a copy of the latter is not required.

1. REASON FOR CHANGE

a. To provide instructions for modification of connecting rod assembly, part No. 17541, to prevent interference between the edge of the connecting rod bolt hole and the fillet of the connecting rod bolt head resulting in possible failure of the bolt.

b. This change will be accomplished on the following engines:

<u>Model</u>	<u>Serial Number</u>
6V4-200-C32 & C33 <i>also 150/165</i>	26001 - 26924

c. The following engines have this change incorporated during production prior to delivery:

<u>Model</u>	<u>Serial Number</u>
6V4-200-C32 & C33	26925 and subsequent

2. MODIFICATION DATA

Modify connecting rods affected by this change order as follows:

a. Procure a piloted counterbore tool similar to that shown in figure 8-1.

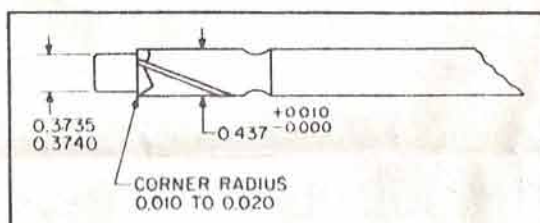


Figure 8-1

b. Counterbore the blade half of the connecting rod at the bolt head end of both bolt holes to a diameter of 0.437 +0.010 inch in accordance with figure 8-2.
-0.000

c. Burr mouth of counterbore (A, Figure 8-2) using hand ball burr. Remove minimum stock.

d. Burr bolt hole edge (B, Figure 8-2) using 60° included hand burr. Remove minimum stock.

e. Upon completion of the rework described herein, replace all connecting rod bolts and install new bolts, part No. 19632, which are identified with the symbol "△" on the head of each bolt as shown in figure 8-3.

3. SUPPLY DATA

a. Parts required per engine to accomplish modification:

<u>Qty. Per Engine</u>	<u>Part No.</u>	<u>Nomenclature</u>
12	19632	Bolt - Connecting Rod

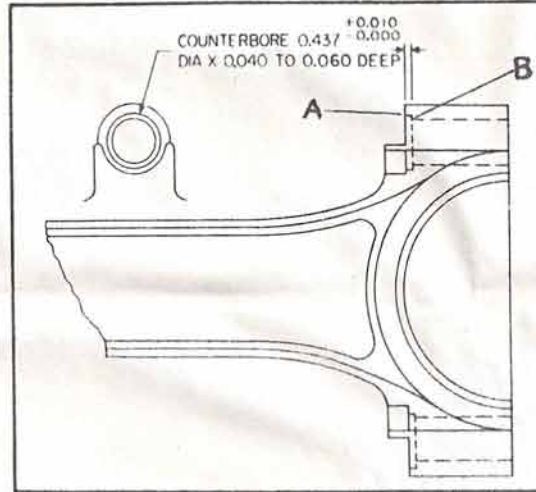


Figure 8-2

b. Spares affected: Modify all stock spares listed below in accordance with the procedures of paragraph 2.

<u>Part No.</u>	<u>Nomenclature</u>	<u>Part No. After Modification</u>
17541	Rod Assembly - Connecting	19633

c. Disposition of removed parts:

<u>Part No.</u>	<u>Nomenclature</u>
17684	Bolt - Connecting Rod

Above items removed from engines and spares will be scrapped. Connecting rod bolts, part No. 19632, with the symbol "△" on the head may be reinstalled.

d. Special tools required: None

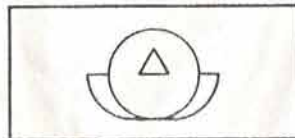


Figure 8-3